Helpful Tips

- **Choosing a Silicone Rubber:**
  - Quickset Silicone Rubber is good for simple one and two piece molds such as the flat ornamental owl used in the molding instructions above.
  - If your item/part is more 3 dimensional with undercuts, use High Strength 2 or 3 silicone rubber, such as the bunnies used in the casting instructions on the reverse side. A one or two piece mold will need to be determined based on the object being molded.
  - Always shake the catalyst bottle before using.
  - Mini Kit Catalyst bottle may feel empty due to the small amount needed to cure the base.
  - Best if products are used within one year of purchasing.
  - Pressure Casting: If you plan on pressure casting your resin, you must either vacuum or pressure cast the rubber to eliminate tiny air bubbles under the mold surface.

For technical assistance please call 1-800-447-9344, or visit www.alumilite.com for additional product information and tutorials.
### Casting Your Parts

#### Step 1: Measure out equal parts of side “A” and side “B”
- Shake black side “A” and Alumilite Regular side “B” prior to pouring from bottles.
- Before casting your part, preheat mold in an oven for 140°F or in a microwave for 1 minute per pound of rubber.
- A preheated mold will allow resin to properly cure and harden especially when casting small or thin parts.
- Do not microwave resin.

#### Step 2: Combine both sides into a mixing cup & mix thoroughly
- Use stir sticks for proper stirring. Do not shake.
- Use a paper or plastic cups. Do not use Styrofoam cups.
- Adequate mixing should be achieved in 25-30 seconds.
- No swirls should be visible once mixed.
- Mixing and pouring of resin into mold must be done within the stated working time of the casting resin being used (see chart at the top of the page).

#### Step 3: Pour mixed resin into mold
- While mold release is not required with silicone molds, we recommend its use to increase mold life and to make demolding easier. Release is required for molds other than silicone.
- Slowly pour casting resin down the side of your mold allowing the resin to flow naturally into the detail of your silicone rubber mold.
- If the mold contains undercuts or crevices, rotate mold to allow resin to flow into these areas.
- You can also gently squeeze the mold to force out any trapped air within.

#### Step 4: Wait for resin to cure and demold part
- Shortly after work time is exceeded, the material will begin to transform from liquid to solid. This will also be visible by a color change in the resin.
- Demold times will vary depending on size of part, preheating of mold, and Alumilite casting resin being used (see chart at the top of the page).
- As a general rule, the larger the part, the quicker it will cure. Small and/or thin parts require more time to cure. Preheating mold will also assist with cure.
- To demold, gently flex the rubber mold away from the casting and pull the cast resin piece out.

### Helpful Tips
- Lightly dust your silicone mold with talc or baby powder to break the surface tension and reduce or eliminate the possibility of air bubbles in your casted part.
- Apply UMR mold release to silicone molds to prolong the life of the mold.
- Both liquid mold making rubber and resin are sensitive to moisture. Replace caps immediately after using, store in a cool dry place, and use within 1 year of purchase.
- When using Alumilite Regular or Super Plastic, lightly shake side “B” prior to use.