

TD219
Rev.00**PLANT PURCHASING
SPECIFICATION
HYDERABAD****FY40012**

Rev. No. 00

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2 PART LIQUID SILICONE RUBBER**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 Viscosity in uncured condition = 10.0^{s-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 (1:1 ratio) and curing below mentioned properties are required.

3.2	Tensile Strength	ASTM D 412	Minimum 4.0 N/mm ²
3.3	Ultimate Elongation	ASTM D 412	Minimum 300%
3.4	Tear Strength	ASTM D 624-B	Minimum 20 N / mm
3.5	Specific Gravity	ASTM D 792	1.10±0.05
3.6	Hardness (Shore A)	ASTM D 2240 & IEC 62217	36 ± 8 Hardness of each specimen shall not change from the pre-boiling value by more than 20 %

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 20 Kg poly lined HDPE bag/20 Kg sealed container.

It should be marked with the following details.

LIQUID SILICONE RUBBER PART A/B (whichever is applicable).

Net weight

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