



Certified  
Skin Safe!



www.smooth-on.com

## PRODUCT OVERVIEW

Si-Tac™ is a two-part pourable liquid silicone adhesive that is applied to natural or synthetic fabric/clothing for the purpose of keeping sports or leisure wear in place during exercise. Garments will not shift or fall. Si-Tac™ can be mixed and applied by hand, but is also often meter mix dispensed and delivered to the garment surface at strategic points through a narrow static mixing tube before being quickly heat cured. Certified Skin Safe, cured rubber is soft, comfortable and flexes with every movement; never noticed by the wearer.

Si-Tac™ silicone performs over a wide temperature range, is very strong, sweat resistant and lasts through many laundering cycles.

### TECHNICAL OVERVIEW

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

Mixed Viscosity: 80,000 cps

Elongation @ Break: 550% (ASTM D-412)

Pot Life: 2.5 hours (73°F/23°C) (ASTM D-2471)

Cure time: 6 hours (73°F/23°C)

Cure time at 94°C: 15 seconds

Color: Translucent

Specific Gravity, g/cc: 1.08 (ASTM D-1475)

Shore A Hardness: 30 (ASTM D-2240)

### Safety First!

The Material Safety Data Sheet (SDS) 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

**BECAREFUL** - Avoid contact with eyes. Silicone polymers are generally non-irritating to the eyes however a slight transient irritation is possible. Flush eyes with water for 15 minutes and seek medical attention. Remove from skin with waterless hand cleaner followed by soap and water. Children should not use this product without adult supervision.

**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 rubber 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. These products have 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.

### MEASURING & MIXING...

**Mixing by Hand** - Before you begin, pre-mix Part B thoroughly. After dispensing required amounts of Parts A and B into mixing container (1A:1B by volume or weight), mix thoroughly by hand or using a turbine mixer (available at your local Smooth-On distributor). Material should be mixed for 3 minutes before pouring, making sure that you scrape the sides and bottom of the mixing container several times.

### APPLYING & CURING...

**Applying by Hand** - Apply a uniform layer across all surfaces using a scraper tool or brush. If applying in layers (approximately 0.06" / 1.5mm per layer), let the first coat cure for 3 hours at room temperature until material becomes "tacky" before adding the next coat. Repeat until the necessary thickness is achieved.

**Meter Mix Dispensing - Si-Tac™** Parts A and B are meter mix dispensed and delivered to the garment surface at strategic points through a narrow static mixing tube. The garment is then run through a heat tunnel and exposed to 200°F/94°C or higher so that the silicone cures in 1 minute or less. For information on meter mix equipment, contact Smooth-On or your nearest Smooth-On distributor.

**Curing** - Let silicone cure 6 hours at 73°F/23°C.

**Heat Curing** - Cure time can be reduced to under 1 minute by applying heat (200°F/94°C).



Call Us Anytime With Questions About Your Application.

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

www.smooth-on.com is loaded with information about mold making, casting and more.