

FILLING PHASE



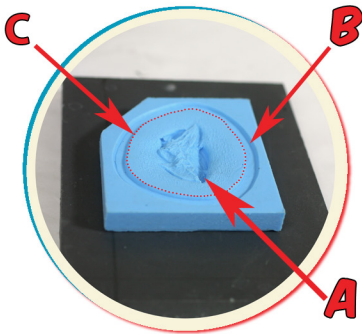
STEP 1: Materials

To begin, you'll need PTM™, tongue depressors, scissors, PTM™ release film, a Hi-Ro Slip™ silicone mold, a flat (preferably freezable) slab and a freezer.



STEP 2: Identify the parts of your mold

Get familiar with your mold and the terminology we use to describe the different parts of your mold.



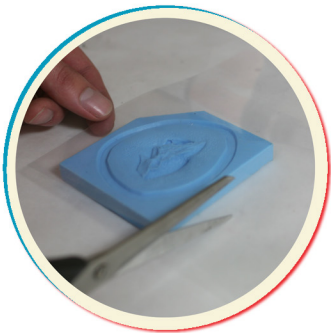
A: Cavity - The deepest point(s) of a mold which becomes the highest point(s) of your transfer.

B: Flashing Trench - The border surrounding the cavity that helps capture excess PTM™.

C: Cutting Edge - The edge dividing the cavity from the flashing trench. Contact with your release film on the cutting edge will create a blending edge.

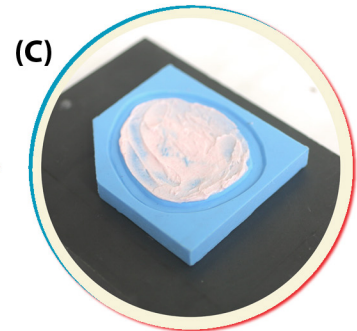
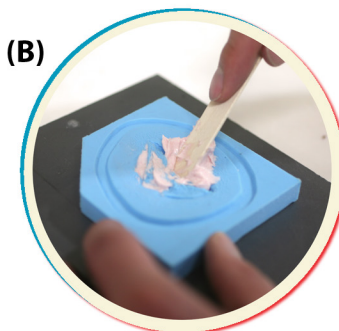
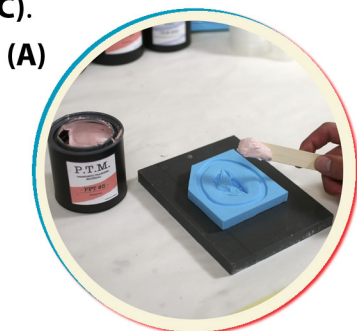
STEP 3: Pre-cut the release film

Cut the clear release film slightly larger than your mold.



STEP 4: Spreading PTM™

Place your mold on your flat slab and begin with a decent amount of PTM™ on a tongue depressor (A). Start by filling the deepest point of the cavity (B). Continue adding PTM™ until you have a nice even layer (C).

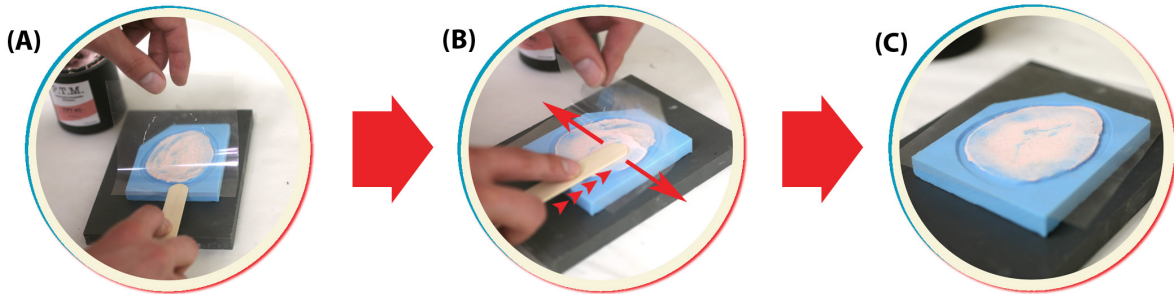


Note: Make sure all cavities are fully filled to their deepest points to eliminate trapped air.

Note: Smooth out your PTM™ like icing on a cake.

STEP 5: Laying the release film

Place the clear release film against one side of your mold (A). Using the flat side of a tongue depressor against the backside of the release film, begin brushing left to right while moving forward, simultaneously (B). Finish laying the release film over your mold and pushing trapped air out until fully covered (C).



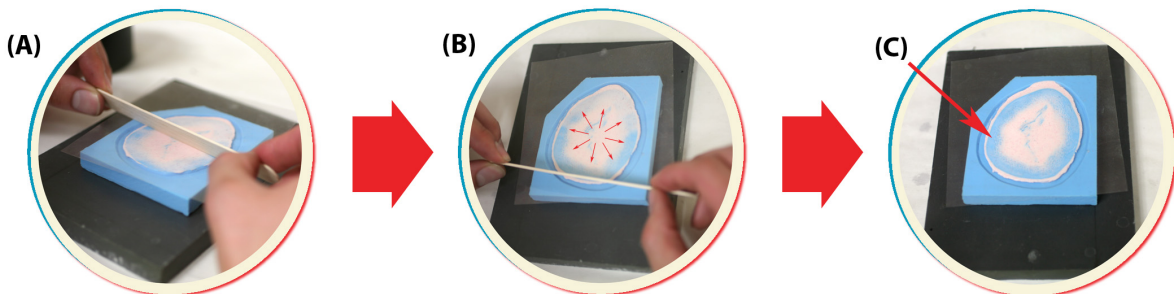
Note: Not too hard! Just enough even pressure to remove excess PTM™.



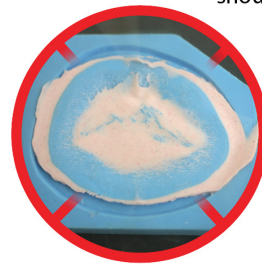
Warning! Too much pressure while laying the release film and not having enough PTM™ can create trapped air and rough edges.

STEP 6: "Squeegee"

Use a tongue depressor like a "squeegee" and always start from the middle of your mold (A). Press down and pull excess PTM™ into your mold's flashing trench (B). Continue to rotate your mold if needed to allow for even distribution of PTM™. This will create a nice transparency (lack of material) around your mold's cutting edge (C).



Note: Your cutting edge should be as thin as possible.



Warning! Too much "squeegee" pressure can affect your finished product and again, create trapped air and an uneven surface. Also, notice the uneven distribution of PTM™ in the flashing trench. Good distribution of PTM™ in the trench will help in the Demolding Phase.

STEP 7: Place your slab with transfer into a freezer for 1-2 hours, depending on transfers size and thickness.

See

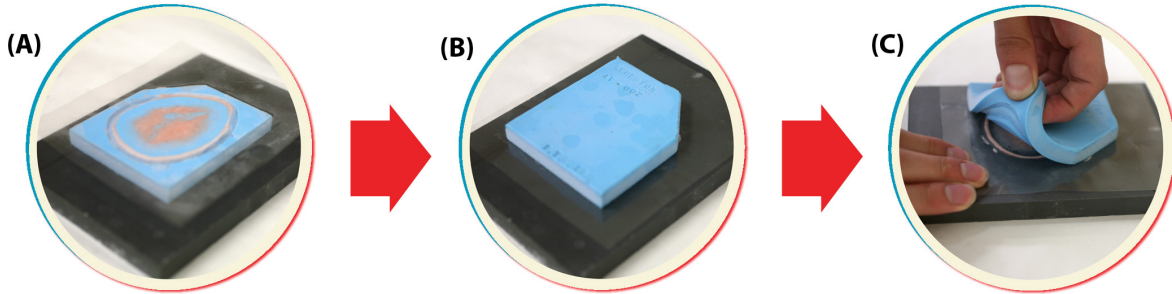
DEMOLDING PHASE

DEMOLDING PHASE



STEP 1: Demold

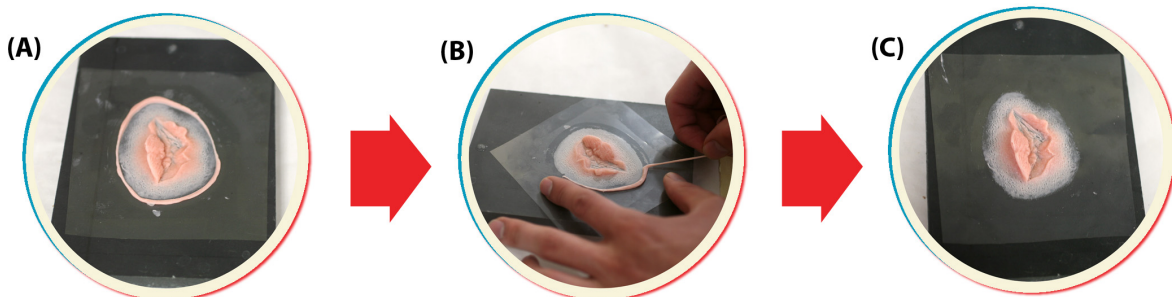
Remove your mold from the freezer (A). Turn over and place your mold face down on your cold slab (B). Starting from one corner, peel your mold carefully up away from the release film (C).



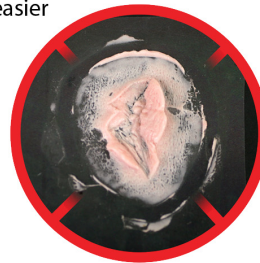
Note: Take your time and maintain contact with your cold slab.

STEP 2: Remove flashing material

Remove the flashing material from your cutting edge while still frozen on your cold slab (A). Use your finger nail to get it started, then use a plucking motion to pull away the material from your transfer (B). Your transfer is now finished and ready to dry (C).



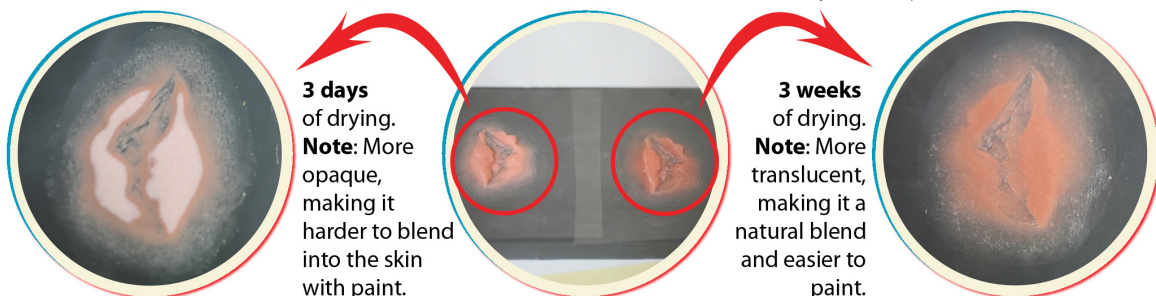
Note: Rotating your transfer while pulling makes for easier removal.



Warning! Uneven distribution of PTM™ into the flashing trench creates **rough edges**. The **trapped air** caused by **uneven** pressure or **lack** of PTM™ make for a less realistic transfer.

STEP 3: Place in a safe area for drying. Your prosthetic transfer, depending on its size, may take 1 DAY to 3 WEEKS for a complete dry.

Note: Your prosthetic transfer **DOES NOT** need to be fully dried for application, however, for best results, we recommend a complete dry.



3 days of drying.
Note: More opaque, making it harder to blend into the skin with paint.

3 weeks of drying.
Note: More translucent, making it a natural blend and easier to paint.



Hi-Ro Slip™ was developed and designed as an additive to create self-releasing silicone molds for prosthetic transfers. Transfers can be stubborn when trying to release them their silicone molds and usually requires applying a release agent to the molds before hand. The problem with the use of release agents is that they can create build up on your transfers and require washing and extra gluing to restore their adhesiveness. Hi-Ro Slip™ eliminates this constant use of release agents and unneeded steps, thereby creating a more efficient process and allowing you to run better quality prosthetic transfers.

STEP 1: Items needed

Hi-Ro Slip™
RTV Silicone such as 1065 with Hi Pro BLUE Catalyst.
Freezer (needed for charging the mold. See step 8)

STEP 2: Mix your silicone

Mix your silicone as normally directed. Silicone 1065 usually uses a 10:1 ratio (base to catalyst).

STEP 3: Add correct amount of Hi-Ro Slip™ to silicone mix (12 or 14%)

Once your silicone is fully mixed, its time to add the correct amount of Hi-Ro Slip™. 12% Hi-Ro Slip™ to silicone base (not the total weight of base and catalyst) is the recommended amount. Each silicone mold you create will have to be “Charged” (activation of Hi-Ro Slip™) in the freezer after demolding. Using Hi-Ro Slip™ at 12% will need a charge time of 12 hours in a freezer, following demold.

- If a quicker use of your mold is required, a 14% ratio of Hi-Ro Slip™ to base may be used, reducing charge time to 4 hours.

Example:

Base	Hi-Ro Slip™ (12%)	Hi-Ro Slip™ (14%)
100g	12g	14g
450g	54g	63g

MAKE SURE TO MIX THOROUGHLY.

Note: Your silicone mix with the added Hi-Ro Slip™ will seem to have a lower viscosity. This is normal.

STEP 4: Use an Evacuator (recommended only)

Evacuate your now Hi-Ro Slip™ infused silicone mix with an evacuator. An evaluator helps remove any trapped air within the mix, lowering the chance of air bubbles within your mold(s).

STEP 5: Pour your silicone

STEP 6: Let cure

Let your silicone mold(s) fully kick for the normal 5-6 hours or time recommended by manufacturer.

STEP 7: Demold your silicone mold(s)

STEP 8: Charge mold(s) before use

Place your Hi-Ro Slip™ silicone mold(s) into the freezer for the recommended charge time.

- 12 hours for 12% Hi-Ro Slip™
- 4 hours for 14% Hi-Ro Slip™

STEP 9: Remove and let warm

Remove your Hi-Ro Slip™ silicone mold(s) and let them warm up naturally. Once defrosted to room temperature, your Hi-Ro Slip™ silicone mold(s) are ready for filling and running transfers faster than ever.