

# ROMANOFF INTERNATIONAL

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## CAD-CAM CLEAR LMR

A. **PRODUCT OVERVIEW:** CAD-CAM LMR is a premium water white translucent silicone rubber that cures at room temperature with no shrinkage. CAD-CAM LMR has a Shore hardness of 40A and features exceptional tear and tensile strength.

B. It is best if the CAD-CAM LMR mold material is kept at room temperature (70-75°F/21°-24°C), and preferably not below 65°F/18°C when ready to mix and cure. The 'pot life' is 60 minutes and therefore all mixing, vacuuming and pouring into the frame should be completed within this time. Molds should be stored on a level surface in a cool, dry environment.

C. **MEASURING & MIXING:** You must use an accurate scale (gram scale) to weight Parts A and B. Before you begin, pre-mix Part B (base) thoroughly. After dispensing required amounts of Parts A and B into mixing container (100 parts A to 10 parts B by weight), **mix thoroughly for at least 3 minutes** making sure that you **scrape the sides and bottom of the mixing container several times**. After mixing parts A and B, vacuum degassing is recommended to eliminate any entrapped air. Vacuum material for 2-3 minutes (29 inches of mercury), making sure that you leave enough room in container for product volume expansion.

D. **POURING & CURING:** For best results, pour your mixture in a single spot at the lowest point of the bowl or frame. 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. Allow the mold to cure overnight (at least 16 hours) at room temperature (72°F/23°C) before cutting open. Do not cure rubber where temperature is less than 65°F/18°C. Time to cure can be reduced with mild heat.

### Temperature

### Approximate Cure Time (Hours)

72°F 23°C  
86°F 30°C  
125°F 52°C

16  
7  
3

Note: Allow mold to cool to room temperature before cutting.

E. **SAFETY FIRST:** The Material Safety Data Sheet (MSDS) for this or any product should be read prior to use and is available upon request from Romanoff. All Romanoff products are safe to use if directions are read and followed carefully.

Be careful. Use only with adequate ventilation. Contact with skin and eyes may cause irritation. Flush eyes with soap and 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.

Serving the White Metal and Precious Metal Industries since 1949...and Still Growing  
Manufacturers of Spin Casting and Lost Wax Investment Equipment.  
Suppliers of all materials used to manufacture jewelry.

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