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INTERNATIONAL SUPPLY CORPORATION

PRODUCT INSTRUCTIONS
SKU: 73-050-2

CAD CAM CLEAR LMR

Clear No-Shrink Mold Rubber 2lb Kit

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-cure silicone rubber may be inhibited by certain contaminants in or on the pattern to be molded resulting in tackiness at the pattern interface or a total lack of cure throughout the mold. Latex, tin-cure silicone, sulfur clays, certain wood surfaces, newly cast polyester, epoxy or urethane rubber may cause inhibition. If compatibility between the rubber and the surface is a concern, a small-scale test is recommended. Apply a small amount of rubber onto a non-critical area of the pattern. Inhibition has occurred if the rubber is gummy or uncured after the recommended cure time has passed.

To prevent inhibition, one or more coatings of a clear acrylic lacquer applied to the model surface is usually effective. Allow any sealer to thoroughly dry before applying rubber. Note: Even with a sealer, platinum silicones will not work with modeling clays containing heavy amounts of sulfur. Do a small scale test for compatibility before using on your project.

MEASURING & MIXING (Mixing ratio: 100 parts A to 10 parts B)

Before you begin, pre-mix Part B thoroughly. After dispensing the required amounts of Parts A and B into mixing container, **mix thoroughly for 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.

Pouring - For best results, pour your mixture in a single spot at the lowest point of the containment field. 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.

Curing - Allow the material to cure fully at room temperature (73°F / 23°C) before demolding. Natural curing at room temperature will take approximately 16 hours. Do not cure rubber where temperature is less than 65°F / 18°C.

Time to demold can be reduced with mild heat. **IMPORTANT: Rubber will darken considerably when exposed to heat.** Note: Allow mold to cool to room temperature before handling.

Post Curing - Post curing the mold will aid in quickly attaining maximum physical and performance properties. After curing at room temperature, expose the rubber to 176° F / 80° C for 2 hours and 212° F / 100° C for one hour. Allow mold to cool to room temperature before using.

IMPORTANT: Rubber will darken considerably when exposed to heat.

Using The Mold - New silicone rubber molds exhibit natural release characteristics. Depending on what is being injected into the mold, mold lubricity may be depleted over time and parts will begin to stick. No release agent is necessary when injecting wax.

Mold Performance & Storage - The physical life of the mold depends on how you use it (materials cast, frequency, etc.). The mold should be cleaned with a soap solution and wiped fully dry. Two part (or more) molds should be assembled. Molds should be stored on a level surface in a cool, dry environment.