



Technical Data Sheet

QM 265

60 Shore A, Addition Cure Moldmaking Material

PRODUCT DESCRIPTION

QM 265 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 and other applications 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 application
- 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		
TEST	QM 265 A	QM 265 B
Appearance	Beige	Clear
Viscosity	150,000 cps	1000 cps
Specific Gravity	1.28	1.03

CATALYZED	
MIX RATIO 10:1	
TEST	RESULT
Catalyzed color	Beige
Catalyzed viscosity	120,000 cps
Work life at 25°C *	120 minutes
Demold time	12 – 18 hours

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



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CURED PROPERTIES	
30 Minutes at 150°C	
TEST	RESULT
Durometer, Shore A	60
Tensile	800 psi
Elongation	240 %
Tear	120 ppi

ADDITIONAL PROPERTIES	
Service Temperature Range	- 55°C - 204°C
Linear Shrinkage	< 0.1 %

MIXING

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

Combine ten parts of QM 265 A and one part of QM 265 B by weight into a clean, compatible container and mix by hand or with mixing equipment until a uniform consistency is observed. The material should have a uniform color with no visible striations. Use caution when mixing to minimize air entrapment.

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.

STORAGE AND SHELF LIFE

If QM 265 A and QM 265 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.



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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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