

## Tufel™ II 94205

### Description

Tufel II 94205 Rubber Compounds 94205 and 94305 are 20 and 30 durometer low volatile, fast-cure, addition cured silicone elastomers for molding. They may be used by themselves or blended to intermediate durometers. Applications include fabricated molding that require short cycle time, deep section cures, and parts with low extractable requirements.

### Key Features and Typical Benefits

- LV Bases Minimize Post Cure Times
- Totally Peroxide-Free Cure System
- Significant Reduction in Molding Cycle Systems
- Lower Molding Temperature Range (150-166°C) (300-330°F)
- Superior Mixed Shelf Life
- Tight Surface Cure
- Non-blooming
- Translucency

### Typical Physical Properties

TYPICAL CHARACTERISTICS OF UNCURED TUFEL II SILICONE RUBBER - 94005 SERIES

| PROPERTIES | 94205 | 94305 |
|------------|-------|-------|
|------------|-------|-------|

|   |             |             |
|---|-------------|-------------|
| Specific Gravity                        | 1.07        | 1.10        |
| Appearance                              | Translucent | Translucent |
| Polymer Classification<br>(ASTM D-1418) | VMQ         | VMQ         |

TYPICAL RHEOLOGICAL PROFILE - MONSANTO RHEOMETOR MODEL 100 WITH  
3° ARC @ 177°C (350°F)

|                         |           |           |
|-------------------------|-----------|-----------|
| Minimum Viscosity       | 3.8-6.0   | 4-7       |
| T1, Minutes             | 0.30-0.45 | 0.12-0.70 |
| 7 Min. Torque (lb./in.) | 19-29     | 21-34     |

TYPICAL PHYSICAL PROPERTIES OF TUFEL II SILICONE RUBBER - 94005  
SERIES

| ASTM METHOD | PRESS CURE - 10 MINUTES @ 177°C (350°F) | 94205 | 94305 |
|-------------|---|-------|-------|
| D-2240      | Hardness, Durometer A                   | 22    | 28    |
| D-412       | Tensile Strength, psi                   | 1200  | 1350  |
|             | MPa                                     | 8.3   | 9.3   |
| D-412       | Elongation, %                           | 1000  | 1050  |
| D-624       | Tear Resistance, Die B, ppi             | 125   | 170   |
|             | KN/M                                    | 22    | 30    |
| D-412       | Tensile Modulus @ 100% psi              | 63    | 87    |
|             | MPa                                     | 0.4   | 0.6   |

### Regulatory Compliance

- A representative sample of an analogous product to LIM 6040 met the requirements of USP Class VI.
- Compositionally compliant with 21 CFR 177.2600 – Rubber articles intended for repeated use<sup>(1)</sup>

(1) 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**

Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute the permission, inducement or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.

### **Product Safety, Handling and Storage**

Customers should review the latest Safety Data Sheet (SDS) and label for product safety information, safe handling instructions, personal protective equipment if necessary, emergency service contact information, and any special storage conditions required for safety. Momentive Performance Materials (MPM) maintains an around-the-clock emergency service for its products. SDS are available at [www.momentive.com](http://www.momentive.com) or, upon request, from any MPM representative. For product storage and handling procedures to maintain the product quality within our stated specifications, please review Certificates of Analysis, which are available in the Order Center. Use of other materials in conjunction with MPM products (for example, primers) may require additional precautions. Please review and follow the safety information provided by the manufacturer of such other materials.

### **Limitations**

Customers must evaluate Momentive Performance Materials products and make their own determination as to fitness of use in their particular applications.

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