

## Tufel™ II 94606

### Description

Tufel II Silicone Rubber Compounds 94406, 94506, 94606, 94706 are 40-70 durometer low volatile fast-cure addition cured silicone elastomers for extrusion and calendering. They may be used by themselves or blended to intermediate durometers. Applications include extruded tubings, profiles and calendered sheets.

### Key Features and Typical Benefits

- LV Bases Minimize Porosity and Post Cure
- Totally Peroxide-Free Cure System
- Broad Processing Window
- High Output Rates
- High Tear Strength
- Tight Surface Cure
- Non-blooming
- Translucency

### Typical Physical Properties

TYPICAL CHARACTERISTICS OF UNCURED TUFEL II SILICONE RUBBER - 94006 SERIES

PROPERTIES	94406	94506	94606	94706
Specific Gravity	1.11	1.15	1.19	1.22
Appearance	Translucent	Translucent	Translucent	Translucent

Polymer Classification (ASTM D-1418)	VMQ	VMQ	VMQ	VMQ
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TYPICAL RHEOLOGICAL PROFILE - MONSANTO ODR WITH 3° ARC @ 150°C  
(300°F)

Minimum Viscosity	1-6	3-7	3-8	3-9
T1, Minutes	0.1-0.4	0.1-0.4	0.1-0.3	0.1-0.4
7 Min. Torque (lb./in.)	33-48	34-53	45-60	45-60

TYPICAL PHYSICAL PROPERTIES OF TUFEL II SILICONE RUBBER - 94006  
SERIES

ASTM METHOD	PRESS CURE - 10 MINUTES @ 177°C (350°F)	94406	94506	94606	94706
D-2240	Hardness, Durometer A	39	48	56	71
D-412	Tensile Strength, psi	1300	1348	1230	1320
	MPa	9.0	9.2	8.5	9.1
D-412	Elongation, %	900	900	740	630
D-624	Tear Resistance, Die B, ppi	225	250	240	320
	KN/M	39	44	42	56
D-412	Tensile Modulus @ 100% psi	140	190	245	500
	MPa	1.0	1.3	1.7	3.4
	POST CURE 2 HOURS @ 177°C (350°F)				
D-2240	Hardness, Durometer A	43	53	61	73
D-412	Tensile Strength, psi	1350	1400	1250	1350
	MPa	9.3	9.7	8.6	9.3
D-412	Elongation, %	800	850	680	600
D-624	Tear Resistance, Die B, ppi	235	270	270	330
	KN/M	41	47	47	58
D-412	Tensile Modulus @ 100% psi	170	225	300	530
	MPa	1.2	1.6	2.1	3.7
D-395	Compression Set, % 22 hrs. @ 150°C (300°F)	20	20	20	20

## Regulatory Compliance

- A representative sample of an analogous product to Tufel II 94606 met the requirements of USP Class VI and ISO 10993 under Good Laboratory Practices (GLP).
- Listed as UL 94 HB (File No. E205753)
- The ingredients are listed in the BfR recommendation XV “Silicones” <sup>(1)</sup>
- Compositionally compliant with 21 CFR 177.2600 – Rubber articles intended for repeated use<sup>(2)</sup>

(1) Producer of the final article needs to test and confirm that the final product meets the extraction limits of BfR XV or corresponding EU legislation.

(2) It is the responsibility of the user to determine that the final product complies with the extractive limitations and other requirements of 21 CFR 177.2600, under their specific manufacturing procedures

### Patent Status

Standard copy to come

### Product Safety, Handling and Storage

Standard copy to come

### Limitations

Standard copy to come

### Contact Information

Email

[commercial.services@momentive.com](mailto:commercial.services@momentive.com)

### Telephone

<b>Americas</b>	<b>Latin America</b>	<b>EMEAI- Europe, Middle East, Africa &amp; India</b>	<b>ASIA PACIFIC</b>
+1 800 295 2392	<b>Brazil</b>	<b>Europe</b>	<b>China</b>
Toll free*	+55 11 4534 9650	+390510924300	800 820 0202
+704 805 6946	Direct Number	Direct number	Toll free
Direct Number			+86 21 3860 4892
			Direct number
*All American countries	<b>Mexico</b>	<b>India, Middle East &amp; Africa</b>	<b>Japan</b>
	+52 55 2169 7670	+ 91 44 71212207	+81 3 5544 3111
	Direct Number	Direct number*	Direct number
		<b>*All Middle Eastern countries, Africa, India,</b>	<b>Korea</b>
			+82 2 6201 4600

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