

LiquaGlass™

At Last! You Can See!

Technical Datasheet



Injecting Castaldo® LiquaGlass™ molds is easy because you can SEE the wax as it is injected!

LiquaGlass™ 0% shrinkage CLEAR liquid RTV jewelry molding rubber makes strong, tough, flexible production molds at only a fraction of the price of clear silicone rubbers.

LiquaGlass™ is easy to measure, and de-bubble. It also cures at room temperature in 24 hours with 0% shrinkage.

Castaldo® LiquaGlass™ is packaged in a 1 kg. / 2.2 lb. kit containing equal parts A & B in an attractive consumer-oriented carton that is easy to handle and easy to ship. Use with Castaldo® Liquid Rubber Mold Frames.

- 0% Shrinkage RTV.
- Not an expensive hard-to-mix silicone rubber!
- Not an amateur "bake in the oven" material!
- Makes strong, flexible, easy to cut molds.
- Inexpensive and easy to use 1:1 mix ratio.
- Clear as Glass.
- Thin, easy to pour and mix, Castaldo® LiquaGlass™ molds are easy to make because you can SEE what you are cutting!

Name	LiquaGlass
Shore A Hardness	50 +/- 2
Mix Ratio by Weight	1:1
Rubber Shrinkage	0.0%
Viscosity	Very Low 1,200cps
Vulcanises at	70°F / 21°C
Cure Time	16hrs
Rapid Cure Time @150F / 65C	90 mins
Specific Gravity	1.00
Elongation Before Break	750%
Tensile Strength Before Break	2.1 n/mm ²
Tear Strength Die C Before Break	12.9 n/mm ²
Colour	Clear Blue/Green

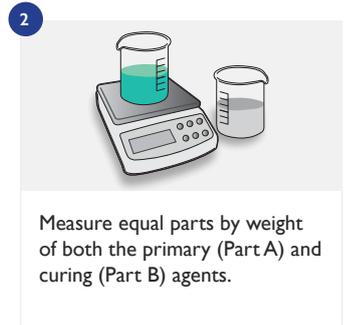
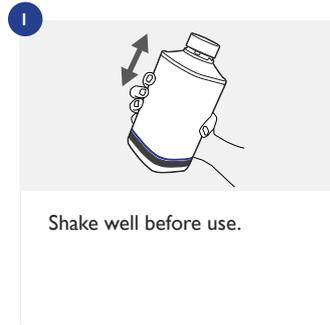


*Shrinkage rates given are for the rubber mold itself. Final casting shrinkage rates depend on moldmakers and caster's skill, knowledge, precision and attention to detail.

** Specific gravity.Water = 1.00. Low specific gravity = more molds per pound/kg.

Castaldo® LiquaGlass™ liquid molding rubber is NOT a silicone rubber. Procedures may be different than those you may be accustomed to using. Please read and observe the following instructions carefully.

1. STIR BEFORE USE! Mix 1 Part A and 1 Part B by WEIGHT. Components MUST BE WEIGHED CAREFULLY. Use an accurate scale. DO NOT MEASURE BY VOLUME. DO NOT ESTIMATE. DO NOT GUESS! Make sure both parts are at room temperature.
2. Pour the required amounts of both parts A & B into a mixing container. A rubber mixing bowl of the type commonly used to mix jewelry investment is ideal.
3. Always pour catalyst (Part A) into rubber (Part B).
4. Mix thoroughly by hand for 3 to 4 minutes until no traces of the catalyst can be seen. Take care to scrape the sides of the mixing bowl into the centre several times during mixing.
5. Make sure the bowl is big enough to allow for temporary expansion of the rubber during vacuuming of 300% to 400% without overflowing.
6. Vacuum the liquid rubber for approximately 5 minutes, making sure that it boils and bubbles vigorously. Vacuuming is complete once the rubber rises and collapses. Do not wait for the rubber to stop bubbling completely.
7. Pour the liquid rubber into the mold frame, taking care to avoid entrapping air. Vacuum again for 3 minutes. Do not over-vacuum.
8. Working time before cure begins is approximately 45 to 60 minutes at room temperature.
9. Put the mold aside to cure at room temperature (77°F / 25°C) for 16 to 18 hours. A period of 24 hours is best. Always remember that longer cure times will improve the mold and will not hurt it, while shorter mold times will result in soft and deformed molds.



The following is only a guide, the mass of your model will increase or decrease the amount of rubber needed.

Mold Size	Part A	Part B	Total
0.75" / 19 mm	60.0 g	60.0 g	120.0 g
1.00" / 25 mm	77.0 g	77.0 g	154.0 g
1.25" / 32 mm	105.0 g	105.0 g	210.0 g
1.50" / 38mm	113.0 g	113.0 g	226.0 g