



Mold Max® 60

Condensation Cure Silicone Rubber Compound

PRODUCT OVERVIEW

Mold Max® 60 is a Shore 60A tin catalyzed silicone rubber formulated for applications requiring high heat resistance (up to 560°F/294°C). It features a low mixed viscosity and cured rubber exhibits very low linear shrinkage. Parts A & B are mixed 100A & 3B by weight. Pot life is 40 minutes and cure time is 24 hours.

Applications include making foundry patterns, flat pattern reproductions and casting melt metal alloys such as tin and pewter.

TECHNICAL REVIEW

Shore A	Mix Ratio By Weight	Color	Specific Volume	Specific Gravity	Mixed Viscosity	Die B Tear Strength	Elongation At Break	Tensile Strength	100% Modulus	Shrinkage*	
Mold Max 60	60	100A:3B	Red	19.1	1.45	20,000 cps	63 pli	132%	398 psi	331 psi	.0015 in./in.*

~Pot Life: 40 Minutes

~Cure Time/Demold: 24 hrs. (optional: follow with postcure)

*Shrinkage measured at 7 days

Useful Temperature Range: -65°F to 560°F (-19°C to 294°C)

Dielectric Constant, 100 Hz: 3.4

Volume Resistivity, ohms-cm: 9×10^{14}

Dielectric Strength, volts/mil: >500

Dissipation Factor, 100 Hz: 0.02

Thermal Conductivity: 0.21

PREPARATION TIPS

Applying A Sealer / Release Agent . . . Materials should be stored and used in at room temperature (73°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. 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 and used in a warm environment (72° F / 22°C). Store material where temperature does not exceed 75°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. 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 (100 parts A to 3 parts B by weight), **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 expansion.

Pouring

Curing

Mold 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 24 hours) at room temperature (77°F/25°C) before demolding. **Post curing the mold an additional 4 - 5 hours at 125°F (51°C)** will eliminate any residual moisture and alcohol that is a by-product of the condensation reaction. This water and alcohol can inhibit the cure of some casting resins. Allow mold to cool to room temperature before using. Do not cure rubber where temperature is less than 65°F /18°C.

Decreasing demold time with **Accel-T® Silicone Cure Accelerator:**

Important: Thoroughly Pre-mix Accel T® with Part B before adding Part A. Be aware that the working time is drastically reduced with the addition of Accel T®. Also, library life of cured rubber is reduced in proportion to the amount of Accel-T® added.

Accel-T® added by weight To Part "B"	~Pot Life in minutes	~Demold time in hours
0.2%	20	3
0.6%	5	2
1.0%	3	1

Silicone Thinner will 1) lower mixed viscosity which means that the rubber will de-air faster when vacuuming and 2) lower the ultimate shore hardness (durometer) of cured silicone rubber. Physical properties will also be lower. See the Silicone Thinner technical bulletin (available from Smooth-On or your Smooth-On Distributor) for full details.

*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.*

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