



## 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 (73°F/23°C) before demolding. **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 XLS with THI-VEX™ thixotropic additive:** For vertical surface application, *Mold Max XLS* silicone 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		4 Parts		1/2 Part (0.5%) (% of Part A)		Thick
100 Parts		4 Parts		1.0 Parts (1.0%) (% of Part A)		Thicker
100 Parts		4 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.

### Decreasing demold time with *Accel-T<sub>m</sub>* Silicone Cure Accelerator:

Important: Thoroughly Pre-mix Accel T with Part B before adding Part A. Be aware that the working time is drastically reduced with the addition of Accel T. *Mold library life is also drastically reduced.*

Accel-T <sub>m</sub> added by weight To Part "B"	~Pot Life in minutes	~Demold time in hours
0.2%	20	3
0.6%	5	2
1.0%	3	1

**Silicone Thinner** will 1) lower mixed viscosity which means that the rubber will de-air faster when vacuuming and 2) lower the ultimate shore hardness (durometer) of cured silicone rubber. See the Silicone 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 at [www.smooth-on.com](http://www.smooth-on.com). 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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