

370 Silicone Moulding Rubber

Description

This is a two component room temperature condensation curing silicone compound. The cured product is an exceptionally flexible rubber with very high mechanical properties and good shelf life stability. It is suitable for mould making of intricate patterns with extremely good pick up of fine details. Softer grades are better suited for use where there are deep undercuts.

Key Features

- Good with deep undercuts
- Easy degassing
- High Elongation
- High tear strength

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.

How To Use

Charge 95-100 parts by weight of Base Rubber and 5 parts by weight of catalyst into a suitable plastic or metal container. The volume of the mixing vessel should be sufficient to allow for rapid expansion which takes place during the initial degassing of the catalysed rubber. Mix thoroughly avoiding excessive air entrapment but using the colour contrast to achieve homogeneity. Stop mixing to scrape the vessel walls a few times. To prevent imperfections due to bubbles in the cured rubber, it is advisable to de-aerate the liquid rubber by using intermittent evacuation for a few minutes. Normally after releasing the vacuum 2 or 3 times, the mass collapses naturally after which degassing should continue for only a few minutes.

The viscosity of uncured silicone moulding rubber is affected by temperature and will thicken when used in colder temperatures. To make mixing and pouring easier, ensure that silicone moulding rubber is used at room temperature of 20°C or above.

Technical Data

Uncured:

Colour: Beige
Appearance: Viscous Liquid
Viscosity: Brookfield 14000 mPa.s
Catalysed viscosity Brookfield 11000 mPa.s
Pot Life: 45 - 120 minutes *
De-mould time 10 hours *
* measured at 23+/-2°C and 65% relative humidity using T26 catalyst.

Cured Elastomer:

(after 7 days cure at 23+/-2°C and 65% relative humidity)
Tensile Strength: BS903 Part A2 2.80 MPa
Elongation at Break : BS903 Part A2 622 %
Youngs Modulus: 0.79MPa
Modulus at 100% Strain: BS903 Part A2 0.38MPa
Tear Strength: BS903 Part A3 20.18 kN/m
Hardness: ASTM D 2240-95. 13° Shore A
Specific Gravity: BS 903 Part A1 1.23
Linear Shrinkage: 0.46 %
Coefficient of Thermal Expansion:
Volumetric 750 ppm / °C
Linear 250 ppm / °C

Whilst all reasonable care is taken in compiling technical data on the Company's products, all recommendations or suggestions regarding the use of such products are made without guarantee, since the conditions of use are beyond the control of the Company. It is the customer's responsibility to satisfy themselves that each product is fit for the purpose for which they intend to use it, that the actual conditions of use are suitable and that in the light of our continual research and development programme the information relating to each product has not been superseded.

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Product Code: 370**TECHNICAL DATA SHEET**

Min. Service Temperature: -50°C

Max. Service Temperature: AFS 1540B 200 °C

All values are typical and should not be accepted as a specification.

Storage

Silicone Moulding Rubber should be stored unopened in its original packaging in cool, dry conditions. Under such conditions it will have a shelf life of at least 12 months below 40°C.

Health & Safety

For information and advice on the safe handling and storage of products, users should refer to the current safety Data Sheet containing physical, ecological, toxicological and other safety related data.

Disposal

Product recommendations: Must be disposed of in a special waste disposal unit in accordance with the corresponding regulations.

Packaging recommendations: Completely emptied packaging can be given for recycling. Packaging that cannot be cleaned should be disposed of as product waste.

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