

ALPA-SIL 97071-3 THI 2 part Silicone Moulding Rubber

Description	Property	Test Method	Value
This is a pourable 2-part addition cure silicone elastomer system. After mixing parts 'A' and 'B' in the correct proportions, the 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.	Uncured Product		
	Appearance		viscous liquid translucent
Key Features	Color A		Addition
	Cure Type		
<ul style="list-style-type: none"> crosslinks at temperatures above 23 °C/77°F easy processing due to low viscosity easy mixing of the components very good mechanical properties 	De-mould Time / Full Cure at 23°C/73°F		1.5 hrs
	Density A	BS ISO 2781	1.1
Use and Cure Information	Density B	BS ISO 2781	1.1
	Mix Ratio By Weight		1:1
IMPORTANT:	Pot Life mins at 23°C/73°F		20 mins
	Viscosity A	Brookfield	15000 cP
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 B	Brookfield	15000 cP
	Cured Product		
Mixing	Color		Black
	Elongation at Break	ISO 37	250 %
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 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.	Hardness Shore A	DIN 53 505	45
	Linear Shrinkage (%)		<0.1 %
Inhibition of Cure	Tear Resistance (N/mm)	BS ISO 34-1	10 N/mm / 58 ppi
	Tensile Strength	ISO 37	5 N/mm² / 725 psi
Curing Conditions	Storage		
	Max Storage Temperature		30 °C / 86 °F
Health & Safety	Shelf Life		6 mths
	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.		

Revision Date 29 Apr 2021
Revision No 1
Download Date 16 May 2022