

MM903 2 part moulding compound

| Description | Property | Test Method | Value | | | | | | | | | | | | | | | | | | | | |
|---|--|---|---|----------|----------|-------------|------|------|----------|---------|-------------|------|-----|------------|--------|--------------|------|-------|----------|---------|--|-------------------|--|
| <p>This is a two-component room temperature condensation curing silicone compound. The cured product is an exceptionally flexible rubber with very high mechanical properties and good shelf life stability. It is suitable for mould making of intricate patterns with extremely good pick up of fine details. Softer grades are better suited for use where there are deep undercuts.</p> <p>Key Features</p> <ul style="list-style-type: none"> • High tear strength • Flexibility for deep undercuts • High elongation • Easily degassed <p>Application</p> <p>making of intricate patterns with extremely good pick up of fine details</p> <p>Use and Cure Information</p> <p>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.</p> <p>How to Use</p> <p>Charge 100 parts by weight of Base Rubber and 5 parts by weight of catalyst into a suitable plastic or metal container. The volume of the mixing vessel should be sufficient to allow for rapid expansion which takes place during the initial degassing of the catalysed rubber. Mix thoroughly avoiding excessive air entrapment but using the colour contrast to achieve homogeneity. Stop the mixer and scrape the vessel walls a few times. To prevent imperfections due to bubbles in the cured rubber, it is advisable to de-aerate the liquid rubber by using intermittent evacuation for a few minutes. Normally after releasing the vacuum 2 or 3 times, the mass collapses naturally after which degassing should continue for only a few minutes.</p> <p>Vertical Application</p> <p>This Product can be used to make mouldings on vertical surfaces by employing Thixotroping Agent, MMTA2. A typical formulation for good thixotropy and approximately the same working life of the normal rubber is shown below:</p> <ul style="list-style-type: none"> • MM900 series 100 parts by weight • Catalyst 5 parts by weight • MMTA2 2 - 3 parts by weight <p>Mix the components in the above order. When using the fast cure catalyst, if degassing is required it must be done quickly after catalysation and before the addition of the Thixotroping Agent MMTA2. Pot life and rate of cure is slightly shorter in the presence of TA2.</p> <p>Standard catalyst for use with the MM900 series of rubbers</p> <table border="1"> <thead> <tr> <th>Code</th> <th>Ratio</th> <th>Colour</th> <th>Pot Life</th> <th>De-Mould</th> </tr> </thead> <tbody> <tr> <td>MM CAT B5NT</td> <td>20:1</td> <td>Blue</td> <td>>45 mins</td> <td><24 hrs</td> </tr> <tr> <td>MM CAT R5NT</td> <td>20:1</td> <td>Red</td> <td>15-45 mins</td> <td><3 hrs</td> </tr> <tr> <td>MM CAT L6WNT</td> <td>20:1</td> <td>Clear</td> <td>>45 mins</td> <td><24 hrs</td> </tr> </tbody> </table> <p>MM CAT W Booster is available to speed up standard cure catalysts</p> <p>Health & Safety</p> <p>Safety Data Sheets available on request.</p> <p>Packaging</p> <p>CHT Moulding Rubbers are available in a variety packaging including bulk containers. Please contact our sales department for more information.</p> | Code | Ratio | Colour | Pot Life | De-Mould | MM CAT B5NT | 20:1 | Blue | >45 mins | <24 hrs | MM CAT R5NT | 20:1 | Red | 15-45 mins | <3 hrs | MM CAT L6WNT | 20:1 | Clear | >45 mins | <24 hrs | <p>Uncured Product</p> <p>Cure Profile</p> <p>Cure Type</p> <p>De-mould Time / Full Cure at 23°C/73°F</p> <p>Mix Ratio By Weight</p> <p>Pot Life mins at 23°C/73°F</p> <p>Rheology</p> <p>Viscosity Mixed</p> | <p>Brookfield</p> | <p>23°C and 50% humidity Condensation</p> <p>>24 hr hrs</p> <p>20:1</p> <p>>45 min mins</p> <p>Liquid</p> <p>9000 cP</p> |
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| MM CAT L6WNT | 20:1 | Clear | >45 mins | <24 hrs | | | | | | | | | | | | | | | | | | | |
| | <p>Cured Product</p> <p>7 days at 23+/-2°C and 50+/-5% humidity</p> <p>Color</p> <p>Density</p> <p>Elongation at Break</p> <p>Hardness Shore A</p> <p>Linear Shrinkage (%)</p> <p>Max Working Temp</p> <p>Min Working Temp</p> <p>Tear Resistance (N/mm)</p> <p>Tensile Strength</p> | <p>BS ISO 2781</p> <p>ISO 37</p> <p>ASTM D 2240-95</p> <p>BS ISO 34-1</p> <p>ISO 37</p> | <p>Blue</p> <p>1.19 g/cm3</p> <p>900 %</p> <p>3</p> <p>0.5 %</p> <p>180 °C / 356 °F</p> <p>-50 °C / -58 °F</p> <p>9 N/mm / 51 ppi</p> <p>1.4 N/mm2 / 203 psi</p> | | | | | | | | | | | | | | | | | | | | |
| | <p>Storage</p> <p>Max Storage Temperature</p> <p>Shelf Life</p> | | <p>40 °C / 104 °F</p> <p>12 mths</p> | | | | | | | | | | | | | | | | | | | | |

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