



# LIQUID RUBBER

Versatile, Hot-Cast, Low-Adhesion Formulation Used To Create Customized Parts

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## Description

Liquid Rubber is a two-component hot-cast material that is specifically designed for creating customized parts. Its low viscosity – low adhesion properties allow you to mould and mimic existing parts in order to create master moulds with minimal to no shrinkage.

**\*This is not a silicone-based product and does not cure via tin nor platinum.**

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## Features

- Low viscosity
  - Quick curing
  - Can be used with coloured systems
  - Low adhesion
  - Low shore hardness for easy demoulding
  - Minimal – no shrinkage
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## Application

**SHAKE WELL BEFORE USE (PART A + B) !**

Please Note: This material needs to be casted hot ( **55°C – 65°C** ) to avoid bubbles and imperfections !

**Casting Temperature:** Base / Part A = 55°C – 65°C

Curative / Part B = 55°C – 65°C

These temperatures are a guideline and can be increased depending on your experience !

If You Can Heat Up Your Mould, That's A Bonus - Mould Temperature: **40°C – 50°C**

1. Ensure that your mixing container and mixer are perfectly clean. A mixing container that is 50% bigger than the desired pour volume is recommended to avoid spillage
2. Apply DTECC's Liquid release agent to the mould for an easy release after curing.

3. Measure out part A then add any colourants and mix thoroughly until no streaks or clear liquid is visible.
4. Measuring component, A and B precisely, add part B. Variations to mix ratio may cause incomplete curing. The mix ratio is 7:3 (A:B) by weight.
5. Thoroughly mix the liquid components for about 2 - 3 minutes. Scrape the sides of the mixing container every few seconds.
6. Pour the mixed product into the mould. Do not scrape the sides of the mixing container as this may result in uncured spots in your final casting.
7. Use a heat gun or butane torch to pop any bubbles that rise to the surface after 2 – 3min of casting.
8. Cover the product so that dust and other debris don't settle on the surface as it is curing.
9. The product can be demoulded after 5 hours – full cure is 1 day when cured at ambient conditions around 25 °C.

Use the times given as a rough estimate, any difference in temperature will cause these times to differ ... Just take your time and use a Scriber or Toothpick to check the surface and flame when it's starting to cure to avoid an unfinished surface. ( This is due to the material curing very quickly )

## PART A & B PROPERTIES & PROCEDURE

Part A – Will become very thick under 25°C, a simple water bath or leaving the bottle in the sun for a few minutes will liquify it quite quickly.

Part B – Ensure you wipe off excess liquid when closing the lid as this will crystalize and fall into your curative when opening it up again.

\* Please note that **Clear Casts** will slightly darken ( Receive A Brownish Tint ) over time ... this is normal and will not affect any of the physical properties. **Coloured Casts** will darken if left in the sun !

Vacuum degassing mixed material using a vacuum pump and chamber to remove entrapped air is recommended ... Make sure to warm the material up ( approx. 50°C ) before doing so. Once degassing is completed let the material cool back down to operating temperature before casting !

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### Specifications

Property	Unit	Component A	Component B
Mix ratio by weight		7	3

<b>Mixed Properties</b>			
Pot life (60 g) @ 50°C	Minutes	5 - 7	
Demould cure time @ 25 °C	Hours	5	
Full cure time @25 °C	Days	1	
Hardness	Shore A	35 - 40	
<b>Packaging</b>		A	B
1 Kg Kit		0.70 g	0.30 g
6 Kg Kit		4.20 Kg	1.80 Kg
<b>6 Kg+</b>	<b>Contact</b>	<a href="mailto:info@dtecc.co.za">info@dtecc.co.za</a>	

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