

	TD219 Rev.00	PLANT PURCHASING SPECIFICATION HYDERABAD	FY40013 Rev. No. 00 Page 1 of 1		
2 PART 100_10 LIQUID SILICONE RUBBER (ELASTOSIL M 4630 A/B of M/s WACKER)					
1.0 GENERAL: This specification governs the requirement of 2 part liquid silicon rubber.					
2.0 APPLICATION: For making flexible mould.					
3.0 PROPERTIES 3.1 Both Part A and Part B liquid must be individually homogeneous and free from air/bubble. Suitable stabilizing agents and additives must not settle down or get deteriorated during storage. After mixing (10:1 ratio) and curing below mentioned properties are required.					
Product data (catalyzed A + B)					
Mix ratio	A : B	10 : 1 pbw			
Product data (cured)					
Hardness Shore A	ISO 868	28			
Tensile strength	ISO 37	6,50 N/mm ²			
Elongation at break	ISO 37	700 %			
Tear strength	ASTM D 624 B	> 30 N/mm			
Linear shrinkage		< 0,1 %			
4.0 FREEDOM FROM DEFECTS The material shall be free from any foreign matter.					
5.0 ACCEPTANCE TEST Each consignment shall be accepted on successful trial after supply.					
6.0 INSPECTION, DEVIATION AND REPLACEMENT BHEL reserves the right to inspect the material at BHEL and material can be accepted or rejected based on result.					
7.0 TEST CERTIFICATE One original and three copies of test certificate from the Manufacturer containing the following information should be provided. Manufacturer's Name Name of the material. Quantity. Results of all the tests as called for in this specification/order.					
8.0 PACKING AND MARKING The material shall be packed such as to prevent loss / deterioration in quality during handling, transport and Storage i.e., preferably in 30/3 Kg poly lined HDPE bag or 30/3 Kg sealed container. It should be marked with the following details. LIQUID SILICONE RUBBER PART A/B (which ever is applicable). Net weight					
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