TECHNICAL DATA SHEET



QM 237 2 part moldmaking material

Description	Property	Test Method	Value
This is a pourable 2-part addition cure silicone elastomer system.	Uncured Product		
After mixing parts 'A' and 'B' in the correct proportions, the	Color A		Beige
system will cure at ambient temperatures within 24 hours, but the	Color B		Dark blue
rate of cure can be accelerated by heat. The cured rubber	Cure Profile		RTV heat accelerated
exhibits excellent physical and electrical properties.	Cure Type		Addition
Key Features	De-mould Time / Full Cure at		
Low viscosity Fast de-mold time	23°C/73°F		6 - 8 hrs
Casting resin resistance	Mix Ratio By Weight		10:1
Excellent flexibility	Rheology		Liquid
Application	Specific Gravity A		1.32
Statues, polyester, PU and epoxy casting resins, prototypes and	Specific Gravity B		0.97
technical articles, architectural, picture frames	Viscosity A	Brookfield	17,000 cP
Use and Cure Information	Viscosity B	Brookfield	2,000 cP
IMPORTANT:	,	Brookfield	,
The 'A' part of product	Viscosity Mixed	Brooklieid	10,000 cP
contains the platinum catalyst; great care should be taken when	Work life at 25°C to Double Initial Viscosity		35 minutes
using automatic dispensing equipment. Please ensure that it is	Initial Viscosity		
not contaminated by residual hydride containing rubber in the	Cured Product		
dispensing equipment, as curing will result. If in doubt, it's advised to thoroughly purge the equipment with a suitable	3 days at 25°C		
hydrocarbon solvent or silicone fluid.	Color		Blue
Mixing	Hardness Shore A	ASTM D 2240-95	37
Both the 'A' and 'B' parts should be well stirred to ensure the	Linear Shrinkage (%)		<0.1 %
material is uniform and any settlement of the fillers have been	Max Working Temp		204 °C / 399 °F
remixed. Place the required amount of 'A' and 'B' parts by weight	Min Working Temp		-55 °C / -67 °F
at the mix ratio shown opposite, in a clean plastic or metal	Tensile Strength	ISO 37	3.62 N/mm2 / 525 psi
container of approximately 3 times their volume, and mix until the		100 07	0.02 14/11112 / 525 p31
colour of the mixture is uniform. For best results, we recommend degassing. Degas by intermittent evacuation, the larger volume of	Storage		
the mixing vessel helps prevent overflow during this operation. In	Max Storage Temperature		38 °C / 100 °F
case of automatic dispensing with static mixing head, the two	Shelf Life		24 mths
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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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