

CopyFlex®

CopyFlex® is a food grade liquid silicone rubber that was designed specifically for mold making. Unlike many liquid silicones that have complicated mix ratios and very thick consistencies, CopyFlex® is easy to use because equal amounts of both catalyst and base are combined to produce a silky smooth, low viscosity liquid silicone rubber that reproduces the finest details. A 1:1 mix ratio is very convenient for large projects and also enables mold makers to easily pour molds that may weigh as little as two ounces. Conventional liquid silicone mold making rubber often has a demold time of 24 to 36 hours, which is very long compared to CopyFlex, with a demold time of approximately 4 hours at 70 degrees F.

Simple and Easy to Use!



Step 1

Apply Mold-Dit™ to the back side of the original and press it down into the center of the mold box. Mold-Dit™ should squish out under the edges, ensuring that a strong yet temporary bond has been established and that no silicone will creep underneath. With the excess Mold-Dit™ removed, the mold box is ready to receive the CopyFlex® liquid.

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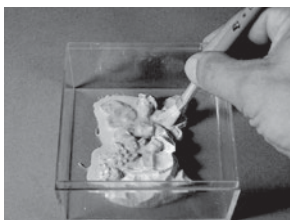
Step 2

Mix a small amount of CopyFlex® liquid silicone rubber - just enough to paint a thin coat over the object. Work it into small details to ensure air bubbles do not get trapped on the surface.



Step 3

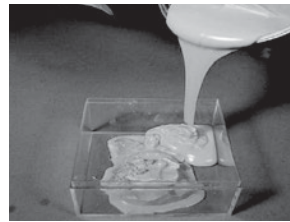
Scale out equal parts of A and B by weight. Combine the two parts in a container and mix thoroughly until the color is uniform with no streaks. Scrape the sides and bottoms to ensure no unmixed material remains.



Step 4

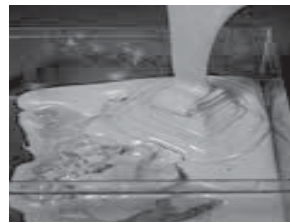
Using a natural bristle artist brush, paint a thin coat of CopyFlex® onto the original. The idea is not to completely cover the object, but to work the silicone into the details. This is called a "skim coat" and it ensures that no air

bubbles will be trapped in the nooks and crannies of the surface.



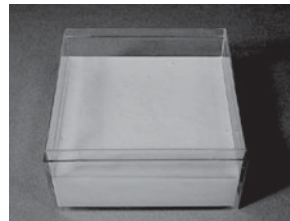
Step 5

Once the skim coat is applied, a larger batch of CopyFlex® silicone rubber is prepared and poured to fill the mold box at the 1/4" above the highest point on the original.



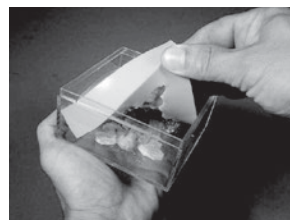
Step 6

CopyFlex® should be poured in one spot from a height of about 12" above the original, which allows the material to stretch as it falls. This "stretch pour" helps eliminate any air that was incorporated into the liquid silicone during mixing.



Step 7

Allow CopyFlex® to slowly creep over the original until it is covered completely.



Step 8

Your CopyFlex® mold will be ready to demold in about four hours. The best way to check if it is ready to demold is to press the edge of a coin into the surface to see if it leaves an imprint. CopyFlex® that is ready

to demold will spring back with no noticeable imprint.

Important! Mold Making Guidelines:

- Wash and dry your hands before working with CopyFlex®. In addition to good hygiene, washing hydrates dry skin and prevents CopyFlex® from sticking to your hands.
- When making molds for food, all mold making materials and objects to be duplicated should be non-toxic and/or food grade. Do not use a food mold to make non-food items. You can always make another mold from materials such as plaster, casting resins and clay.
- Some materials inhibit the cure of CopyFlex®. Sulfur (found in many sculpting clays and in latex gloves), adhesives, caulk, and some types of vinyl are common examples that cause problems. When in doubt, test for compatibility by applying a small amount of mold making material and allow to cure before making a mold of the entire piece.
- FDA guidelines state that all newly made molds should be washed after curing and before use. Cured molds can be washed in the dishwasher, or cleaned with soap and hot water. You can even sterilize them in boiling water.
- If you want more time to make a mold, refrigerate parts A and B separately before mixing. Cold CopyFlex® will cure at a slower rate allowing more time for its application onto a large or intricately detailed original.
- CopyFlex® can be used to cast materials at temperatures as high as 400°F and can also be used to freeze foods into a particular shape.
- Once CopyFlex® is cured, it cannot be melted or reformed. A finished CopyFlex® mold is permanent.
- This product has not been designed or tested for baking.

Our silicone mold making materials are food grade and have been tested to assure compliance with FDA 21 CFR 177.2600. However, since we have no control over how our products are used, no warranty is expressed or implied concerning the results obtained from using our silicone mold-making materials.

Safety

Parental supervision is recommended for children under 12. Keep out of reach of children. CopyFlex® should not be eaten. In case of accidental ingestion, do not induce vomiting and call a physician immediately. If skin irritation occurs, remove CopyFlex® from skin and wash with soap and water. Keep CopyFlex® out of eyes. If eye contact occurs, flush with water and call a physician immediately.