TECHNICAL DATA SHEET



Value

light blue

light blue

Addition

> 48 hrs

350000 cP

300000 cP

325000 cP

Light blue

< 25 %

600 %

< 0.1 %

6 N/mm2 / 870 psi

30 °C °C / 86 °F

0°C °C / 32 °F

12 mths

23.5

ASTM D 624, Die B 15 N/mm / 86 ppi

1.1

1:1

1.08

translucent

Test Method

DIN 53 479

DIN 53 479

Brookfield HBTD

Brookfield HBTD

Brookfield HBTD

BS ISO 815-1

DIN 53 505

DIN 53 504, S 3 A

DIN 53 504, S 3 A

ALPA-LSR 120203 - Preliminary datasheet! -

Property

Color A

Color B

Cure Type

23°C/73°F

Density A

Density B

Viscosity A

Viscosity B

Color

Viscosity Mixed

Cured Product

Compression Set %

Elongation at Break

Linear Shrinkage (%)

Tear Resistance (N/mm)

Max Storage Temperature

Min Storage Temperature

Hardness Shore A

Tensile Strength

Storage

Shelf Life

Mix Ratio By Weight

Appearance

Uncured Product

De-mould Time / Full Cure at

Description

This is a 2-part addition cure silicone elastomer system for Liquid Injection Moulding (LSR). After mixing parts 'A' and 'B' in the correct proportions, the system will cure at elevated temperatures, usually in the range of 100 °C to 180 °C. The cycle time depends mainly on the temperature and the shape of the mould. The cured rubber exhibits excellent physical and electrical properties.

Key Features

- selfadhesive to aluminium
- low compression set

Application

ALPA-LSR 120203 is particularly suited for the production of gaskets & sealings. Self adhesive to metals without the use of primer.

In order to achieve the described properties, the vulcanization time, if a hot-air oven is used, should be at least 45 minutes at 175 °C. If a heating press is used, at least 5 minutes at 175 °C are required. In addition a postcure 4 h at 200 °C is recommended.

Use and Cure Information IMPORTANT:

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.

Mixing

LSR silicone elastomers usually have a very high viscosity, which is why automatic mixing and dosing equipment is recommended for mixing!

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, tubes and mixer) 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

LSR silicone elastomers do crosslink extremely slowly at room temperature. Temperatures greater than 100 °C are usually required to crosslink the materials in short time.

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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