

TECHNICAL DATA SHEET

QM 247 2 part moldmaking material

Description

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

- Excellent tear resistance
- Casting resin resistance
- Fast de-mold time, good mold stability
- FDA CFR 177.2600 compliant

Application

Statues, polyester, PU and epoxy casting resins, prototypes and technical articles, architectural, picture frames

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. In order to achieve optimum performance, the same "A" and "B" side lot number should be used.

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 & 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.

Revision Date 05 Oct 2021
Revision No 2
Download Date 17 May 2024

Property

Uncured Product

Color A

Color B

Cure Profile

Cure Type

De-mould Time / Full Cure at
23°C/73°F

Mix Ratio By Weight

Rheology

Specific Gravity A

Specific Gravity B

Viscosity A

Viscosity B

Viscosity Mixed

Work life at 25°C to Double
Initial Viscosity

Cured Product

3 days at 25°C

Color

Elongation at Break

FDA Tested

Hardness Shore A

Linear Shrinkage (%)

Max Working Temp

Min Working Temp

Tensile Strength

Storage

Max Storage Temperature

Shelf Life

Test Method

Value

Beige

Clear

RTV heat
accelerated
Addition

6 - 8 hrs

10:1

Liquid

1.34

0.96

50,000 cP

2,000 cP

30,000 cP

45 minutes

Beige

400 %

CFR 177.2600

45

<0.1 %

204 °C / 399 °F

-55 °C / -67 °F

4.14 N/mm2 / 600 psi

38 °C / 100 °F

24 mths

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