



Softening PMC-121/50 & PMC-744 Using 'SO-FLEX®'

'SO-FLEX®' is a softening agent that will lower the cured durometer of a variety of Smooth-On flexible polyurethane products. The charts below indicate the effect 'SO-FLEX®' has on fully cured (7 days) PMC®-121/50 and PMC®-744 when added as a percentage of the total mix. This product has a limited shelf life and should be used as soon as possible.

Use 'SO-FLEX®' By WEIGHT. . . . For best results, you should use an accurate scale to properly use 'SO-FLEX®' with PMC®-121/50 or PMC®-744, or any other flexible Smooth-On polyurethane product. 'SO-FLEX®' should be weighed and thoroughly mixed (at least one minute) with the appropriate amount of Part B before combining with Part A. Store and use products in a warm environment (72° F / 22° F). This product has a limited shelf life and should be used as soon as possible. Wear safety glasses, long sleeves and rubber gloves to minimize contamination risk.

Softening PMC®-121/50 with 'SO-FLEX®'

Normally, PMC®-121/50 cures to a hardness of Shore A 50. PMC®-121/50 can be made softer and more flexible by adding different percentages of 'SO-FLEX®'.

Parts By Weight

Part B	+	SO-FLEX® (mix thoroughly)	+	Part A	=	Shore A* Hardness
50		0		50	=	50
50		20		50	=	43
50		40		50	=	35
50		50		50	=	30

*Shore A hardness after 7 days.

Using SO-FLEX® by volume with PMC®-121/50 . . . if you want to add SO-FLEX® by volume instead of by weight, you can do so by measuring out equal amounts of parts A, B or SO-FLEX®. As indicated above, this will result in a cured Shore A hardness of 30.

Softening PMC®-744 with 'SO-FLEX®'

Normally, PMC®-744 cures to a hardness of Shore A 45. PMC®-744 can be made softer and more flexible by adding different percentages of 'SO-FLEX®' as indicated below.

Parts By Weight

Part B	+	SO-FLEX® (mix thoroughly)	+	Part A	=	Shore A* Hardness
50		0		100	=	45
50		20		100	=	40
50		40		100	=	35
50		50		100	=	30

*Shore A hardness after 7 days.

Smooth-On Inc. * 2000 Saint John Street * Easton * PA * 18042 * USA

Questions? Call Toll-Free: (800) 762-0744

Or Visit Our Website:

www.smooth-on.com 121306