



Equinox™ Series

Mix & Apply-By-Hand Platinum Mold Putty

PRODUCT OVERVIEW

Equinox™ Silicone Putty Products are new fast-set silicone compounds (platinum catalyst) that can be easily mixed and applied by hand to a variety of surfaces. Equinox™ Putty is mixed in equal amounts (1A:1B) by volume. Pot life is about 1 minute with a cure time of about 7 minutes at room temperature (72°F / 23°C). Shrinkage is low and cured rubber is exceptionally strong (very high tensile strength), durable and will resist high temperatures (for casting low-temperature melt metal alloys). They also resist cure inhibition. **Three Hardness's To Choose From:**

- **Equinox™ 25 - Shore 25A**
- **Equinox™ 35 – Shore 35A**
- **Equinox™ 50 – Shore 50A**

Applications include making fast mold impressions from almost any surface, orthotics / orthopedic, equine hoof repair, jewelry making and more.

TECHNICAL OVERVIEW

	Shore A*	Mix Ratio By Weight	Color	Spec. Vol. Cu. In./Lb	Spec. Grav. G/C.C.	Mixed Viscosity	Die B Tear	Elongation At Break	Tensil Strength	100% Modulus	Shrinkage In./In.
Equinox 25	25	100A:100B pbw/pbv	Blue	21.47	1.29	Putty	120	400%	450 psi	170 psi	0.0003
Equinox 35	35	100A:100B pbw/pbv	Light Purple	21.25	1.25	Putty	140 pli	430%	520 psi	119 psi	0.0003
Equinox 50	50	100A:100B pbw/pbv	Yellow	21.25	1.29	Putty	165 pli	300%	600 psi	119 psi	0.0003

*Ultimate Shore hardness attained after 24 hours at room temperature.

Preparation

Measuring

Mixing

Store and use silicones at room temperature (72°F / 23°C). Storing material at warmer temperatures will shorten shelf life of material. Using rubber in warmer temperatures will reduce pot life and cure time significantly.

Applying A Sealer . . . Silicone rubber may be inhibited by sulfur-based clays resulting in tackiness at the model surface interface. Sulfur clays, certain wood surfaces, newly cast polyester, epoxy or urethane rubber may cause inhibition. If compatibility between the rubber and the surface is in question, a small-scale test is recommended. Apply a small amount of rubber onto a non-critical area of the pattern. Inhibition has occurred if the rubber is gummy or uncured after the recommended cure time has passed. To prevent inhibition, a “barrier coat” of clear acrylic lacquer sprayed directly onto the pattern is usually effective.

This product is mixed by hand. If you choose to wear gloves, wear vinyl gloves *only*. Latex gloves will inhibit the cure of the rubber.

Measuring . . . Equinox Series Putty comes as two parts. Dispense equal amounts (golf ball size, for example) of Part A and Part B.

Mixing . . . Knead parts together aggressively to a uniform color and apply quickly.
Putty begins to cure after 30 seconds.

Applying

Curing

Applying Support Shell

Casting

Applying the Rubber: Putty can be applied directly to almost any model surface (see preparation above).

Curing: Allow the rubber to cure for 5 to 7 minutes at room temperature (72°F/23°C) before removing from model surface. Applying heat (heat gun, hair dryer, heat lamp, etc.) will cause the rubber to cure faster.

Making A Mold? Apply A Support Shell: Usually, Putty molds will be too thin to support themselves during casting. A support shell made of Plasti-Paste_{tm} or Matrix NEO_{tm} and chopped fiber can be applied over the mold surface.

Using The Mold: When first made, 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 (available from Smooth-On) prior to casting polyester, polyurethane and epoxy resins is recommended to prevent mold degradation.

*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 in a properly ventilated area ("room size" ventilation). Wear vinyl gloves only. Latex gloves will inhibit the cure of the rubber. 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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