



# PR 810/60 Moulding Grade

## High Consistency Fluorosilicone Rubber (HCR)

### Characteristics

Vulcanised articles manufactured from PR810/60 moulding grade fluorosilicone rubber exhibit a unique combination of characteristics and properties. They are noted for their good flexibility and mechanical properties, together with excellent chemical resistance to many kinds of organic solvents and petroleum based fluids. PR810/60 has good processing characteristics and can be pigmented.

### Product Data

**Material Reference:** PR 810 / 60 (Fluorosilicone HCR Moulding Grade)

**Special Features:**

- Temperature range from -55 °C to 200 °C
- Excellent resistance to many solvents, lubricants, petrol's, oils, ATF fluids or other, aggressive fluids / greases that have an 'un-polar' chemical nature

**Colour:** Off-white

### 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	60
Density	ISO 2781	g/cm <sup>3</sup>	1.43
Tensile Strength	ISO 37	MPa	10.5
Elongation @ Break	ISO 37	%	420
Tear Strength	ASTM D 624 B	kN/m	24
Compression Set: (22 Hrs @ 175 °C)	ISO 815-1	%	8

### Fluid Resistance

<b>IRM 903 Oil (70 Hrs @ 160 °C):</b>			
Hardness	ISO 7619-1	Shore A	-6
Tensile Strength	ISO 37	%	-15
Elongation @ Break	ISO 37	%	-5
Volume Swell	ISO 1817	%	+4.2
<b>Fuel C (72 Hrs @ 25 °C):</b>			
Hardness	ISO 7619-1	Shore A	-9
Tensile Strength	ISO 37	%	-40
Elongation @ Break	ISO 37	%	-45
Volume Swell	ISO 1817	%	+23

**Disclaimer:** The information & data contained herein is believed to be accurate & reliable. However, it is the user's responsibility to determine suitability for the application of intended use. Primasil Silicones Ltd make no warranties concerning fitness or suitability of its products for a particular use or purpose. Alterations may be made to the above information on the basis of further knowledge being obtained.

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



## Typical Cure Conditions

<b>Press-Cure</b>	10 minutes @ 165 °C
<b>Post-Cure</b>	4 hours @ 200 °C (in ventilated air)
<b>Catalyst Type</b>	Dicumyl Peroxide (98%) or, 45 % paste of 2,5-bis-(t-butylperoxy)-2,5-dimethyl-hexane in silicone rubber

*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 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.

**Disclaimer:** The information & data contained herein is believed to be accurate & reliable. However, it is the user's responsibility to determine suitability for the application of intended use. Primasil Silicones Ltd make no warranties concerning fitness or suitability of its products for a particular use or purpose. Alterations may be made to the above information on the basis of further knowledge being obtained.

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