

**MM928 (old RTV928)
2-Part Moulding Rubber**

Introduction

MM928 is a two component room temperature condensation curing silicone compound.

The cured product is a hard rubber in the series with very high mechanical properties and good shelf-life stability. It is an excellent rubber for mouldmaking of intricate patterns, skin moulding and applications demanding an extremely tough rubber.

Key Features

- No inhibition
- Easy degassing
- Very high tear strength
- Dimensional stability
- Good chemical resistance to resins (PE-PU-Epoxy)

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.

The normal catalyst for use with the MM900 series of rubbers is MM CAT B5. Relatively fast cure and demoulding is possible using MM CAT R5.

How to Use

Charge 95-100 parts by weight of MM928 and 5 parts by weight of MM CAT B5 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. (Consult the Wall Chart for advice).

Vertical Application

MM928 can be used to make mouldings on vertical surfaces by employing Thixotroping Agent TA2. A typical formulation for good thixotropy and approximately the same working life of the normal rubber is shown below:-

- MM928 95 - 100 parts by weight
- MM CAT B5 5 parts by weight (or CAT RED 5)
- TA2 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 TA2. Pot life and rate of cure is slightly shorter in the presence of TA2.

Property	Test Method	Value
Uncured Product		
Colour:		Pale blue
Appearance:		Viscous liquid
Viscosity:	Brookfield	34000 mPa.s
Catalysed paste	Brookfield	26000 mPas
Pot Life:		109 minutes *
De-mould time		7 hours *
* measured at 23+/-2°C and 65% relative humidity.		

Cured Elastomer <i>(after 7 days cure at 23+/-2°C and 65% relative humidity)</i>		
Tensile Strength:	BS903 Part A2	4.40 MPa
Elongation at Break:	BS903 Part A2	370 %
Youngs Modulus:		2.00 MPa
Modulus at 100% Strain:	BS903 Part A2	1.56 MPa
Tear Strength:	BS903 Part A3	29 kN/m
Hardness:	ASTM D 2240-95	27° Shore A
Specific Gravity:	BS 903 Part A1	1.31
Linear Shrinkage:		0.46 %
Coefficient of Thermal Expansion:		
Volumetric		709 ppm / °C
Linear		236 ppm / °C
Min. Service Temperature:		-50 °C
Max. Service Temperature:	AFS 1540B	200 °C

Electrical Properties

Volume Resistivity:	ASTM D-257	1x10 ¹³ Ω.cm
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All values are typical and should not be accepted as a specification.

Health and Safety - Material Safety Data Sheets available on request.

Packages – MM928 is supplied in 5 kg and 20 kg bulk containers.

MM CAT B5 is supplied in 250 g and 1 kg containers.

MM TA2 is supplied in 50g, 100 g, 500 g and 1 kg containers.

Arrangements can be made to supply in other pack sizes.

Storage and Shelf Life – Expected to be 12 months in original, unopened containers below 40°C.

Revision Date: 28.09.04