

# 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.

Revision Date 29 Apr 2021  
Revision No 1  
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### Property

#### Uncured Product

Cure Profile

Cure Type

De-mould Time / Full Cure  
at 23°C/73°F

Mix Ratio By Weight

Pot Life mins at  
23°C/73°F

Rheology

Viscosity Mixed

### Test Method

Brookfield

### Value

**23°C and 50%  
humidity  
Condensation**

**3 hr hrs**

**20:1**

**15 min mins**

**Liquid  
8400 cP**

#### Cured Product

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

Color

Density

Elongation at Break

Hardness Shore A

Linear Shrinkage (%)

Max Working Temp

Min Working Temp

Tear Resistance (N/mm)

Tensile Strength

BS ISO 2781

ISO 37

ASTM D  
2240-95

BS ISO 34-1

ISO 37

**Grey**

**1.18 g/cm<sup>3</sup>**

**250 %**

**16**

**0.5 %**

**180 °C / 356 °F**

**-50 °C / -58 °F**

**2.5 N/mm / 14 ppi**

**1 N/mm<sup>2</sup> / 145 psi**

#### Storage

Max Storage  
Temperature

Shelf Life

**40 °C / 104 °F**

**12 mths**

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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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