



# Freeman Jewel-Sil Silicone Rubber Bulk Instructions

Jewel-Sil is available in economic bulk packaging, including a 1 kg kit and a 5 kg kit. Larger 22 kg kits and a 220 kg drum kits are also available, but are usually purchased for use with automated dispensing equipment.

Although the process for using bulk silicone rubber is more labor intensive than using the no-mix, no-mess cartridge (see other side), the material cost savings make these kits a better choice for many jewelry manufacturers.

Following these instructions is crucial to ensuring Jewel-Sil performance.



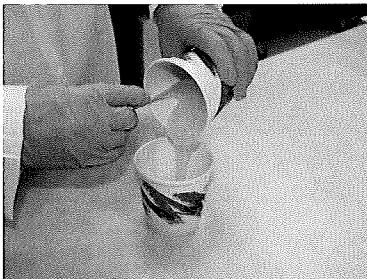
## STEP ONE

Place a clean mixing container on the scale and zero the scale (tare the scale) in order to cancel out the weight of the container. Pour the desired amount of silicone base (about 90% of your total material requirement) into the container. Use a stirring rod or paddle to add or remove material towards the end since it is easier to control.



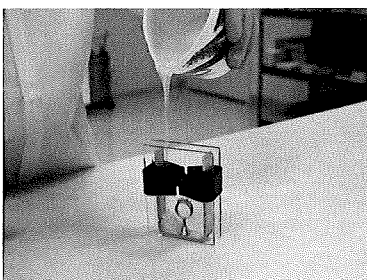
## STEP TWO

Zero the scale again and then add the catalyst directly on top of the base. The mix ratio for Jewel-Sil is ten parts base to one part catalyst (10:1) by weight. Therefore, the use of an accurate and precise scale is mandatory.



## STEP THREE

Mix the two materials together slowly using a spatula, tongue depressor, or paint paddle. Unless you have professional vacuum degassing equipment to de-air the mixture before pouring into the mold, do not use a mechanical mixer because this will introduce excessive air bubbles into the mixture.



## STEP FOUR

Pour the material into a second clean mixing container and mix it again thoroughly. This step is important to ensure that any unmixed material that may be present on the sidewall of the first container is not poured into the mold cavity.

## STEP FIVE

Fill your mold from the bottom until your pattern is completely encapsulated. Allow silicone rubber to cure. Put your mold in a pressure pot (an empty wax injection pot will work fine) and allow the rubber cure under 15 PSI of pressure overnight. This step is mandatory when using silicone from a bulk package.

Cure time can be accelerated with heat. Temperatures of 115°F/46°C can shorten cure time to as little as two hours without degrading performance or mold clarity.

### Disclaimer:

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