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# MOLDSIL SOFT

## RTV SILICONE RUBBER

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### MOLDSIL SOFT

**MOLDSIL SOFT** is a high quality silicone moulding compound developed for the Fibrous Plaster and resin casting industry. Moulds made from **MOLDSIL SOFT** will give high quality reproduction and a long mould life with virtually no shrinkage and no risk of the plaster ever gripping to the mould surface. **MOLDSIL SOFT** has been designed to be easy to mix by hand with colour-coded components to offer a visual aid to ensure mixing is complete. The two components mix easily and because of its low viscosity **MOLDSIL SOFT** can be used without the use of a vacuum chamber. **MOLDSIL SOFT** comes in three grades: slow, fast and very fast, giving you a choice in how quickly you wish to have a finished mould in production. **MOLDSIL SOFT** also has a thixotropic additive to enable you to make skin moulds or to mould on site.

A simple guide to using **MOLDSIL SOFT** :-

1. Apply release agent to the master model once you have removed any loose paint or dirt. Use a single brush coat of "PETROGEL" on bare plaster - wet or dry, never use shellac. Allow the "PETROGEL" to dry for about 20 minutes before pouring the **MOLDSIL SOFT**. If the model is made of wood, clay or is painted, use a wax spray as a release agent (MacWax or similar).
2. Mixing **MOLDSIL SOFT** is easy, it is supplied in 5Kg, and 1Kg, kits so you don't have to use any scales (if you want to part-mix, the ratio is 100 parts of base to 10 parts catalyst, by weight). Simply pour the red catalyst on top of the white base and start by folding the two components together gently, as they become inter-mixed you can mix with more vigour until a uniform "strawberry-pink" colour is attained. Pay particular attention to the sides and base of the container. When you think it is mixed, pour the entire contents into another clean container and re-mix, this is the only way you can be sure the material is thoroughly mixed.
3. You can now either pour the **MOLDSIL SOFT** over the model as it is, or you can add the THIXO additive to turn it into a non-slumping paste which can be brushed onto the model (about 1 teaspoonful per 1Kg. of **MOLDSIL SOFT** is sufficient - add a bit more if you need to - it's not critical). The THIXO additive will go solid if it gets cold, a bit like lard, simply warm it up to get it liquid again. Mix in the THIXO additive for about 90 seconds or until the **MOLDSIL SOFT** starts to stiffen. It is better to use **MOLDSIL F** (fast) or **MOLDSIL VF** (very fast) if you are using it with THIXO, this means you can build up layers more quickly and if you're working on-site you can take the mould off within a few hours.

If you are pouring the **MOLDSIL SOFT**, pour in a long steady stream, which helps burst any air bubbles introduced while mixing. For most open-pour moulds **MOLDSIL F** is suitable, whereas when pouring through a long case using **MOLDSIL S** will give you a longer pour-time to ensure the materials fills the case. (All three grades can be used together and will bond to each other).

De-mould times will vary According to the grade of MOLDSIL SOFT used. As a general guide:-

<b>MOLDSIL SOFT</b>	<b>Moldsil 'S' Slow</b>	<b>Moldsil 'F' Fast</b>	<b>Moldsil 'VF' V. Fast</b>
De-mould Time or Skin time (Hrs).	20	10	3
Gel Time (Mins).	120	50	10
Hardness Shore A	12	12	12
Tensile Strength mPa	3.2	3.2	3.2
Elongation to Break %	500	500	500
Tear Strength KN/m	21	21	15
Relative Density	1.15	1.15	1.15
Linear Shrinkage %	0.2-0.4	0.2-0.4	0.2-0.4

For customers using large volumes of moulding materials **MOLDSIL SOFT** is also available in 22Kg and 220Kg packs.