



Factor II, Incorporated
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How to Use Flocking (H-100 Series, H-135-R, KT-896)

1. OVERVIEW

Flocking is a fine rayon fiber used in both intrinsic and extrinsic coloring of silicone prostheses. It enhances realism by introducing subtle visual depth, reducing shine, and simulating the natural vascularity and translucency of skin. When incorporated into translucent materials such as silicone or gelatin, flocking produces optical diffusion that mimics the mottled texture and depth of real skin.

- H-100 Series – Individual rayon flocking colors (red, brown, yellow, blue, black, etc.) for custom color blending.
- H-135-R – Specialized vascular red flocking, ideal for adding capillary or blush tones in translucent regions.
- KT-896 – Eight-color sample kit containing a curated selection of flocking shades for testing, education, or establishing new color formulas. Provides a convenient range of tones for clinics and training environments.

Flocking can be incorporated into silicone intrinsically (during mix) or applied extrinsically for surface detailing and optical correction.

2. MATERIALS REQUIRED

| Component | Description | Recommended Product |
|-------------------------------------|---|--------------------------------|
| Flocking Fibers | Rayon fiber pigmentation for natural skin depth | H-100 Series, H-135-R, KT-896 |
| Silicone Base | Medical-grade platinum-cure silicone elastomer | VST-50 or equivalent |
| Thixotropic Agent | Adjusts viscosity for controlled flock suspension | A-300-1 Thixo |
| Mixing Tools | Precision scale, clean spatulas, mixing cups | Laboratory-grade |
| Solvent Carrier (for extrinsic use) | Dissolves pigment and flock into surface silicone | A-840 (CCH Solvent, preferred) |



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Curing Equipment

Heat cure oven or pressure pot 100 °C for 40 minutes

3. SAFETY & HANDLING PRECAUTIONS

- Flocking fibers are non-toxic and not classified as hazardous under OSHA standards.
- Avoid creating airborne fiber dust; use local exhaust ventilation when handling loose flock.
- Store in a cool, dry environment below 80 °C (176 °F).
- Use gloves and safety glasses to prevent irritation during handling.
- Dispose of waste by landfill or incineration per local regulations.
- When working with loose fibers, wear a particulate respirator mask and minimize drafts that could make fibers airborne.

4. INTRINSIC APPLICATION (MIXED INTO SILICONE)

1. Prepare silicone base: Weigh base and catalyst (10:1 ratio by weight).
2. Add Thixo (optional): Incorporate 1–2 drops per 10 g silicone for controlled viscosity.
3. Introduce flocking: Add a small pinch (typically 0.01–0.05 g per 100 g silicone) of desired H-100 or KT-896 fibers. For best realism, use short flocking fibers (1–2 mm). Longer fibers may become visible as lines in thin sections.
4. Mix thoroughly: Use gentle folding motion to disperse fibers evenly. Over-mixing may cause fiber clumping.
5. Adjust tone: Blend with FI or FI-SK pigments to fine-tune color depth.
6. Pour or inject silicone as usual and cure per manufacturer instructions (typically 40 min at 100 °C or 20 min at 120 °C).

Tip: The addition of flocking helps control translucency and masks unwanted shine while enhancing optical realism. Flocking behaves like a spice — start with a small amount and increase gradually for subtle, realistic results. A clean spice shaker or perforated dispenser can help control dosage efficiently.

5. EXTRINSIC APPLICATION (SURFACE COLOR ENHANCEMENT)

1. Thin A-840 solvent or FE-100 with small amounts of flocking and pigment.
2. Brush or stipple the mixture onto cured silicone for subtle vascular highlights or texture control.
3. Allow solvent to evaporate fully before applying sealants (TS-564, A-564, MD-564).
4. Cure sealed surface at 100 °C for 15 minutes between coats.



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For a natural appearance, use H-135-R Red Flocking lightly over translucent regions such as temples or nasal bridge.

6. COLOR BLENDING RECOMMENDATIONS

| Target Skin Tone | Suggested Flocking Blend |
|---------------------------|---|
| Fair / Translucent | H-100 Light Yellow + KT-896 |
| Medium | H-100 Tan + KT-896 + small amount H-135-R |
| Dark / Olive | H-100 Brown + KT-896 |
| Vascular / Pink undertone | H-135-R (Red) + KT-896 |

7. FINISHING & CLEANUP

- Remove residue from mixing tools with A-830 (Acetone) or B-3808 (Ethyl Acetate).
- Avoid airborne fiber dispersal; use damp wipes for surface cleanup.
- Store unused flock in sealed containers.

8. SAFETY SUMMARY (FROM SDS)

- Not hazardous per OSHA and SARA standards.
- Stable and biodegradable.
- Avoid high heat, flame, or static discharge during handling.
- Dispose in accordance with 40 CFR 261 (non-hazardous material).

9. KEY NOTES

- A minimal amount of flocking achieves significant color modulation.
- Excessive flocking can reduce mechanical strength or make the silicone appear chalky.
- Combine with FI Intrinsic Pigments for controlled realism and repeatable tones.
- The KT-896 Flocking Kit provides eight pre-measured colors for sampling or instructional use, ideal for developing consistent color standards.
- Use the H-100 Series for full production or repeatable work where specific color control is required.