

Measuring & Mixing . . .

Pouring . . .

After dispensing equal amounts of Parts A and B into mixing container, **mix thoroughly for 3 minutes** making sure that you **scrape the sides and bottom of the mixing container several times**.

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

Mold Performance

Curing . . . Allow to cure as prescribed (75 minutes for OOMOO 25 and 6 hours for OOMOO 30) at room temperature (77°F/25°C) before demolding. Post curing the mold an additional 4 - 5 hours at 125°F (51°C) will eliminate any residual moisture and alcohol which is a by product of the condensation reaction. Allow mold to cool to room temperature before using. Do not cure rubber where temperature is less than 65°F /18°C.

Using The 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 (Universal Mold Release or Ease Release) prior to casting polyurethane, polyester and epoxy resins is recommended to prevent mold degradation.

Mold Performance & Storage. . . The physical life of the mold depends on how you use it (materials cast, frequency, etc.). Casting abrasive materials such as concrete will quickly erode mold detail, while casting non-abrasive materials (wax) will not affect mold detail. Before storing, the mold should be cleaned with a soap solution and wiped fully dry. Two part (or more) molds should be assembled. Molds should be stored on a level surface in a cool, dry environment. **Because no two applications are quite the same, a small test application to determine suitability for your project is recommended if performance of this material is in question.**

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 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.

Feel free to call or fax us any time with your questions.

Chances are there is a distributor in your area to offer local support.

Toll-free: (800) 762-0744

Fax: (610) 252-6200

Website: www.smooth-on.com