

## ALPA-LSR 170201 Preliminary datasheet

Description	Property	Test Method	Value
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.	<b>Uncured Product</b>		
	Color A		<b>translucent</b>
<b>Key Features</b>	Color B		<b>translucent</b>
	Cure Type		<b>addition</b>
• Product is suitable for Liquid Injection Moulding process • Curing speed can be accelerated by temperature • Very good mechanical properties • Easy demoulding	De-mould Time / Full Cure at 23°C/73°F		<b>&gt; 48 hrs</b>
	Density A	DIN 53 479	<b>1.13</b>
<b>Application</b>	Density B	DIN 53 479	<b>1.13</b>
	Mix Ratio By Weight		<b>1:1</b>
<b>Use and Cure Information</b>	Viscosity A	Brookfield HBTD	<b>550.000 cP</b>
	Viscosity B	Brookfield HBTD	<b>550.000 cP</b>
<b>IMPORTANT:</b> 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.	Viscosity Mixed	Brookfield HBTD	<b>550.000 cP</b>
	<b>Cured Product</b>		
• <b>Mixing</b> LSR silicone elastomers usually have a very high viscosity, which is why automatic mixing and dosing equipment is recommended for mixing!	Color		<b>translucent</b>
	Compression Set %	BS ISO 815-1	<b>- %</b>
• <b>Inhibition of Cure</b> 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.	Density	DIN 53479	<b>1.13 g/cm3</b>
	Elongation at Break	DIN 53 504, S 3 A	<b>200 %</b>
• <b>Curing Conditions</b> 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.	Hardness Shore A	DIN 53 505	<b>70</b>
	Linear Shrinkage (%)		<b>&lt; 0.1 %</b>
• <b>Health &amp; Safety</b> Safety Data Sheets available on request.	Max Working Temp		<b>200 °C / 392 °F</b>
	Min Working Temp		<b>-40 °C / -40 °F</b>
• <b>Packaging</b> CHT Moulding Rubbers are available in a variety packaging including bulk containers. Please contact our sales department for more information.	Tear Resistance (N/mm)	ASTM D 624, Die B	<b>20 N/mm / 115 ppi</b>
	Tensile Strength	DIN 53 504, S 3 A	<b>10 N/mm2 / 1450 psi</b>
Revision Date 05 Aug 2022 Revision No 5 Download Date 02 Oct 2022	<b>Storage</b>		
	Max Storage Temperature		<b>30 °C / 86 °F</b>
	Shelf Life		<b>12 mths</b>