

ALPA-SIL TD SH. A 18 2 part Silicone Moulding Rubber

Description

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.

Key Features

- Easy 1:1 mix ratio
- Shore A 18
- Blue color
- For use as a printing pad elastomer

Application

Silicone Elastomer for Pad-Printing applications.

Use and Cure Information

Mixing

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.

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. 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.

Health & Safety

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.

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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Property

Uncured Product

Property	Test Method	Value
Appearance		Blue
Colour A Part		Translucent
Cure Type		Addition
De-mould Time / Full Cure at 23°C/73°F		12 hrs
Mix Ratio By Weight		1:1
Pot Life at 23°C/73°F		60 - 90 mins
Tack Free Time / Skin Formation at 23°C/73°F		10 - 12 hr
Viscosity A-Part mPas	Brookfield	25000 mPas
Viscosity B-Part mPas	Brookfield	25000 mPas
Viscosity Mixed mPas	Brookfield	25000 mPas

Cured Product

Colour		Blue
Hardness Shore A	DIN 53 505	18
Linear Shrinkage (%)		< 0.1 %
Storage		
Max Storage Temperature		30 °C / 86 °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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