duglasil®

Instructions for use

Elastomeric vinylpolysiloxane, low viscosity,
silanaddition-system, 2 components (1:1) with platinum catalyst

Especially recommended for fabrication of clear-transparent forms, also for photo-plastics - the forms are UVA-light translucent.

Application: at approx. 23 °C/73 °F, 50% ± 5% rel. humidity

Colour code: Components A + B: transparent

Final hardness: approx. 15 shore A

Application: **There are various possibilities to mix A + B components with a ratio of 1:1:**

1) Using a silicone mixing device: Place the containers (1 l or 5 l) onto the mixing device. Mount a mixing cannula; mixing and bubblefree dosing are set going by push-botton. During filling of the investing form, cannula tip should stay immersed at the bottom of the form.
Hint: Using 5 l canisters, connecting tubes for the respective silicone mixing device are required.

2) Use of a double cartridge with inject dispenser: Remove the closure cap from the cartridge and mount the static mixing cannula. By pressing the dispenser handle, both components will be mixed uniformely and bubblefree. To avoid air bubbles during injection into the form, hold mixing cannula immersed at the bottom of the form.

3) Manual mixing: Mix the components in a mixing bowl by means of a spatula. To achieve a transparent bubblefree negative form, after filling of the silicone the filled investing form must be polymerized in a pressure pot at 2 - 6 bar and 20 - 30 °C / 68 - 86 °F warm water for approx. 12 - 15 minutes. (Caution: prevent the water from reaching the silicone surface!)

4) Mixing in a vaccum-mixer: Both components are mixed under vacuum. Cast the bubblefree material slowly into the tilted investing form.

Please note: To remove air inclusions (e.g. formed during transportation) place the open containers into a drying cabinet at up to 60 °C/140 °F for approx. 12 hours.

Setting time: approx. 12 - 15 minutes in a pressure pot
approx. 25 - 30 minutes at room temperature

Caution: Prevent the components A + B from contacting with one another before mixing. Do not interchange lids. Cured materials are chemically inert - spots on clothing should be avoided.

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