OOMOO™ 25 & 30

1A:1B Mix By Volume Silicone Rubber

PRODUCT OVERVIEW

No Vacuuming – No Scale – Stupid Name . . Introducing New! OOMOO™ 25 & 30. OOMOO™ 25 & 30 are easy to use silicone rubber compounds that feature convenient one-to-one by volume mix ratios (no scale necessary). Both have very low viscosity for easy mixing and pouring, and **vacuum degassing is not necessary.** Both products cures at room temperature with negligible shrinkage. **OOMOO™ 30** has a 30-minute pot life, with a six-hour cure time. **OOMOO™ 25** is a faster version, with a 15-minute pot life and 75 minute cure time. **For The Novice Mold Maker** - OOMOO silicones do not have great tear strength. They are good for making simple one- or two-piece block molds. If you require a high-tear strength silicone, Mold Max™ silicones are recommended (contact SMOOTH-ON for more information).

OOMOO™ 25 & 30 are suitable for a variety of art-related and industrial applications including making molds for sculpture and prototype reproduction, casting plaster, resins and wax.

TECHNICAL OVERVIEW

Key Values: ***~Mixing Ratio****:* One to One by volume (100A:130B by weight) ***~Shore A Harnesses:*** 25 & 30
~ Pot Life*:* OOMOO 25 –15 min. / OOMOO 30 – 30 min. ***~Demold:*** OOMOO 25 – 75 min. / OOMOO 30 – 6 Hours.
~Color*:* OOMOO™ 25: Light Blue / OOMOO™ 30: Lavender

Properties	Viscosity	G/CC	Cu. In./Lb.	Tensile Strength	Mix Ratio
Part A	-	-	-	-	100 pbv / 100 pbw
Part B	-	-	-	-	100 pbv or 130pbw
Mixed	4,250 cps	1.34	20.6	240 psi	-

Elongation At Break . . . 250% Die C Tear Strength . . . 40 pli Compression Set . . . 37%
Tensile Strength . . . . . 240 psi Shrinkage . . . . . .0025 in./in

Cure Inhibition - Materials should be stored and used in a warm environment (72° F / 23° C). Store material where temperature does not exceed 75°F / 23°C. Silicone rubber may be inhibited by certain contaminants in or on the pattern to be molded, 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.

Materials found to cause cure inhibition include sulfur-based modeling clays and latex rubber. **To prevent inhibition**, a "barrier coat" of clear acrylic lacquer sprayed directly onto the pattern is usually effective.

Applying A Release Agent . . . A release agent will make demolding easier when casting into or over most surfaces. **Options:** **Sonite™ Paste Wax** will work well with all silicone rubbers. Brush-on a **thin layer** to model surface (be sure to eliminate any brush strokes) and let dry. Ease Release 200™ is a proven release agent for making molds with silicone rubber. **~IMPORTANT**: To ensure thorough coverage, lightly brush the release agent with a soft brush over all surfaces of the model. Follow with a light mist coating and let the release agent dry for 10 minutes.

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. Also, you can **call Smooth-On for technical assistance at (800) 762-0744 or (610) 252-5800.**

Measuring & Mixing . . . *Pouring . . .*

After dispensing equal amounts of Parts A and B into mixing container, **mix thoroughly for 3 minutes** making sure that you **scrape the sides and bottom of the mixing container several times**.

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 *Mold Performance*

Curing . . . Allow to cure as prescribed (75 minutes for OOMOO 25 and 6 hours for OOMOO 30) 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 which is a by product of the condensation reaction. Allow mold to cool to room temperature before using. Do not cure rubber where temperature is less than 65°F /18°C.

Using The Mold . . . When first cast, silicone rubber molds exhibit natural release characteristics. Depending on what is being cast into the mold, mold lubricity may be depleted over time and parts will begin to stick. No release agent is necessary when casting wax or gypsum. Applying a release agent (Universal Mold Release or Ease Release) prior to casting polyurethane, polyester and epoxy resins is recommended to prevent mold degradation.

Mold Performance & Storage. . . The physical life of the mold depends on how you use it (materials cast, frequency, etc.). Casting abrasive materials such as concrete will quickly erode mold detail, while casting non-abrasive materials (wax) will not affect mold detail. Before storing, the mold should be cleaned with a soap solution and wiped fully dry. Two part (or more) molds should be assembled. Molds should be stored on a level surface in a cool, dry environment. **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.**

Safety First

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.

Smooth-On offers a complete line of *Liquid Rubber, Liquid Plastic* and *Release Agent* products for hundreds of industrial and art related applications.
Feel free to call or fax us any time with your questions.
Chances are there is a distributor in your area to offer local support.

Toll-free: (800) 762-0744 ***Fax: (610) 252-6200*** ***Website: www.smooth-on.com***