

## Moldmaster Cat Clear Standard Cure, Condensation Catalyst for QM 2125 and QM 2128

Description	Property	Test Method	Value
This is one of several catalysts for a two-component, room temperature, condensation cure system. The cured rubber has excellent mechanical properties and good shelf-life stability.	<b>Uncured Product</b>		
<b>Key Features</b>	Appearance		<b>Liquid</b>
<ul style="list-style-type: none"> <li>• Quick tack-free time</li> <li>• Fast demold time</li> <li>• Minimal impact on cured physical properties</li> </ul>	Color		<b>Translucent</b>
<b>Key Applications</b>	Cure Type		<b>Condensation</b>
<ul style="list-style-type: none"> <li>• Molds for polyester, polyurethane and epoxy resin castings</li> <li>• Molds for large and small statues, GFRC pre-cast</li> <li>• Molds for technical articles and prototypes</li> <li>• Molds for furniture and picture frame replication</li> </ul>	De-mould Time / Full Cure at 23°C/73°F		<b>8 to 12 hrs</b>
<b>Use and Cure Information</b>	Pot Life mins at 23°C/73°F		<b>45 to 70 mins</b>
<b>CURE CHARACTERISTICS</b>	Specific Gravity		<b>1.00</b>
The curing process begins as soon as the catalyst is mixed with the base. The material will cure as described in the data above under normal temperature (25°C) and humidity conditions (50% RH). Because this system is sensitive to heat and humidity, a change in cure speed may be observed if one or both of these variables are altered. A large difference in temperature (+/- 5°C) or humidity (> 60% – 70%) may alter the cure profile of the material. In addition, if the product is to be used with aggressive resins such as high styrene polyester resins, it is recommended that the rubber be allowed to cure for 48 hours.	Tack Free Time / Skin Formation at 23°C/73°F		<b>4 to 6 hrs</b>
<b>MIXING</b>	Viscosity	Brookfield	<b>&lt; 300 cP</b>
The catalyst should be thoroughly mixed prior to catalyzation of the base.	<b>Storage</b>		
CHT recommends that the catalyzed material be tested on a small area of the mold prior to use.	Max Storage Temperature		<b>38 °C / 100 °F</b>
The base should be thoroughly mixed with the catalyst of choice using a 10:1 ratio (base:catalyst) by weight. Shake the catalyst well before use. Material should be mixed in a clean, compatible metal or plastic container. The volume of the container should be 3 - 4 times the volume of the material to be mixed. This allows for expansion of the siloxane material during de-aeration.	Shelf Life		<b>12 mths</b>
Mix thoroughly by hand or with mixing equipment while minimizing air entrapment until a homogeneous mixture is obtained. This will occur when the material takes on a uniform color with no visible striations. Machine mixing is recommended for best results.			
<b>DE-AERATION</b>			
Air trapped during mixing should be removed by vacuum at 29 inches of mercury. During the process, the material will expand, and intermittent evacuation may be required. Typically, after releasing the vacuum 2 - 3 times, the mass will collapse on itself at which time the vacuum should be left on for an additional 2 - 4 minutes.			
<b>Health &amp; Safety</b>			
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Please observe our safety data sheets and the safety remarks on our container labels when handling our products. The dangerous goods regulations and the accident prevention regulations of the professional associations must be particularly observed. Keep the safety data sheet of the applied product at hand since it provides you with useful instructions for the safe use and disposal of the product as well as for actions to be taken in case of accidents.			
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