

M.D. FOAM LATEX MIXING INSTRUCTIONS

SINGLE BATCH (SB)

- Part "A" ¾ cup latex Base (6oz)
 Part "B" ½ Tablespoon
 Part "C" ½ teaspoon (or as needed)

DOUBLE BATCH (DB)

- Part "A" 1 ½ cup latex Base (12oz)
 Part "B" 1 Tablespoon
 Part "C" 1 teaspoon (or as needed)

MOLD PREP AND SET – UP

- 1) Bake out excess moisture from Ultracal molds by heating the molds in a convection oven for :30 min. at 180°F. Molds should be warm and "thirsty" to help moisture from the Foam Latex escape into the plaster.
- 2) Apply release agent with a brush and remove any excess with a paper towel. Do not allow the release to puddle. (optional) Apply talc with a powder puff and blow any excess away.
- 3) (optional) Using a cotton swab apply one thin coat of Part "A" to the negative and allow to dry. This will form a skin on the finished appliance and facilitate removal. This step is not essential but recommended when a durable appliance is required. NOTE if a skin coat is applied you MAY need to increase the baking time.

MEASUREMENT AND MIXING

- 1) Measure ¾ cup of Part "A" into a mixing vessel and place in the mixer. We recommend the sunbeam Mixmaster small bowl for small batches.
- 2) Add ½ Tablespoon of Part "B" and mix on speed one for 1:00 min, while using a spatula to direct ingredients towards the center of the bowl, making sure that the ingredients are completely dispersed.
- 3) Increase speed of mixer to highest speed (speed 12 on the Mixmaster) to whip latex ingredients into a foam. Occasional backspinning is ok. Mix to the highest volume desired, usually for about 1:30 min. The longer the whip time the higher the volume, not to exceed 4:00 min.
- 4) Reduce mixer speed to speed 4 or "Mix". Refine the foam and mix the foam for 2 min or until the foam has a uniform cell structure. Use the spatula to make sure foam at the edge or bottom of the bowl has been refined.
- 5) Reduce the speed to speed one and "ULTRA" refine for 1:00 min.
- 6) Add ½ tsp. of gelling agent Part "C" OVER :30 sec. Then backspin the bowl for another :30 sec. To make sure that the gelling agent has been dispersed. Use the spatula to make sure foam at the edge or bottom of the bowl has been mixed thoroughly. Allow the foam to mix for another :30 sec. (If the setting time is too slow increase the gelling agent by 25%. If too quick decrease by 25%)
- 7) Turn off your mixer and IMMEDIATELY fill the molds or injection gun. You should have between 5-10 min or a total run time between 12 to 14 min.

DOUBLE BATCH

- 1) Simply double amounts including Gelling Agent Part "C" using the LARGE Mixmaster bowl.
- 2) Increase whip time to 3 min with frequent backspins. Use the spatula to concentrate the foam towards the back of the beaters to increase the force of the whipping.

FILLING THE MOLDS AND BAKING

- 1) When the molds are filled allow the foam to gel or load immediately in a preheated oven to speed the gel.
- 2) Allow to bake for at least 2 hrs. at 180°F or until the sponge springs back when pressed with a finger. Larger molds will require a longer baking time.
- 3) Allow a minimum of 1 hour for the molds to cool before removing from the oven. Pry the mold open gently and test for cure by pressing your finger into an overflow area. If it does not bounce back do not remove the appliance but return that half of the mold to the oven to continue baking until the appliance is fully cured.

RUN SCHEDULE

SPEED	TIME	TOTAL RUNNING TIME	ACTION
1	SB 1:00 DB 1:00	SB 1:00 DB 1:00	MIX INGREDIENTS "A" AND "B"
12	SB 1:30 DB 3:00	SB 2:30 DB 4:00	WHIP TO VOLUME
4	SB 2:00 DB 2:00	SB 4:30 DB 6:00	REFINE CELL STRUCTURE
2	SB 1:00 DB 1:00	SB 5:30 DB 7:00	ULTRA REFINE
2	SB :30 DB :30	SB 6:00 DB 7:30	ADD GELLING AGENT OVER :30 SEC
2	SB :30 DB :30	SB 6:30 DB 8:00	BACKSPIN
2	SB :30 DB :30	SB 7:00 DB 8:30	FORWARD SPIN
0			TURN OFF MIXER AND LOAD MOLDS
	5:00	12:00	FOAM SHOULD GELL

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