Specialty Resins
2612 Kersten Court, Kalamazoo MI 49048
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TECHNICAL DATA SHEET

CAST-A-MOLD 30T

Cast-A-Mold 30TF is faster and slightly harder than the Cast-A-Mold 25T. It is a general purpose rtv silicone elastomer which exhibits excellent tear strength, long library life, and accurate detail reproduction. Cast-A-Mold 30TF is a condensation cured silicone (tin catalyzed) It is used to make rubber molds that can be used to cast polyurethanes, epoxy's, polyester's, cement, concrete, soap, wax, plaster, etc.. It is easy to mix and de-air, and will cure at room temperature over virtually any surface. Cast-A-Mold 30TF is extremely useful for applications where superior physical properties are required.

PRODUCT SPECIFICATIONS	
Mix Ratio	10 Base :1 Activator by weight
Working Time	15.0 minutes
Demold Time	8 hours
Heat Deflection	300°F +
Tensile Strength	600 psi
Elongation	500%
Tear Resistance	150 ppi
Color	Blue
Hardness	30-A
Viscosity	30,000 cps

BEFORE USE: Thoroughly read Safety Data Sheets, product labels and the “SAFETY” section in this Technical Data Sheet.

IMPORTANT: PLEASE NOTE

- It is critical that your frame or mold is watertight. Frames should be built out of material that can easily dissipate heat.
- Curing may be inhibited by certain contaminants resulting in tackiness on the surface of the mold. Latex, sulfur based clays, tin cured silicone rubber, amines, nitriles, organo-metallic salt containing compounds should be avoided. If you are unsure of the compatibility of the substrate being molded a small test is recommended. To prevent inhibition it is usually helpful to coat the pattern with a clear acrylic lacquer or paint. Do not use polyurethane or latex.

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- This product should not be poured directly over an oil-based paint or stain. There should be a definitive barrier between the two products. We suggest applying a water-based clear coat over the oil-based product.
- This product can be mixed with pigment powders and liquid dyes to achieve your desired color. Do not mix any oil or water-based products with the resin. When in doubt, test a sample batch to ensure you can achieve your desired color without issues.
- Storing unused product– Unmixed resin & hardener have a long shelf life of 1 year. Store in original containers in a cool, dry place. Over time, the unused material may yellow/amber as expected with most epoxies.

BEFORE YOU BEGIN

Work Environment: The ideal working temperature is around 65-75°F in a clean, dry, dust-free environment. We highly recommend keeping fans on your project to help dissipate heat.

Coverage: You can use the coverage calculator on our website to determine the volume of mixed resin that you will need before you begin your project. Please remember, this is not an exact science, as each project is different and each substrate will absorb the product differently. As the product fills the cracks and crevices in your mold, the level may drop. Be prepared to add more as needed. The calculator does not take into account embedded objects. It is always best to have more than enough material on hand to ensure completion of your project.

Release Agent: A release agent may be necessary when working with a porous surface or object. Some surfaces may contain both air and moisture that can contaminate the finish. We suggest applying a thin coat as a seal coat. Other water-based clear coats may also be used.

Materials: Be prepared with all necessary materials and tools before beginning your project. These items might include graduated mixing containers, clean stir sticks or power mixer, gloves, drop cloth, casting molds, cleaners, etc.

LET'S GET STARTED: MIXING & POURING

Step 1: Prepare 10 parts Base and 1 part Activator by weight. Pour the activator first and then the base into a clean, smooth-sided container large enough to hold all of the liquid, allowing room for mixing without spillage. Use graduated mixing containers help to ensure properly measured amounts of Part A and B. Any variance in this mix ratio may result in curing issues.

Step 2: The material must be mixed thoroughly for 3-5 minutes. Be sure to scrape the sides, corners and bottom of container as you mix.

Step 3: Apply a release agent if the object doesn't have a glossy surface. Pour the mixture into the mold or onto surface of object in a thin stream, which prevents bubbles from getting trapped.

Step 4: To remove air bubbles, jiggle/vibrate the mold and/or use heat (i.e. heat gun, space heater, or oven) as it will force the bubbles to the surface and out of the mold.

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Step 5: Curing times can vary greatly by project, depending on mass and temperature. Demold time is 8 hours. Do not demold prematurely.

Step 6 (optional): If you are going to make a second pour, the first pour should be firm but tacky.

CLEAN UP & DISPOSAL

Tools can be cleaned with Isopropyl Alcohol or a residue-free cleaner. Do not use soap and water.

Dispose of product and container according to Federal, State and local regulations. Store any remaining product in the original bottles, tightly sealed and locked up in a cool, dry environment.

SAFETY

Safety: Before use, thoroughly read Safety Data Sheets and product labels. Follow safety precautions and directions.

Base: Keep out of reach of children. Avoid breathing vapors. Use with adequate general or local exhaust ventilation to minimize exposure levels. If needed, a NIOSH-approved respirator with organic vapor cartridge may be used. If inhaled, remove victim to fresh air and keep at rest in a position comfortable for breathing. Wear impervious gloves, such as butyl rubber or nitrile rubber. Wash skin thoroughly with soap and water after handling. Take off contaminated clothing and wash it before reuse. If skin irritation occurs, get medical help. Wear eye protection, such as chemical safety glasses/googles. If in eyes, rinse cautiously with water for several minutes, removing contact lenses if present and easy to do. If eye irritation persists, get medical help.

Activator: Keep out of reach of children. Do not eat, drink, or smoke when using this product. If swallowed, rinse mouth and get medical help. Use with adequate general or local exhaust ventilation to minimize exposure levels. If needed, a NIOSH-approved respirator with organic vapor cartridge may be used. If inhaled, remove victim to fresh air and keep at rest in a position comfortable for breathing. Wear impervious gloves, such as butyl rubber or nitrile rubber. Wash skin thoroughly with soap and water after handling. Wear eye protection, such as chemical safety glasses/googles. If in eyes, immediately rinse with water for several minutes, removing contact lenses if present and easy to do. If eye irritation persists, get medical help.

WARNING: THE CURE REACTION IS EXOTHERMIC. Do not apply in thicknesses greater than the recommended maximum application thickness for the product.

DISCLAIMER: The information contained herein is considered accurate; however, Specialty Resins makes no warranty regarding its accuracy. The user must determine the suitability of the product for the intended use and accepts all risk and liability associated with that use.