



# Freeman Jewel-Sil Silicone Rubber User Information

Sold through worldwide distribution

Jewel-Sil is a two-component, room-temperature-curing silicone rubber. It is specifically designed for making clear and flexible molds for injection of wax used to manufacture intricate jewelry using the investment casting method.

The following instructions should be used to obtain the best results possible.



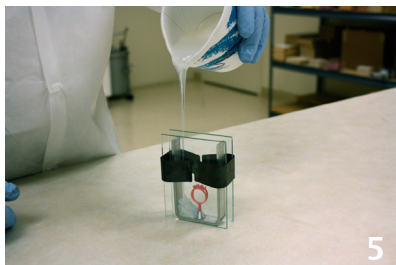
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- 1** Place a clean, disposable mixing container on an accurate scale. Zero (tare) the scale to cancel the weight of the container and add the desired amount of Jewel-Sil base component.
- 2** Zero the scale again and then add the Jewel-Sil catalyst directly on top of the base using a 10:1 ratio of base to catalyst by weight.
- 3** Mix these two components completely using a spatula, paint paddle, or tongue depressor. Make sure to frequently scrape the sides and bottom of the container as well as the spatula, paint paddle, or tongue depressor.
- 4** Pour into a second clean container. This step is important to make sure that any unmixed material that may be present on the sidewall of the first container is not poured into the mold cavity.
- 5** Fill your mold from the bottom until the pattern is completely encapsulated. Place the completed mold in a pressure pot (an empty wax injection pot will work fine) and allow the rubber to cure under 15 psi of pressure overnight. Cure time may be accelerated with heat. Temperatures of 115°F can shorten the cure time to as little as two hours without degrading the performance or mold clarity.

*Disclaimer: Manufacturer/seller shall NOT be liable for any injury, loss, damage arising directly, consequentially from the proper/improper use of product, but shall be obligated to replace quantity of product proved defective for intended application. User shall determine suitability of the product for intended use and assumes all risk and liability whatsoever in connection therewith. The foregoing may not be altered except by express written consent by an officer of manufacturer/seller.*