

## Technical Bulletin | **Magikmold® Silicone Putty Series**

### DESCRIPTION

The Magikmold® Silicone Putty Series is a line of easy-to-use, platinum-cure silicone putties designed for the manufacture of simple, but detailed flexible molds.

These putties offer easy 1A:1B mix ratios and cure quickly at room temperature. Putties are great for small to medium-scale mold making projects, including hobby and craft, model making, and some architectural restoration projects.

### PRODUCT OPTIONS | PHYSICAL PROPERTIES

Magikmold® Product	Magikmold® SP-250 Pink Silicone Putty	Magikmold® SP-450 Blue Silicone Putty
Type	Platinum-cure (addition-cure)	Platinum-cure (addition-cure)
Mix Ratio by Volume	1 Part A : 1 Part B	1 Part A : 1 Part B
Shore Hardness	A25	A50
Working Time	~4 min.	~15 min.
Demold Time @ 73°F	~30 min.	~1-2 hr.
Cured Color	Pink	Blue
Tensile Strength	202 psi	200 psi
Elongation	605%	100%
Tear Strength	19 pli	35 pli
Specific Gravity	1.24	1.20

### PREPARE THE ORIGINAL MODEL

Magikmold® Silicone Putties are self-releasing and do not stick to many surfaces; however, a small test cure is always recommended prior to completing a full-scale project. Some very porous models may need to be sealed prior to mold making; these models can be sealed with wax, petroleum jelly, PVA, and some lacquers and paints. Some non-porous model surfaces (e.g. metals and glass) may need to be sprayed or brushed with a suitable release agent.

Do not use silicone-based release agents on surfaces that contact liquid silicone rubbers since inhibition and/or adhesion may occur.

### CURE INHIBITION

Contamination from amines, sulfur, tin compounds, polyester resins, some paints and some silicone rubbers may inhibit surface cure of this product. Perform a test cure on an identical surface to determine that complete curing and good release are obtained.

DO NOT wear latex rubber gloves when handling this product - cure inhibition may occur.

### MIX & CURE

Before use, be sure that Parts A and B are at room temperature (~73°F) and that all tools are ready. All mixing and curing should be done in room temperature conditions. Mix ratio by volume is 1 Part A : 1 Part B. While wearing vinyl or nitrile gloves, combine proper

amounts of Part A and Part B and then fold and knead the two components by hand until a uniform color is reached and there are no visible streaks.

Once thoroughly mixed, apply the putty to a properly prepared model and allow it to cure. Refer to individual product labels or the “Product Options | Physical Properties” section above for the demold times of each putty. At room temperature (~73°F), this rubber cures to full hardness in the specified demold time. At higher temperatures, they cure faster. At lower temperatures, more time may be needed to reach full hardness.

## **CASTING IN MAGIKMOLD® SILICONE PUTTY MOLDS**

Release agent is not necessary for casting most materials into Magikmold® Putty molds, but for longer mold life with epoxy, polyurethane or polyester resins, a barrier coat or release agent (e.g., Stoner E-236 Urethane Mold Release) is recommended.

## **SHELF LIFE**

This product will remain useful for six months from the date of shipment when stored in the original, unopened containers at room temperature (60-90°F).

## **CLEAN UP**

Tools should be wiped clean before the rubber cures. Denatured ethanol is a good cleaning solvent, but it must be handled with extreme caution owing to its flammability and health hazards.

## **SAFETY**

Before use, read products labels and Safety Data Sheets. Follow safety precautions and directions. Avoid contact with eyes and mucous membranes. Best method of cleanup is by wiping with paper towels and washing with waterless hand cleaner, then soap and water.

## **DISCLAIMER**

The information in this bulletin and otherwise provided by Raw Material Suppliers is considered accurate. However, no warranty is expressed or implied regarding the accuracy of the data, the results to be obtained by the use thereof, or that any such use will not infringe any patent. Before using, the user shall determine the suitability of the product for the intended use and user assumes all risk and liability whatsoever in connection therewith.