TECHNICAL DATA SHEET



QM 247 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	Uncured Product Color A Color B		Beige Clear
 exhibits excellent physical and electrical properties. Key Features Excellent tear resistance 	Cure Profile Cure Type		RTV heat accelerated Addition
 Casting resin resistance Fast de-mold time, good mold stability FDA CFR 177.2600 compliant 	De-mould Time / Full Cure at 23°C/73°F Mix Ratio By Weight		6 - 8 hrs 10:1
Application	Rheology		Liquid
Statues, polyester, PU and epoxy casting resins, prototypes and technical articles, architectural, picture frames	Specific Gravity A Specific Gravity B		1.34 0.96
Use and Cure Information	Viscosity A	Brookfield	50.000 cP
IMPORTANT:	Viscosity B	Brookfield	2,000 cP
The 'A' part of product	Viscosity Mixed	Brookfield	30,000 cP
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	Work life at 25°C to Double Initial Viscosity		45 minutes
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.	Cured Product 3 days at 25°C		
Mixing	Color	10.0 07	Beige
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	Elongation at Break FDA Tested	ISO 37 CFR (21] 177.2600	400 % CFR 177.2600
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. 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.	Hardness Shore A Linear Shrinkage (%) Max Working Temp Min Working Temp	ASTM D 2240-95	<0.1 % 204 °C / 399 °F -55 °C / -67 °F
	Tensile Strength Storage Max Storage Temperature Shelf Life	ISO 37	4.14 N/mm2 / 600 psi 38 °C / 100 °F 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.

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