

## QM 260 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

- High durometer
- Casting resin resistance
- Fast de-mold time, excellent dimensional stability
- FDA CFR 177.2600 compliant

### Application

Candy and other food molds, polyester, PU and epoxy casting resins, prototypes and technical articles, architectural, picture frames, furniture

### 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      06 Oct 2021  
Revision No        4  
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

Tear Resistance (N/mm)

Tensile Strength

#### Storage

Max Storage Temperature

Shelf Life

### Test Method

### Value

Beige

Blue

RTV heat  
accelerated  
Addition

8 - 12 hrs

10:1

Liquid

1.32

0.98

Brookfield

Brookfield

Brookfield

130,000 cP

1,000 cP

90,000 cP

70 minutes

ISO 37

CFR (21]  
177.2600

ASTM D 2240-95

60

<0.1 %

204 °C / 399 °F

-55 °C / -67 °F

BS ISO 34-1

ISO 37

Light blue

190 %

CFR 177.2600

60

<0.1 %

204 °C / 399 °F

-55 °C / -67 °F

18.2 N/mm / 104 ppi

5.86 N/mm2 / 850 psi

38 °C / 100 °F

24 mths

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CHT Germany GmbH: Postfach 12 80, 72002 Tübingen, Bismarckstraße 102, 72072 Tübingen, Germany

Telephone: 07071/154-0, Fax: 07071/154-290, Email: info@cht.com, Homepage: www.cht.com / www.cht-silicones.com