Si-Tac™ II

"Next Generation" Silicone Fabric Adhesive

Certified Skin Safe!

www.smooth-on.com

PRODUCT OVERVIEW

Si-Tac™ II is a skin-safe silicone adhesive applied to natural or synthetic fabrics for the purpose of holding garments in place during normal wear or heavy exercise. It features exceptional adhesive properties, very high tensile strength and wear resistance. Withstands repeated laundering. **Si-Tac II** can be hand mixed, mechanically mixed and applied or dispensed through meter-mix equipment in production.

TECHNICAL OVERVIEW

Mix Ratio: 1A:1B by weight or volume	
Mixed Viscosity: 350,000 cps	
Pot Life: 48 hours at 73°F (23°C) 9 hours at 90°F (32°C)	(ASTM D-2471)
Cure time at 180°F (82°C): 5 minutes **Cure time at 250°F (121°C):** 20 seconds	
Color: Translucent	
Specific Gravity, g/cc: 1.1	(ASTM D-1475)
Shore A Hardness: 30	(ASTM D-2240)
Useful Temperature Range: -65°F to 450°F (-53°C to 232°C)	
Elongation @ Break: 750%	(ASTM D-412)
Tensile Strength, psi: 900	(ASTM D-412)
Die B Tear Strength, pli: 220	(ASTM D-624)

- *Bonds to Activewear/Shapewear Fabrics Including Nylon, Spandex™ & Lycra™*
- *Strongest, Longest Lasting Garment Adhesive Available Anywhere*
- *Waterproof, Sweatproof and Wear Resistant*
- *No-Slip Formula to Hold Garments in Place*
- *Moves Comfortably with the Body*
- *Remains Flexible at -65°F to 450°F (-53°C to 232°C)*
- *Certified Skin-Safe*
- *Resists UV, Ozone and Pool Chlorine*
- *Withstands Hundreds of Laundry Cycles*
- *Custom Colors Available*
- *Eco-friendly - Vegan and No VOCs*

PROCESSING RECOMMENDATIONS

PREPARATION...

Safety - Use in a properly ventilated area ("room size" ventilation). Wear safety glasses, long sleeves and gloves to minimize contamination risk. Wear vinyl gloves only. Latex gloves will inhibit the cure of the rubber. **Store and use material at room temperature 73°F (23°C).** Warmer temperatures will drastically reduce working time and cure time. Storing material at warmer temperatures will also reduce the usable shelf life of unused material. This product has a limited shelf life and should be used as soon as possible.

Cure Inhibition - Addition cured silicone rubber may be inhibited by certain surface contaminants. **If surface compatibility is in question, do a small compatibility test before using for an important project.**

MIXING & CURING...

Mix by Hand - Dispense equal amounts of Part A and Part B into a mixing container. Mix thoroughly for at least 5 minutes using a flat edge mixing paddle. Scrape sides and bottom of mixing container several times using flat edge of paddle. Vacuum Degas - place mixing container in vacuum chamber and subject mixture to 29 inHg vacuum until mixture rises and falls. Remove from vacuum chamber and apply. Heat cure as directed below.

Safety First!

The Material Safety Data Sheet (MSDS) for this or any Smooth-On product should be read prior to use and is available upon request from Smooth-On. All Smooth-On products are safe to use if directions are read and followed carefully.

Keep Out of Reach of Children

Be careful. Use only with adequate ventilation. Contact with skin and eyes may cause irritation. Flush eyes with water for 15 minutes and seek immediate medical attention. Remove from skin with waterless hand cleaner followed by soap and water.

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 upon a patent. User shall determine the suitability of the product for the intended application and assume all risk and liability whatsoever in connection therewith.

Mechanical Mixing - Dispense equal amounts of Part A and Part B into a mixing container. Using a drill with attached mechanical mixer (such as a Turbine Mixer), mix thoroughly for at least 3 minutes on medium speed. Avoid high speeds and creating a vortex as this will entrain air into the silicone. Follow with 2 minutes of hand mixing using a flat edge mixing paddle. Scrape sides and bottom of mixing container several times. Vacuum Degas - place mixing container in vacuum chamber and subject mixture to 29 inHg vacuum until mixture rises and falls.Remove from vacuum chamber and apply. Heat cure as directed below.

Meter Mix Dispensing - When meter mix dispensing, contact meter mix equipment manufacturer for instructions on proper equipment setup and usage.

Heat Curing - **Si-Tac II** must be heat cured to achieve optimal properties. **Standard Cure: 20 seconds at 250°F (121°C).** Alternatively, it can be cured at **180°F (82°C) for 5 minutes.**

Cure times may vary slightly depending on part thickness, substrate, and oven performance. If the fabric or bonded assembly is at room temperature when entering the oven, a longer post-cure may be necessary to ensure a full cure throughout.

SMOOTH-ON SINCE 1895

Call Us Anytime With Questions About Your Application.

Toll-free: **(800) 381-1733** Fax: **(610) 252-6200**

www.smooth-on.com is loaded with information about mold making, casting and more.