

TECHNICAL DATA SHEET



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QVB 720 2 Part Molding Silicone for Reusable Vacuum Bags

Description

This is a pourable 2-part addition cure silicone elastomer system. After mixing parts 'A' and 'B' in the correct proportions, the system will cure at ambient temperatures within 24 hours, but the rate of cure can be accelerated by heat. The cured rubber exhibits excellent physical and electrical properties.

Key Features

- Transparent purple in thin cured sections which enables layer thickness evaluation
- Fast gel time
- Excellent tear and elongation properties
- Flowable, self-leveling and mildly thixotropic for vertical surfaces

Key Applications

- Closed molding
- Composite part manufacturing
- Resin infusion/pre-preg
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Application

QVB 720 is a silicone molding rubber for producing reusable vacuum bags. This formulation can also be used as a moldmaking material if a fast cure is required.

Note:

An equivalent final formulation is also available as a 1:10 mix ratio (by weight or volume only) if fixed-ratio dispensing equipment is desired. Refer to QVB 701 Technical Data Sheet.

Use and Cure Information

IMPORTANT:

The 'A' part of product

contains the platinum catalyst; great care should be taken when using automatic dispensing equipment. Please ensure that it is not contaminated by residual hydride containing rubber in the dispensing equipment, as curing will result. If in doubt, it's advised to thoroughly purge the equipment with a suitable hydrocarbon solvent or silicone fluid.

Mixing

Both the 'A' and 'B' parts should be well stirred to ensure the material is uniform and any settlement of the fillers have been remixed. Place the required amount of 'A' and 'B' parts by weight at the mix ratio shown opposite, in a clean plastic or metal container of approximately 3 times their volume, and mix until the colour of the mixture is uniform. For best results, we recommend degassing. Degas by intermittent evacuation, the larger volume of the mixing vessel helps prevent overflow during this operation. In case of automatic dispensing with static mixing head, the two components should be degassed before processing. Recommended vacuum conditions are 30-50 mbar intermittently over 5-10 minutes. Cast the mixture either by gravity or pressure injection. In order to achieve optimum performance, the same "A" and "B" side lot number should be used.

Inhibition of Cure

Great care must be taken when handling and mixing all addition cured silicone elastomer systems, ensuring that all the mixing tools (vessels and spatulas) are clean and constructed in materials which do not interfere with the curing mechanism. The cure of the rubber can be inhibited by the presence of compounds of nitrogen, sulphur, phosphorus and arsenic; organotin catalysts and PVC stabilizers; epoxy resin catalysts and even contact with materials containing certain of these substances e.g. moulding clays, sulphur vulcanised rubbers, condensation cure silicone rubbers, onion and garlic.

Curing Conditions

The data offers a guide to the rate of cure at various temperatures, mixing of the components at temperatures between 15 and 25°C is recommended to ensure adequate pot life for degassing and handling. The pot life can be extended to several hours by chilling the components before mixing.

Health & Safety

Safety Data Sheets available on request.

Packaging

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

Property

Uncured Product

Property	Test Method	Value
Color A		Translucent white
Color B		Translucent purple
Cure Type		Addition
Density A	BS ISO 2781	1.07
Density B	BS ISO 2781	1.07
Gel Time at 25°C/77°F		8-13 mins
Mix Ratio By Weight		1:1
Viscosity A	Brookfield	35,000 cP
Viscosity B	Brookfield	35,000 cP

Cured Product

Color		Translucent purple
Density	BS ISO 2781	1.07 g/cm ³
Elongation at Break	ISO 37	800 %
Hardness Shore A	ASTM D 2240-95	28
Linear Shrinkage (%)		< 0.1% %
Tear Resistance (N/mm)	BS ISO 34-1	10.50 N/mm / 60 ppi
Tensile Strength	ISO 37	4.826 N/mm ² / 700 psi

Storage

Max Storage Temperature	38 °C / 100 °F
Shelf Life	24 mths

The content set out in the technical data sheet does not contain information upon which you should rely. It is provided for general information purposes only and does not constitute a product specification. You must obtain professional or specialist advice before taking any action based on the information provided in the technical data sheet.

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The CHT technical service department is available to offer further information and advice and should it be needed to look at modifying current products or custom formulate a new one to meet your specific requirements. Please contact the technical service department.

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Revision Date 20 Oct 2021
Revision No 3
Download Date 23 Dec 2021



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