



Technical Data Sheet

QM 263

60 Shore A, Inhibition Resistant, Addition Cure Moldmaking Material

PRODUCT DESCRIPTION

QM 263 is a two-component, room temperature, addition cure, silicone material. The cured rubber has excellent mechanical properties and good shelf-life stability. This material is a good choice for the molding of furniture, picture frames and architectural materials.

KEY FEATURES

- High durometer
- Casting resin resistance
- Fast demold time
- Excellent dimensional stability

MAIN APPLICATIONS

- Molds for architectural application
- Molds for polyester, epoxy resin casting, and rigid or foam polyurethane
- Molds for technical articles and prototypes
- Molds for furniture and picture frame replication

TYPICAL PROPERTIES

UNCATALYZED		
TEST	QM 263 A	QM 263 B
Appearance	Beige	Blue
Viscosity	116,000 cps	850 cps
Specific Gravity	1.32	1.01

CATALYZED	
MIX RATIO 10:1	
TEST	RESULT
Catalyzed color	Light Blue
Catalyzed viscosity	60,000 cps
Work life at 25°C *	65 minutes
Demold time	8 - 12 hours

* Work life is defined as the time required for the material to double in catalyzed viscosity.



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CURED PROPERTIES	
30 Minutes at 150°C	
TEST	RESULT
Durometer, Shore A	66
Tensile	900 psi
Elongation	180 %
Tear	110 ppi

ADDITIONAL PROPERTIES	
Service Temperature Range	- 55°C - 204°C
Linear Shrinkage	< 0.1 %

MIXING

QM 263 B should be thoroughly mixed prior to catalyzation.

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

Combine ten parts of QM 263 A and one part of QM 263 B by weight into a clean, compatible container and mix by hand or with mixing equipment until a uniform consistency is observed. The material should have a uniform color with no visible striations. Use caution when mixing to minimize air entrapment.

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.

Machine mixed material does not normally need to be de-aired.

STORAGE AND SHELF LIFE

If QM 263 A and QM 263 B are stored in their original unopened containers, in an environment that does not exceed 38°C (100°F) then QSi will warranty the material for a period of 12 months from the date of shipment.



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DISCLAIMER

The technical data listed is provided for reference only and is not intended as product specifications. QSi has the capability to customize products as requested. For sales and technical assistance please contact customer service at **(804) 271-9010** or **1-800-852-3147**.

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