



Mold Max® Series

Condensation Cure Silicone Rubber Compounds

PRODUCT OVERVIEW

Mold Max® Silicones are tin-cured silicone rubber compounds that have exceptional working properties and library life. Mold Max® Silicones feature Smooth-On's exclusive "Libra®" catalyst for long library life. **Mold Max® 10T, 15T & 27T** are translucent clear (no color) and can be used for making molds or creating skins and other special effects using Silc Pig® silicone colorants. Pot life for the pourable silicones is 45 minutes and they cure overnight at room temperature.

Mold Max® Silicones will reproduce the finest detail and are suitable for a variety of industrial and art related applications including making molds for reproducing prototypes, furniture, sculpture and architectural elements. Mold Max® 10, 10T, 15T, 20, 27T, 30, XLS and STROKE® Silicones can be thickened with THI-VEX® additive for brush-on applications. (Note; THI-VEX® is NOT compatible with Mold Max® 40). Mold Max® 60 offers high heat resistance for casting metal.

Mold Max® Silicones can be used to cast a variety of materials including wax, gypsum, low melt alloys/metals and urethane, epoxy or polyester resins (without using a release agent).

TECHNICAL OVERVIEW

	Shore A	Mix Ratio By Weight	Color	Specific Volume	Specific Gravity	Viscosity	Die B Tear Strength	Elongation At Break	Tensile Strength	100% Modulus	Shrinkage*
Mold Max® 10	10	100A:10B	Light Pink	24.1	1.15	15,000 cps	100 pli	529%	473 psi	35 psi	.001 in./in.
Mold Max® 10T†	10	100A:10B	Translucent	25.4	1.09	14,000 cps	87 pli	586%	405 psi	29 psi	.0025 in./in.
Mold Max® 15T†	15	100A:10B	Translucent	25.6	1.08	20,000 cps	94 pli	600%	490 psi	35 psi	.002 in./in.
Mold Max® 20	20	100A:10B	Light Pink	23.5	1.18	25,000 cps	110 pli	512%	555 psi	49 psi	.001 in./in.
Mold Max® 27T†	27	100A:10B	Translucent	25.0	1.11	30,000 cps	110 pli	400%	575 psi	65 psi	.002 in./in.
Mold Max® 30	30	100A:10B	Pink	23.5	1.18	25,000 cps	125 pli	300%	577 psi	110 psi	.002 in./in.
Mold Max® 40	40	100A:10B	Mint Green	24.3	1.14	45,000 cps	120 pli	250%	550 psi	190 psi	.004 in./in.
Mold Max® 60†	60	100A:3B	Red	19.1	1.45	20,000 cps	63 pli	132%	398 psi	331 psi	.0015 in./in.
Mold Max® XLS†	35	100A:4B	Blue	23.5	1.18	40,000 cps	130 pli	375%	630 psi	110 psi	.001 in./in.
Mold Max® STROKE†	30	100A:10B	White	23.5	1.18	Variable	125 pli	300%	577 psi	110 psi	.002 in./in.

† See detailed individual Technical Bulletin at smooth-on.com

*Shrinkage measured after 24 hours.

Preparation

Measuring

Mixing

Applying A Sealer / Release Agent – Mold Max® rubber may be inhibited by sulfur base clays resulting in tackiness at the pattern interface or a total lack of cure throughout the mold. 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, a "barrier coat" of clear acrylic lacquer sprayed directly onto the pattern is usually effective. Allow to thoroughly dry. Although not usually necessary, a release agent will make demolding easier when casting into or over most surfaces. Ease Release® 200 is a proven release agent for making molds with silicone rubber and for releasing new silicone from cured silicone. Mann Ease Release® products are available from Smooth-On or your Smooth-On distributor. Because no two applications are quite the same, a small test application to determine suitability for your project is recommended if performance of this material is in question.

Measuring & Mixing – Materials should be stored at about 72° F / 23°C. These products have a limited shelf life and should be used as soon as possible. Wear safety glasses, long sleeves and rubber gloves to minimize contamination risk. Before you begin, pre-mix Part A (base) thoroughly to re-disperse fillers that may have settled. After dispensing 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 in pourable Mold Max® rubber. Vacuum material for 2-3 minutes (29 inches of mercury), making sure that you leave enough room in container for product expansion. Pot life is 45 minutes at room temp.

Pouring

Curing

Performance

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 mold to cure overnight (at least 16 hrs) at room temperature (72°F/23°C) before demolding. **Option; Post curing the mold an additional 4 hours at 150°F (65°C)** will eliminate any residual moisture and alcohol that is a by-product of the condensation reaction that can inhibit the cure of some urethane resins and rubbers. Allow mold to cool to room temperature before using. Do not cure rubber where temperature is less than 65°F /18°C.

Thickening Mold Max® 10, 10T, 15T, 20, 27T, 30, XLS and STROKE® Silicones with THI-VEX® thixotropic additive for vertical surface/brush-on application. Different viscosities can be attained by varying the amount of THI-VEX®. Note; THI-VEX® will not work with Mold Max®40.

THI-VEX® is added as a percentage of Part A and must be thoroughly mixed with Parts A and B.

Part A	+	Part B Catalyst (Mix Well)	+	THI-VEX® (% of Part A)	=	Consistency
100 Parts		10 Parts		1/2 Part (0.5%) (% of Part A)		Thick
100 Parts		10 Parts		1.0 Parts (1.0%) (% of Part A)		Thicker
100 Parts		10 Parts		2.0 Parts (2 %) (% of Part A)		Thickest

Apply a coat of rubber. Wait for rubber to become "tacky" before applying next coat. Final mold thickness should be at least 3/8" (1 cm). Allow rubber to cure overnight before applying support shell.

FastCat® 30 or Accel T® silicone rubber accelerators will accelerate the cure time of Mold Max® silicone rubbers. Use in place of (or in combination with) Mold Max® regular Part B catalyst, FastCat® 30 for Mold Max 30 will reduce the demold time from overnight to as little as 30 minutes. Accel T® can be used with Mold Max® 10, 10T, 15T, 20, 27T, 40, 60, XLS and STROKE®. Note: working time is reduced in proportion to the amount of FastCat® or Accel T® added. See the technical bulletins for FastCat® 30 and Accel T® respectively (available from Smooth-On or your Smooth-On distributor) for exact mix ratios and cure times. Using these accelerators will result in a shorter library life of the mold.

Silicone Thinner is a non-reactive silicone fluid that will lower the mixed viscosity of tin cure (condensation) or platinum cure (addition) silicone rubber products. Silicone Thinner offers the following advantages: [1] A lower mixed viscosity (A+B) means that the rubber will de-air faster when vacuuming; [2] Mixed rubber (A+B) will flow better over intricate model detail; [3] Silicone Thinner will lower the ultimate shore hardness (durometer) of cured silicone rubber; [4] Pot life (working time) is increased in proportion to the amount of Silicone thinner used. A disadvantage is that ultimate tear and tensile are reduced in proportion to the amount of Silicone thinner added, however knotty tear properties of the Mold Max® Series rubbers are unaffected. See the Silicone Thinner technical bulletin (available from Smooth-On or your Smooth-On Distributor) for full details.

Safety First!

Safety First!

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. **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.

Call Us Anytime With Questions About Your Application

Toll-Free: (800) 762-0744

Fax: (610) 252-6200

Visit Us At Our Website: www.smooth-on.com

031709