Mixing guidelines for PolyArt™ 2-part, tin cure, silicone elastomer.

1. Stir the base (Part A) well before use (except when machine dispensing).
2. Shake the catalyst container (Part B) well before use.
3. Weigh the desired amount of base into a clean mixing container. Tip the container and roll the base all the way around the side wall up to two inches from the top. This will prevent the catalyst from becoming absorbed into the container. It is recommended that the container be filled to not more than 1/3 the container depth to allow sufficient room for expansion during the deaeration procedure.
4. Weigh the proper amount of catalyst into the container. Mix the base and catalyst together by stirring with a stiff, flat ended metal spatula (aluminum not recommended) until a uniform color is obtained but no longer than 15 minutes before pouring into the mold. Scrape the container walls and bottom well to insure a thorough mix.
5. If complete absence of bubbles is required place the container into a vacuum chamber and evacuate the entrapped air from the mixture using a vacuum pump capable of achieving 29 inches of mercury vacuum. The mixture will rise, crest and then collapse in the container. Interruption (bumping) of the vacuum may be necessary to prevent overflowing the container. Keep the mixture under full vacuum for 2-3 minutes after the material has receded in the container.
6. Bleed air slowly into the vacuum chamber. When the chamber is at atmospheric equilibrium, remove the cover plate and take out the container.
7. Pour the desired material slowly in a steady stream from one end of the mold box so that the material flows evenly over the pattern. This should minimize entrapment of air bubbles under the flowing material. A "print" coat may be poured first over the pattern which will also help reduce the possibility of entrapping air on the pattern and in the cured rubber. A mold release (petroleum jelly) may be applied on the pattern first to improve release. Not required in ArtFORM™ or Earthium™(f/x) molds.
8. Allow the rubber to cure for at least 1 to 1.5 hours at 70±5°F before removing the cured rubber mold from the pattern. Heat acceleration is not recommended with this product.
9. For best results, allow the mold to air cure an additional 24 hours before using it in production. Full cure is achieved in 3-5 days.

PROCESSING INFORMATION

CATALYZED PROCESSING PROPERTIES ARE AFFECTED BY TEMPERATURE & HUMIDITY VARIATION

1. For best results, mix and cure the material at 65°F and 50% relative humidity.
2. Higher temperature and humidity will decrease the work life and pot life of the material. The faster cure will also affect the flow properties. Refrigeration of the base prior to use-in hot environments has shown to improve the handling properties of this material.
3. Lower temperatures and humidity will increase the work life and pot life of the material. The slower cure will increase the flow time. Cure temperatures below 68°F (20°C) are not recommended and have been found to cause a reduction in final cure hardness and properties.
4. It is important that the catalyst containers are tightly closed after use. Catalyst exposed to air for extended periods of time will hydrolyze (cure). An indication of hydrolysis is a film or! crust formation on the surface of the catalyst. The use of hydrolyzed catalyst is not recommended and may cause incomplete cure.

SAFETY PRECAUTIONS – USE AT YOUR OWN RISK!

USE MATERIAL IN ACCORDANCE WITH MATERIAL SAFETY DATA SHEET

This rubber system uses an organometallic tin catalyst which may irritate or bum skin and eyes upon contact. If eye contact occurs, flushing with water for at least 15 minutes should relieve discomfort. If irritation or discomfort persists, obtain medical attention.

- KEEP PRODUCT AWAY FROM CHILDREN. Contact MSW Creative to obtain an MSDS for this product.
- FOR TECHNICAL ASSISTANCE ON THIS PRODUCT AND OTHER MSW CREATIVE PRODUCTS, CONTACT CUSTOMER SERVICE VIA OUR WEB SITE: www.lifecast.net