

Measuring & Mixing . . .

Materials should be stored and used in a warm environment (72° F / 23° C). Before you begin, pre-mix Part B (base) thoroughly. After dispensing required amounts of Parts A and B into mixing container (1A:1B by volume or weight), **mix thoroughly for 3 minutes** making sure that you **scrape the sides and bottom of the mixing container several times**. After mixing parts A and B, vacuum degassing is recommended to eliminate any entrapped air. Vacuum material for 2 -3 minutes (29 inches of mercury), making sure that you leave enough room in container for product volume expansion.

Pouring

Curing

Mold Performance

For best results, pour your mixture in a single spot at the lowest point of the containment field. Let the rubber seek its level up and over the model. **A uniform flow will help minimize entrapped air.** The liquid rubber should level off at least 1/2" (1.3 cm) over the highest point of the model surface.

Curing . . . Allow rubber to cure as prescribed at room temperature (75°F/23°C) before demolding. Full physical properties are attained after 24 hours cure at room temperature. Do not cure rubber where temperature is less than 65°F /18°C. Allow mold to cool to room temperature before using.

If Using As A Mold . . . When first cast, silicone rubber molds exhibit natural release characteristics. Depending on what is being cast into the mold, mold lubricity may be depleted over time and parts will begin to stick. No release agent is necessary when casting wax or gypsum. Applying a release agent such as Universal Mold Release or Ease Release 200 (available from Smooth-On) prior to casting polyurethane, polyester and epoxy resins is recommended to prevent mold degradation.

Thickening With Thi-Vex Thickening Agent . . . A very small amount of Thi-vex will thicken the rubber brushable for vertical surface application. 0.25% - 0.5% Thi-vex (% of the total weight of the mixture, A+B) is all that is necessary.

Example: 100 Parts A + 100 Parts B (mix thoroughly) + 0.5 Parts by weight = brushable, some sag
100 Parts A + 100 Parts B (mix thoroughly) + 1.0 Part by weight = thick brushable, no sag

Safety First

The Material Safety Data Sheet (MSDS) for this or any Smooth-On product should be read prior to use and is available upon request from Smooth-On. All Smooth-On products are safe to use if directions are read and followed carefully.

Be careful. Use only with adequate ventilation. Contact with skin and eyes may cause irritation. Flush eyes with soap and water for 15 minutes and seek immediate medical attention. Remove from skin with waterless hand cleaner followed by soap and water.

Important: The information contained in this bulletin is considered accurate. However, no warranty is expressed or implied regarding the accuracy of the data, the results to be obtained from the use thereof, or that any such use will not infringe upon a patent. User shall determine the suitability of the product for the intended application and assume all risk and liability whatsoever in connection therewith.

Smooth-On offers a complete line of Liquid Rubber, Liquid Plastic and Release Agent products for hundreds of industrial and art related applications. Chances are there is a distributor in your area to offer local support.

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