

TECHNICAL DATA SHEET

MM816 2 part moulding compound

Description

This is a two-component low tear room temperature condensation cure silicone system. The cured rubber is suitable for the mould making of patterns with fine details, where some dimensional stability is required. Low tear silicone moulding rubbers are cost effective for the production of moulds only requiring a few impressions. They find uses in the reproduction of plane surface objects

Key Features

- Easy demoulding
- Easily degassed
- Low viscosity
- Fine detail pick up

Application

reproduction of plane surface models

Use and Cure Information

The curing process starts as soon as the catalyst is added. Under normal conditions of temperature and humidity typical curing characteristics are described below. If the product is to be used in contact with aggressive chemicals, such as high styrene polyester resins or epoxies, it is recommended that the rubber be allowed to cure for 48 hours before use.

Pour the catalysed rubber into the mould from one point, ensuring air is not entrapped. Allow the rubber to cure before removing from the mould. To allow the rubber to achieve its maximum physical properties and chemical resistance leave the partially cured rubber to age at room temperature for at least a further 12 hours.

How to Use

Charge the base rubber into a clean plastic or metal container, approximately 3-4 times its volume.

Add standard catalyst in the proportion of 5 parts by weight of catalyst to 100 parts by weight of the rubber base. Mix thoroughly, slowly at first to avoid splashing and taking care to avoid excessive air entrapment. After catalysation any entrapped air may be removed by intermittent evacuation for several minutes. The use of a sufficiently large container permits degassing without overflow.

Catalysts

Use the following catalysts:

Code	Colour	Pot Life	De-Mould
MM CAT L5 NT	Clear	>60 mins	<24 hrs

Health & Safety

Health and 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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Property

Uncured Product

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
Rheology
Viscosity Mixed mPas

Test Method

Brookfield

Value

Condensation

3 hr hrs
23°C and 50% humidity
20:1
15 min mins
Liquid
8400 mPas

Cured Product

7 days at 23+/-2°C and 50+/-5% humidity

Colour **Grey**
Density **1.18 g/cm³** BS ISO 2781
Elongation at Break (%) **250 %** ISO 37
Hardness Shore A **16** ASTM D 2240-95
Linear Shrinkage (%) **0.5 %**
Max Working Temp (°C) **180 °C / 356 °F**
Min Working Temp (°C) **-50 °C / -58 °F**
Tear Resistance (N/mm) **2.5 N/mm / 14 ppi** BS ISO 34-1
Tensile Strength (N/mm²) **1 N/mm² / 145 psi** ISO 37

Storage

Max Storage Temperature **40 °C / 104 °F**
Shelf Life (mths) **12**

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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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