

MM940 2 part moulding compound

Description

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.

Key Features

- High tear strength
- High dimensional stability
- Chemically resistant to PU and PE
- Fine detail pick up

Application

Fine detail pick up

Use and Cure Information

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.

How to Use

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.

Vertical Application

This Product can be used to make mouldings on vertical surfaces by employing thixotroping agent MM TA2. A typical formulation for good thixotropy and approximately the same working life of the normal rubber is shown below:

- MM900 series 100 parts by weight
- Catalyst 5 parts by weight
- MM TA2 2 - 3 parts by weight

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 MM TA2. Pot life and rate of cure is slightly shorter in the presence of TA2.

Use the following catalysts:

MM Product	Feature	Colour	Mixing ratio	Demould time [h]	Pot life [mins]
High tear catalyst (MM900 series)					
CAT B 5 NT	Standard cure	Blue	20:1	<24	>45
CAT L6W NT	Standard cure	Clear	20:1	<24	>45
CAT R 5 NT	Fast cure	Red	20:1	2	15
Additive					
MM CAT W*	Booster to accelerate cure	Clear	100:1	1-2	15
MM TA2	Thixotropic agent	Clear	100:2	N/A	N/A

*must be used in addition to standard cure speed MM catalyst.

Health & 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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Property

Uncured Product

Cure Profile		23°C and 50% humidity
Cure Type		Condensation
De-mould Time / Full Cure at 23°C/73°F: hrs		<24 hrs
Mix Ratio By Weight		20:1
Pot Life mins at 23°C/73°F		15 or >45 mins
Rheology		Liquid
Viscosity Mixed	Brookfield	50000 cP

Cured Product

7 days at 23+/-2°C and 50+/-5% humidity

Color		White, blue or red
Density	BS ISO 2781	1.12 g/cm ³
Elongation at Break	ISO 37	400 %
Hardness Shore A	ASTM D 2240-95	32
Linear Shrinkage (%)		0.4 %
Max Working Temp		200 °C / 392 °F
Min Working Temp		-50 °C / -58 °F
Tear Resistance (N/mm)	BS ISO 34-1	19 N/mm / 108 ppi
Tensile Strength	ISO 37	4.4 N/mm ² / 638 psi

Storage

Max Storage Temperature	40 °C / 104 °F
Shelf Life	6 mths

Test Method

Value

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