

MM50T 2 part moulding compound

Description	Property	Test Method	Value
This is a two-component low tear room temperature condensation cure silicone system. The cured rubber is suitable for the mould making of patterns with fine details, where some dimensional stability is required. Low tear silicone moulding rubbers are cost effective for the production of moulds only requiring a few impressions. They find uses in the reproduction of plane surface objects	Uncured Product		
	Appearance		Viscous liquid
Key Features	Color A		Grey
	Cure Profile		23°C and 50% humidity
• Soft resilient rubber • Suitable for tampon print pads • Flexibility for deep undercuts • Fine detail pick up	Cure Type		Condensation
	De-mould Time / Full Cure at 23°C/73°F		8 hr hrs
Application Printing pads	Mix Ratio By Weight		20:1
	Pot Life mins at 23°C/73°F		>45 min mins
Use and Cure Information	Rheology		Liquid
	Viscosity A	Brookfield	12000 cP
The curing process starts as soon as the catalyst is added. Under normal conditions of temperature and humidity typical curing characteristics are described below. If the product is to be used in contact with aggressive chemicals, such as high styrene polyester resins or epoxies, it is recommended that the rubber be allowed to cure for 48 hours before use.	Viscosity B	Brookfield	50 cP
	Cured Product		
Pour the catalysed rubber into the mould from one point, ensuring air is not entrapped. Allow the rubber to cure before removing from the mould. To allow the rubber to achieve its maximum physical properties and chemical resistance leave the partially cured rubber to age at room temperature for at least a further 12 hours.	CTE Volumetric ppm/°C		799 ppm/°C
	Color		Blue
How to Use	Density	BS ISO 2781	1.21 g/cm3
	Elongation at Break	ISO 37	700 %
Charge the base rubber into a clean plastic or metal container, approximately 3-4 times its volume.	Hardness Shore 00	ASTM D 2240-95	47
	Linear Coefficient of Thermal Expansion (ppm/°C)		266 ppm/°C
Add standard catalyst in the proportion of 5 parts by weight of catalyst to 100 parts by weight of the rubber base. Mix thoroughly, slowly at first to avoid splashing and taking care to avoid excessive air entrapment. After catalysation any entrapped air may be removed by intermittent evacuation for several minutes. The use of a sufficiently large container permits degassing without overflow.	Linear Shrinkage (%)		0.5 %
	Max Working Temp		180 °C / 356 °F
Catalysts Use the following catalysts:	Min Working Temp		-50 °C / -58 °F
	Tear Resistance (N/mm)	BS ISO 34-1	6 N/mm / 35 ppi
The use of a sufficiently large container permits degassing without overflow.	Tensile Strength	ISO 37	1.7 N/mm2 / 247 psi
	Storage		
Use the following catalysts:	Max Storage Temperature		40 °C / 104 °F
	Shelf Life		12 mths

Code	Colour	Pot Life	De-Mould
MM CAT L5 NT	Clear	>60 mins	<24 hrs

Health & Safety

Health and 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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