

# Low Density LIMS (Liquid Silicone Rubber Injection Molding System)

## X-34-4347-A/B, X-34-4352-A/B

Low-density, lightweight LIMS

Automated molding

Short time molding

Energy saving

Flashless, runnerless

Lightweight

Floating on water



Features

Superior to conventional silicone rubber in low density and low thermal conductivity

Applications

Rubber parts that are required to be lighter, such as transport aircraft and wearable parts



### General properties

Grade		Low density, High strength		Low density	
Parameter	Product name	X-34-4347-A/B		X-34-4352-A/B	
Appearance		Reddish brown		Reddish brown	
Viscosity 0.9s-1	Pa·s	A: 223/B: 226		A: 248/B: 265	
Curing speed at 130°C MDR	T10	34		32	
	T90	65		55	
Standard molding condition (Injection molding)	Primary cure	140°C x 35 s	140°C x 35 s	140°C x 30 s	140°C x 30 s
	Post cure	No need	150°C x 1 h	No need	150°C x 1 h
Hardness Durometer A		38	40	34	38
Density	g/cm <sup>3</sup>	0.90	0.94	0.47	0.63
Linear shrinkage	%	2.0	3.0	-7.0*	4.0
Tensile strength	MPa	5.5	5.4	1.6	2.2
Elongation at break	%	600	560	500	630
Tear strength Crescent	kN/m	9	9	6	6
Compression set 150°C x 22 h	%	20	15	—	—

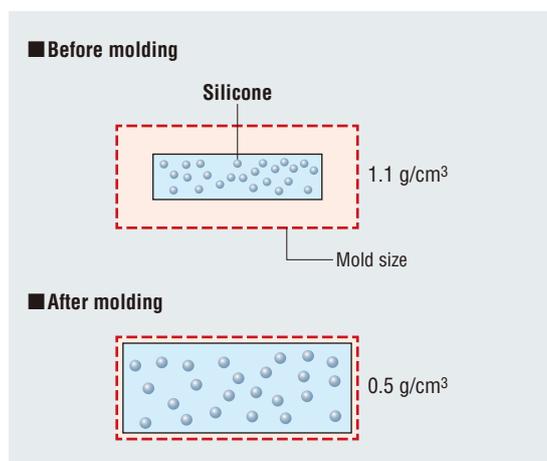
\* 7% swelling

(Not specified values)

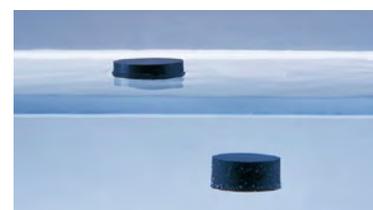
# Low Density LIMS

X-34-4347-A/B, X-34-4352-A/B

## Molding with low density liquid silicone rubber



Injection filling	When heating		
	Normal	Clamping pressure: low	Evacuating
Finished product	Middle density	Low density	Low density



Low-density silicone rubber molded product floating on water

## Handling precautions

1. Seal container tightly and store in a cool, dark place (25°C or below, out of direct sunlight) with good ventilation. Keep away from heat and flame because the primers used may be classified as flammable hazardous materials.
2. LIMS liquid silicone rubbers may not cure properly if they come in contact with certain substances, including amines, sulfur, organophosphorus compounds and organotin compounds. If there is a possibility of curing inhibition, the user should perform a test to determine whether the product will cure properly.

### Some curing inhibitors

- Chloroprene and other synthetic rubbers
- Amine-cure epoxies
- Sulfur compounds
- PVC insulating tape
- Soft PVC
- Soldering flux that contains rosin

3. Mixing Liquid B with alkaline substances produces flammable hydrogen gas, so handle with caution.

## Safety and hygiene

1. This product causes serious eye irritation and may cause skin irritation. When handling the product, be sure to avoid contact with the skin and mucous membranes by wearing protective glasses and protective gloves. In case of skin contact, immediately wipe off with dry cloth and then flush thoroughly with running water. In case of accidental eye contact, flush immediately with plenty of clean water for at least 15 minutes and then seek medical attention. Contact lens wearers must take special care. If the products get into the eye, the contact lens may become stuck to the eye.
2. In a confined space with poor ventilation, please wear a protective mask. It is recommended to provide local ventilation. If vapors are inhaled and victims feel uncomfortable, move immediately to an area with fresh air. When you put non-hardening substance into the discard, silica and other powder generate. So you should wear a protective mask.
3. Keep out of reach of children.
4. Please read the Safety Data Sheets (SDS) before use. SDS can be obtained from our Sales Department.

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