

ALPA-LSR 120203 2 part, addition curing silicone elastomer for Liquid Injection Moulding (LSR)

Description	Property	Test Method	Value
Uncured Product			
This is a 2-part addition cure silicone elastomer system for Liquid Injection Moulding (LSR). After mixing parts 'A' and 'B' in the correct proportions, the system will cure at elevated temperatures, usually in the range of 100 °C to 180 °C. The cycle time depends mainly on the temperature and the shape of the mould. The cured rubber exhibits excellent physical and electrical properties.	Appearance		blue translucent
	Color A		blue
	Color B		addition
	Cure Type		
	De-mould Time / Full Cure at 23°C/73°F		> 48 hrs
Key Features	Density A	DIN 53 479	1.1
<ul style="list-style-type: none"> • selfadhesive to aluminium • low compression set 	Density B	DIN 53 479	1.08
Application	Mix Ratio By Weight		1:1
LSR silicone elastomer particularly suited for the production of gaskets & sealings. Self adhesive to metals without the use of primer.	Viscosity A	Brookfield HBTD	350000 cP
	Viscosity B	Brookfield HBTD	300000 cP
	Viscosity Mixed	Brookfield HBTD	325000 cP
Use and Cure Information	Cured Product		
IMPORTANT:	Color		blue
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.	Compression Set %	BS ISO 815-1	< 25 %
	Elongation at Break	DIN 53 504, S 3 A	600 %
	Hardness Shore A	DIN 53 505	22
	Linear Shrinkage (%)		< 0.1 %
	Tear Resistance (N/mm)	ASTM D 624, Die B	20 N/mm / 115 ppi
	Tensile Strength	DIN 53 504, S 3 A	8 N/mm² / 1160 psi
Mixing	Storage		
LSR silicone elastomers usually have a very high viscosity, which is why automatic mixing and dosing equipment is recommended for mixing!	Max Storage Temperature		30 °C °C / 86 °F
	Min Storage Temperature		0°C °C / 32 °F
	Shelf Life		12 mths
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, tubes and mixer) 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.		
Curing Conditions	LSR silicone elastomers do crosslink extremely slowly at room temperature. Temperatures greater than 100 °C are usually required to crosslink the materials in short time.		
Health & Safety	Safety Data Sheets available on request.		
Packaging	CHT Moulding Rubbers are available in a variety packaging including bulk containers. Please contact our sales department for more information.		
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