



OOMOO® 25 & 30

1A:1B Mix By Volume Silicone Rubber

PRODUCT OVERVIEW

No Vacuuming – No Scale – Stupid Name . . . Introducing OOMOO® 25 & 30. OOMOO® 25 & 30 are easy to use silicone rubber compounds that feature convenient one-to-one by volume mix ratios (no scale necessary). Both have very low viscosity for easy mixing and pouring, and **vacuum degassing is not necessary**. Both products cure at room temperature with negligible shrinkage.

OOMOO® 30 has a 30-minute pot life, with a six-hour cure time.

OOMOO® 25 is a faster version, with a 15-minute pot life and 75 minute cure time.

For The Novice Mold Maker - OOMOO® silicones do not have great tear strength. They are good for making simple one- or two-piece simple shape block molds. If you require a high-tear strength silicone, Mold Max® silicones are recommended (contact SMOOTH-ON for more information).

OOMOO® 25 & 30 are suitable for a variety of art-related and industrial applications including making molds for sculpture and prototype reproduction, casting plaster, resins and wax.

TECHNICAL OVERVIEW

Product	Shore A Hardness	Mix Ratio By Volume	Mix Ratio By Weight
OOMOO® 25	25	1A : 1B	100A:130B
OOMOO® 30	30	1A : 1B	100A:130B
~Pot Life: OOMOO® 25 – 15 min. OOMOO® 30 – 30 min.	~Demold Time: OOMOO® 25 – 75 min. OOMOO® 30 – 6 hours	~Color: OOMOO® 25 – Light Blue OOMOO® 30 - Lavender	

Properties	Viscosity	G/CC	Cu. In./Lb.	Tensile Strength	Mix Ratio
Part A	-	-	-	-	100 pby / 100 pbw
Part B	-	-	-	-	100 pby / 100 pbw
Mixed	4,250 cps	1.34	20.6	240 psi	-
Elongation at break: 250%	Die C Tear Strength: 40 pli		Compression Set: 37%		Shrinkage: .0025 in./in.

Surface Preparation

Preparing To Mix

Measuring

Preparation – Materials should be stored and used in a warm environment (72° F / 22° C). Store material where temperature does not exceed 75° F / 23° C. These products have a limited shelf life and should be used as soon as possible. Wear safety glasses, long sleeves and rubber gloves to minimize contamination risk.

Cure Inhibition – Silicone rubber may be inhibited by certain contaminants in or on the pattern to be molded, resulting in tackiness at the pattern interface or a total lack of cure throughout the mold. If compatibility between the rubber and the surface is a concern, 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. Materials found to cause cure inhibition include sulfur-based modeling clays and latex rubber. **To prevent inhibition apply a sealing agent . . .** apply a “barrier coat” of **clear acrylic lacquer** sprayed onto the clay surface.

Applying A Release Agent – A sealing agent or release agent will make demolding easier when pouring rubber over most surfaces. **Options:** **Sonite® Wax** will work to seal highly porous models (i.e. dry plaster or concrete). Brush-on a **thin layer** to model surface (be sure to eliminate any brush strokes) and let dry. **Ease Release® 200** release agent will release silicone from all smooth surfaces and is recommended for releasing new silicone from cured silicone (2 part molds). **~IMPORTANT:** To ensure thorough coverage, lightly brush the release agent with a soft brush over all surfaces of the model. Follow with a light mist coating and let the release agent dry for 10 minutes.

Measuring

Mixing

Applying

Curing

Performance

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 – 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 hours at 150°F (65°C) will eliminate any residual moisture and alcohol which is a by product of the condensation process and may inhibit some resins. 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 – 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 sticking and 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!

Safety First!

Safety First!

OOMOO®-30 PART A:

CAUTION: In case of eye contact, flush thoroughly with water for 15 minutes. If irritation persists, get medical attention. For skin contact, wash with soap and water. **Keep Out Of Reach Of Children.**

OOMOO®-30 PART B:

CAUTION: In case of eye contact, flush thoroughly with water for 15 minutes. If irritation persists, get medical attention. For skin contact, wash with soap and water. **Keep Out Of Reach Of Children.**

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.

Call Us Anytime With Questions About Your Application

Toll-Free: (800) 762-0744 Fax: (610) 252-6200

Visit Us At Our Website: www.smooth-on.com