

## QM 237 2 part moldmaking material

| Description  | Property                                      | Test Method    | Value                            |
|--|---|----------------|----------------------------------|
| This is a pourable 2-part addition cure silicone elastomer system. After mixing parts 'A' and 'B' in the correct proportions, the system will cure at ambient temperatures within 24 hours, but the rate of cure can be accelerated by heat. The cured rubber exhibits excellent physical and electrical properties.   | <b>Uncured Product</b>                        |                |                                  |
|  | Color A                                       |                | Beige                            |
| <b>Key Features</b>  | Color B                                       |                | Dark blue                        |
|  | Cure Profile                                  |                | RTV heat accelerated             |
| • Low viscosity<br>• Fast de-mold time<br>• Casting resin resistance<br>• Excellent flexibility  | Cure Type                                     |                | Addition                         |
|  | De-mould Time / Full Cure at 23°C/73°F        |                | 6 - 8 hrs                        |
| <b>Application</b>   | Mix Ratio By Weight                           |                | 10:1                             |
|  | Rheology                                      |                | Liquid                           |
| Statues, polyester, PU and epoxy casting resins, prototypes and technical articles, architectural, picture frames  | Specific Gravity A                            |                | 1.32                             |
|  | Specific Gravity B                            |                | 0.97                             |
| <b>Use and Cure Information</b>  | Viscosity A                                   | Brookfield     | 17,000 cP                        |
|  | Viscosity B                                   | Brookfield     | 2,000 cP                         |
| <b>IMPORTANT:</b>  | Viscosity Mixed                               | Brookfield     | 10,000 cP                        |
|  | Work life at 25°C to Double Initial Viscosity |                | 35 minutes                       |
| The 'A' part of product contains the platinum catalyst; great care should be taken when using automatic dispensing equipment. Please ensure that it is not contaminated by residual hydride containing rubber in the dispensing equipment, as curing will result. If in doubt, it's advised to thoroughly purge the equipment with a suitable hydrocarbon solvent or silicone fluid.   | <b>Cured Product</b>                          |                |                                  |
|  | <b>3 days at 25°C</b>                         |                |                                  |
| <b>Mixing</b>  | Color   |                | Blue                             |
|  | Hardness Shore A                              | ASTM D 2240-95 | 37                               |
| Both the 'A' and 'B' parts should be well stirred to ensure the material is uniform and any settlement of the fillers have been remixed. Place the required amount of 'A' and 'B' parts by weight at the mix ratio shown opposite, in a clean plastic or metal container of approximately 3 times their volume, and mix until the colour of the mixture is uniform. For best results, we recommend degassing. Degas by intermittent evacuation, the larger volume of the mixing vessel helps prevent overflow during this operation. In case of automatic dispensing with static mixing head, the two components should be degassed before processing. | Linear Shrinkage (%)                          |                | <0.1 %                           |
|  | Max Working Temp                              |                | 204 °C / 399 °F                  |
| Recommended vacuum conditions are 30-50 mbar intermittently over 5-10 minutes. Cast the mixture either by gravity or pressure injection. In order to achieve optimum performance, the same "A" and "B" side lot number should be used.   | Min Working Temp                              |                | -55 °C / -67 °F                  |
|  | Tensile Strength                              | ISO 37         | 3.62 N/mm <sup>2</sup> / 525 psi |
| <b>Inhibition of Cure</b>  | <b>Storage</b>                                |                |                                  |
|  | Max Storage Temperature                       |                | 38 °C / 100 °F                   |
| Great care must be taken when handling and mixing all addition cured silicone elastomer systems, ensuring that all the mixing tools (vessels and spatulas) are clean and constructed in materials which do not interfere with the curing mechanism. The cure of the rubber can be inhibited by the presence of compounds of nitrogen, sulphur, phosphorus and arsenic; organotin catalysts and PVC stabilizers; epoxy resin catalysts and even contact with materials containing certain of these substances e.g. moulding clays, sulphur vulcanised rubbers, condensation cure silicone rubbers, onion and garlic.                                    | Shelf Life                                    |                | 24 mths                          |

### Inhibition of Cure

Great care must be taken when handling and mixing all addition cured silicone elastomer systems, ensuring that all the mixing tools (vessels and spatulas) are clean and constructed in materials which do not interfere with the curing mechanism. The cure of the rubber can be inhibited by the presence of compounds of nitrogen, sulphur, phosphorus and arsenic; organotin catalysts and PVC stabilizers; epoxy resin catalysts and even contact with materials containing certain of these substances e.g. moulding clays, sulphur vulcanised rubbers, condensation cure silicone rubbers, onion and garlic.

### Curing Conditions

The data offers a guide to the rate of cure at various temperatures, mixing of the components at temperatures between 15 and 25°C is recommended to ensure adequate pot life for degassing and handling. The pot life can be extended to several hours by chilling the components before mixing.

### 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.

Revision Date 01 Oct 2021  
Revision No 3  
Download Date 16 May 2022

The content set out in the technical data sheet does not contain information upon which you should rely. It is provided for general information purposes only and does not constitute a product specification. You must obtain professional or specialist advice before taking any action based on the information provided in the technical data sheet.

CHT make reasonable efforts to ensure that information set out in the technical data sheet is complete, accurate, and up-to-date. CHT do not, however, make any representations, warranties or guarantees (whether express or implied) that information set out in the technical data sheet is complete, accurate, or up-to-date or that the product will be suitable for your requirements. You should carry out your own testing to determine the applicability of such information and whether the product will be suitable. CHT reserve the right to modify the technical data sheet at any time. The CHT technical service department is available to offer further information and advice and should it be needed to look at modifying current products or custom formulate a new one to meet your specific requirements. Please contact the technical service department.

CHT Germany GmbH: Postfach 12 80, 72002 Tübingen, Bismarckstraße 102, 72072 Tübingen, Germany  
Telephone: 07071/154-0, Fax: 07071/154-290, Email: info@cht.com, Homepage: www.cht.com / www.cht-silicones.com