Technical Data Sheet

MM4400
Condensation cure paste high tear

Introduction

This is a two component room temperature, condensation cure, silicone paste system. The cured rubber is a medium hardness material ideal for vertical mould making of architectural materials, columns and big statues.

Key Features

- Thixotropic Paste
- 10:1 mix ratio
- Ideal for taking impressions of verticle surfaces
- Catalyst in easy to use tubes

Use and Cure Information

MM4400 is manually mixed with the 5% of curing agent MM CAT4400, and applied within the pot life time; it is advisable use small quantities (200-300 gr.) each time, just to prevent a procuring of the product that should make it useless. Reaching of the perfect mixture can be established when the colour is uniform.

The catalysed mass is manually pressed onto the pattern. In case of necessity of very detailed reproductions is advisable use as follows:

1. Clean and degrease the pattern (this step is anyway suggested for a good impression result).

2. Paint one or two coats of pourable product in addition with MMTA2 Thixotroping agent; this step is necessary just to reach the perfect details definition of the pattern's surface.

The products used in this way are all the MM 900 series.

3. Before the painted coats are cured, start the application of catalyzed MM4400, in order to give fast thickness to the mould; usually the desired thickness is about 20 - 30 mm.

4. Once cured, is possible build up a mother mould in fibreglass or gypsum.

This process allows a faster solution in case of big dimension objects and is widely used in monumental restoration

Health and Safety

Safety Data Sheets available on request.

Property	Test Method	Value
Uncured product		
Appearance		**Thixotropic Paste**
Colour A Part		**Grey**
Colour B Part		**Yellow**
Cure Type		**Condensation**
De-Mould Time Hrs		**1 hrs**
Max Cure Hrs @ 25 °C		**1 hrs**
Mix Ratio		**20:1**
Pot Life mins		**15 mins**
Cured product		
After 7 days cure at 23°+/-2°C and 50+/-5% humidity		
CTE Linear ppm/°C		**268 ppm/°C**
CTE Volumetric ppm/°C		**804 ppm/°C**
Colour		**Yellow**
Duro Shore A	ASTM D 2240-95	**16**
Elongation %	ISO 37	**400 %**
FDA	CFR (21] 177.2600	**No**
Linear Shrinkage %		**0.5 %**
Max Working Temp +°C	AFS_1540B	**200 °C**
Min Working Temp - °C		**-50 °C**
SG	BS ISO 2781	**1.2**
Tear kN/m	BS ISO 34-1	**8 kN/m**
Tensile MPa	ISO 37	**1.5 MPa**
Storage		
Max storage temperature °C		**40 °C**
Shelf life		**12 mths**

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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