TECHNICAL DATA SHEET



Liquid

Purple

10 to 1

1.00

Brookfield

Condensation

12 to 16 hrs

30 to 55 mins

38 °C / 100 °F

4 to 6 hrs

< 500 cP

12 mths

QMCat 135 Moldmaking Condensation Cure Catalyst for QM135

Color

Uncured Product

Mix Ratio By Weight

Tack Free Time / Skin

Formation at 23°C/73°F

Max Storage Temperature

Specific Gravity

De-mould Time / Full Cure at

Pot Life mins at 23°C/73°F

Appearance

Cure Type

23°C/73°F

Viscosity

Storage

Shelf Life

Test Method Description Property Value

This is a catalyst for a specific two-component, room temperature, condensation cure system. The cured rubber has excellent mechanical properties and good shelf-life stability.

Key Features

- Long work life
- Fast demold time
- · Excellent physical properties and dimensional stability

- Molds for polyester, polyurethane and epoxy resin castings Molds for technical articles and prototypes
- Molds for furniture and picture frame replication

Use and Cure Information

CURE CHARACTERISTICS

The curing process begins as soon as the catalyst is mixed with

the base. The material will cure as described in the data above

under normal temperature (25°C) and humidity conditions (50% RH). Because this system is sensitive to heat and humidity, a change in cure speed may be observed if one or both of these variables are altered. A large difference in temperature (+/- 5°C) or humidity (> 60% - 70%) may alter the cure profile of the material. In addition, if the product is to be used with aggressive resins such as high styrene polyester resins, it is recommended that the rubber be allowed to cure for 48 hours.

MIXING

The catalyst should be thoroughly mixed prior to catalyzation of the base.

CHT recommends that the catalyzed material be tested on a small area of the mold prior to use.

The base should be thoroughly mixed with the catalyst of choice using a 10:1 ratio (base:catalyst) by weight. Shake the catalyst well before use. Material should be mixed in a clean, compatible metal or plastic container. The volume of the container should be 3 - 4 times the volume of the material to be mixed. This allows for expansion of the siloxane material during de-aeration.

Mix thoroughly by hand or with mixing equipment while minimizing air entrapment until a homogeneous mixture is obtained. This will occur when the material takes on a uniform color with no visible striations. Machine mixing is recommended for best results.

DE-AERATION

Air trapped during mixing should be removed by vacuum at 29 inches of mercury. During the process, the material will expand, and intermittent evacuation may be required. Typically, after releasing the vacuum 2 - 3 times, the mass will collapse on itself at which time the vacuum should be left on for an additional 2 - 4 minutes.

Health & Safety

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 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.

Revision Date 26 Oct 2021

Revision No 5

Download Date 28 Apr 2024

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