

MM4400 Condensation cure paste high tear

Introduction

This is a two component room temperature condensation cure silicone paste system. The cured rubber is a medium hardness material designed for vertical mould making of architectural materials, columns and big statues.

Key Features

- Thixotropic paste
- 20:1 mix ratio
- Ideal for taking impressions of vertical surfaces
- Catalyst in easy to use tubes

Use and Cure Information

MM4400 is manually mixed with 5% of curing agent MM CAT 4400, and applied within the pot life time; it is advisable to use small quantities (200 - 300 g) each time, to prevent pre-curing of the product which would make it useless. The achievement of the perfect mixture can be seen when the colour is uniform.

The catalysed mixture is manually pressed onto the pattern. In case very detailed reproductions are needed, it is advisable to proceed as follows:

1. Clean and degrease the pattern (this step is advisable in any case for a good impression result)
2. Paint one or two coats of pourable product with addition of MMTA2 Thixotroping Agent; this step is necessary to reach the perfect detailed definition of the pattern's surfaces.
3. Before the painted coats are cured, start the application of the catalyzed MM4400, in order to give fast thickness to the mould, usually the desired thickness is about 20 – 30 mm.
4. Once cured, it is possible to build up a mother mould in fibreglass or gypsum.

This process allows a faster solution in case of large dimension objects and is widely used in monumental restoration.

Health and Safety

Material Safety Data Sheets available on request.

Packaging

CHT Moulding Rubbers are available in a variety of packaging including bulk containers. Please contact our sales team for more information.

Property	Test Method	Value
Uncured Product		
Appearance		Thixotropic paste
Colour A Part		Grey
Colour B Part		Yellow
Cure Type		Condensation
De-Mould Time		1 hour
Max Cure at 25°C		1 hour
Mix Ratio		20:1
Pot life		15 mins

Cured Product (after 7 days cure at 23°C +/- 2°C and 50 +/- 5% humidity)

CTE Linear		268 ppm/°C
CTE Volumetric		804 ppm/°C
Colour		Yellow
Durometer Shore A	ASTM D 2240-95	16
Specific Gravity	ISO 2781	1.2
Elongation	ISO 37	400%
Linear Shrinkage		0.5 %
FDA	CRF(21) 177.2600	No
Tear Strength	ISO34-1	8 kN/m
Tensile Strength	ISO 37	1.5 MPa
Min. Working Temperature	AFS 1540B	-50 °C
Max. Working Temperature	AFS 1540B	200 °C

Storage

Maximum Storage Temperature	40°C
Shelf Life	12 months

Revision Date: 06/11/2023

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