

TECHNICAL DATA SHEET

MM 4400 2 part moulding compound

Description

This is a two component room temperature, condensation cure, silicone paste system. The cured rubber is a medium hardness material ideal for vertical mould making of architectural materials, columns and big statues.

Key Features

- Thixotropic paste
- 10:1 mix ratio
- Ideal for taking impressions of vertical surfaces
- Catalyst packed in easy to use tubes

Use and Cure Information

MM4400 is manually mixed with the 5% of curing agent MM CAT4400, and applied within the pot life time; it is advisable use small quantities (200-300 gr.) each time, just to prevent a procuring of the product that should make it useless. Reaching of the perfect mixture can be established when the colour is uniform.

The catalysed mass is manually pressed onto the pattern. In case of necessity of very detailed reproductions is advisable use as follows:

1. Clean and degrease the pattern (this step is anyway suggested for a good impression result).
2. Paint one or two coats of pourable product in addition with MMTA2 Thixotroping agent; this step is necessary just to reach the perfect details definition of the pattern's surface.

The products used in this way are all the MM 900 series.

3. Before the painted coats are cured, start the application of catalyzed MM4400, in order to give fast thickness to the mould; usually the desired thickness is about 20 - 30 mm.

4. Once cured, is possible build up a mother mould in fibreglass or gypsum.

This process allows a faster solution in case of big dimension objects and is widely used in monumental restoration

Health & Safety

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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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Property

Uncured Product

Appearance
Cure Type
De-mould Time / Full Cure at 23°C/73°F
Drying / Fixing Conditions
Mix Ratio By Weight
Pot Life at 23°C/73°F

Cured Product

Colour
Density
Elongation at Break (%)
Hardness Shore A
Linear Shrinkage (%)
Max Working Temp (°C)
Min Working Temp (°C)
Tear Resistance (N/mm)
Tensile Strength (N/mm2)

Storage

Max Storage Temperature
Shelf Life (mths)

Test Method

Value

**Yellow Putty
Condensation**

1 hr hrs

**23°C and 50%
humidity**

10:1

15 min mins

Yellow

1.2 g/cm3

400 %

16

0.5 %

200 °C / 392 °F

-50 °C / -58 °F

8 N/mm / 46 ppi

1.5 N/mm2 / 218

psi

40 °C / 104 °F

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The CHT technical service department is available to offer further information and advice and should it be needed to look at modifying current products or custom formulate a new one to meet your specific requirements. Please contact the technical service department.

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