

Mold Max[®] 14NV

Low Viscosity Tin-Cure Silicone Rubber



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PRODUCT OVERVIEW

Mold Max[®] 14NV is a Shore 15A tin-catalyzed silicone rubber that offers low viscosity, fast cure and long library life. **Mold Max[®] 14 NV does not require vacuum degassing.** Mix ratio is 100A:10B by weight. Working time is 40 minutes and cure time is 4 hours at room temperature. **Mold Max[®] 14NV** will reproduce the finest detail and is suitable for a variety of industrial and art related applications including making molds for reproducing prototypes, furniture, sculpture and architectural elements. **Mold Max[®] 14NV** can also be used to create movie special effects. Cure time can be reduced with Accel-T[®] cure accelerator. **Mold Max[®] 14NV** can be used to cast a variety of materials including concrete, wax, gypsum, low melt alloys/metals and urethane, epoxy or polyester resins.

Important; you must weigh Part A & B components using a **gram scale** to be successful with Mold Max[®] 14NV.

TECHNICAL OVERVIEW

Mix Ratio: 100A : 10B by weight	
Mixed Viscosity, cps: 7,500	(ASTM D-2393)
Specific Gravity, g/cc: 1.12	(ASTM D-1475)
Specific Volume, cu. in./lb.: 24.7	
Pot Life: 40 minutes (73° F / 23°C)	(ASTM D-2471)
Cure time: 4 hrs (73° F / 23°C)	
Color: White	
Shore A Hardness: 15	(ASTM D-2240)
Tensile Strength, psi: 490	(ASTM D-412)
100% Modulus, psi: 35	(ASTM D-412)
Elongation @ Break: 600%	(ASTM D-412)
Die B Tear Strength, pli: 87	(ASTM D-624)
Shrinkage, in./in.: 0.002	(ASTM D-2566)
Useful Temp. Range: -65°F to 400°F (-53°C to 205° C)	
Dielectric Strength, volts/mil: >500	
Dielectric Constant, 100 Hz: 3.4	
Dissipation Factor, 100 Hz: 0.02	
Volume Resistivity, ohms-cm: 9 x 10 ¹⁴	
Thermal Conductivity: 0.21	

* All values measured after 7 days at 73°F/23°C

PROCESSING RECOMMENDATIONS

START BY PREPARING YOUR MODEL...

Applying a Sealer / Release Agent - Mold Max[®] 14NV rubber may be inhibited by sulfur base clays 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 uncured after the recommended cure time has passed. To prevent inhibition, a "barrier coat" of clear acrylic lacquer sprayed directly onto the pattern is usually effective. Allow to thoroughly dry. Although not usually necessary, a release agent will make demolding easier when casting into or over most surfaces. **Ease Release[®] 200** is a proven release agent for making molds with silicone rubber and for releasing new silicone from cured silicone. Mann Ease Release[®] products are available from Smooth-On or your Smooth-On distributor.

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.

MEASURING & MIXING...

Materials should be stored at about 73°F / 23°C. These products have a limited shelf life and should be used as soon as possible. Wear safety glasses, long sleeves and rubber gloves to minimize contamination risk. Before you begin, pre-mix Part A (base) thoroughly to re-disperse fillers that may have settled. **Using a gram scale**, dispense required amounts of parts A and B into a mixing container and mix for 3 minutes. Scrape the sides and bottom of the 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.

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 soap and 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.

CURING & PERFORMANCE ...

Curing / Post Curing - Allow the mold to cure 4 hours at room temperature (73°F / 23°C) before demolding. Post curing the mold an additional 4 hours at 150°F / 65°C will eliminate any residual moisture and alcohol that is a by-product of the condensation reaction that can inhibit the cure of some urethane resins and rubbers. Allow mold to cool to room temperature before using. Do not cure rubber where temperature is less than 65°F / 18°C.

Accelerating Mold Max® 14NV - Accel-T® tin cure silicone rubber accelerator will accelerate the cure time of **Mold Max® 14NV**. Note: working time is reduced in proportion to the amount of Accel-T® added. See the Accel-T® technical bulletin (available from Smooth-On or your Smooth-On distributor) for exact mix ratios and cure times. Using this accelerator will result in a shorter library life of the mold.

	% of Accel-T® added by weight to PART B	Pot Life	Cure Time
Mold Max® 14NV	0.2%	25 min.	2 hours
	1%	4.5 min.	15 min.

Silicone Thinner® is a non-reactive silicone fluid that will lower the mixed viscosity of tin cure (condensation) or platinum cure (addition) silicone rubbers.

Silicone Thinner offers the following advantages: [1] Mixed rubber (A+B) will flow better over intricate model detail; [2] Silicone Thinner will lower the ultimate shore hardness (durometer) of cured silicone rubber; [3] Pot life (working time) is increased in proportion to the amount of Silicone thinner used. **A disadvantage** is that ultimate tear and tensile are reduced in proportion to the amount of Silicone thinner added. See the **Silicone® Thinner technical bulletin** (available from Smooth-On or your Smooth-On Distributor) for full details.

Making Brush-On Rubber Molds - Due to low viscosity, **Mold Max® 14NV is not recommended** for making brush-on rubber molds. If you want to make a brush-on rubber mold, **Mold Max® Stroke®** was developed especially for this purpose.



Call Us Anytime With Questions About Your Application.

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The new www.smooth-on.com is loaded with information about mold making, casting and more.