



## PR 791/70 Railsil Extrusion Grade High Consistency Silicone Rubber (HCR)

### Characteristics

Vulcanised articles manufactured from PR791/70 Railsil extrusion grade silicone rubber exhibit a unique combination of characteristics and properties. They are noted for their good blend of physical properties, excellent flame retardant characteristics, coupled with low smoke and low toxicity ratings making the material ideal for railway rolling stock, mass transit applications. The grade has good processing characteristics, and is pigmented black.

### Product Data

**Material Reference:** PR 791 / 70 Railsil (HCR Extrusion Grade)

- Special Features:**
- Temperature range from -55 °C to 250 °C
  - Good blend of physical properties
  - Meets CEN / TS 45545-2 HL3\*
  - Meets BS 6853 Cat 1a\*
  - Meets NF F-16-101 Cat F1 & I2\*
  - Meets DIN 5510-2\*
  - Meets LUL 1-085 A2 Table 4\*
  - Fire resistant to UL94 V0 (3mm)\*
  - +/- 10 years storage suitability (ISO 2230)

**Colour:** Jet Black (RAL 9005)

### Safety Information

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

### Product Data

### Safety Information

Test	Standard	Units	Typical Values
Hardness	ISO 7619-1	Shore A	70
Density	ISO 2781	g/cm <sup>3</sup>	1.24
Tensile Strength	ISO 37	MPa	8.0
Elongation @ Break	ISO 37	%	400
Tear Strength	ISO 34	kN/m	24
Compression Set: (22 Hrs @ 175 °C)	ISO 815-1	%	28

\*Full test reports available on request. Testing undertaken by Exova.

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## Typical Cure Conditions

<b>Press-Cure</b>	6 minutes @ 115 °C
<b>Post-Cure</b>	4 hours @ 200 °C (in ventilated air)
<b>Catalyst Type</b>	50% paste of bis-(2,4-dichlorobenzoyl)-peroxide in silicone fluid

*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.*

## 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 Silicone, 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.

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