

Duplicating silicone, addition curing 1:1

clear-transparent, final hardness 15 Shore A

Especially recommended for fabrication of clear-transparent forms, also for photo-plastics (forms are UVA-light translucent)

Application: at approx. 23 °C/73 °F, 50% ± 5% rel. humidity

Colour code: A and B - transparent

Final hardness: approx. 15 Shore A

Application: There are various possibilities to mix A and B components with a ratio of 1:1:

1) Using a silicone mixing device: Place the containers (1 l or 5 l) onto the mixing device. Mount a mixing cannula; mixing and bubble-free dosing are set going by push-button. During filling of the investing form, keep the end of the cannula immersed on the surface of the material to prevent air-bubbles. Hint: Using 5 l canisters, connecting tubes for the respective silicone mixing device are required.

2) Manual mixing: Mix the components in a mixing bowl by means of a spatula. To achieve a transparent bubble-free negative form, after filling of the silicone the filled investing form must be polymerised in a pressure pot at 2 - 6 bar and 20 - 30 °C / 68 - 86 °F warm water for approx. 12 - 15 minutes. (Caution: Prevent the water from reaching the silicone surface!)

3) Mixing in a vacuum-mixer: Both components are mixed under vacuum. Cast the bubble-free material slowly into the investing form.

Please note: To remove air inclusions (e.g. formed during transportation) place the open containers into a drying cabinet at up to 60 °C/140 °F for approx. 12 hours.

Setting time: approx. 12 - 15 minutes in a pressure pot
approx. 25 - 30 minutes at room temperature

Caution: Prevent the components A + B from contacting with one another before mixing. Do not interchange lids. Cured materials are chemically inert - spots on clothing should be avoided.

Processing by trained specialist staff only. The working instructions and precautionary measures have to be strictly observed.