MM830
Condensation cure silicone moulding rubber 27 Shore A low tear

Property | Test Method | Value
--- | --- | ---
Uncured product | | |
Appearance | | Viscous Liquid
Colour A Part | | Grey
Cure Type | | Condensation
De-Mould Time Hrs | | 24 hrs
Mix Ratio | | 20:1
Pot Life mins | | 60 mins
Viscosity A-Part mPas | Brookfield | 18000 mPas
Viscosity B-Part mPas | Brookfield | 50 mPas
Viscosity Mixed mPas | Brookfield | 10800 mPas

Cured product
After 7 days cure at 23°+/-2°C and 50+/-5% humidity
CTE Linear ppm/°C | 258 ppm/°C
CTE Volumetric ppm/°C | 857 ppm/°C
Duro Shore A | ASTM D 2240-95 | 27
Elongation % | ISO 37 | 200 %
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 | 1.11
Tear kN/m | BS ISO 34-1 | 2 kN/m
Tensile MPa | ISO 37 | 1.5 MPa

Storage
Max storage temperature °C | 40 °C
Shelf life | 12 mths

Introduction
This is a two-component low tear room temperature condensation cure silicone system. The cured rubber is suitable for the mould making of patterns with fine details, where some dimensional stability is required. Low tear silicone moulding rubbers are cost effective for the production of moulds only requiring a few impressions. They find uses in the reproduction of plane surface objects.

Key Features
- Easy demoulding
- Easily degassed
- Low viscosity
- Fine detail pick up

Use and Cure Information
The curing process starts as soon as the catalyst is added. Under normal conditions of temperature and humidity typical curing characteristics are described below. If the product is to be used in contact with aggressive chemicals, such as high styrene polyester resins or epoxies, it is recommended that the rubber be allowed to cure for 48 hours before use.

Pour the catalysed rubber into the mould from one point, ensuring air is not entrapped. Allow the rubber to cure before removing from the mould. To allow the rubber to achieve its maximum physical properties and chemical resistance leave the partially cured rubber to age at room temperature for at least a further 12 hours.

How to Use
Charge the base rubber into a clean plastic or metal container, approximately 3-4 times its volume.

Add standard catalyst in the proportion of 5 parts by weight of catalyst to 100 parts by weight of the rubber base. Mix thoroughly, slowly at first to avoid splashing and taking care to avoid excessive air entrapment. After catalysis any entrapped air may be removed by intermittent evacuation for several minutes. The use of a sufficiently large container permits degassing without overflow.

Catalysts
Use the following catalyst available from ACC Silicones

<table>
<thead>
<tr>
<th>Code</th>
<th>Colour</th>
<th>Pot Life</th>
<th>De-Mould</th>
</tr>
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<tbody>
<tr>
<td>MM CAT L5 NT</td>
<td>Clear</td>
<td>&gt;60 mins</td>
<td>&lt;24 hrs</td>
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</table>

Health and 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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