



# Using *Kick-It*® to Accelerate Smooth-On Urethane Rubbers

Smooth-On Kick-It® Cure Accelerator is an additive designed to “accelerate” the cure time of Smooth-On VytaFlex®, ReoFlex® and PMC® rubber products without significantly affecting the ultimate physical properties. This allows for much faster removal (demold) of a part or rubber mold from the original model.

**The accelerator is added by weight to Part B and should be thoroughly mixed into Part B before adding Part A.**

**Note:** Adding the accelerator significantly reduces the pot life (time you have to mix and pour material) of the liquid rubber product. This product has a limited shelf life and should be used as soon as possible.

Smooth-On Urethane Rubber	Cure Accelerator Added by Weight To Part ‘B’	Approximate Pot Life In Minutes	Approximate Demold Time In Hours
VytaFlex® 10	1%	8	15
	2%	7	11
	3%	6	7
VytaFlex® 20	1%	9	8
	2%	8	7
	3%	7	6
VytaFlex® 30	1%	8	8
	2%	7	7
	3%	6	6
VytaFlex® 40	1%	14	5
	2%	13	4
	3%	11	3
VytaFlex® 50	1%	18	6
	2%	17	5
	3%	16	4
VytaFlex® 60	1%	14	7
	2%	13	6
	3%	12	5
ReoFlex® 20	1%	10	9
	2%	9	7
	3%	8	6
ReoFlex® 30	1%	8	9
	2%	7	8
	3%	6	7
ReoFlex® 40	1%	8	6
	2%	7	5
	3%	6	4

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<b>Smooth-On Urethane Rubber</b>	<b>Cure Accelerator Added by Weight To Part 'B'</b>	<b>Approximate Pot Life In Minutes</b>	<b>Approximate Demold Time In Hours</b>
ReoFlex® 50	1%	21	7
	2%	19	6
	3%	17	5
ReoFlex® 60	1%	17	8
	2%	15	7
	3%	14	6
PMC®-724	0.3 %	10	3
	1.0	5	2
PMC®-726	0.3 %	10	3
	1.0	5	2
*PMC®-121/30	5.0 %	15	4
	10.0	10	3
*PMC®-121/50	5.0 %	12	3
	10.0	8	2
*PMC®-744	5.0 %	15	3
	10.0	10	2
<b>PMC®-780</b>	5.0 %	25	5
	10.0	15	4

**\*Note:** No significant increase in demold time was noticed at percentages greater than 3% **except with PMC® urethane rubbers**, which can be accelerated at greater speeds than ReoFlex® or VytaFlex®. Demold time can generally reduced by ½ by exposing the material to 150° F.

**Example 1 – VytaFlex®10 (1:1 Mix Ratio):**

To reduce the demold time of VytaFlex® 10 from 24 hours to 7 hours, add 30 grams of accelerator to 1000 grams of VytaFlex® 10 Part B. Mix thoroughly for at least one minute, making sure that you scrape the sides and bottom of your container several times. Next, add 1000 grams of Part A and mix thoroughly for at least one minute, again making sure that you scrape the bottom and sides of your container several times. Pour the contents into a clean separate container and mix thoroughly. This will help to ensure that unmixed material does not contaminate the mold. Do not delay between mixing and pouring, as your pot life is about 6 minutes.

In about 7 hours, the rubber mold can be removed from the original model. Demold time can generally be reduced by ½ by exposing the material to 150° F