**Product Data**

**Transparent Silicone Rubber for Liquid Injection Molding**

**LED-60(A/B)**

LED-60(A/B) is a 60-durometer, transparent two-component silicone rubber for liquid injection molding.

**KEY FEATURES**
- Excellent transparency
- Excellent injection molding capability

**TYPICAL APPLICATIONS**
- Packing, o-ring, keypad, switch cover and sports goggle

**TYPICAL PROPERTY DATA** (JIS K 6249)

<table>
<thead>
<tr>
<th>UNCURED PROPERTIES</th>
<th>LED-60(A)</th>
<th>LED-60(B)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Appearance</td>
<td>Transparent, liquid</td>
<td>Transparent, liquid</td>
</tr>
<tr>
<td>Viscosity (23°C) Pa-s (P)</td>
<td>56 (560)</td>
<td>32 (320)</td>
</tr>
<tr>
<td>Mixing ratio by weight</td>
<td>1:1</td>
<td></td>
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<tr>
<td>Refractive Index (n_D)</td>
<td>1.41</td>
<td></td>
</tr>
</tbody>
</table>

**CURED PROPERTIES (15min @ 170°C)**

| Density (23°C) g/cm³         | 1.01      |
| Hardness (Type A)           | 60        |
| Tensile strength MPa (kg/cm²) | 6.7 (68) |
| Elongation %                | 380       |
| Tear strength (Crescent) N/mm (kg/cm) | 13 (13) |

*Typical property data values should not be used as specifications.*

**INSTRUCTION FOR USE**

Ready-to-use mixtures LED-60(A) and LED-60(B) are fed directly to the injection-molding machine from the original containers by means of a metering and mixing unit. The mixture, consisting of the two components in the ratio 1:1, is injected into the heated mold. At mold temperatures of 130-200°C, the mixture cures within a few seconds with no byproducts. High curing speed and ease of demolding permit fully automated production of large numbers of articles in short cycle times.
Although the viscosity of the mixture will be increased without heating, it can be injected for three days at 25°C. When stopping the machine for more days, clean the residual substance in the equipment with a solvent.

Note:
Materials such as water, sulfur, nitrogen compounds, organic metallic salts, phosphorus compounds, etc. contained in the surface of the substrate can inhibit curing. It is recommended that a preliminary test be performed to determine the compatibility.

HANDLING AND SAFETY
♦ Wear eye protection and protective gloves as required while handling the product.
♦ Maintain adequate ventilation in the workplace at all times.

STORAGE
♦ Store in a cool and dry place out of direct sunlight.
♦ Keep out of the reach of children.

PACKAGING
♦ LED-60(A): 18kg pail available
♦ LED-60(B): 18kg pail available

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