

MM228 10:1 addition cure silicone moulding rubber

Introduction

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.

Key Features

- Good abrasion resistant properties
- Good dimensional stability
- Very low viscosity
- Can be diluted with ACC Tampo 50 fluid

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

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. Recommended vacuum conditions are 30-50 mbar intermittently over 5-10 minutes. Cast the mixture either by gravity or pressure injection.

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 and Safety

Safety Data Sheets available on request.

Packaging

ACC 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

Appearance	
Colour A Part	
Colour B Part	
Cure Type	
De-Mould Time Hrs	
Max Cure Hrs @ 25 °C	
Max Cure Mins @ 100 °C	
Mix Ratio	
Pot Life mins	
Viscosity A-Part mPas	Brookfield
Viscosity B-Part mPas	Brookfield
Viscosity Mixed mPas	Brookfield

Cured product

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

CTE Linear ppm/°C		267 ppm/°C
CTE Volumetric ppm/°C		801 ppm/°C
Colour		Translucent
Duro Shore A	ASTM D 2240-95	28
Elongation %	ISO 37	746 %
FDA	CFR (21) 177.2600	No
Linear Shrinkage %		0.06 %
Max Working Temp +°C	AFS_1540B	200 °C
Min Working Temp - °C		-60 °C
Modulus Youngs MPa		0.62 MPa
SG	BS ISO 2781	1.12
Tear kN/m	BS ISO 34-1	31 kN/m
Tensile MPa	ISO 37	5.06 MPa

Storage

Max storage temperature °C	30 °C
Shelf life	12 mths

Test Method

Value

Viscous liquid
Translucent
Translucent
Addition

5 hrs
24 hrs
30 mins
10:1

55 mins
18000 mPas
1000 mPas
13000 mPas

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