

# ELASTOSIL<sup>®</sup> R 861/60 S



## High Consistency Silicone Rubber (HCR/HTV)

ELASTOSIL<sup>®</sup> R 861/60 S is noted for a low compression set and improved media and coolant resistance.

## Properties

### Specific features

- Coolant resistant
- Food-contact
- Steam resistant
- Ultra-low compression set

## Technical data

### Properties Cured

Cure conditions:

0.7 % ELASTOSIL® AUX Crosslinker C1 (Dicumylperoxide); 15 min / 165 °C in press, post-cured 4 h / 200 °C

Property	Condition	Value	Method
Appearance	-	translucent	-
Hardness Shore A	-	61	DIN ISO 48-4
Density	-	1.16 g/cm <sup>3</sup>	DIN EN ISO 1183-1 A
Tensile strength	-	8.4 N/mm <sup>2</sup>	ISO 37 type 1
Elongation at break	-	380 %	ISO 37 type 1
Tear strength	-	18 N/mm	ASTM D 624 B
Compression Set <sup>(1)</sup>	22 h   175 °C	6 %	DIN ISO 815-1 type B method A
Compression Set <sup>(2)</sup>	70 h   175 °C	16 %	DIN ISO 815-1 type B method A
Rebound resilience	-	56 %	ISO 4662

<sup>1</sup>post-cured 4 h / 200 °C

<sup>2</sup>post-cured 4 h / 200 °C

These figures are only intended as a guide and should not be used in preparing specifications.

## Properties Cured

### Cure conditions:

1.5 % ELASTOSIL® AUX Crosslinker E (50% paste of bis-(2,4-dichlorobenzoyl)-peroxide in silicone fluid), 10 min / 135 °C in press, post-cured 4 h / 200 °C

Property	Condition	Curing Agent E	Method
Appearance	-	translucent	-
Hardness Shore A	-	57	DIN ISO 48-4
Density	-	1.16 g/cm <sup>3</sup>	DIN EN ISO 1183-1 A
Tensile strength	-	8.2 N/mm <sup>2</sup>	ISO 37 type 1
Elongation at break	-	370 %	ISO 37 type 1
Tear strength	-	18 N/mm	ASTM D 624 B
Compression Set <sup>(1)</sup>	22 h   175 °C	23 %	DIN ISO 815-1 type B method A
Compression Set <sup>(2)</sup>	70 h   175 °C	33 %	DIN ISO 815-1 type B method A
Rebound resilience	-	51 %	ISO 4662

<sup>1</sup>post-cured 4 h / 200 °C

<sup>2</sup>post-cured 4 h / 200 °C

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## Coolant resistance

### After immersion in coolant

1000 h / 125 °C in autoclave

Cure conditions: 0.7 % ELASTOSIL® AUX Crosslinker C1 (Dicumylperoxide), 15 min / 165 °C in press, post-cured 4 h / 200 °C

Property	Glycantin® G40 / distilled water 50:50	Method
Hardness Shore A	63	DIN ISO 48-4
Tensile strength	7.3 N/mm <sup>2</sup>	ISO 37
Elongation at break	330 %	ISO 37
Compression Set <sup>(1)</sup>	55 %	DIN ISO 815-1 type B method B
Volume change	-1 %	-

<sup>1</sup>post-cured 4 h / 200 °C

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## Oil resistance

Cure conditions: 0.7 % ELASTOSIL® AUX Crosslinker C1 (Dicumylperoxide), 15 min / 165 °C in press, post-cured 4 h / 200 °C

Property	70 h / 150 °C IRM 901	70 h / 150 °C IRM 903	Method
Hardness Shore A	56	40	DIN ISO 48-4
Tensile strength	6.7 N/mm <sup>2</sup>	6.1 N/mm <sup>2</sup>	ISO 37
Elongation at break	340 %	280 %	ISO 37
Volume change	5 %	50 %	-

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All the information provided is in accordance with the present state of our knowledge. Nonetheless, we disclaim any warranty or liability whatsoever and reserve the right, at any time, to effect technical alterations. The information provided, as well as the product's fitness for an intended application, should be checked by the buyer in preliminary trials. Contractual terms and conditions always take precedence. This disclaimer of warranty and liability also applies particularly in foreign countries with respect to third parties' rights.

## Applications

- Dairy & Food Applications
- General Automotive Parts
- Molded Parts
- Profiles & Tubings

## Application details

This compound can be used in the manufacture of molded parts, but also particularly extrusion, for producing profiles, e. g. for windows and facades.

Provided appropriate processing, articles produced from ELASTOSIL® R 861/60 S can be used for food contact applications in accordance with the Recommendation "XV. Silicones" of the BfR and FDA 21 CFR § 177.2600 under observance of any given limitations on extractable and volatile substances. Furthermore, the product contains low levels of residual toluene which has to be completely removed from the final food contact article.

## Processing

The raw rubber requires the addition of peroxides for vulcanization at elevated temperatures. A homogeneous incorporation is a must to maintain best processing behavior. Pot life is depending on the used peroxide and storage condition. Please consider the technical data sheet of the corresponding curing agent.

For detailed information refer to our latest brochure "SOLID AND LIQUID SILICONE RUBBER - MATERIAL AND PROCESSING GUIDELINES".

## Packaging and storage

### Packaging

This product is available in 20 kg and 540 kg cardboard packaging.

Special delivery forms are possible but depend on several technical and commercial aspects. Please contact your local sales manager in such cases.

### Storage

Please store the cardboard boxes in a dry and cool place. Already opened boxes should be closed again to avoid any contamination.

The 'Best use before end' date of each batch is shown on the product label. Storage beyond the date specified on the label does not necessarily mean that the product is no longer usable. In this case however, the properties required for the intended use must be checked for quality assurance reasons.

## Safety notes

Comprehensive instructions are given in the corresponding Material Safety Data Sheets. They are available on request from WACKER subsidiaries or may be printed via WACKER web site <http://www.wacker.com>.

## QR Code ELASTOSIL® R 861/60 S



### For technical, quality or product safety questions, please contact:

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