

PRODUCT OVERVIEW

Accel-T® is a one-component additive that will reduce the cure time of Smooth-On tin cure silicone rubber compounds from overnight to a few hours in proportion to the amount added. **Accel-T® is added as a percentage of part B**

	% of Accel-T® added by weight to PART B	Pot Life	Cure Time
Mold Max® 10	0.2%	20 min	3 hours
	1%	10 min	1 hour
Mold Max® 14NV	0.2%	25 min	2 hours
	1%	4.5 min	15 min.
Mold Max® 20	0.2%	15 min	2 hours
	1%	5 min	1 hour
Mold Max® 25	0.2%	60 min	9 hours
	1%	15 min	4 hours
Mold Max® 30	0.2%	15 min	3 hours
	1%	7 min	1 hour
Mold Max® 40	0.2%	15 min	2 hours
	1%	8 min	1 hour
Mold Max® 60	0.2%	20 min	3 hours
	1%	3 min	1 hour
Mold Max® T Series	0.2%	20 min	3 hours
	1%	3 min	1 hour
Mold Max® XLS II	0.2%	20 min	3 hours
	1%	3 min	1 hours
Mold Max® STROKE®	0.2%	15 min	4 hours
	1%	5 min	2 hours

IMPORTANT: Thoroughly Pre-mix Accel-T® with Part B before adding Part A. Adding Accel-T® will reduce the library life of tin-cured silicone rubber in proportion to the amount added.

PROCESSING RECOMMENDATIONS

PREPARATION... Safety – Use in a properly ventilated area (“room size” ventilation). Wear safety glasses, long sleeves and rubber gloves to minimize contamination risk. Store and use all products at room temperature. This product has a limited shelf life and should be used as soon as possible. Wear gloves and eye protection to minimize risk of contamination.

MEASURING & MIXING...

All components must be measured using an accurate gram scale.

1. Determine the total amount of rubber required for your application. Calculate the correct amounts of Part A, Part B and Accel-T® in advance.
2. Weigh out the required amount of Part B
3. Weigh out and add the required amount of Accel-T® as a percentage of the Part B. Mix Part B and Accel-T® thoroughly.
4. Weigh out and add the required amount of Part A.
5. Mix thoroughly, eliminating all color streaks from the mixture.
6. Pour mixture into new, clean mixing container and mix again.
7. Vacuum material (29 h.i.g. mercury) as directed on the silicone rubber technical bulletin.
8. Pour rubber into containment field, let rubber rise over model.

Because no two applications are quite the same, a small test application to determine suitability for your project is recommended if performance of this material is in question.

IMPORTANT: Working time (pot life) is drastically reduced in proportion to the amount of Accel-T® added. Viscosity of rubber will also increase. Mix, vacuum and pour quickly.

Safety First!

The material safety data sheet (MSDS) for this or any Smooth-On product should be read before using and is available on request. All Smooth-On products are safe to use if directions are read and followed carefully.

IMPORTANT - The information contained in this bulletin is considered accurate. However, no warranty is expressed or implied regarding the accuracy of the data, the results to be obtained from the use thereof, or that any such use will not infringe a copyright or patent. User shall determine suitability of the product for the intended application and assume all associated risks and liability.



**Call Us Anytime With Questions
About Your Application.**

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The new www.smooth-on.com is loaded with information about moldmaking, casting and more.