

Silicone Rubber Kits – Basic Instructions

The MBFG range of silicones is a group of quality silicone-moulding compounds developed to give the maximum economy in terms of price while maintaining and providing high quality reproduction, long mould life, very low shrinkage and no risk of the sating material gripping the mould surface.

Our Silicone has been formulated for easy mixing by hand, with colour coded components giving a visual aid to ensure mixing is adequate. The two components mix easily and because of the low viscosity most grades can be used without processing in a vacuum chamber.

HOW TO USE - Always weight the silicone and catalyst precisely before mixing otherwise the silicone may not cure. This allows for any discrepancies that may occur.

Preparation

The surface of the original should be clean and free of any dust or loose material. If necessary, particularly with porous surfaces, a suitable release agent such a petrogel or a spray wax should be used.

Mixing

Mix Ratio 100:10 by weight

Pour the orange Curing Agent on to the white base in its own container and gently mix and fold the two components together avoiding as much air entrapment as possible. As the mixed material becomes more intermixed you can employ more vigour until a uniform "Salmon Pink" colour is obtained. Pay particular attention to the sides and base of container. When you are sure that the mix is uniformly blended pour the contents into another clean container and re-mix. This is the only way to ensure that the material is thoroughly mixed.

Pouring

The silicone can now be gently poured at lowest point into the mould box in ensuring that any of the air bubbles burst over the squashed rim until the level of the liquid in box has risen sufficiently over the master models highest point. During this process it is advisable to pour the mixed material in a long streaky stream which also helps in bursting air bubbles introduced during mixing.

Care of Moulds

Which casting polyester resin into silicone moulds, styrene attack can be minimised, by leaving the moulds open for as long as possible between casts to allow free styrene to evaporate. To achieve maximum mould life with polyester resin it is advisable to first allow the moulds to fully cure after pouring for approximately 5-7 days before casting into them. The moulds can however be used immediately after de-moulding for plaster casting.

Cured Properties of MBFG Silicone

Colour	Salmon Pink
Mix Ratio	100:10
Working Time Mins	40-60
De-Mould Time Hrs	12-14
Mixed Viscosity mPas	18000
Hardness Shore A	27
Tensile Strength Mpa	3.0
Elongation @ Break %	520
Tear Strength kN/m	23
S.G	1.18
Linear Shrinkage %	0.2-0.4