

Pouring

Curing

Mold Performance

Pouring ...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 the mold to cure overnight (at least 16 hours) at room temperature (77°F/25°C) before demolding. Cure time can be reduced with mild heat (125°F / 51°C for 4 - 6 hours). **Post curing the mold an additional 4 - 5 hours at 125°F (51°C)** will eliminate any residual moisture and alcohol that is a by-product of the condensation reaction. This water and alcohol can inhibit the cure of some casting resins. Allow mold to cool to room temperature before using. Do not cure rubber where temperature is less than 65°F/18°C.

Thickening Mold Max™ 10, 20 & 30 Silicones with THI-VEX™ thixotropic additive: For vertical surface application, Mold Max™ 10, 20 & 30 Silicones can be thickened for brush-on application. Different viscosities can be attained by varying the amount of THI-VEX™.

THI-VEX™ is added as a percentage of Part A and must be thoroughly mixed with Parts A and B.

Part A	+	Part B Catalyst (Mix Well)	+	THI-VEX (% of Part A)	=	Consistency
100 Parts		10 Parts		1/2 Part (0.5%) (% of Part A)		Thick
100 Parts		10 Parts		1.0 Parts (1.0%) (% of Part A)		Thicker
100 Parts		10 Parts		2.0 Parts (2 %) (% of Part A)		Thickest

Apply a coat of rubber. Wait for rubber to become "tacky" before applying next coat. Final mold thickness should be at least 3/8" (1 cm). Allow rubber to cure overnight before applying support shell.

FastCat™ silicone rubber catalyst will accelerate the cure time of Mold Max™ silicone rubbers. Used in place of (or in combination with) Mold Max™ regular Part B catalyst, FastCat™ will reduce the demold time from overnight to as little as 30 minutes. **Note:** working time is reduced in proportion to the amount of FastCat™ added. See the technical bulletins for FastCat™ 10, 20 & 30 respectively (available from Smooth-On or your Smooth-On distributor) for exact mix ratios and cure times.

Mold Max™ Thinner is a non-reactive silicone fluid that will lower the mixed viscosity of tin cure (condensation) or platinum cure (addition) silicone rubber products. MM Thinner offers the following advantages: [1] A lower mixed viscosity (A+B) means that the rubber will de-air faster when vacuuming; [2] Mixed rubber (A+B) will flow better over intricate model detail; [3] MM Thinner will lower the ultimate shore hardness (durometer) of cured silicone rubber; [4] Pot life (working time) is increased in proportion to the amount of MM thinner used. A disadvantage is that ultimate tear and tensile are reduced in proportion to the amount of MM thinner added, however knotty tear properties of the Mold Max™ Series rubbers are unaffected. See the Mold Max™ Thinner technical bulletin (available from Smooth-On or your Smooth-On Distributor) for full details.

*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 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.*

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