

Silbione® HCRA 4120 A/B HC

October 2017

Addition Cure Silicone Elastomer

Description **Silbione® HCRA 4120 A/B HC** is a two-part, addition-cure, platinum catalyzed silicone elastomer designed for use in processes where high strength molded parts or extruded profiles are desired. It is formulated for rapid cure in transfer and compression molds and in short-dwell vulcanizing ovens for extrusion processes. **Silbione® HCRA 4120 A/B HC** meets USP Class VI requirements and can be used in short term (under 30 days) implant materials.

Applications

- Molded or extruded medical parts for <30 day implantation
- Healthcare applications: stoppers, plungers, seals, needle entry ports, tubing

Advantages

- No volatile cure by-products
- Optional post cure
- Non-tacky surface
- Non-blooming
- No peroxide residue

Typical Properties

<u>Product Properties</u>	<u>Test Method</u>	<u>Value</u>
<i>Mixed A:B 1:1 ratio</i>	CTM	
• Appearance		Clear, translucent solid
• Specific Gravity	TP 013	1.12
• Pot Life, 23°C, hours	NM 128	8
<u>Cured 10 minutes, 120°C</u>		
	ASTM	
• Hardness, Shore A	D 2240	24
• Tensile Strength, psi (N/mm ²)	D 412	1,430 (9.9)
• Elongation, %	D 412	1,260
• Tear Strength, ppi (N/mm)	D 624, Die B	220(39)
• Tension Set, %	D 412	8

Please note: The typical properties listed in this bulletin are not intended for use in preparing specifications for any particular application of **Silbione®** silicone materials. Please contact our Technical Service Department for assistance in writing specifications

Instructions for use Parts A and B components of **Silbione® HCRA 4120 A/B HC** are designed to be mixed in equal parts by weight or volume using standard rubber processing techniques such as two roll milling. For optimum results, freshen both parts separately on the two roll mill before mixing them. Do not allow the material temperature to exceed 30°C during the milling. The mixed material should be used within two hours to prevent structuring and premature crosslinking. Molding is typically 10 minutes at 120°C or 3 minutes at 165°C.

Curing Curing can be achieved in 10 minutes at 120°C. Post curing for one hour at 165°C is recommended to stabilize physical properties. For extrusion applications, cure for 3 seconds at 593°C.

Pot Life The mixture of Parts A and B components of **Silbione® HCRA 4120 A/B HC** will remain stable for at least 6 hours at 23°C. Working time can be further extended by storing the mixed material in a freezer.

Silbione® HCRA 4120 A/B HC

Cleaning Care must be taken to work in a clean area with clean equipment, as traces of foreign materials can poison the catalyst, and inhibit the cure.





Limitations **Silbione®** silicone HC products are used for healthcare, medical and pharmaceutical applications within specified limitations. Elkem Silicones supports the sales of these **Silbione®** products to customers involved in manufacturing and assembling approved medical devices for skin contact or less than 30-day implantation. The purchaser has the sole responsibility to select a particular Elkem **Silbione®** product and determine its application suitability. The purchaser also has the sole responsibility to comply with all applicable statutory, regulatory and industry requirements and standards for compatibility, extractability, testing, safety, efficacy and labeling.

Storage and shelf life **Silbione® HCRA 4120 A/B HC** when stored in its original unopened packaging, at a temperature between 24°C (77°F), may be stored for 12 months from the date of manufacture. Beyond this date, Elkem Silicones no longer guarantees that the product meets the sales specifications.

Safety Please read the container labels for **Silbione® HCRA 4120 A/B HC** or consult the Safety Data Sheet (SDS) before handling for safe use, physical and health hazard information.

Packaging **Silbione® HCRA 4120 A/B HC** is available in 22.6 kg kits.

Silbione® is a registered Trademark of **Elkem SILICONES**

 EUROPE	 NORTH AMERICA	 LATIN AMERICA	 ASIA PACIFIC
<p><i>Elkem Silicones France</i> 21 Avenue Georges Pompidou F69486 Lyon Cedex 03 FRANCE Tel. (33) 4 72 13 19 00 Fax (33) 4 72 13 19 88</p>	<p><i>Elkem Silicones USA</i> Two Tower Center Boulevard Suite 1601 East Brunswick, NJ 08816-1100 United States Tel. (1) 732 227 2060 Fax (1) 732 249 7000</p>	<p><i>Elkem Silicones Brazil Ltda.</i> Av. Maria Coelho Aguiar, 215 Bloco G - 1º Andar 05804-902 - São Paulo - SP - Brazil Tel. (55) 11 3747 7887 Fax (55) 11 3741 7718</p>	<p><i>Elkem Silicones Hong Kong</i> Trading Co. Ltd. Unit C, 18/F Manulife Tower 169 Electric Road North Point-Hong Kong Tel. (852) 3106 8200 Fax (852) 2979 0241</p>
<p>Warning to the users The information contained in this document is given in good faith based on our current knowledge. It is only an indication and is in no way binding, particularly as regards infringement of or prejudice to third party rights through the use of our products. Elkem SILICONES guarantees that its products comply with its sales specifications. This information must on no account be used as a substitute for necessary prior tests which alone can ensure that a product is suitable for given use. Users are responsible for ensuring compliance with local legislation and for obtaining the necessary certifications and authorizations. Users are requested to check that they are in possession of the latest version of this document and Elkem SILICONES is at their disposal to supply any additional information.</p>			