TECHNICAL DATA SHEET



QM 272 2 part moldmaking material

Description This is a pourable 2-part addition cure silicone elastomer system. After mixing parts 'A' and 'B' in the correct proportions, the **Uncured Product** Color A system will cure at ambient temperatures within 24 hours, but the

rate of cure can be accelerated by heat. The cured rubber exhibits excellent physical and electrical properties.

Key Features

- High durometer
- Casting resin resistance
- Fast de-mold time, excellent dimensional stability
- Heat is required to achieve 70 Shore A durometer

Architectural replication, furniture, picture frames, prototypes, rubber rolls

This material is a good choice for the molding of rubber rolls especially when a textured surface is required.

Use and Cure Information

IMPORTANT:

The 'A' part of product

contains the platinum catalyst; great care should be taken when using automatic dispensing equipment. Please ensure that it is not contaminated by residual hydride containing rubber in the dispensing equipment, as curing will result. If in doubt, it's advised to thoroughly purge the equipment with a suitable hydrocarbon solvent or silicone fluid.

Mixing

Both the 'A' and 'B' parts should be well stirred to ensure the material is uniform and any settlement of the fillers have been remixed. Place the required amount of 'A' and 'B' parts by weight at the mix ratio shown opposite, in a clean plastic or metal container of approximately 3 times their volume, and mix until the colour of the mixture is uniform. For best results, we recommend degassing. Degas by intermittent evacuation, the larger volume of the mixing vessel helps prevent overflow during this operation. In case of automatic dispensing with static mixing head, the two

Property Test Method Value

Beige Color B Clear/Hazy

RTV heat accelerated Cure Profile

Cure Type Addition

De-mould Time / Full Cure at 8 - 12 hrs 23°C/73°F

Mix Ratio By Weight 10:1

Specific Gravity A 1.28 Specific Gravity B 1.02

45,000 cP Viscosity A **Brookfield** 2.500 cP Viscosity B Brookfield 35,000 cP **Brookfield** Viscosity Mixed Work life at 25°C to Double

60 minutes Initial Viscosity

Cured Product

30 minutes at 150°C

Color **Beige** Elongation at Break **ISO 37** 100 % ASTM D 2240-95 70 Hardness Shore A Linear Shrinkage (%) < 0.1 % Max Working Temp 204 °C / 399 °F

-55 °C / -67 °F Min Working Temp Tear Resistance (N/mm) BS ISO 34-1 15.7 N/mm / 90 ppi ISO 37 5.52 N/mm2 / 800 psi Tensile Strength

Storage

Max Storage Temperature 38 °C / 100 °F Shelf Life 24 mths

components should be degassed before processing. Recommended vacuum conditions are 30-50 mbar intermittently over 5-10 minutes. Cast the mixture either by gravity or pressure injection. In order to achieve optimum performance, the same "A" and "B" side lot number should be used.

Inhibition of Cure

Great care must be taken when handling and mixing all addition cured silicone elastomer systems, ensuring that all the mixing tools (vessels and spatulas) are clean and constructed in materials which do not interfere with the curing mechanism. The cure of the rubber can be inhibited by the presence of compounds of nitrogen, sulphur, phosphorus and arsenic; organotin catalysts and PVC stabilizers; epoxy resin catalysts and even contact with materials containing certain of these substances e.g. moulding clays, sulphur vulcanised rubbers, condensation cure silicone rubbers, onion and garlic.

Curina Conditions

The data offers a guide to the rate of cure at various temperatures, mixing of the components at temperatures between 15 and 25°C is recommended to ensure adequate pot life for degassing and handling. The pot life can be extended to several hours by chilling the components before mixing.

Health & Safety

Safety Data Sheets available on request.

CHT Moulding Rubbers are available in a variety packaging including bulk containers. Please contact our sales department for more information.

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