

## QM 264 2 part moldmaking material

Description	Property	Test Method	Value
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.	<b>Uncured Product</b>		
	Color A		Beige
<b>Key Features</b> <ul style="list-style-type: none"><li>• High durometer</li><li>• Casting resin resistance</li><li>• Fast de-mold time, excellent dimensional stability</li><li>• FDA CFR 177.2600 compliant</li></ul>	Color B		Blue
	Cure Profile		RTV heat accelerated Addition
<b>Application</b> Polyester, PU and epoxy casting resins, prototypes and technical articles, architectural, picture frames, furniture	Cure Type		
	De-mould Time / Full Cure at 23°C/73°F		12 - 18 hrs
<b>Use and Cure Information</b> <b>IMPORTANT:</b> 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.	Mix Ratio By Weight		10:1
	Rheology		Liquid
	Specific Gravity A		1.28
	Specific Gravity B		1.03
	Viscosity A	Brookfield	150,000 cP
	Viscosity B	Brookfield	5,200 cP
	Viscosity Mixed	Brookfield	110,000 cP
	Work life at 25°C to Double Initial Viscosity		75 minutes
	<b>Cured Product</b>		
	<b>3 days at 25°C</b>		
	Color		Light blue
	Elongation at Break	ISO 37	240 %
	FDA Tested	CFR (21) 177.2600	CFR 177.2600
	Hardness Shore A	ASTM D 2240-95	60
	Linear Shrinkage (%)		<0.1 %
	Max Working Temp		204 °C / 399 °F
	Min Working Temp		-55 °C / -67 °F
	Tear Resistance (N/mm)	BS ISO 34-1	20.8 N/mm / 119 ppi
	Tensile Strength	ISO 37	5.52 N/mm2 / 800 psi
	<b>Storage</b>		
	Max Storage Temperature		38 °C / 100 °F
	Shelf Life		24 mths

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.

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