



Plasti-Paste®

Trowelable Plastic Paste

PRODUCT OVERVIEW

Plasti-Paste® is a two component fiber resin that is designed for vertical surface application. Part A is a liquid and Part B is a paste. Mix ratio is 1A : 3B by volume (41A:100B by weight). It has no odor and pot life is 8 – 10 minutes depending on mass. Demold time (can be handled) is about 90 minutes depending on mass.

Plasti-Paste® holds a vertical surface without sagging and cures to a strong, durable and lightweight plastic. Suitable as a mother mold / support shell (reinforces shape of rubber mold during casting), or as a laminating material. Can be pigmented with So-Strong® color tints from Smooth-On. Add cabosil or other filler as an extender or for special effects.

TECHNICAL OVERVIEW

<i>Product</i>	<i>Color</i>	<i>Mix Ratio By Volume</i>	<i>Durometer</i>	<i>Specific Volume</i>	<i>Pot Life</i>	<i>Demold Time</i>
<i>Plasti-Paste®</i>	Pale Yellow	1A : 3B (41A:100B by weight)	Shore 70D	26.8 cu.in./lb.	8 – 10 minutes	90 minutes (Depending on mass)

Description: Plasti-Paste® consists of two components, Part A (Yellow Label) and Part B (Blue Label). When combined in a mixing ratio of 1A : 3B by volume (41A:100B by weight), Plasti-Paste® quickly cures in about 90 minutes to a durable plastic.

Surface Preparation

Preparing To Mix

Measuring

Preparation – Mixing should be done in a well-ventilated area. Wear safety glasses, long sleeves and rubber gloves to minimize contamination risk. If making a 2 or more piece mother mold, apply appropriate shim apparatus to rubber mold exterior. **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.**

Applying A Release Agent – A release agent is necessary to facilitate demolding when applying as a mother mold over a cured urethane mold rubber. Use Sonite Wax® and/or Universal® Mold Release available from Smooth-On or your Smooth-On distributor. A liberal coat of release agent should be applied onto all surfaces that will contact the plastic. You can also apply aluminum foil over the rubber followed by Universal® Mold Release.

PRE-MIX Part B Before You Start – Part B is a thick paste that needs to be pre-mixed THOROUGHLY before being dispensed into measuring container. This will re-disperse components that may have separated.

Measuring – Materials should be stored and used in a warm environment (72° F / 22° C). This product has a limited shelf life and should be used as soon as possible. The components of Plasti-Paste® require two different sized containers. The first will be used for measuring out amounts of Part A and Part B. The second should be large enough to contain both components and allow thorough mixing. **IMPORTANT:** Shelf life of Part A (Yellow Container) is drastically reduced after opening. Remaining product should be used as soon as possible. Immediately replacing the lids on both containers after dispensing product will prolong the shelf life of the unused product. **XTEND-IT® Dry Gas Blanket** (available from Smooth-On) will significantly prolong the shelf life of unused liquid urethane products.

Mixing – Mix Ratio is 1A:3B by volume (41A:100B by weight). **(Step 1)** Fill measuring container to the top with Part B paste, making sure to eliminate any large voids. Level off the top of the container and remove any excess material. The paste should then be thoroughly emptied into a larger container that will act as your mixing container. Repeat As Necessary. **(Step 2)** Fill the measuring container to the top with Part A liquid and empty into mixing container. **Mix thoroughly for 1 -2 minutes** making sure that you **scrape the sides and bottom of the mixing container several times.** If adding So-Strong® color tints, pre-mix with the Part B before adding Part A.

Measuring**Mixing****Applying****Curing****Performance**

Applying – Plasti-Paste® thickens quickly and pot life is limited. Do not delay between mixing and applying. To increase working time, spread entire container contents over rubber mold surface and cover and spread mixture to uncovered areas. Apply uniformly with spatula over mold surface. Plasti-Paste® will adhere to itself if additional layers are needed. Apply at least 3/8” (1 cm) thickness, making sure rubber mold is thoroughly covered. Large molds may require added thickness for support shell stability. Supports (wood or metal) may be embedded for added stability and handling. Final layer of Plasti-Paste® can be smoothed by applying solvent (acetone) with gloved hand.

Curing – Castings will be extremely hot immediately following cure and may burn the skin. Let cool to room temperature before handling. Plasti-Paste® will develop handling strength and can be removed from rubber surface in about 90 minutes. At this point, it is stable enough to assemble over rubber mold and make a casting (hold 2 or more piece assemblies together with elastic bands, mold straps or bolts). Large sections should be bolted together to minimize distortion. Do not subject material to temperatures above 90°F / 32°C for 24 hours. Full strength will develop in 24 hours. Following full cure, do not subject material to temperatures above 130°F/54°C. **To improve heat resistance to 176°F / 80°C, post cure Plasti-Paste® at 150°F/65°C for 16 hours. If machining, wear dust mask or other apparatus to prevent inhalation of residual particles.**

Making A Two Piece Shell – Plasti-Paste® will bond to urethane rubber and itself. A barrier coat of paste wax followed by Universal® Mold Release applied to all surfaces is necessary to prevent adhesion. Applying aluminum foil to the contours of all surfaces followed by Universal® Mold Release will also prevent adhesion.

Storage – Plasti-Paste® will maintain shape of rubber molds. Store rubber molds assembled inside mother molds indoors at room temperature in a dry place. Cured plastic may exude an (oil) which will make the surface appear “slick”. The oil is inert and will not harm the skin. This can be caused by inaccurate mixing proportions of Parts A and Part B or storing cured plastic in high temperature / humid environments.

Safety First!**Safety First!****Safety First!**

The material safety data sheet (MSDS) 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.

Plasti-Paste® PART A:**WARNING: IRRITANT TO EYES, SKIN & MUCOUS MEMBRANES.**

Contains Methylene Diphenyl Isocyanate and Polymethylene Polyphenylisocyanate. Do not get in eyes, mucous membranes or on skin. Do not take internally. Do not breathe fumes. Use only with adequate ventilation. Wear chemical-resistant gloves and eye protection when using this product.

First Aid: In case of eye contact, flush thoroughly with water for 15 minutes and get immediate medical attention. In case of skin contact, wash thoroughly with soap and water. If irritation persists, get medical attention. If swallowed, do not induce vomiting. Drink 1 - 2 glasses of water and get immediate medical attention. If vapors are inhaled or if breathing becomes difficult, remove person to fresh air. If symptoms persist, get medical attention. **Keep Out Of Reach Of Children.**

Plasti-Paste® PART B:

CAUTION: In case of eye contact, flush 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.

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