

## Silopren™ LSR 2750

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### Description

**Silopren LSR 2750 TP 3824** is a two-component liquid silicone rubber for injection moulding, which offers primer-less adhesion to a wide range of substrates including metals and engineering plastics, but without adhesion to the mould. Full bond strength is reached after a short post cure (e.g. 1 h at 100°C) or by longer storage at room temperature. This makes **Silopren LSR 2750 TP 3824** the optimal choice for cost-efficient manufacturing of high numbers of articles in integrated processes such as multi-component injection moulding or insert-moulding.

### Key Features and Benefits

- Primer-less adhesion to many substrates
- No special mould treatment needed: Final adhesion builds up with time
- High temperature stability
- Excellent stability and flexibility at low temperatures
- Outstanding ageing behavior and weathering resistance
- Good dielectric and mechanical properties
- Easy pigmentable due to translucent colour

### Typical Physical Properties

		A Component	B Component
Appearance		translucent	translucent
Viscosity in Pa.s $\gamma = 10 \text{ s}^{-1}$ at 20 ° C	DIN 53018	600	600
The pot-life of the mixed components (closed container) at 20 ° C is three days. Increased temperatures reduce the pot-life.			

The mechanical properties were measured on test sheets (2 mm). These were produced by mixing the components A & B in 1:1 ratio and curing the resulting mixture 10 min at 175°C.			
Density	DIN 53 479 A	g/cm <sup>3</sup>	1.12
Hardness	DIN 53 505	Shore A	50
Tensile strength	DIN 53 504 S2	N/mm <sup>2</sup>	9.5
Elongation at break	DIN 53 504 S2	%	650
Tear strength	ASTM D 624 die B	N/mm	30

### Potential Applications

**Silopren LSR 2750 TP 3824** is particularly suitable for the manufacturing of parts, where engineering plastics and elastomeric materials need to be combined in an overmoulding or co-moulding process such as sealing elements, automotive connectors, membranes, vibration dampening elements, etc. Parts made from **Silopren LSR 2750 TP 3824** can generally be used in technical applications without post-cure, but do not comply with regulations applicable for parts, which are intended for the pharmaceutical or food industry.

### Processing Recommendations

**Silopren LSR 2750 TP 3824** is a kit-matched product. As such, work time (pot-life), cure time, and final cured properties can only be assured if the batch numbers on the A component and B component are identical and the material is mixed at a ratio of 1:1 (by weight).

Pumping and meter-mixing systems for **Silopren LSR 2750 TP 3824** and appropriate injection moulding machines are available from a number of manufacturers, most of whom will provide a complete integrated system (exclusive of the mould itself).

When starting up a new mould the first moulding cycles (approx. 1000) should be carried out with a standard Silopren LSR grade such as Silopren LSR 20xx. It is also possible to use a fluoro containing release agent.

For further information please contact Momentive performance materials.

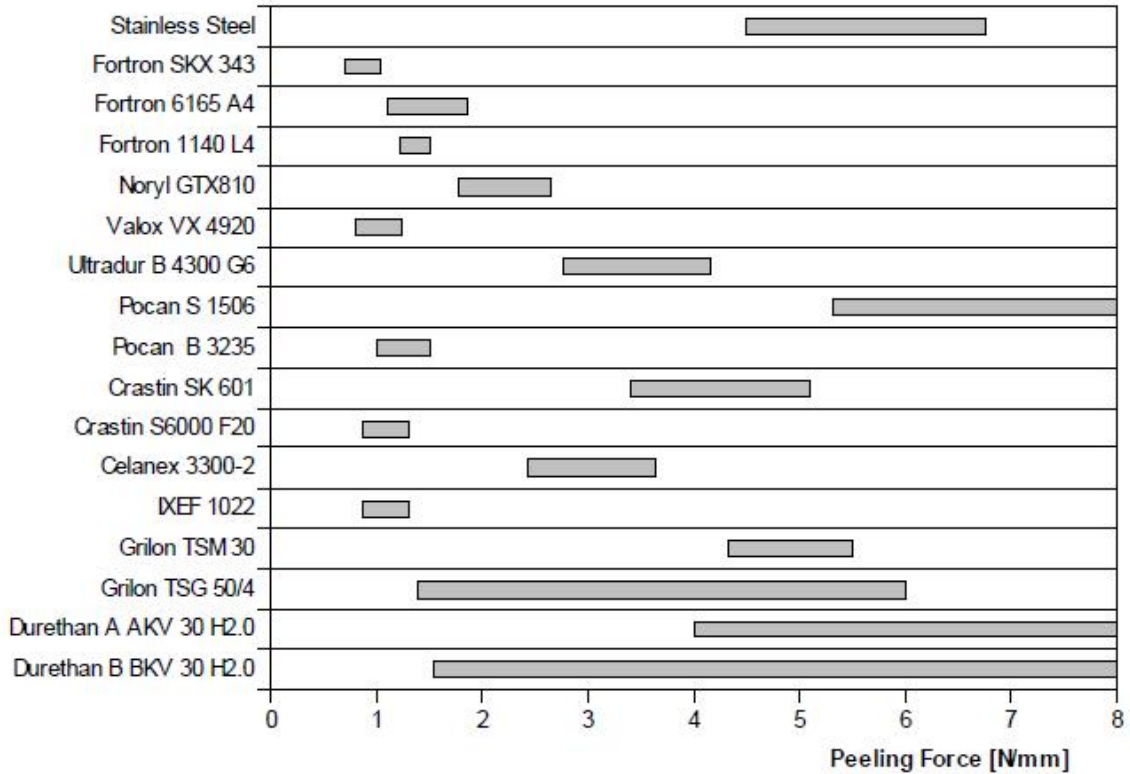
### Availability

**Silopren LSR 2750 TP 3824** is available in 20 kg pails and 200 kg drums.

### Adhesion Testing Results

Test specimen moulded with injection moulding process and subjected to an additional heat treatment for 1 h at 100°C.

ETP	Supplier	Grade	Peeling Force [N/mm]		ETP	Supplier	Grade	Peeling Force [N/mm]	
			As moulded	100°C/1h				As moulded	100°C/1h
PA 6	Bayer	Durethan BKV 30 H2.0	1,55	8,00	PBT	Bayer	Pocan S 1506	5,30	8,00
PA 6.6	Bayer	Durethan AKV 30 H2.0	4,00	8,00	PBT	BASF	Ultradur B 4300 G6	2,77	4,16
PA 6/6.6	EMS-Chemie	Grilon TSG 50/4	1,40	6,00	PBT	GE Plastics	Valox VX 4920	0,82	1,23
PA 6/6.6	EMS-Chemie	Grilon TSM 30	4,33	5,50	PPE/PA	GE Plastics	Noryl GTX810	1,77	2,66
PA MXD6	Solvay	IXEF 1022	0,88	1,32	PPS	Ticona	Fortron 1140 L4	1,22	1,50
PBT	Ticona	Celanex 3300-2	2,43	3,65	PPS	Ticona	Fortron 6165 A4	1,10	1,87
PBT	Du Pont	Crastin S6000 F20	0,88	1,32	PPS	Ticona	Fortron SKX 343	0,70	1,05
PBT	Du Pont	Crastin SK 601	3,40	5,10	Steel	Lab Standard	VA Steel	4,50	6,75
PBT	Bayer	Pocan B 3235	1,00	1,50					



Left end of bar are values "As moulded"; right end of the bar after "100°C / 1 h".  
 These typical data are only intended as a guide and should not be used in preparing specifications.

### Patent Status

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### Product Safety, Handling and Storage

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### 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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