TECHNICAL DATA SHEET



SilSo Replicate 21009 (ALPA-SIL CLEAR) 2-part silicone moulding rubber

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	Uncured Product Color A		transparent
system will cure at ambient temperatures within 24 hours, but the rate of cure can be accelerated by heat. The cured rubber	Cure Type		Addition
exhibits excellent physical and electrical properties.	De-mould Time / Full Cure at 23°C/73°F	t	0.5 hrs
 Key Features Crosslinks at temperatures as of 23 °C/77°F 	Density A	BS ISO 2781	0.98
 High flowing capacity 	Density B	BS ISO 2781	0.98
 Easy mixing of the components 	Mix Ratio By Weight		1:1
Excellent reproduction fidelity of details	Pot Life mins at 23°C/73°F		2.5 mins
Application	Viscosity A	Brookfield	6000 cP
For dental laboratories and for producing otoplastics.	Viscosity B	Brookfield	5500 cP
Use and Cure Information			
IMPORTANT:	Cured Product		
The 'A' part of product	Color		Transparent
contains the platinum catalyst; great care should be taken when	Elongation at Break	ISO 37	200 %
using automatic dispensing equipment. Please ensure that it is	Hardness Shore A	DIN 53 505	20
not contaminated by residual hydride containing rubber in the dispensing equipment, as curing will result. If in doubt, it's	Tear Resistance (N/mm)	BS ISO 34-1	3 N/mm / 17 ppi
advised to thoroughly purge the equipment with a suitable hydrocarbon solvent or silicone fluid.	Storage		
Mixing	Max Storage Temperature		30 °C / 86 °F
Dath the (A' and (D' north about d he well attimed to ensure the	Shelf Life		12 mths

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.

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