

## MM922 2 part moulding compound

### Description

This is a two-component room temperature condensation curing silicone compound. The cured product is an exceptionally flexible rubber with very high mechanical properties and good shelf life stability. It is suitable for mould making of intricate patterns with extremely good pick up of fine details. Softer grades are better suited for use where there are deep undercuts.

### Key Features

- High tear strength
- Good dimensional stability
- Easily degassed
- Fine detail pick up

### Application

High tear resistance

### 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.

### How to Use

Charge 100 parts by weight of Base Rubber and 5 parts by weight of catalyst into a suitable plastic or metal container. The volume of the mixing vessel should be sufficient to allow for rapid expansion which takes place during the initial degassing of the catalysed rubber. Mix thoroughly avoiding excessive air entrapment but using the colour contrast to achieve homogeneity. Stop the mixer and scrape the vessel walls a few times. To prevent imperfections due to bubbles in the cured rubber, it is advisable to de-aerate the liquid rubber by using intermittent evacuation for a few minutes. Normally after releasing the vacuum 2 or 3 times, the mass collapses naturally after which degassing should continue for only a few minutes.

### Vertical Application

This Product can be used to make mouldings on vertical surfaces by employing Thixotroping Agent, MMTA2. A typical formulation for good thixotropy and approximately the same working life of the normal rubber is shown below:

- MM900 series 100 parts by weight
- Catalyst 5 parts by weight
- MMTA2 2 - 3 parts by weight

Mix the components in the above order. When using the fast cure catalyst, if degassing is required it must be done quickly after catalysation and before the addition of the Thixotroping Agent MMTA2. Pot life and rate of cure is slightly shorter in the presence of TA2.

### Standard catalyst for use with the MM900 series of rubbers

Code	Ratio	Colour	Pot Life	De-Mould
MM CAT B5NT	20:1	Blue	>45 mins	<24 hrs
MM CAT R5NT	20:1	Red	15-45 mins	<3 hrs
MM CAT L6WNT	20:1	Clear	>45 mins	<24 hrs
MM CAT L8W	20:1	Clear	>120 mins	<24 hrs

MM CAT W Booster is available to speed up standard cure catalysts

### Health & Safety

#### Health and Safety

Safety Data Sheets available on request.

### 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**

**<24 hrs**

**20:1**

**>45 min mins**

**Liquid**

**19000 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

**Blue**

**1.26 g/cm3**

**497 %**

**22**

**0.5 %**

**200 °C / 392 °F**

**-50 °C / -58 °F**

**26.2 N/mm / 151  
ppi**

**3.64 N/mm2 / 528  
psi**

#### Storage

Max Storage Temperature

Shelf Life

**40 °C / 104 °F**

**12 mths**

The content set out in the technical data sheet does not contain information upon which you should rely. It is provided for general information purposes only and does not constitute a product specification. You must obtain professional or specialist advice before taking any action based on the information provided in the technical data sheet.

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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

## 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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Telephone: 07071/154-0, Fax: 07071/154-290, Email: [info@cht.com](mailto:info@cht.com), Homepage: [www.cht.com](http://www.cht.com) / [www.cht-silicones.com](http://www.cht-silicones.com)