



Technical Data Sheet

QM 264

*Quantum Silicones' 60 Durometer Addition Cure
Moldmaking Material*

Product Description

Quantum Silicones' QM 264 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. In addition, this material is exceptionally good where high durometer and dimensional stability are required.

Key Features

- High Durometer
- Casting resin resistance
- Fast demold time
- Excellent dimensional stability
- Complies with FDA indirect food contact regulation CFR 177.2600

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

Typical Properties

UNCATALYZED PROPERTIES	
Mix Ratio	10:1 by weight
BASE	
Base Appearance	QM 264A Beige
Base Viscosity, cps	150,000
Base Specific Gravity, g/cm ²	1.28
CATALYST	
Catalyst Appearance	QM 264B Blue
Catalyst Viscosity, cps	5,000
Catalyst Specific Gravity, g/cm ²	1.03

Typical Properties Continued

CATALYZED PROPERTIES-QM 264	
PROPERTY	QM 264
Catalyzed Color	Light Blue
Catalyzed Viscosity, cps	110,000
Pot Life ⁽¹⁾ (minutes)	60 minutes
Demold Time(hours)	12 to 18 hours

TYPICAL CURED PROPERTIES (3 DAYS @ 25C)	
Durometer, Shore A	60
Tensile Strength, psi	800
Elongation, %	240
Tear B, ppi	120
Linear Shrinkage, %	<0.1
Useful Temperature Range	-60C to 204C

(1)Pot Life is defined as the time at which the catalyzed viscosity has doubled.

Cure Characteristics

The curing process begins as soon as the catalyst is mixed with the base. Under normal temperature (25C) and humidity (50% RH) conditions, the material will cure as described in the data above. Because this system is sensitive to heat and humidity, a change in cure speed may be seen if one or both of these variables are altered. Any large difference in temperature (+/-5C) or humidity (>60-70%) may change 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. For best results, QM 264A and QM 264B components of the **same lot number** should be used.

Mixing and De-aeration

The following procedure should be followed for obtaining optimal performance from the QM 264.

Charge 100 parts, **by weight**, of QM 264A and 10 parts, **by weight**, of QM 264B into a clean, compatible metal or plastic container. Shake the catalyst well before use. 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 as it de-gasses.

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. Once mixing * is complete it is recommended that the material be de-aired 2-3 times by intermittent evacuation for a few minutes to minimize any imperfections due to bubbles in the cured material. Typically after releasing the vacuum 2-3 times the mass will collapse on itself at which time the vacuum should be left on only 2-4 minutes longer.

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

Shelf-life and Storage

QM 264A and QM 264B should be stored in their original, sealed containers in an environment that does not exceed 90F. Under these conditions the expected shelf-life of the material is 12 months.

Not for Product Specification

The technical data listed herein is provided as a reference only and **is not** intended as sales specifications. For sales and technical assistance or for product recommendations, please call 1-800-852-3147.

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