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AeroMarine Products AM125 Silicone Moldmaking Rubber

Product Description

AeroMarine Products AM125 Silicone Moldmaking Rubber RTV is a two component, room temperature tin condensation cure silicone material. The cured rubber has excellent mechanical properties and good shelf-life stability. This material is an excellent choice for beginning mold makers, quickly making one or two part molds and making molds for candles and soap. **This silicone IS NOT for use in ovens!**

PLEASE NOTE: Do NOT expose uncured AM125 to any moisture—moisture ruins it! Re-cap the containers immediately after pouring. Store AM125 at 72F/room temperature. AM125 has a 60 day shelf life once you open the containers.

Do NOT use silicone thinners, thickeners or accelerator with the AM125! It will not work with these additives. **Do NOT use AM125 Silicone Rubber with any sulfur-based clay or with latex gloves!**

Key Features

- Simple one to one mix ratio
- Low viscosity
- Fast demold time
- Excellent dimensional stability

Main Applications

- Molds for small figurines
- Molds for plaster, polyurethane and low temperature resins
- Molds for technical articles and prototypes
- Molds for furniture and picture frame replication
- Molds for candles and soap

Typical Properties

Uncured properties	"A" component	"B" component
Appearance	Green	Blue
Viscosity, cps	4000	4000
Catalyzed properties		
Specific gravity	1.34	
Pot life	~15 minutes	
Cure time (demold)	75 minutes	
Post Cure	8 hours	
Typical cured properties		
Durometer	25	
Tensile Strength, psi	>240	
Elongation, %	>250	
Tear B, pli	~40	
Linear shrinkage	0.0025 in/in	
Useful Temperature Range	-65F to 400F	



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Cure Characteristics

The curing process begins as soon as the catalyst is mixed with the base. Under normal temperature (25C) and humidity (50% RH) conditions, the material will cure as described in the data above. Any large change in temperature (+/-5C) or humidity (>60-70%) may alter the cure profile of the material.

Silicone RTV Rubber Mold Making 101

Making a mold can either be very simple or an art. It depends on the intricacy of your part. If you have never made a silicone mold before, begin by making a mold of a simple part before making a mold of a complicated part.

You will need an original piece, clean mixing containers, mixing utensils, and a mold box into which to place your piece while making your mold. A mold box can be made out of almost anything, including a clean reusable food container, cardboard, sealed wood and Legos. You may also need a glue gun and/or clay. Depending on the size of the piece, 1/2" of silicone mold-making rubber is the minimum thickness necessary for the walls of your mold. Making it too thick will reduce the flexibility of the mold; while too thin will reduce the resistance to tearing.

Silicone RTV mold making rubber may soak into a porous surface like wood or plaster. To prevent sticking, first seal the piece with a sealant appropriate to the material.

Material Compatibility

This product works with most Epoxy and Urethane resins on the market today, however due to the wide variety of products with different chemistries and formulations, we cannot guarantee that it will work with all of them. Some epoxy resin products will not cure when they come in contact with TIN CURE silicone resin and can only work with Platinum Cure silicone. If you are not sure about your epoxy product's compatibility with this material, please contact the vendor of your epoxy and ask them about compatibility with Tin Cure silicone, or perform a small test before engaging on a major project.

Types of molds to make with AM125 silicone:

BLOCK mold, one piece. The part usually has no negative draft or undercuts. Building this mold is simple. Mount your part in the center of a container or mold box. You will need at least ½ inch of silicone on all sides of the part. Apply mold release, if needed. Next, pour your mixed silicone in the shallowest area of the container. Pour only into this spot and let the silicone flow naturally around the part. This reduces air bubbles in the silicone. Once the silicone has cured, you can de-mold your part.

BLOCK mold, multiple piece. This part has undercuts and/or is complex. The mold must be taken apart to remove casing. You can make this type of mold using non-sulfur, non-drying modeling clay and pouring the silicone in 2 separate pours. Use a mold release between the pours to keep the silicone from sticking to it. To keep the cured mold together, you can use rubber bands or painter's tape.

For more detailed instructions and videos on mold making, go to our website, www.aeromarineproducts.com

Mold Release

Generally, silicone RTV mold making rubber does not stick to anything, and nothing will stick to it. ***The exception is that it will stick to itself, other silicones, silica, some ceramics, some porcelains, and glass.*** Mold release will prolong the life of your mold by reducing the wear on the mold by making it easier to remove your cast piece.



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Measuring and Mixing

Measure out by volume equal parts A and B. Once you have correctly measured both parts, mix parts A and B together with a plastic or wooden stirring utensil. Take care to scrape the sides and bottom of the mixing container. Keep your stirring utensil on the bottom of the container to reduce the amount of air being mixed into the silicone. Mix for a few minutes, scraping the sides and bottom frequently, until the silicone is one uniform color with no streaks.

Pouring Silicone

When pouring your silicone, do NOT pour it directly onto the part. Instead, pour the silicone into the shallowest part of the mold and let it find its own level. This method prevents air bubbles forming on the surface of your part.

Storing Your Cured Silicone Mold (Storage longer than 1 week)

Insert a previously cast cured piece into the prepared mold. Put your mold (if a smaller mold) with the piece in it into a doubled "Ziploc" type bag with all the air pressed out of the bags. Seal the bags tightly closed using either a plastic bag sealer or over-tape them with duct tape. For larger molds, use very heavy duty doubled garbage bags, remove all the air and seal tightly either with a plastic bag sealer or over-tape with duct tape. Put your sealed, bagged mold into a plastic storage container with a lid, close the lid and store on a flat shelf/surface (**NOT the floor or window**) at continuous 70F out of direct sunlight. Do not store in an area with fluctuating temperatures like a shed or garage as this can decrease the life span of the mold.

Cleaning Your Silicone Mold

Wash your cured silicone mold with warm/hot water and mild liquid dish soap. Pat dry thoroughly and then let the mold air-dry fully. Never use any type of abrasive soap, cleaner or scrubbing pad to clean your silicone mold!

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