

TECHNICAL DATA SHEET

MM709 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
	Color A		Translucent
	Cure Profile		23°C and 50% humidity
	Cure Type		Condensation
	De-mould Time / Full Cure at 23°C/73°F		<24 hr hrs
	Mix Ratio By Weight		20:1
	Pot Life mins at 23°C/73°F		>45 min mins
	Rheology		Liquid
	Viscosity A	Brookfield	18000 cP
	Viscosity B	Brookfield	50 cP
Key Features	Cured Product		
<ul style="list-style-type: none">• Very soft moulding rubber• Suitable for tampon print pads• Easily degassed• Low viscosity	CTE Volumetric ppm/°C		930 ppm/°C
Application	Color		Blue
Printing pads	Density	BS ISO 2781	1.00 g/cm3
Use and Cure Information	Elongation at Break	ISO 37	600 %
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.	Hardness Shore 00	ASTM D 2240-95	20
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.	Linear Coefficient of Thermal Expansion (ppm/°C)		310 ppm/°C
How to Use	Linear Shrinkage (%)		0.5 %
Charge the base rubber into a clean plastic or metal container, approximately 3-4 times its volume.	Max Working Temp		180 °C / 356 °F
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.	Min Working Temp		-50 °C / -58 °F
	Tear Resistance (N/mm)	BS ISO 34-1	3 N/mm / 17 ppi
	Tensile Strength	ISO 37	0.3 N/mm2 / 44 psi
	Storage		
	Max Storage Temperature		40 °C / 104 °F
	Shelf Life		12 mths

Catalysts

Use the following catalysts:

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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