Specialty Resins
2612 Kersten Court, Kalamazoo MI 49048
Phone: (269) 462-9256
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TECHNICAL DATA SHEET

MOLD DOUGH 30P

Mold Dough 30P is a quick and easy 2 part silicone mold putty that allows you to make a mold in less than 20 minutes. Simply mix equal amounts of the yellow and white putty together by hand until a uniform color is achieved, then press it onto the item to be molded. It will then cure to a flexible rubber mold and will reproduce the exact details of the original piece. Mold Dough 30P complies with FDA standards and is an excellent mold making material for chocolate, sugar, fondant, polymer clay, resin, soap, wax, plaster, and much more. It is also highly recommended for art classes as the demold time, ease of use, and quick/accurate/flexible mold allows you to mold and be ready to cast in less than 20 minutes.

PRODUCT SPECIFICATIONS	
Mix Ratio by weight or volume	1 : 1
Work Time (100 gram mass)	3 minutes
Viscosity	Putty
Demold Time	15-20 minutes
Full Cure Time	20 minutes
Hardness, (ASTM D-2240) Shore A	25-30A
Tensile Strength (ASTM D-638) (psi)	81
Elongation (in/in) 626%	530%
Die T Tear Srength (pli)	26
Color	Beige
Shelf Life	1 year

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

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IMPORTANT: PLEASE NOTE

- Mold Dough 30Pcomplies with FDA 21 CFF 177.2600 and can be used safely in contact with food. Molds intended for food use to only be used for food and no other casting.
- Mold release is required when pouring against another silicone if you do not want the two to bond, as when making two-piece molds. Use mold release or a thin layer of Vaseline are adequate for this application. Avoid contact with all porous materials such as fabric, clothing, carpet, and other non-sealed materials as the silicone will bond itself to these materials. Make sure your master is fastened securely to your mold base to prevent it from floating.
- Your master must have a high gloss surface to produce a see through/glossy appearance identical to your casting. If the surface of your master has a matte finish, your clear casting will too.
- Mold Dough 30P as well as all other platinum base silicones are susceptible to Inhibition. Inhibition is when the material comes in contact with certain materials and fails to cure (remains wet … never hardens) whereas the rest of the material not in contact with the certain materials will cure absolutely fine. These materials will act like a poison and not allow the Platinum base silicone to cure. Materials consisting of or that are known to inhibit platinum base silicones are: tin or amine cured resins, vinyl (duct tape, pvc, etc), sulphur (clays), cyanoacrylates (super glue), latex, neoprene, Buna N, and natural rubbers (rubber stamps). Whenever you are in question and are not 100% sure the material you are pouring is compatible, it is recommended to test in a small area prior to making your entire mold. Simply mix up a small amount of Mold Dough 30P and press it over the area/substrate in question to make sure it cures completely. If the Mold Dough 30P inhibits, the detail will smear and the putty will not harden on the surface of the mold in those areas.

BEFORE YOU BEGIN

Work Environment: The ideal working temperature is around 65-75°F in a clean, dry, dust-free environment. The more humid and warmer the environment is, the faster your silicone will cure. Temperature alone will not accelerate the cure of Mold Dough 30P or any other platinum-based silicone. Moisture/humidity is also required.

Coverage: Take one side of the putty and pretend to cover half of your original up with the thickness you desire in your mold. Once you have half of the master completely covered (don't need to actually press it on … just hold or lay over the top to get an approximate volume of putty), roll the putty into a ball and measure out an equal amount of the other side of the putty.

Materials: Be prepared with all necessary materials and tools before beginning your project.

• Stir-sticks
• Molds for artistic creation
• Misc. handling tools – X-acto knife, spatulas, pliers, a drill or Dremel tool, heat gun, etc.

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MIXING

When measuring for use, stick with the recommended ratios and blend just what you think you'll need. Once mixed, leftover mixed material can't be saved. Depending upon the ambient conditions (temperature & humidity) – you'll have about 15-20 minutes.

Step 1: The mix ratio of Mold Dough 30P is 1:1 by volume or weight. Measure side A and side B, then knead the two thoroughly in less than a minute. Press while rolling to eliminate all of the creases.

Step 2: After the materials have been combined, roll the mixed putty into a ball and press while rolling to eliminate all of the creases.

Step 3: Starting from the highest point, lay the mixed putty ball on the master and roll the ball around the master. Rolling the putty around the master will roll the putty into the detail of your master rather than simply pressing the master into the putty in which the detail may drag or smear. Continue rolling the putty around the master until you have achieved the desired depth of your mold.

CLEAN UP & DISPOSAL

Life expectancy is a variable of many different factors including but not limited to the type of resin being used in the mold, the length of time the resin is in the mold, the exotherm of the resin, cycle times, the design of the part, the intricacies of the detail, the force needed to demold, etc. Even with all of these factors, there are some things you can do to get the most life out of your molds. In no order, here are some popular ways to extend the life of your molds:

• If a release is needed for a food application, a food grade release such as Pam cooking spray should be used.
• Avoid leaving castings in the molds any longer than needed.
• Allow molds time to cool from peak resin exotherms before pouring the next part.
• Use Silicone Oil to condition molds whenever you stop production for a day or two as well as condition molds with Silicone Oil before storing for periods of time.
• Integrate a bake-out process of 400-degrees for 2-hours and allow to cool back down before running more parts every 25% of the expected mold life (this process will draw silicone oil back to the surface of your mold rejuvenating what has been lost or depleted from the casting process).

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.
• Wear gloves
• Safety glasses or
• Protect clothing with a work smock or other outer garment

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• For cleaning surfaces, containers – use Acetone, rubbing alcohol or nail polish remover
• store in a cool dry area in tightly sealed containers

Part A: Keep out of reach of children. 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.

Part B: Keep out of reach of children. Do not eat, drink, or smoke when using this product. If swallowed, rinse mouth and get medical help. 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.

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.