



POR-A-MOLD® THIXOTROPIC

Applications

Por-A-Mold S111 TA, S333 TA, and S555 TA are thixotropic versions of Por-A-Mold S111, S333, and S555. Thixotropic means that the molding systems are thick enough to be applied with a brush or a trowel. Use a TA molding system to make freestanding molds of large and/or complex masters.

Characteristics

Por-A-Mold TA systems are mixed one-to-one by volume and cure at room temperature in 24 hours. Por-A-Mold S111 TA cures to a soft (Shore A20 \pm 2), off-white rubber. S333 TA cures to a medium hardness (Shore A33 \pm 2), blue rubber. And, Por-A-Mold S555 cures to a firm (Shore A50 \pm 2), pink rubber. These systems spread smoothly and easily and adhere to vertical surfaces in an initial thickness of 1/4" or more.

Instructions for Use

Prepare Master and Mold Housing

First, clean and dry your master thoroughly. If the master has a porous surface (clay, concrete, plaster, etc.) or is made of sulfur-based clay, you must seal it. You can use polyurethane varnish, polyurethane sealant, or paste wax to seal your master. Next, anchor your master and seal the base so that the molding material does not leak under your master. A hot glue gun works to anchor and seal the base at the same time. Then, apply an appropriate release agent (we recommend Synlube 531) to the master and interior of the mold housing. Apply release agent sparingly, while coating all surfaces of the master. Too much release agent may cover the details of the master. You should allow the release agent to dry approximately 10 minutes before you apply the Por-A-Mold TA.

Measure Curative and Prepolymer

Note: Por-A-Mold TA provides approximately 20 minutes for you to mix and apply the material before it begins to gel.

Make sure that curative and prepolymer are room temperature before mixing them. Please note that in cold weather it may take up to 24 hours for the curative and prepolymer to reach room temperature. Using two clean, dry, plastic containers of equal size, measure equal amounts of the curative (part A) and the prepolymer (part B).

Mix Curative and Prepolymer

After you prepare the master and mold housing and measure the curative and prepolymer, you are ready to pour the curative and prepolymer into another clean, dry, plastic container. Scrape the curative and prepolymer containers to move all of the material into the mixing container. Combine the two ingredients for several minutes until no color striations are visible. Be sure to scrape the sides and bottom of the mixing container while combining the two ingredients. You must mix the curative and prepolymer completely so that Por-A-Mold TA will cure correctly.

Apply Por-A-Mold

Allow the mixture to stand for three to four minutes. Next, apply a thin base coat onto the master with a thin metal spatula or trowel. Make sure that you do not trap air bubbles between this initial layer of molding material and the master. Then, you can apply layers between 1/4 and 3/8 inches (8-10 minutes after mixing you can apply layers as thick as 3/4 inch).

Demold and Cure Mold

Once you have poured your mold, allow the mold to cure 16 hours before demolding. To prolong the life of the mold, allow it to cure for 3-4 days before using it.

Properties

Please refer to the Por-A-Mold S111, S333, or S555 product bulletin for physical properties.

Storage and Handling

Keep the Por-A-Mold TA container tightly closed when not in use and store at temperatures between 60–90° F (16–32° C). Do not expose the curative or prepolymer to moisture! If moisture contaminates PAM TA, it will not cure. If these storage requirements are met, Por-A-Mold TA carries a shelf life warranty of six months.

Be sure to read the *Material Safety Data Sheet* that comes with Por-A-Mold TA. When working with PAM TA, please observe the following safety precautions.

- Use only in well-ventilated areas.
- Wear safety glasses, chemical-resistant rubber or plastic gloves, and an apron.
- Avoid prolonged or repeated contact with skin.
- In the case of skin contact, wipe affected area with isopropyl alcohol, followed by soap and water.
- In the case of eye contact, flush eyes with water for 15 minutes and consult a physician.
- If swallowed, drink one to two glasses of water and seek medical attention immediately.