



Technical Data Sheet

QM 2325

25 Shore A, Condensation Cure Moldmaking Material

PRODUCT DESCRIPTION

QM 2325 is a two-component, room temperature, condensation cure, silicone material. The cured rubber is flexible and has excellent mechanical and physical properties in addition to good shelf-life stability. This material is an excellent choice for the molding of intricate patterns which involve deep undercuts and where dimensional stability becomes important while maintaining a fairly low modulus.

KEY FEATURES

- Low viscosity
- Excellent tear resistance
- Fast demold time
- Moderately high durometer with a moderately low modulus

MAIN APPLICATIONS

- Molds for large statues, small statues and monument restoration
- Molds for polyester, polyurethane and epoxy resin castings
- Molds for technical articles and prototypes
- Molds for architecture and picture frames

TYPICAL PROPERTIES

UNCATALYZED		
PROPERTY	QM 2325	MM Cat 2300 Green
Color	Beige	Green
Viscosity	35,000 cps	200 cps
Specific Gravity	1.11	1.00

CATALYZED	
MIX RATIO 100:5 by weight	
PROPERTY	MM Cat 2300 Green
Color	Light Green
Viscosity	28,000 cps
Specific Gravity	1.10
Work life at 25°C *	60 minutes
Tack-free time	6 - 8 hours
Demold time	16 - 24 hours

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



Technical Data Sheet

CURED PROPERTIES	
3 DAYS @ 25°C	
Durometer, Shore A	25
Tensile Strength	500 psi
Elongation	400 %
Tear B	140 ppi
Linear Shrinkage	< 0.30 %

CURE CHARACTERISTICS

The standard catalyst for QM 2325 is MM Cat 2300 Green catalyzed at a 100:5 (base:catalyst) ratio by weight. Faster cure can be obtained using DBT or a higher level of MM Cat 2300 Green. However, rapid cure of condensation cure moldmaking materials can often result in a small sacrifice of physical properties or an increase in hardness.

The curing process begins as soon as the catalyst is mixed with the base. The material will cure as described in the data above under normal temperature (25°C) and humidity conditions (50% RH). Because this system is sensitive to heat and humidity, a change in cure speed may be observed if one or both of these variables are altered. A large difference in temperature (+/- 5°C) or humidity (> 60% – 70%) may alter the cure profile of the material. In addition, if the product is to be used with aggressive resins such as high styrene polyester resins, it is recommended that the rubber be allowed to cure for 48 hours.

MIXING

All condensation cure catalysts 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.

QM 2325 should be thoroughly mixed with MM Cat 2300 Green using a 100:5 (base:catalyst) ratio by weight. Shake the catalyst well before use. Material should be mixed in a clean, compatible metal or plastic container. The volume of the container should be 3-4 times the volume of the material to be mixed. This allows for expansion of the siloxane material during de-aeration.

Mix thoroughly by hand or with mixing equipment while minimizing air entrapment until a homogeneous mixture is obtained. This will occur when the material takes on a uniform color with no visible striations.



Technical Data Sheet

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.

STORAGE AND SHELF LIFE

If QM 2325 and MM Cat 2300 Green 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 6 months from the date of shipment.

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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