



SILICONE MOLDING SYSTEMS

The Products

Sil-Mold® SI-12

Because Sil-Mold® SI-12 cures to a soft (Shore A12 ± 2), yellow rubber, it is ideal for making molds of detailed masters with deep undercuts. Sil-Mold SI-12 is mixed ten-to-one by weight, does not require a separate release agent, and is a tin-cure (or condensation-cure) system.

Sil-Mold® SI-25

Sil-Mold® SI-25 is a tin-cure (or condensation-cure) silicone molding system designed for reproducing detailed masters that contain some undercuts. SI-25 is mixed ten-to-one by weight, cures to a medium-soft (Shore A25 ± 2), blue rubber, and is self-releasing.

Sil-Mold® SI-30

Sil-Mold® SI-30 is designed as a **variable hardness rubber** with high strength properties, long library life, excellent detail reproduction, excellent release characteristics, and improved resistance to inhibition. SI-30 is mixed ten-to-one by weight, cures to a medium-soft (Shore A33), blue rubber.

Physical Properties of Silicone Molding Products

Property	SI-12	SI-25	SI-30
Shore A Hardness	12 ± 2	25 ± 2	33
Specific Gravity (Cured Elastomer)	1.11	1.11	1.3
Ultimate Tensile, PSI	551	720	650
Elongation, %	450	425	500
Mix Ratio by Weight (Base:Catalyst)	10:1	10:1	10:1
Mix Ratio by Volume (Base:Catalyst)	N/A	N/A	N/A
Resin Shelf Life (Months)	6	6	24
Pot Life*	2-4 hours	3-5 hours	1 hour 40 minutes
Gel Time* (Hours)	1	1	TBD
Cure Temperature	70° F (21° C)	70° F (21° C)	75±5°F (24°C)
Cure Time* (Hours)	24	24	24

*Pot life, gel time, and cure time will vary with mass and the temperature of the components.

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