



# PR 110/10 Moulding Grade – Low Durometer High Consistency Silicone Rubber (HCR)

## Characteristics

Vulcanised articles manufactured from PR110/10, low durometer silicone rubber exhibit a unique combination of characteristics and properties. They are noted for having acceptable to good mechanical properties, as well as good processing characteristics. It is primarily suited for moulding applications, but simple extrusions may also be possible. PR110/10 is transparent but can be easily pigmented\*.

## Product Data

**Material Reference:** PR 110 / 10 (HCR Moulding Grade)

**Special Features:**

- Temperature range from -55 °C to 200 °C
- Low durometer / hardness
- High elongation, good damping
- Complies with BfR and FDA CFR 21 § 177.2600

**Colour:** Transparent (\*N.B. pigment addition may affect approvals / certifications)

## Safety Information

*Detailed, safety specific information can be obtained from the Material Safety Data Sheets (MSDS), which are available upon request.*

## Physical Properties

| Test                                  | Standard     | Units             | Typical Values |
|---------------------------------------|--------------|-------------------|----------------|
| Hardness                              | ISO 7619-1   | Shore A           | 13             |
| Density                               | ISO 2781     | g/cm <sup>3</sup> | 1.07           |
| Tensile Strength                      | ISO 37       | MPa               | 6              |
| Elongation @ Break                    | ISO 37       | %                 | 1200           |
| Tear Strength                         | ASTM D 624 B | kN/m              | 24             |
| Compression Set:<br>(22 Hrs @ 175 °C) | ISO 815-1    | %                 | 34             |

## Typical Cure Conditions

|               |                                      |
|---------------|--------------------------------------|
| Press-Cure    | 10 minutes @ 165 °C                  |
| Post-Cure     | 4 hours @ 200 °C (in ventilated air) |
| Catalyst Type | Dicumyl Peroxide (98%)               |

*This data is obtained from test pieces moulded in the laboratory and are intended as a guide. They should not be used in preparing specifications.*

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**Primasil Silicones Limited**  
 Kington Road, Weobley, Herefordshire  
 HR4 8QU United Kingdom  
 Tel: +44 (0)1544 312600  
 Email: [enquiries@primasil.com](mailto:enquiries@primasil.com)  
 Web: [www.primasil.com](http://www.primasil.com)



## Quality Assurance

All Primasil Silicone Rubber products are manufactured in accordance to the Quality Management Systems of ISO 9001 and if required; ISO 13485 and TS 16949. Full documentation and full traceability are ensured.

## Production Conditions

At Primasil Silicones, controls are implemented to ensure critical parameters are monitored throughout the entire production process to achieve customer requirements.

## Sterilizing Conditions

It is the user's responsibility to validate a sterilisation process for silicone mouldings / products. The user should conduct testing if sterilisation conditions vary and/or if minor property changes could affect performance. Common sterilisation procedures include:

### 1. Autoclave (Steam-sterilisation).

Silicone mouldings can be effectively sterilised by steam in an autoclave. However, silicone materials are more difficult to heat than other materials, such as thermoplastics, because they have thermal insulating properties and so care must be taken to ensure properties are not altered.

### 2. Gamma Radiation Sterilisation.

Gamma radiation studies of the effects on the physical properties of the silicone elastomer have shown that doses of radiation up to 2.5 Mrad (25kGy) do not adversely affect hardness, elongation, modulus, tensile or tear strength. Repeated gamma sterilisation or processing at higher doses and for longer periods however, may affect some of the physical properties of the elastomer. Testing should therefore be conducted by the user if sterilisation conditions vary and if minor property changes could affect application performance.

### 3. Ethylene Oxide Sterilisation (ETO).

ETO has been used to sterilise silicone products with no degradation of physical properties. Sterilisation by this method is only recommended if procedures allow sufficient time for complete out-gassing of residual ETO and ETO by-products.