Sealer and Release Agent
Reference Guide

For sealing and releasing your model, you can use the charts below as a general guide for making molds using urethane rubber or silicone rubber. The best way to determine the appropriate sealer and release agent for your application is to read the product technical bulletin.

When You Are Making a Polyurethane Rubber Mold . . .

and your original model is made of...	seal it with...	then apply...
Modeling Clay - Water Based	Spray Shellac*	Universal™ Mold Release
Modeling Clay - Sulfur Based	Spray Shellac*	Universal™ Mold Release
Modeling Clay - Sulfur Free	Spray Shellac*	Universal™ Mold Release
Wax	Spray Shellac*	Universal™ Mold Release
Foam (Polyurethane)	Spray Shellac*	Universal™ Mold Release
Non Porous Hard Plastic	Not Required	Universal™ Mold Release
Wood	Super Seal™ , Sonite™ Wax**, or Spray Shellac*	Universal™ Mold Release
Plaster / Gypsum	Super Seal™ , Sonite™ Wax**, or Spray Shellac*	Universal™ Mold Release
Stone / Concrete / Cement	Sonite™ Wax**	Universal™ Mold Release

General Information

1. The above combinations of sealers and release agents are necessary for successfully making rubber molds using Smooth-On PMC™, ReoFlex™, VytaFlex™ and Brush-On™ rubber mold compounds.

2. Porous materials need to be sealed, followed by a release agent before applying mold rubber.

3. Nonporous materials require only a release agent before applying the mold rubber.

4. *Use a high quality Spray Shellac like Zinser Bullseye Shellac. Don't use Acrylic Spray! - Universal™ Mold Release can soften the acrylic making the rubber bond to the model.

5. **Sonite™ Wax is suitable for sealing a variety of surfaces. It is available from Smooth-On and its distributors, Butcher's Wax can be substituted in a pinch.

When You Are Making a Silicone Rubber Mold...

and your original model is made of...	seal it with...	then apply...
Modeling Clay - Water Based	Acrylic Spray** (optional)	Ease Release™ 200 (optional)
Modeling Clay - Sulfur Based (Platinum Silicones cannot be used to make molds of clays containing sulfur)	Acrylic Spray** (optional)	Ease Release™ 200 (optional)
Modeling Clay - Sulfur Free	Not Required	Ease Release™ 200 (optional)
Wax	Not Required	Not Required
Foam (Polyurethane)	Acrylic Spray**	Ease Release™ 200 (optional)
Non Porous Hard Plastic	Not Required	Not Required
Wood	Super Seal™, Petroleum Jelly, or Acrylic Spray**	Ease Release™ 200 (optional)
Plaster / Gypsum	Super Seal™, Petroleum Jelly, or Acrylic Spray**	Ease Release™ 200 (optional)
Stone / Concrete / Cement	Super Seal™, Petroleum Jelly, or Acrylic Spray**	Ease Release™ 200 (optional)
3D Print Media (FDM, ABS, PLA, etc.)	XTC-3D® Print Coating	Ease Release™ 200
3D Print Media (SLS Powder Print)	XTC-3D® Print Coating Thinned with Acetone	Ease Release™ 200

General Information

1. Your best bet is to refer to the specific product technical bulletin for the mold rubber that you are using.
2. The above combinations of sealers and release agents are suggested for successfully making rubber molds using Smooth-On Mold Max™, Smooth-Sil™, Dragon Skin™, EcoFlex™, OOMOO™ and other silicone mold rubbers.
3. Use only sealers or release agents that are compatible with silicone rubber such as Ease Release™ 200, proven and reliable. Apply a light mist coating, brush release over surface detail, apply second light mist coating and let dry.
4. *Modeling Clay - Sulfur Based cannot be used with Platinum Silicone under any circumstance.
5. **Don't Use Shellac! – shellac contains alcohol and the rubber will bond to the model.
6. Don't wipe model down with alcohol prior to applying silicone rubber.

Safety First!

The safety data sheet (SDS) for this or any Smooth-On product should be read before using and is available on request. All Smooth-On products are safe to use if directions are read and followed carefully.

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 a copyright or patent. User shall determine suitability of the product for the intended application and assume all associated risks and liability.

Call Us Anytime With Questions About Your Application.

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The new **www.smooth-on.com** is loaded with information about moldmaking, casting and more.