

## PRODUCT OVERVIEW

Si-Tac™ II is an industrial silicone “no-slip” adhesive applied to natural or synthetic fabrics for the purpose of holding garments in place during normal wear or heavy exercise. It is a powerful adhesive with very high tensile strength and wear resistance. It is also sweat-proof, waterproof and withstands hundreds of laundering cycles.

**Health, Safety & Environment Certified** – Si-Tac II has received the textile industry’s highest certification and is certified as skin-safe by an independent laboratory.

Si-Tac II can be hand mixed, mechanically mixed and applied or dispensed through meter-mix equipment in production. Heat curing this product is required (see heat cure directions on technical bulletin).

**Packaging;** Trial, Gallon, 5-gallon, 55-gallon and Tote Units

### TECHNICAL OVERVIEW

Mix Ratio: 1A:1B by weight or volume

Mixed Viscosity: 350,000 cps

Pot Life: 48 hours at 73°F (23°C) (ASTM D-2471)  
9 hours at 90°F (32°C)

Cure time at 180°F (82°C): 5 minutes  
Cure time at 250°F (121°C): 20 seconds

Color: Translucent

Specific Gravity, g/cc: 1.1 (ASTM D-1475)

Die B Tear Strength, pli: 220 (ASTM D-624)

Shore A Hardness: 30 (ASTM D-2240)

Useful Temperature Range:  
-65°F to 450°F (-53°C to 232°C)

Elongation @ Break: 750% (ASTM D-412)

Tensile Strength, psi: 900 (ASTM D-412)

### FEATURES...

- **Strongest, Longest Lasting Garment Adhesive Available Anywhere**
- **Certifies to OEKO-TEX ECO PASSPORT Standards & Skin-Safe Certified**
- **Bonds to Activewear/Shapewear Fabrics Including Nylon, Spandex™ & Lycra™**
- **Waterproof, Sweatproof and Wear Resistant**
- **No-Slip Formula to Hold Garments in Place**
- **Moves Comfortably with the Body**
- **Remains Flexible at -65°F to 450°F (-53°C to 232°C)**
- **Certified Skin-Safe**
- **Resists UV, Ozone and Pool Chlorine**
- **Withstands Hundreds of Laundry Cycles**
- **Custom Colors Available**
- **Eco-friendly - Vegan and No VOCs**

## 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.

### Keep Out of Reach of Children

**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.

## PROCESSING RECOMMENDATIONS

### PREPARATION...

**Safety**-Use in a properly ventilated area ("room size" ventilation). Wear safety glasses, long sleeves and gloves to minimize contamination risk. Wear vinyl gloves only. Latex gloves will inhibit the cure of the rubber. **Store and use material at room temperature 73°F (23°C).** Warmer temperatures will drastically reduce working time and cure time. Storing material at warmer temperatures will also reduce the usable shelf life of unused material. This product has a limited shelf life and should be used as soon as possible.

**Cure Inhibition** - Addition cured silicone rubber may be inhibited by certain surface contaminants. **If surface compatibility is in question, do a small compatibility test before using for an important project.**

### MIXING & CURING...

**Mix by Hand** - Dispense equal amounts of Part A and Part B into a mixing container. Mix thoroughly for at least 5 minutes using a flat edge mixing paddle. Scrape sides and bottom of mixing container several times using flat edge of paddle. Vacuum Degas - place mixing container in vacuum chamber and subject mixture to 29 inHg vacuum until mixture rises and falls. Remove from vacuum chamber and apply. Heat cure as directed below.

**Mechanical Mixing** - Dispense equal amounts of Part A and Part B into a mixing container. Using a drill with attached mechanical mixer (such as a Turbine Mixer), mix thoroughly for at least 3 minutes on medium speed. Avoid high speeds and creating a vortex as this will entrain air into the silicone. Follow with 2 minutes of hand mixing using a flat edge mixing paddle. Scrape sides and bottom of mixing container several times. Vacuum Degas - place mixing container in vacuum chamber and subject mixture to 29 inHg. vacuum until mixture rises and falls. Remove from vacuum chamber and apply. Heat cure as directed below.

**Meter Mix Dispensing** - When meter mix dispensing, contact meter mix equipment manufacturer for instructions on proper equipment setup and usage.

**Heat Curing** - Si-Tac II must be heat cured to achieve optimal properties. **Standard Cure: 20 seconds at 250°F (121°C).** Alternatively, it can be cured at **180°F (82°C) for 5 minutes.**

Cure times may vary slightly depending on part thickness, substrate, and oven performance. If the fabric or bonded assembly is at room temperature when entering the oven, a longer post-cure may be necessary to ensure a full cure throughout.



**Call Us Anytime With Questions About Your Application.**

**Toll-free: (800) 381-1733 Fax: (610) 252-6200**

[www.smooth-on.com](http://www.smooth-on.com)

is loaded with information about mold making, casting and more.