



Technical Data Sheet

QM 1125

25 Shore A Addition Cure Moldmaking Material

PRODUCT DESCRIPTION

QM 1125 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, architectural materials and duplicating silicone for dental lab use. QM 1125 is exceptionally good where highly detailed parts and mold flexibility are required.

KEY FEATURES

- Low viscosity
- Fast demold time
- Casting resin resistance
- Excellent flexibility

MAIN APPLICATIONS

- Molds for architectural replication
- Molds for polyester, epoxy, and rigid or foam polyurethane resin casting
- Molds for technical articles and prototypes
- Molds for furniture and picture frame replication
- Duplicating silicone for dental lab use

TYPICAL PROPERTIES

UNCATALYZED		
TEST	QM 1125 A	QM 1125 B
Appearance	Beige	Blue
Viscosity	3,960 cps	3,480 cps
Specific Gravity	1.23	1.23

CATALYZED	
MIX RATIO 1:1 by weight	
PROPERTY	RESULT
Catalyzed color	Light blue
Gel time at 25°C *	2 - 5 minutes
Tack Free time	< 15 minutes

* Gel time is defined as the time required for the material to become a solid or semi-solid.



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CURED PROPERTIES	
60 minutes at 25°C	
PROPERTY	RESULT
Durometer, Shore A	26
Tensile	287 psi
Elongation	230 %
Linear Shrinkage	< 0.1 %
Useful temperature range	- 55°C - 204°C

CURE CHARACTERISTICS

QM 1125 A is catalyzed with QM 1125 B at a 1:1 ratio by weight. In order to achieve optimum performance the same lot number of QM 1125 A and QM 1125 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 1125 A and QM 1125 B should be thoroughly mixed prior to catalyzation.

Combine equal parts of QM 1125 A and QM 1125 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 1125 A and QM 1125 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 Reycan Road
Richmond, VA 23237

Phone: 804-271-9010
Fax: 804-271-9055
Toll Free: 800-852-3147