

# Earmould Silicone ES-1.1/25

## Instructions

pro3dure  
medical

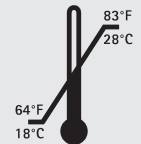
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**Indications for use:**  
silicone earmould  
material

### Technical data:

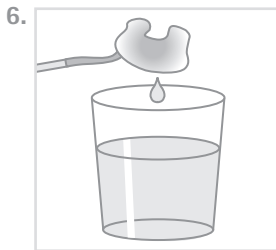
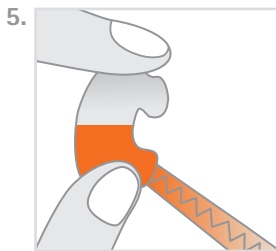
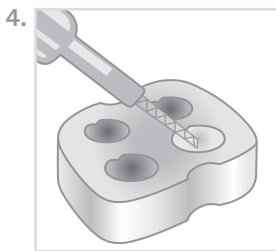
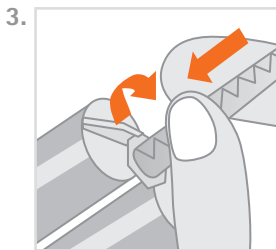
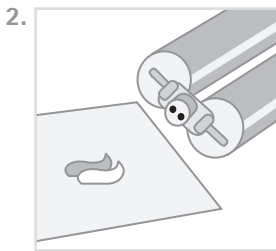
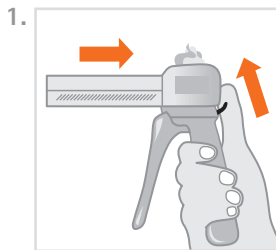
- Mixing volume:  
48 ml cartridge
- Mixing ratio: 1:1
- Color code:  
Base: depends on  
chosen material  
Catalyst: white
- Setting time:  
60 min. at  
50 °C / 122 °F  
in pressure pot
- Final hardness:  
25 ± 5 Shore A
- Application:  
At 73 ± 4 °F,  
50 ± 5 % rel.  
humidity
- Storage:



### Ordering information:

cartridges of 8 x 48 ml  
clear-transparent  
item no.: A0030800  
reddish-transparent  
item no.: A0030203  
black-opaque  
item no.: A0030376  
white-opaque  
item no.: A0030100  
neon-green-opaque  
item no.: A0030530  
neon-yellow-opaque  
item no.: A0030729  
neon-pink-opaque  
item no.: A0030903  
neon-orange-opaque  
item no.: A0031327  
dark-blue-opaque  
item no.: A0030428  
light-blue-opaque  
item no.: A0031128  
red-opaque  
item no.: A0030627  
violet  
item no.: A0030680  
smoke grey  
item no.: A0030690  
Injector DS  
50 ml / Stück  
item no.: A40000  
5,4 mm  
Clear Mixing Tip  
100 Stück  
item no.: A40002

These data result from  
measurements of a  
representative sample,  
which were determined  
within the scope of our  
quality assurance.



The **ES-1.1/25** is a permanently elastic addition-vulcanizing silicone material for the generation of soft silicone and hearing protection earmoulds.

### 1. Mixing and dispensing

Place the cartridge (**fig 1**) into the dispensing gun. Unscrew cap. In order to ensure a proper flow and mixing ratio from both orifices (**fig 2**) extrude carefully a small amount of the material. Insert the static mixer into the guided grooves of cartridge. Rotate the mixing cannula anti-clockwise to a stop (**fig 3**). If necessary, mount an Intra-tip. For reducing forces during dispensing, static mixers of a larger diameter (9mm) can be used alternatively. Dispenser is now ready to mix the 2 component earmould silicone in any amount needed.

### 2. Application (PnP method)

In combination with the **ES-1.1/25** material all commercially available materials for negative forms like plasters, gels or 3D-printing resins can be used for the manufacturing of the negative form (**fig 4**). If necessary, coat the negative form with a separation liquid (e.g. alginate based for plaster). 3D-printed cast forms have to be cleaned carefully before use in order to avoid inhibition of the silicone reaction. Inject the **ES-1.1/25** material slowly and bubblefree into the generated negative form (**fig.5**). In case of narrow structures (e.g. auditory canals), we recommend using a thin mixing canula. Put the negative mold with the injected material into a pressure pot for about 60 min at 122 °F (50 °C).

### 3. Final surface treatment and lacquering

The silicone earmould can now be shaped by using special cutters and grinding sleeves. Roughen the surface with corundum paper (grit 180) before varnishing. Clean the surface and coat it with a silicone lacquer according to the special instructions of the lacquer (**fig 6**).

### 4. Important working hints

- In case of the generative fabricated castforms a careful preparation as well as a thorough cleaning will ensure better and more reliable results.
- Ensure that all traces of residual resin is removed from the negative form.
- The cured earmould material **ES-1.1/25** is chemically inert.  
Avoid spots on clothing.
- We recommend standard gloves made of nitrile or polyethylene.

### Safety advice:

pro3dure medical is not liable for any damage caused by improper application of the earmould material.

Despite of the fact that the high biocompatibility of silicone materials is proven over decades in exceptional cases undesired reactions of the immune system like allergies, irritations can't be absolutely excluded. In case of doubt, we recommend to contact your consulting physician and make an allergy test before the application of the material.

**For use by trained specialists.**

ES-1.1

idea to product.

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