

ALPA-SIL TD 00:50 2 part Silicone Moulding Rubber

Description	Property	Test Method	Value
Pourable, addition-curing, 2-part silicone rubber that cures at room temperature. This product is mainly used for making silicone printing pads. The cured rubber exhibits excellent physical and electrical properties. Fast and non-shrink cure at room temperature which can be accelerated considerably by the application of heat.	Uncured Product		
Key Features	Appearance		Red
<ul style="list-style-type: none"> • Crosslinks at temperatures higher than 23 °C/77°F • Crosslinkage can be accelerated by temperature increase • Easy 1:1 mixing of components • Can be used with our dosing system ALPA 2-K-DOS 	Colour A Part		Translucent Addition
Application	Cure Type		12 hrs
Soft Silicone Elastomer for Pad-Printing applications.	De-mould Time / Full Cure at 23°C/73°F		1:1
Use and Cure Information	Mix Ratio By Weight		60 - 90 mins
Mixing	Pot Life at 23°C/73°F		10 - 12 hr
Components A and B are mixed at a mass ratio of 1 : 1. The two components are thoroughly mixed either by hand or with an electric or pneumatic stirrer at low speed to avoid air from being dragged in and/or to avoid a temperature increase. Crosslinking is slowed down by reducing the temperature and accelerated by increasing it. The non-tacky time is about 8 - 12 hours.	Tack Free Time / Skin Formation at 23°C/73°F		5000 mPas
Inhibition of cure	Viscosity A-Part mPas	Brookfield	5000 mPas
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.	Viscosity B-Part mPas	Brookfield	5000 mPas
These substances may impair or even completely prevent the curing behavior of addition crosslinking silicones typically indicated by tacky surfaces. Therefore, it is absolutely important to check the compatibility in preliminary tests if unknown substrates are used.	Viscosity Mixed mPas	Brookfield	5000 mPas
Health & Safety	Cured Product		
Please observe our safety data sheets and the safety remarks on our container labels when handling our products. The dangerous goods regulations and the accident prevention regulations of the professional associations must be particularly observed. Keep the EC safety data sheet of the applied product at hand since it provides you with useful instructions for the safe use and disposal of the product as well as for actions to be taken in case of accidents.	Colour		Brick Red
Delivery Units	Hardness Shore 00	ASTM D 2240-95	50
Component A: 5 kg or 25 kg	Linear Shrinkage (%)		< 0.1 %
Component B: 5 kg or 25 kg	Storage		
Other container sizes upon demand.	Max Storage Temperature		30 °C / 86 °F
	Shelf Life (mths)		12

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Delivery Units

Component A: 5 kg or 25 kg
Component B: 5 kg or 25 kg
Other container sizes upon demand.

Storage

Components A and B of KÖRAFORM PP 18 can be optimally processed for approx. 12 months if stored properly at temperatures below 30 °C and protected from frost in closed original containers.

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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.

CHT Germany GmbH: Postfach 12 80, 72002 Tübingen, Bismarckstraße 102, 72072 Tübingen, Germany
Telephone: 07071/154-0, Fax: 07071/154-290, Email: info@cht.com, Homepage: www.cht.com / www.cht-silicones.com