



Technical Data Sheet

QM 264HT

60 Shore A, Addition Cure Moldmaking Material

PRODUCT DESCRIPTION

QM 264HT is a two-component, room temperature, addition cure, silicone material. The cured rubber has excellent mechanical properties, good shelf-life stability, excellent physical properties and resin resistance. This material is a good choice for the molding of furniture, picture frames, architectural materials and rubber rollers and belting. QM 264HT is exceptionally good where high durometer and dimensional stability are required.

KEY FEATURES

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

MAIN APPLICATIONS

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

TYPICAL PROPERTIES

UNCATALYZED		
TEST	QM 264HT A	QM 264 HT B
Appearance	Beige	Black
Viscosity	150,000 cps	7,000 cps
Specific Gravity	1.28	1.04

CATALYZED	
MIX RATIO 10:1 by weight	
PROPERTY	RESULT
Catalyzed color	Dark Gray
Catalyzed viscosity	110,000 cps
Work life at 25°C *	160 minutes
Demold time	18 hours
Durometer, Shore A 30 minutes at 110°C	63

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



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CURED PROPERTIES	
3 days at 25°C	
PROPERTY	RESULT
Durometer, Shore A	53
Tensile	830 psi
Elongation	220 %
Tear	116 ppi
Linear Shrinkage	< 0.1 %
Useful temperature range	- 55°C - 225°C

CURE CHARACTERISTICS

QM 264HT A is catalyzed with QM 264HT B at a 10:1 ratio (base:catalyst) by weight. In order to achieve optimum performance the same lot number of QM 264HT A and QM 264HT B should be used.

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.

MIXING

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

QM 264HT B should be thoroughly mixed prior to catalyzation.

Combine ten parts of QM 264HT A with one part of QM 264HT B by weight into a clean, compatible container and mix by hand or with mixing equipment until a uniform consistency is observed. Accurate weighing of components on a suitable scale is essential for optimal product performance. The material should have a uniform color with no visible striations.

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.



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STORAGE AND SHELF LIFE

If QM 264HT A and QM 264HT 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.

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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Quantum Silicones Headquarters

*7820 Whitepine Road
Richmond, VA 23237*

Manufacturing, Research and Development Facility

*8021 Reygan Road
Richmond, VA 23237*

Phone: 804-271-9010

Fax: 804-271-9055

Toll Free: 800-852-3147