



Technical Reference Chart

Silicone Rubber

All values measured after 7 days at 73°F/23°C

	Product Name	A:B Mix Ratio by Volume	A:B Mix Ratio by Weight	Mixed Viscosity (ASTM D-2393)	Pot Life (ASTM D-2392)	Cure Time	Shore Hardness (ASTM D-2240)	Specific Gravity (ASTM D-1475)	Specific Volume (ASTM D-1475)	Die B Tear Strength (ASTM D-624)	Tensile Strength (ASTM D-412)	Shrinkage (ASTM D-2566)	Elongation at Break (ASTM D-412)	Useful Temperature Range	Color
Tin-Cure	Mold Max™ 10	N/A	100A:10B	15,000 cps	45 min.	24 hrs.	10 A	1.15 g/cc	24.1 cu. in./lb.	100 pli	473 psi	0.001 in./in.	529 %	-65°F to 400°F (-53°C to 205°C)	Light Pink
	Mold Max™ 10T	N/A	100A:10B	14,000 cps	45 min.	24 hrs.	10 A	1.09 g/cc	25.4 cu. in./lb.	87 pli	405 psi	0.0025 in./in.	586 %	-65°F to 400°F (-53°C to 205°C)	Translucent
	Mold Max™ 14NV	N/A	100A:10B	7,500 cps	40 min.	4 hrs.	14 A	1.12 g/cc	24.7 cu. in./lb.	87 pli	490 psi	0.002 in./in.	600 %	-65°F to 400°F (-53°C to 205°C)	White
	Mold Max™ 15T	N/A	100A:10B	20,000 cps	45 min.	24 hrs.	15 A	1.08 g/cc	25.6 cu. in./lb.	94 pli	490 psi	0.002 in./in.	600 %	-65°F to 400°F (-53°C to 205°C)	Translucent
	Mold Max™ 20	N/A	100A:10B	25,000 cps	45 min.	24 hrs.	20 A	1.18 g/cc	23.5 cu. in./lb.	110 pli	555 psi	0.001 in./in.	512 %	-65°F to 400°F (-53°C to 205°C)	Light Pink
	Mold Max™ 25	N/A	100A:5B	25,000 cps	60 min.	24 hrs.	25 A	1.18 g/cc	23.5 cu. in./lb.	130 pli	577 psi	0.001 in./in.	375 %	-65°F to 400°F (-53°C to 205°C)	Purple
	Mold Max™ 27T	N/A	100A:10B	30,000 cps	45 min.	24 hrs.	27 A	1.11 g/cc	25.0 cu. in./lb.	110 pli	575 psi	0.002 in./in.	400 %	-65°F to 400°F (-53°C to 205°C)	Translucent
	Mold Max™ 29NV	N/A	100A:10B	10,000 cps	40 min.	6 hrs.	29 A	1.17 g/cc	23.7 cu. in./lb.	96 pli	417 psi	0.002 in./in.	361 %	-65°F to 400°F (-53°C to 205°C)	Yellow
	Mold Max™ 30	N/A	100A:10B	25,000 cps	45 min.	24 hrs.	30 A	1.18 g/cc	23.5 cu. in./lb.	125 pli	577 psi	0.002 in./in.	300 %	-65°F to 400°F (-53°C to 205°C)	Pink
	Mold Max™ 40	N/A	100A:10B	45,000 cps	45 min.	24 hrs.	40 A	1.14 g/cc	24.3 cu. in./lb.	120 pli	550 psi	0.004 in./in.	250 %	-65°F to 400°F (-53°C to 205°C)	Mint Green
	Mold Max™ 60	N/A	100A:3B	20,000 cps	40 min.	24 hrs.	60 A	1.45 g/cc	19.1 cu. in./lb.	63 pli	398 psi	0.0015 in./in.	132 %	-65°F to 560°F (-53°C to 294°C)	Red
	Mold Max™ STROKE	N/A	100A:10B	Brushable	30-45 min.	16 hrs.	30 A	1.18 g/cc	23.5 cu. in./lb.	125 pli	577 psi	0.002 in./in.	300 %	-65°F to 400°F (-53°C to 205°C)	White
	Mold Max™ XLS™ II	N/A	100A:10B	30,000 cps	40 min.	24 hrs.	30 A	1.22 g/cc	22.7 cu. in./lb.	110 pli	550 psi	0.001 in./in.	375 %	-65°F to 400°F (-53°C to 205°C)	Blue
	OOMOO™ 25	1A:1B	100A:130B	4,250 cps	15 min.	75 min.	25 A	1.34 g/cc	20.6 cu. in./lb.	40 pli	240 psi	0.0025 in./in.	250 %	-65°F to 400°F (-53°C to 205°C)	Light Blue
	OOMOO™ 30	1A:1B	100A:130B	4,250 cps	30 min.	6 hrs.	30 A	1.34 g/cc	20.6 cu. in./lb.	40 pli	240 psi	0.0025 in./in.	250 %	-65°F to 400°F (-53°C to 205°C)	Lavender
Platinum-Cure	PoYo™ Putty 40	20A:1B	100A:6B	Putty	3-5 min.	30 min.	40 A	1.30 g/cc	21.31 cu. in./lb.	85 pli	450 psi	0.003 in./in.	250 %	-65°F to 400°F (-53°C to 205°C)	Light Pink
	Body Double™ Fast Set	1A:1B	1A:1B	Brushable	90 seconds	7 min.	25 A	1.17 g/cc	23.7 cu. in./lb.	N/A	450 psi	<0.001 in./in.	500 %	-65°F to 450°F (-53°C to 232°C)	Aqua Green
	Body Double™ SILK	1A:1B	1A:1B	Brushable	6 min.	20 min.	25 A	0.91 g/cc	30.4 cu. in./lb.	N/A	N/A	<0.001 in./in.	N/A	-65°F to 450°F (-53°C to 232°C)	Green
	Body Double™ Standard Set	1A:1B	1A:1B	Brushable	5 min.	20 min.	25 A	1.17 g/cc	23.7 cu. in./lb.	N/A	525 psi	<0.001 in./in.	500 %	-65°F to 450°F (-53°C to 232°C)	Purple
	Dragon Skin™ 10 VERY FAST	1A:1B	1A:1B	23,000 cps	4 min.	30 min.	10 A	1.07 g/cc	25.8 cu. in./lb.	102 pli	475 psi	<0.001 in./in.	1,000 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Dragon Skin™ 10 FAST	1A:1B	1A:1B	23,000 cps	8 min.	75 min.	10 A	1.07 g/cc	25.8 cu. in./lb.	102 pli	475 psi	<0.001 in./in.	1,000 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Dragon Skin™ 10 MEDIUM	1A:1B	1A:1B	23,000 cps	20 min.	5 hrs.	10 A	1.07 g/cc	25.8 cu. in./lb.	102 pli	475 psi	<0.001 in./in.	1,000 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Dragon Skin™ 10 SLOW	1A:1B	1A:1B	23,000 cps	45 min.	7 hrs.	10 A	1.07 g/cc	25.8 cu. in./lb.	102 pli	475 psi	<0.001 in./in.	1,000 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Dragon Skin™ 10 NV	1A:1B	1A:1B	6,000 cps	15 min.	75 min.	10 A	1.07 g/cc	25.8 cu. in./lb.	90 pli	400 psi	<0.001 in./in.	663 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Dragon Skin™ 10 AF Anti Fungal	1A:1B	1A:1B	23,000 cps	20 min.	5 hrs.	10 A	1.07 g/cc	25.8 cu. in./lb.	102 pli	475 psi	<0.001 in./in.	1,000 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Dragon Skin™ 15	1A:1B	1A:1B	21,000 cps	40 min.	7 hrs.	15 A	1.07 g/cc	25.8 cu. in./lb.	112 pli	537 psi	<0.001 in./in.	771 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Dragon Skin™ 20	1A:1B	1A:1B	20,000 cps	25 min.	4 hrs.	20 A	1.08 g/cc	25.6 cu. in./lb.	120 pli	550 psi	<0.001 in./in.	620 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Dragon Skin™ 20 NV	1A:1B	1A:1B	4,000 cps	6 min.	30 min.	20 A	1.09 g/cc	25.4 cu. in./lb.	138 pli	440 psi	<0.001 in./in.	672 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Dragon Skin™ 25 NV	1A:1B	1A:1B	5,000 cps	10 min.	30 min.	25 A	1.10 g/cc	25.16 cu. in./lb.	139 pli	490 psi	<0.001 in./in.	616 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Dragon Skin™ 30	1A:1B	1A:1B	20,000 cps	45 min.	16 hrs.	30 A	1.08 g/cc	25.7 cu. in./lb.	108 pli	500 psi	<0.001 in./in.	364 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Dragon Skin™ FX- Pro™	1A:1B	1A:1B	18,000 cps	12 min.	40 min.	2 A	1.062 g/cc	25.0 cu. in./lb.	61 pli	288 psi	<0.001 in./in.	763 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Ecoflex™ 00-10	1A:1B	1A:1B	14,000 cps	30 min.	4 hrs.	00-10	1.04 g/cc	26.6 cu. in./lb.	22 pli	120 psi	<0.001 in./in.	800 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Ecoflex™ 00-20	1A:1B	1A:1B	3,000 cps	30 min.	4 hrs.	00-20	1.07 g/cc	26.0 cu. in./lb.	30 pli	160 psi	<0.001 in./in.	845 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Ecoflex™ 00-20 FAST	1A:1B	1A:1B	3,000 cps	20 min.	1 hour	00-20	1.07 g/cc	26.0 cu. in./lb.	30 pli	160 psi	<0.001 in./in.	845 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Ecoflex™ 00-30	1A:1B	1A:1B	3,000 cps	45 min.	4 hrs.	00-30	1.07 g/cc	26.0 cu. in./lb.	38 pli	200 psi	<0.001 in./in.	900 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Ecoflex™ 00-31 Near Clear™	1A:1B	1A:1B	3,000 cps	40 min.	4 hrs.	00-31	1.07 g/cc	26.0 cu. in./lb.	38 pli	200 psi	<0.001 in./in.	900 %	-65°F to 450°F (-53°C to 232°C)	Water Clear Translucent



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Platinum-Cure (cont.)	Ecoflex™ 00-33AF Anti Fungal	1A:1B	1A:1B	3,000 cps	45 min.	4 hrs.	00-33	1.07 g/cc	26.0 cu. in./lb.	38 pli	200 psi	<0.001 in./in.	900 %	-65°F to 450°F (-53°C to 232°C)	Off-White Translucent
	Ecoflex™ 00-35 FAST	1A:1B	N/A	3,500 cps	2.5 min.	5 min.	00-35	1.07 g/cc	26.0 cu. in./lb.	38 pli	200 psi	<0.001 in./in.	900 %	-65°F to 450°F (-53°C to 232°C)	Off-White Translucent
	Ecoflex™ 00-45 Near Clear™	1A:1B	1A:1B	2,000 cps	45 min.	4 hrs.	00-45	1.06 g/cc	26.2 cu. in./lb.	50 pli	315 psi	<0.001 in./in.	980 %	-65°F to 450°F (-53°C to 232°C)	Water Clear Translucent
	Ecoflex™ 00-50	1A:1B	1A:1B	8,000 cps	18 min.	3 hrs.	00-50	1.07 g/cc	25.9 cu. in./lb.	50 pli	315 psi	<0.001 in./in.	980 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Ecoflex™ 5	1A:1B	1A:1B	13,000 cps	1 minute	5 min.	5 A	1.07 g/cc	25.8 cu. in./lb.	75 pli	350 psi	<0.001 in./in.	1,000 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Ecoflex™ GEL	1A:1B	1A:1B	9,300 cps	15 min.	2 hrs.	000-35	0.98 g/cc	28 cu. in./lb.	N/A	N/A	<0.001 in./in.	>1000 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Ecoflex™ GEL 2	1A:1B	1A:1B	5,000 cps	20 min.	50 min.	000-34	0.98 g/cc	26.4 cu. in./lb.	N/A	N/A	<0.001 in./in.	>1000 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Encapso™ K	1A:1B	1A:1B	150 cps	120 min.	16 hrs.	33 A	0.97 g/cc	28.6 cu. in./lb.	N/A	N/A	0.001 in./in.	N/A	N/A	Clear
	Equinox™ 35 FAST	1A:1B	1A:1B	Putty	1 minute	7 min.	35 A	1.25 g/cc	22.2 cu. in./lb.	140 pli	520 psi	0.001 in./in.	430 %	-65°F to 450°F (-53°C to 232°C)	Light Purple
	Equinox™ 38 MEDIUM	1A:1B	1A:1B	Putty	4 min.	30 min.	38 A	1.25 g/cc	22.2 cu. in./lb.	140 pli	520 psi	0.001 in./in.	430 %	-65°F to 450°F (-53°C to 232°C)	Light Purple
	Equinox™ 40 SLOW	1A:1B	1A:1B	Putty	30 min.	5 hrs.	40 A	1.25 g/cc	22.2 cu. in./lb.	140 pli	520 psi	0.001 in./in.	430 %	-65°F to 450°F (-53°C to 232°C)	Light Purple
	EZ-Brush™ Vac Bag Silicone	1A:1B	1A:1B	20,000 cps	30 min.	3.5 hrs.	20 A	1.08 g/cc	25.7 cu. in./lb.	120 pli	550 psi	<0.001 in./in.	364 %	-65°F to 450°F (-53°C to 232°C)	Translucent Green
	EZ-Spray™ 35	1A:1B	N/A	Sprayable	1.5 min.	1 hour	35 A	1.15 g/cc	24.1 cu. in./lb.	92 pli	490 psi	<0.001 in./in.	415 %	-65°F to 450°F (-53°C to 232°C)	Purple
	EZ-Spray™ Silicone 20	1A:1B	N/A	11,000 cps	3 min.	20 min.	20 A	1.08 g/cc	25.6 cu. in./lb.	100 pli	495 psi	<0.001 in./in.	470 %	-65°F to 450°F (-53°C to 232°C)	Translucent Green
	EZ-Spray™ Silicone 22	1A:1B	N/A	11,000 cps	5 min.	45 min.	22 A	1.08 g/cc	25.6 cu. in./lb.	102 pli	490 psi	<0.001 in./in.	450 %	-65°F to 450°F (-53°C to 232°C)	Translucent Green
	Mold Star™ 14T	1A:1B	1A:1B	11,000 cps	3 min.	9 min.	14 A	1.08 g/cc	25.6 cu. in./lb.	90 pli	420 psi	<0.001 in./in.	490 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Mold Star™ 15 SLOW	1A:1B	1A:1B	12,500 cps	50 min.	4 hrs.	15 A	1.18 g/cc	23.5 cu. in./lb.	88 pli	400 psi	<0.001 in./in.	440 %	-65°F to 450°F (-53°C to 232°C)	Green
	Mold Star™ 16 FAST	1A:1B	1A:1B	12,500 cps	6 min.	30 min.	16 A	1.18 g/cc	23.5 cu. in./lb.	88 pli	400 psi	<0.001 in./in.	440 %	-65°F to 450°F (-53°C to 232°C)	Blue-Green
	Mold Star™ 19T	1A:1B	1A:1B	11,000 cps	3 min.	12 min.	19 A	1.08 g/cc	25.6 cu. in./lb.	90 pli	420 psi	<0.001 in./in.	470 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Mold Star™ 20T	1A:1B	1A:1B	11,000 cps	6 min.	30 min.	20 A	1.08 g/cc	25.6 cu. in./lb.	90 pli	420 psi	<0.001 in./in.	470 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Mold Star™ 30	1A:1B	100A:96B	12,500 cps	45 min.	6 hrs.	30 A	1.12 g/cc	24.7 cu. in./lb.	88 pli	420 psi	<0.001 in./in.	339 %	-65°F to 450°F (-53°C to 232°C)	Blue
	Mold Star™ 31T	1A:1B	1A:1B	11,000 cps	5 min.	23 min.	30 A	1.08 g/cc	25.6 cu. in./lb.	90 pli	423 psi	< 0.001 in./in.	400 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Mold Star™ 40T	1A:1B	1A:1B	11,000 cps	20 min.	3 hrs.	30 A	1.12 g/cc	24.7 cu. in./lb.	140 pli	656 psi	< 0.001 in./in.	500 %	-65°F to 450°F (-53°C to 232°C)	Translucent
	Rebound™ 25	1A:1B	1A:1B	Brushable	20 min.	6 hrs.	25 A	1.14 g/cc	23.5 cu. in./lb.	102 pli	515 psi	<0.001 in./in.	690 %	-65°F to 450°F (-53°C to 232°C)	Orange
	Rebound™ 40	1A:1B	1A:1B	Brushable	20 min.	6 hrs.	40 A	1.14 g/cc	23.5 cu. in./lb.	106 pli	486 psi	<0.001 in./in.	324 %	-65°F to 450°F (-53°C to 232°C)	Green
	Rubber Glass™	1A:1B	1A:1B	150 cps	120 min.	16 hrs.	33 A	0.97 g/cc	28.6 cu. in./lb.	N/A	N/A	<0.001 in./in.	N/A	N/A	Clear
	Smooth-Sil™ 933 Flame Out	1A:1B	1A:1B	40,000 cps	45 min.	6 hrs.	33 A	1.42 g/cc	19.5 cu. in./lb.	50 pli	222 psi	<0.001 in./in.	433 %	-65°F to 450°F (-53°C to 232°C)	White
	Smooth-Sil™ 936	N/A	100A:10B	21,000 cps	60 min.	24 hrs.	36 A	1.21 g/cc	22.9 cu. in./lb.	110 pli	550 psi	<0.001 in./in.	500 %	-65°F to 450°F (-53°C to 232°C)	Blue
	Smooth-Sil™ 940	N/A	100A:10B	35,000 cps	30 min.	24 hrs.	40 A	1.18 g/cc	23.4 cu. in./lb.	100 pli	600 psi	<0.001 in./in.	300 %	-65°F to 450°F (-53°C to 232°C)	Pink
	Smooth-Sil™ 945	1A:1B	1A:1B	30,000 cps	25 min.	6 hrs.	45 A	1.24 g/cc	22.3 cu. in./lb.	120 pli	700 psi	<0.001 in./in.	320 %	-65°F to 450°F (-53°C to 232°C)	Purple
	Smooth-Sil™ 950	N/A	100A:10B	35,000 cps	45 min.	18 hrs.	50 A	1.24 g/cc	22.3 cu. in./lb.	155 pli	725 psi	<0.001 in./in.	320 %	-65°F to 450°F (-53°C to 232°C)	Blue
	Smooth-Sil™ 960	N/A	100A:10B	30,000 cps	45 min.	16 hrs.	60 A	1.25 g/cc	22.2 cu. in./lb.	110 pli	650 psi	<0.001 in./in.	270 %	-65°F to 450°F (-53°C to 232°C)	Green
	Solaris™	1A:1B	1A:1B	1,200 cps	240 min.	24 hrs.	15 A	0.99 g/cc	28.1 cu. in./lb.	N/A	180 psi	<0.001 in./in.	290 %	-149°F to 400°F (-100°C to 205°C)	Clear
	SORTA-Clear™ 12	1A:1B	1A:1B	6,000 cps	40 min.	12 hrs.	12 A	1.07 g/cc	25.9 cu. in./lb.	80 pli	320 psi	<0.001 in./in.	590 %	-65°F to 450°F (-53°C to 232°C)	Water Clear Translucent
	SORTA-Clear™ 18	N/A	100A:10B	21,000 cps	60 min.	24 hrs.	18 A	1.08 g/cc	25.6 cu. in./lb.	80 pli	425 psi	<0.001 in./in.	545 %	-65°F to 450°F (-53°C to 232°C)	Water Clear Translucent
	SORTA-Clear™ 37	1A:1B	1A:1B	35,000 cps	25 min.	4 hrs.	37 A	1.08 g/cc	25.6 cu. in./lb.	105 pli	600 psi	<0.001 in./in.	400 %	-65°F to 450°F (-53°C to 232°C)	Water Clear Translucent
	SORTA-Clear™ 40	N/A	100A:10B	35,000 cps	60 min.	16 hrs.	40 A	1.08 g/cc	25.6 cu. in./lb.	120 pli	800 psi	<0.001 in./in.	400 %	-65°F to 450°F (-53°C to 232°C)	Water Clear Translucent



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Brush-On™ 35	1A:1B	100A:67B	Brushable	20 min.	16 hrs.	35 A	1.29 g/cc	21.5 cu. in./lb.	57 pli	335 psi	<0.001 in./in.	1,000 %	Grey-Green
Brush-On™ 40	1A:1B	100A:125B	Brushable	20 min.	16 hrs.	40 A	1.17 g/cc	23.7 cu. in./lb.	60 pli	300 psi	<0.001 in./in.	1,000 %	Off White
Brush-On™ 50	1A:1B	100A:125B	Brushable	20 min.	16 hrs.	50 A	1.17 g/cc	23.7 cu. in./lb.	80 pli	500 psi	<0.001 in./in.	400 %	Off White
Brush-On™ 60	1A:1B	100A:125B	Brushable	20 min.	16 hrs.	60 A	1.18 g/cc	23.5 cu. in./lb.	80 pli	630 psi	<0.001 in./in.	400 %	Off White
Clear Flex™ 30	1A:1B	100A:94B	750 cps	15 min.	16 hrs.	30 A	1.03 g/cc	26.9 cu. in./lb.	54 pli	725 psi	0.002 in./in.	675 %	Clear
Clear Flex™ 50	N/A	1A:2B	250 cps	25 min.	16 hrs.	50 A	1.04 g/cc	26.8 cu. in./lb.	25 pli	250 psi	0.0015 in./in.	500 %	Clear
Clear Flex™ 95	N/A	1A:1.5B	250 cps	25 min.	16 hrs.	95 A	1.04 g/cc	26.8 cu. in./lb.	200 pli	2,500 psi	0.0028 in./in.	175 %	Clear
Compat™ 45	1A:1B	85A:100B	2,600 cps	25 min.	16 hrs.	45 A	1.12 g/cc	24.7 cu. in./lb.	101 pli	629 psi	<0.001 in./in.	772 %	Brown
Econ™ 60	1A:1B	1A:1B	1,400 cps	6 min.	16 hrs.	60 A	1.04 g/cc	26.7 cu. in./lb.	85 pli	350 psi	<0.001 in./in.	500 %	Translucent Amber
Econ™ 80	1A:1B	100A:90B	1,200 cps	13 min.	24 hrs.	80 A	1.06 g/cc	26.16 cu. in./lb.	77 pli	955 psi	0.0014 in./in.	127 %	Translucent
EZ-Mix™ 40	1A:1B	100A:95B	Brushable	18 min.	16 hrs.	40 A	1.025 g/cc	27 cu. in./lb.	67 pli	420 psi	<0.001 in./in.	577 %	Grey
EZ-Spray™ 45	1A:1B	N/A	Sprayable	20 min.	16 hrs.	45 A	1.025 g/cc	27 cu. in./lb.	100 pli	510 psi	<0.001 in./in.	375 %	Light Blue
Formlastic™ 48	1A:1B	100A:118B	3,000 cps	25 min.	24 hrs.	48 A	1.14 g/cc	24.3 cu. in./lb.	98 pli	700 psi	<0.001 in./in.	1,250 %	Off White
Formlastic™ 60	1A:1B	100A:118B	3,000 cps	40 min.	24 hrs.	60 A	1.14 g/cc	24.3 cu. in./lb.	146 pli	1,025 psi	<0.001 in./in.	1,000 %	Off White
PMC™-121 30/DRY	1A:1B	1A:1B	1,800 cps	30 min.	16 hrs.	30 A	1.04 g/cc	26.7 cu. in./lb.	75 pli	400 psi	< 0.001 in./in.	1,000 %	Clear Amber
PMC™-121 30/WET	1A:1B	1A:1B	1,800 cps	30 min.	16 hrs.	30 A	1.04 g/cc	26.7 cu. in./lb.	75 pli	400 psi	< 0.001 in./in.	1,000 %	Clear Amber
PMC™-121 50/WET	1A:1B	1A:1B	1,400 cps	30 min.	16 hrs.	50 A	1.04 g/cc	26.7 cu. in./lb.	85 pli	350 psi	< 0.001 in./in.	500 %	Clear Amber
PMC™-724	N/A	10A:100B	4,000 cps	20 min.	16 hrs.	40 A	1.38 g/cc	20.1 cu. in./lb.	90 pli	600 psi	<0.001 in./in.	>700 %	Off-White
PMC™-744	2A:1B	2A:1B	3,400 cps	15 min.	16 hrs.	44 A	1.01 g/cc	27.5 cu. in./lb.	90 pli	300 psi	< 0.001 in./in.	400 %	Beige
PMC™-746	2A:1B	2A:1B	1,200 cps	15 min.	16 hrs.	60 A	1.03 g/cc	26.9 cu. in./lb.	100 pli	700 psi	< 0.001 in./in.	650 %	Ranges From Amber To Blue
PMC™-746 Clear Amber	2A:1B	2A:1B	1,200 cps	15 min.	16 hrs.	60 A	1.03 g/cc	26.9 cu. in./lb.	100 pli	700 psi	< 0.001 in./in.	650 %	Clear Amber
PMC™-770	N/A	2A:1B	3,000 cps	30 min.	16 hrs.	70 A	1.04 g/cc	26.5 cu. in./lb.	200 pli	750 psi	<0.001 in./in.	750 %	Light Amber
PMC™-780 DRY	2A:1B	2A:1B	2,000 cps	25 min.	48 hrs.	80 A	1.02 g/cc	27.2 cu. in./lb.	200 pli	900 psi	<0.001 in./in.	750 %	Light Amber
PMC™-780 WET	2A:1B	2A:1B	2,000 cps	25 min.	48 hrs.	80 A	1.02 g/cc	27.2 cu. in./lb.	200 pli	900 psi	<0.001 in./in.	750 %	Light Amber
PMC™-790	2A:1B	2A:1B	3,000 cps	20 min.	48 hrs.	90 A	1.07 g/cc	25.9 cu. in./lb.	300 pli	2,000 psi	<0.001 in./in.	550 %	Clear Amber
ReoFlex™ 20	1A:1B	1A:1B	1,800 cps	30 min.	16 hrs.	20 A	1.01 g/cc	27.3 cu. in./lb.	60 pli	200 psi	<0.001 in./in.	1,000 %	Off White
ReoFlex™ 30	1A:1B	1A:1B	1,500 cps	30 min.	16 hrs.	30 A	1.01 g/cc	27.5 cu. in./lb.	82 pli	450 psi	<0.001 in./in.	1,000 %	Off White
ReoFlex™ 40	1A:1B	1A:1B	1,500 cps	30 min.	16 hrs.	40 A	1.02 g/cc	27.2 cu. in./lb.	85 pli	490 psi	<0.001 in./in.	1,000 %	Off White
ReoFlex™ 50	1A:1B	1A:1B	2,000 cps	50 min.	16 hrs.	50 A	1.01 g/cc	27.4 cu. in./lb.	120 pli	580 psi	<0.001 in./in.	435 %	Off White
ReoFlex™ 60	1A:1B	1A:1B	1,800 cps	50 min.	16 hrs.	60 A	1.04 g/cc	26.7 cu. in./lb.	132 pli	782 psi	<0.001 in./in.	581 %	Off White
UreCoat™	N/A	100A:10B	3,800 cps	8 min.	16 hrs.	70 A	1.05 g/cc	26.4 cu. in./lb.	256 pli	1,360 psi	N/A	876 %	Translucent Amber
VytaFlex™ 10	1A:1B	1A:1B	3,100 cps	30 min.	24 hrs.	10 A	1.00 g/cc	27.9 cu. in./lb.	38 pli	200 psi	<0.001 in./in.	1,000 %	Off-White
VytaFlex™ 20	1A:1B	1A:1B	1,000 cps	30 min.	16 hrs.	20 A	1.00 g/cc	27.7 cu. in./lb.	60 pli	200 psi	<0.001 in./in.	1,000 %	Clear Amber
VytaFlex™ 30	1A:1B	1A:1B	1,800 cps	30 min.	16 hrs.	30 A	1.02 g/cc	27.3 cu. in./lb.	78 pli	500 psi	<0.001 in./in.	1,000 %	Off-White
VytaFlex™ 40	1A:1B	1A:1B	2,000 cps	30 min.	16 hrs.	40 A	1.03 g/cc	26.9 cu. in./lb.	82 pli	522 psi	<0.001 in./in.	660 %	Off-White
VytaFlex™ 45	1A:1B	1A:1B	2,000 cps	30 min.	16 hrs.	45 A	1.04 g/cc	26.4 cu. in./lb.	100 pli	886 psi	<0.001 in./in.	900 %	Off White
VytaFlex™ 50	1A:1B	1A:1B	2,000 cps	60 min.	16 hrs.	50 A	1.04 g/cc	26.7 cu. in./lb.	102 pli	588 psi	<0.001 in./in.	400 %	Off-White
VytaFlex™ 60	1A:1B	1A:1B	2,000 cps	60 min.	16 hrs.	60 A	1.04 g/cc	26.6 cu. in./lb.	136 pli	880 psi	<0.001 in./in.	480 %	Off-White



Technical Reference Chart

Urethane Plastic

All values measured after 7 days at 73°F/23°C

¹ If post cured according to heat post curing schedule.

Product Name	A:B Mix Ratio by Volume	A:B Mix Ratio by Weight	Mixed Viscosity (ASTM D-2393)	Pot Life (ASTM D-2392)	Handling Time @ 73°F (23°C)	Cure Time	Shore Hardness (ASTM D-2240)	Specific Gravity (ASTM D-1475)	Specific Volume (ASTM D-1475)	Ultimate Tensile (ASTM D-638) (except tASTM D-412)	Tensule Modulus (ASTM D-638)	Elongation at Break (ASTM D-638) (except ASTM D-412)	Flexural Strength (ASTM D-790)	Flexural Modulus (ASTM D-790)	Compressive Strength (ASTM D-695)	Heat Deflection Temperature (ASTM D-648)	Compressive Modulus (ASTM D-2566)	Shrinkage (ASTM D-2566)	Color
Crystal Clear™ 200	N/A	100A:90B	600 cps	20 min.	N/A	16 hrs.	80 D	1.036 g/cc	26.7 cu. in./lb.	2,500 psi	73,200 psi	10 %	10,650 psi	200,000 psi	6,385 psi	120°F (50°C)	40,000 psi	0.001 in./in.	Clear
Crystal Clear™ 202	N/A	100A:90B	600 cps	9 min.	N/A	90 min.	80 D	1.036 g/cc	26.7 cu. in./lb.	3,500 psi	86,240 psi	10 %	5,390 psi	183,200 psi	4,200 psi	120°F (50°C)	44,000 psi	0.0125 in./in.	Clear
Crystal Clear™ 204	N/A	100A:90B	600 cps	2 hrs.	N/A	48 hrs.	80 D	1.036 g/cc	26.7 cu. in./lb.	3,500 psi	86,240 psi	10 %	5,390 psi	183,200 psi	4,200 psi	120°F (50°C)	44,000 psi	0.002 in./in.	Clear
Crystal Clear™ 206	N/A	100A:90B	600 cps	4.5 hrs.	N/A	7 days	80 D	1.036 g/cc	26.7 cu. in./lb.	2,500 psi	73,200 psi	10 %	10,650 psi	200,000 psi	6,385 psi	120°F (50°C)	40,000 psi	0.002 in./in.	Clear
Crystal Clear™ 220	N/A	100A:75B	675 cps	22 min.	N/A	Overnight*	85 D	1.07 g/cc	25.9 cu. in./lb.	8,190 psi	286,000 psi	12 %	11,400 psi	305,000 psi	10,100 psi	176°F (80°C)	87,000 psi	0.0173 in./in.	Clear
Crystal Clear™ 221	N/A	100A:75B	675 cps	75 min.	N/A	Overnight*	85 D	1.07 g/cc	25.9 cu. in./lb.	8,190 psi	286,000 psi	12 %	11,400 psi	305,000 psi	10,100 psi	176°F (80°C)	87,000 psi	0.0173 in./in.	Clear
EZ-Spray™ Plastic	1A:1B	N/A	Variable	2 seconds	N/A	3 hrs.	75 D	1.11 g/cc	25 cu. in./lb.	2,650 psi	100,000 psi	10 %	5,000 psi	153,000 psi	5,000 psi	130°F (55°C)	45,000 psi	0.016 in./in.	Off White
EZ-Spray™ StyroCoat™	1A:1B	N/A	Variable	2 seconds	N/A	60 min.	80 D	1.12 g/cc	24.7 cu. in./lb.	3,170 psi	131,000 psi	20 %	6,400 psi	205,000 psi	5,000 psi	130°F (55°C)	47,600 psi	0.015 in./in.	Off White
Feather Lite™	1A:1B	N/A	410 cps	8.5 min.	N/A	2 hrs.	58 D	0.67 g/cc	41.3 cu. in./lb.	2,160 psi	156,000 psi	1.6 %	3,440 psi	164,300 psi	3,070 psi	140°F (60°C)	53,700 psi	0.003 in./in.	Beige
KX Flex™ 40	1A:1B	1A:1B	800 cps	2.5 min.	30 min.	24 hrs.	40 A	1.07 g/cc	25.9 cu. in./lb.	457 psi	N/A	400 %	N/A	N/A	N/A	N/A	N/A	0.002 in./in.	Translucent White
KX Flex™ 60	1A:1B	100A:94B	800 cps	2.5 min.	30 min.	24 hrs.	60 A	1.15 g/cc	24.1 cu. in./lb.	1,800 psi	N/A	125 %	N/A	N/A	N/A	N/A	N/A	0.005 in./in.	Off-White
KX Flex™ 90	N/A	100A:120B	800 cps	2.5 min.	30 min.	24 hrs.	90 A	1.15 g/cc	24.1 cu. in./lb.	1,800 psi	N/A	125 %	N/A	N/A	N/A	N/A	N/A	0.005 in./in.	Off-White
Plasti-Paste™	1A:3B	41A:100B	Paste	8-10 min.	90 min.	24 hrs.	70 D	1.16 g/cc	23.9 cu. in./lb.	1,600 psi	168,100 psi	1.5 %	3,410 psi	150,000 psi	3,420 psi	130°F (55°C)	48,800 psi	0.005 in./in.	Off White
Plasti-Paste™ II	1A:2B	62A:100B	Paste	10 min.	90 min.	24 hrs.	70 D	1.0 g/cc	27.73 cu. in./lb.	2,150 psi	235,000 psi	1.14 %	3,840 psi	203,000 psi	4,980 psi	130°F (55°C)	62,700 psi	0.005 in./in.	Off White
Shell Shock™ FAST	1A:4B	1A:5B	3,000 cps	3 min.	N/A	60 min.	85 D	1.60 g/cc	17.3 cu. in./lb.	3,100 psi	435,000 psi	0.4 %	7,150 psi	980,000 psi	9,000 psi	135°F	500,000 psi	0.0006 in./in.	Beige
Shell Shock™ SLOW	1A:4B	1A:5B	3,000 cps	8 min.	N/A	5 hrs.	85 D	1.60 g/cc	17.3 cu. in./lb.	3,100 psi	435,000 psi	0.4 %	7,150 psi	980,000 psi	9,000 psi	135°F	500,000 psi	0.0006 in./in.	Beige
Simpact™ 60A	1A:1B	100A:94B	1,100 cps	4 min.	2 hrs.	48 hrs.	60 A	1.08 g/cc	25.7 cu. in./lb.	142 pli	990 psi ^t	400 % ^t	N/A	N/A	N/A	N/A	N/A	<.007 in./in.	White
Simpact™ 80A-II	2A:1B	100A:48B	2,000 cps	15 min.	4 hrs.	48 hrs.	80 A	1.09 g/cc	25.4 cu. in./lb.	182 pli	2,295 psi ^t	164 % ^t	N/A	N/A	N/A	N/A	N/A	<.007 in./in.	Amber
Simpact™ 85A	N/A	85A:100B	1,100 cps	4 min.	2 hrs.	48 hrs.	85 A	1.09 g/cc	25.4 cu. in./lb.	182 pli	1,573 psi ^t	164 % ^t	N/A	N/A	N/A	N/A	N/A	<.007 in./in.	Off White
SMASH! Plastic™	1A:1B	N/A	900 cps	5 min.	90 min.	16 hrs.	80 D	1.036 g/cc	26.7 cu. in./lb.	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	0.0001 in./in.	Clear
Smooth-Cast™ 45D	1A:1B	100A:93B	250 cps	5 min.	N/A	30 min.	45 D	1.10 g/cc	25.2 cu. in./lb.	1,560 psi	N/A	100 %	N/A	N/A	N/A	N/A	N/A	0.007 in./in.	Translucent White
Smooth-Cast™ 57D	1A:1B	100A:93B	300 cps	3 min.	N/A	30 min.	57 D	1.05 g/cc	26.4 cu. in./lb.	2,420 psi	N/A	100 %	N/A	N/A	N/A	N/A	N/A	0.012 in./in.	Translucent White
Smooth-Cast™ 60D	1A:1B	100A:93B	430 cps	5 min.	N/A	30 min.	60 D	1.05 g/cc	26.4 cu. in./lb.	2,420 psi	N/A	100 %	N/A	N/A	N/A	N/A	N/A	0.012 in./in.	Translucent White
Smooth-Cast™ 61D	1A:1B	100A:93B	430 cps	7 min.	N/A	60 min.	61 D	1.05 g/cc	26.4 cu. in./lb.	2,420 psi	N/A	100 %	N/A	N/A	N/A	N/A	N/A	0.012 in./in.	Translucent White
Smooth-Cast™ 65D	1A:1B	100A:93B	120 cps	2.5 min.	N/A	10-15 min.	65 D	1.05 g/cc	26.4 cu. in./lb.	2,400 psi	N/A	20 %	N/A	N/A	N/A	N/A	N/A	0.01 in./in.	White
Smooth-Cast™ 66D	1A:1B	100A:93B	120 cps	7 min.	N/A	60 min.	66 D	1.05 g/cc	26.4 cu. in./lb.	2,400 psi	N/A	20 %	N/A	N/A	N/A	N/A	N/A	0.01 in./in.	Grey
Smooth-Cast™ 300	1A:1B	100A:90B	80 cps	3 min.	N/A	10 min.	70 D	1.05 g/cc	26.4 cu. in./lb.	3,000 psi	139,500 psi	5 %	4,510 psi	128,000 psi	4,000 psi	120°F (50°C)	45,800 psi	0.01 in./in.	White
Smooth-Cast™ 300Q	1A:1B	100A:90B	80 cps	30 seconds	N/A	4-5 min.	70 D	1.05 g/cc	26.4 cu. in./lb.	3,000 psi	139,500 psi	5 %	4,510 psi	128,000 psi	4,000 psi	120°F (50°C)	45,800 psi	0.01 in./in.	White
Smooth-Cast™ 305	1A:1B	100A:90B	80 cps	7 min.	N/A	30 min.	70 D	1.05 g/cc	26.4 cu. in./lb.	3,000 psi	134,000 psi	7.5 %	4,000 psi	118,000 psi	3,800 psi	120°F (50°C)	44,900 psi	0.0065 in./in.	White
Smooth-Cast™ 310	1A:1B	100A:90B	80 cps	15-20 min.	N/A	3-4 hrs.	70 D	1.05 g/cc	26.4 cu. in./lb.	3,000 psi	134,000 psi	7.5 %	4,000 psi	118,000 psi	3,800 psi	120°F (50°C)	44,900 psi	0.0065 in./in.	White
Smooth-Cast™ 320	1A:1B	100A:90B	80 cps	3 min.	N/A	10 min.	70 D	1.05 g/cc	26.4 cu. in./lb.	3,000 psi	138,000 psi	10 %	4,500 psi	132,000 psi	3,650 psi	140°F (60°C)	45,800 psi	0.01 in./in.	Off White
Smooth-Cast™ 321	1A:1B	100A:90B	80 cps	7-9 min.	N/A	30 min.	70 D	1.05 g/cc	26.4 cu. in./lb.	3,000 psi	138,000 psi	8 %	3,500 psi	110,000 psi	3,550 psi	140°F (60°C)	40,300 psi	0.007 in./in.	Off White
Smooth-Cast™ 322	1A:1B	100A:90B	80 cps	10-20 min.	N/A	2-4 hrs.	70 D	1.05 g/cc	26.4 cu. in./lb.	3,000 psi	134,000 psi	8 %	3,500 psi	110,000 psi	3,550 psi	140°F (60°C)	40,300 psi	0.007 in./in.	Off White
Smooth-Cast™ 325	1A:1B	115A:100B	100 cps	2.5 min.	N/A	10 min.	72 D	1.07 g/cc	25.9 cu. in./lb.	3,170 psi	140,000 psi	10 %	3,690 psi	101,000 psi	3,500 psi	120°F (50°C)	36,500 psi	0.01 in./in.	Clear Amber
Smooth-Cast™ 326	1A:1B	115A:100B	100 cps	7-9 min.	N/A	60 min.	72 D	1.07 g/cc	25.9 cu. in./lb.	3,170 psi	140,000 psi	10 %	3,100 psi	95,700 psi	3,080 psi	120°F (50°C)	32,200 psi	0.0075 in./in.	Clear Amber
Smooth-Cast™ 327	1A:1B	115A:100B	100 cps	10-20 min.	N/A	2-4 hrs.	72 D	1.07 g/cc	25.9 cu. in./lb.	3,170 psi	140,000 psi	10 %	3,100 psi	95,700 psi	3,080 psi	120°F (50°C)	32,200 psi	0.0075 in./in.	Clear Amber
Smooth-Cast™ 380	1A:1B	1A:1B	1,140 cps	6 min.	N/A	60 min.	82 D	1.74 g/cc	15.9 cu. in./lb.	3,550 psi	490,000 psi	1.43 %	4,870 psi	315,000 psi	7,860 psi	125°F (53°C)	126,000 psi	0.0025 in./in.	Tan
Smooth-Cast™ 385	N/A	1A:5B	3,000 cps	20 min.	N/A	2 hrs.	85 D	1.60 g/cc	17.3 cu. in./lb.	3,100 psi	400,000 psi	1 %	5,900 psi	433,000 psi	8,500 psi	135°F (57°C)	400,000 psi	0.0006 in./in.	Beige
Smooth-Cast™ ONYX™ FAST	100A:100B	120A:100B	100 cps	2.5 min.	N/A	15 min.	80 D	1.09 g/cc	27.7 cu. in./lb.	5,840 psi	246,000 psi	4 %	8,280 psi	246,000 psi	8,760 psi	250°F (121°C) ¹	77,400 psi	0.010 in./in.	Black
Smooth-Cast™ ONYX™ SLOW	100A:100B	120A:100B	100 cps	5 min.	N/A	90 min.	80 D	1.09 g/cc	27.7 cu. in./lb.	7,660 psi	374,000 psi	3 %	10,230 psi	286,000 psi	11,400 psi	212°F (100°C) ¹	97,900 psi	0.012 in./in.	Black
TASK™ 2	1A:1B	115A:100B	150 cps	7 min.	N/A	60 min.	80 D	1.12 g/cc	24.7 cu. in./lb.	6,650 psi	290,000 psi	6 %	9,500 psi	288,000 psi	8,300 psi	134°F (57°C)	78,000 psi	0.005 in./in.	White
TASK™ 3	1A:1B	115A:100B	150 cps	20 min.	N/A	90 min.	80 D	1.12 g/cc	24.7 cu. in./lb.	6,650 psi	290,000 psi	6 %	9,500 psi	288,000 psi	8,300 psi	134°F (57°C)	78,000 psi	0.0025 in./in.	White
TASK™ 4	N/A	100A:100B	250 cps	20 min.	N/A	16 hrs.	83 D	1.167 g/cc	23.9 cu. in./lb.	6,500 psi	130,000 psi	4 %	9,000 psi	204,000 psi	7,400 psi	110°F (45°C)	75,000 psi	0.0035 in./in.	Ivory
TASK™ 5	1A:1B	1A:1B	600 cps	3 min.	15 min.	24 hrs.	77 D	1.1 g/cc	25.2 cu. in./lb.	4,530 psi	200,000 psi	5 %	6,480 psi	216,000 psi	6,700 psi	145°F (63°C)	83,000 psi	0.007 in./in.	Tan
TASK™ 6	1A:1B	1A:1B	800 cps	7 min.	75 min.	24 hrs.	75 D	1.07 g/cc	25.9 cu. in./lb.	5,200 psi	146,000 psi	4 %	6,200 psi	182,500 psi	5,570 psi	162°F (72°C)	65,000 psi	0.0031 in./in.	Tan
TASK™ 7	1A:1B	N/A	200 cps	2.5 min.	N/A	10 min.	73 D	1.2 g/cc	23.1 cu. in./lb.	3,390 psi	150,700 psi	15.1 %	5,450 psi	148,900 psi	5,140 psi	131°F (55°C)	57,600 psi	0.0111 in./in.	Off-White
TASK™ 8	1A:1B	120A:100B	100 cps	2.5 min.	N/A	10-15 min.	80 D	1.09 g/cc	25.4 cu. in./lb.	5,840 psi	246,000 psi	4 %	8,280 psi	271,000 psi	8,760 psi	263°F (129°C) ¹	77,400 psi	0.01 in./in.	Off-White
TASK™ 9	1A:1B	115A:100B	300 cps	7 min.	N/A	1 hour	85 D	1.14 g/cc	24.3 cu. in./lb.	7,800 psi	370,000 psi	6 %	11,850 psi	350,000 psi	11,000 psi	131°F (55°C)	98,000 psi	0.009 in./in.	Clear Amber
TASK™ 11	N/A	100A:100B	2,000 cps	20 min.	N/A	16 hrs.	60 D	1.12 g/cc	24.7 cu. in./lb.	2,500 psi	N/A	100 %	N/A	N/A	N/A	N/A	N/A	0.0024 in./in.	Translucent White
TASK™ 12	N/A	100A:44B	2,400 cps	20 min.	N/A	16 hrs.	60 D	1.08 g/cc	26 cu. in./lb.	2,700 psi	N/A	300 %	N/A	N/A	N/A	N/A	N/A	0.001 in./in.	Clear Amber
TASK™ 13	N/A	100A:120B	800 cps	3 min.	N/A	20 min.	50 D	1.15 g/cc	24.1 cu. in./lb.	1,800 psi	N/A	125 %	N/A	N/A	N/A	N/A	N/A	0.005 in./in.	Black
TASK™ 14	N/A	100A:120B	800 cps	10 min.	N/A	45 min.	50 D	1.15 g/cc	24.1 cu. in./lb.	1,800 psi	N/A	125 %	N/A	N/A	N/A	N/A	N/A	0.0035 in./in.	Black
TASK™ 15	N/A	75A:100B	600 cps	6 min.	N/A	1 hour	75 D	1.12 g/cc	24.7 cu. in./lb.	2,720 psi	126,000 psi	20 %	N/A	170,000 psi	5,450 psi	117°F (47°C)	60,000 psi	0.0042 in./in.	Opaque White
TASK™ 16	N/A	1A:2B	1,400 cps	6 min.	N/A	24 hrs.	30 D / 80A	1.08 g/cc	25.64 cu. in./lb.	2,264 psi ^t	N/A	233 % ^t	N/A	N/A	N/A	N/A	N/A	0.0025 in./in.	Light Yellow
TASK™ 18	N/A	26A:100B	4,400 cps	20 min.	N/A	16 hrs.	88 D	1.57 g/cc	17.6 cu. in./lb.	3,250 psi	514,000 psi	1 %	10,700 psi	86,000 psi	8,420 psi	149°F (65°C)	97,300 psi	0.0006 in./in.	Metal Gray
TASK™ 21	2A:1B	2A:1B	500 cps	6 min.	N/A	1 hour	75 D	1.07 g/cc	25.9 cu. in./lb.	5,500 psi	270,000 psi	7.5 %	7,100 psi	250,000 psi	7,100 psi	144°F (62°C)	78,500 psi	0.0058 in./in.	White

Technical Reference Chart

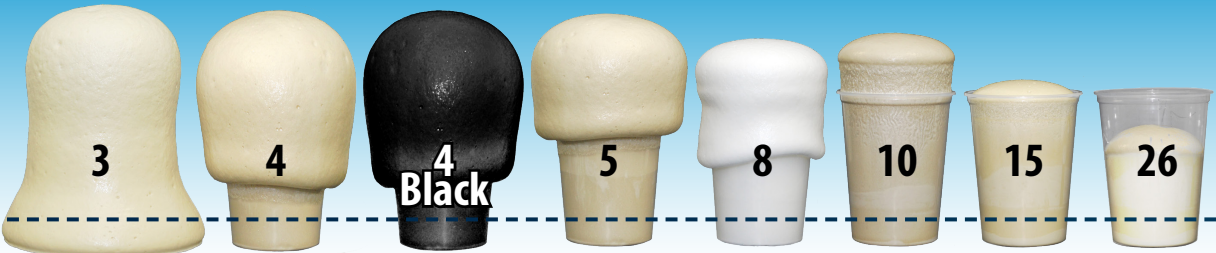
Rigid & Flexible Foams

All values measured after 7 days at 73°F/23°C

Foam expansion may vary depending on mixing technique (hand mix vs. drill mix), ambient/mold temperature, size and shape of mold, degree of back pressure applied and other variables.

	Product Name	A:B Mix Ratio by Volume	A:B Mix Ratio by Weight	Mixed Viscosity (ASTM D-2393)	Pot Life (ASTM D-2392)	Handling Time / Tack-Free Time	Cure Time	Specific Gravity (ASTM D-1475)	Specific Volume	Lbs. / Cubic Foot	Kgs. / Cubic Meter	Approximate Volumetric Expansion	Color
Rigid Foams	FOAM-iT!™ 3	1A:1B	100A:87B	200 cps	1 min.	20 min.	2 hrs.	0.05 g/cc	504 cu. in./lb.	3 lb/ft³	48 kg / m³	18 times	Beige
	FOAM-iT!™ 4	1A:1B	100A:87B	300 cps	1.5 min.	20 min.	2 hrs.	0.06 g/cc	420 cu. in./lb.	4 lb/ft³	64 kg / m³	14 times	Beige
	FOAM-iT!™ 4 BLACK	1A:1B	100A:87B	300 cps	1.5 min.	20 min.	2 hrs.	0.06 g/cc	420 cu. in./lb.	4 lb/ft³	64 kg / m³	14 times	Black
	FOAM-iT!™ 5	1A:1B	100A:87B	300 cps	1.5 min.	20 min.	2 hrs.	0.08 g/cc	315 cu. in./lb.	5 lb/ft³	80 kg / m³	10 times	Beige
	FOAM-iT!™ 8	N/A	2A:1B	300 cps	1.5 min.	20 min.	2 hrs.	0.13 g/cc	194 cu. in./lb.	8 lb/ft³	128 kg / m³	8 times	Off White
	FOAM-iT!™ 10	1A:1B	100A:87B	400 cps	1.5 min.	20 min.	2 hrs.	0.16 g/cc	157 cu. in./lb.	10 lb/ft³	160 kg / m³	6 times	Beige
	FOAM-iT!™ 10 SLOW	1A:1B	100A:87B	400 cps	3.5 min.	1 hour	4 hrs.	0.16 g/cc	157 cu. in./lb.	10 lb/ft³	160 kg / m³	6 times	Beige
	FOAM-iT!™ 15	1A:1B	100A:87B	500 cps	1.5 min.	20 min.	2 hrs.	0.24 g/cc	105 cu. in./lb.	15 lb/ft³	240 kg / m³	4 times	Beige
	FOAM-iT!™ 26	1A:1B	100A:90B	500 cps	1.5 min.	20 min.	2 hrs.	0.42 g/cc	60 cu. in./lb.	26 lb/ft³	416 kg / m³	2 times	White
	EZ-Spray™ Foam	1A:1B	N/A	400 cps	13 sec.	2 min.	10 min.	0.128 g/cc	N/A	8 lb/ft³	128 kg / m³	7 times	Tan
Flexible Foams	FlexFoam-iT!™ III	1A:2B	57.5A:100B	1,000 cps	35 sec.	25 min.	2 hrs.	0.05 g/cc	504 cu. in./lb.	3 lb/ft³	48 kg / m³	15 times	White
	FlexFo am-iT!™ IV Tuff Stuff	N/A	80A:100B	1,000 cps	30 sec.	45 min.	2 hrs.	0.06 g/cc	420 cu. in./lb.	4 lb/ft³	64 kg / m³	13 times	White
	FlexFoam-iT!™ V	1A:1B	105A:100B	1,000 cps	50 sec.	45 min.	2 hrs.	0.08 g/cc	315 cu. in./lb.	5 lb/ft³	80 kg / m³	11 times	White
	FlexFoam-iT!™ 6 Pillow Soft	1A:1B	105A:100B	1,000 cps	35 sec.	60 min.	2 hrs.	0.09 g/cc	280 cu. in./lb.	6 lb/ft³	96 kg / m³	10 times	White
	FlexFoam-iT!™ 7 FR	1A:1B	100A:88B	1,000 cps	35 sec.	60 min.	2 hrs.	0.11 g/cc	229 cu. in./lb.	7 lb/ft³	110 kg / m³	8 times	White
	FlexFoam-iT!™ VIII Pillow Soft	1A:2B	52.6A:100B	1,000 cps	35 sec.	25 min.	2 hrs.	0.13 g/cc	194 cu. in./lb.	8 lb/ft³	128 kg / m³	7 times	White
	FlexFoam-iT!™ X	1A:1B	105A:100B	1,000 cps	50 sec.	45 min.	2 hrs.	0.16 g/cc	157 cu. in./lb.	10 lb/ft³	160 kg / m³	6 times	White
	FlexFoam-iT!™ 14	1A:2B	100A:190B	1,000 cps	60 sec.	45 min.	2 hrs.	0.22 g/cc	114 cu. in./lb.	14 lb/ft³	220 kg / m³	4 times	White
	FlexFoam-iT!™ 15 Tuff Stuff	1A:2B	100A:185B	1,000 cps	2 min.	90 min.	4 hrs.	0.24 g/cc	115 cu. in./lb.	15 lb/ft³	240 kg / m³	4 times	White
	FlexFoam-iT!™ 17	1A:2B	100A:185B	1,000 cps	60 sec.	30 min.	2 hrs.	0.27 g/cc	93 cu. in./lb.	17 lb/ft³	270 kg / m³	3.5 times	White
	FlexFoam-iT!™ 23 FR	N/A	85A:100B	1,000 cps	90 sec.	60 min.	2 hrs.	0.37 g/cc	68 cu. in./lb.	23 lb/ft³	370 kg / m³	2 times	White
	FlexFoam-iT!™ 25	N/A	1A:2B	1,000 cps	90 sec.	25 min.	2 hrs.	0.4 g/cc	63 cu. in./lb.	25 lb/ft³	400 kg / m³	2 times	White
	EZ-Spray™ FlexFoam	1A:1B	N/A	1,000 cps	10 sec.	2 min.	15 min.	0.11 g/cc	N/A	7 lb/ft³	110 kg / m³	7 times	White
Silicone Foams	Soma Foama™ 15	2A:1B	100A:47B	10,000 cps	30 sec.	20 min.	1 hour	0.24 g/cc	115 cu. in./lb.	15 lb/ft³	240 kg / m³	4 times	White
	Soma Foama™ 25	1A:1B	1A:1B	10,000 cps	90 sec.	20 min.	1 hour	0.40 g/cc	69 cu. in./lb.	25 lb/ft³	400 kg / m³	2-3 times	White

Foam-iT!™ Series Expansion Rate Comparison



8oz. of each material poured into a 32oz. cup.

FlexFoam-iT!™ Series Expansion Rate Comparison





Technical Reference Chart

Epoxy

All values measured after 7 days at 73°F/23°C
¹ Testing conducted on a 6 ply/10 oz. laminate after 7 days at 73°F (23°C).
² 24 Hrs. followed by: Heat cure for 2 hrs. at 175°F/80°C, then 3 hrs. at 300°F/150°C.
³ Barcol 935 Hardness (ASTM D2240)
⁴ Shore D Hardness (ASTM D2240)
⁵ If post cured according to heat post curing schedule.

Laminating Epoxy Resins

Product Name	Hardener	A:B Mix Ratio by Volume	A:B Mix Ratio by Weight	Mixed Viscosity (ASTM D-2393)	Pot Life (ASTM D-2471)	Thin Film Working Time	Cure Time @ 73°F/23°C	Shore Hardness (ASTM D-2240)	Specific Gravity (ASTM D-1475)	Specific Volume (ASTM D-792)	Ultimate Tensile (ASTM D-638)	Tensile Modulus (ASTM D-638)	Tensile Elongation (ASTM D-638)	Flexural Strength (ASTM D-790)	Flexural Modulus (ASTM D-790)	Compressive Strength (ASTM D-695)	Compressive Modulus (ASTM D-695)	Heat Deflection Temp (ASTM D-648)	Color
EpoxAmite™ 101	101 Fast	4A:1B	100A:24B	1,000 cps	11 min.	30 min.	6-8 hrs.	84	1.13 g/cc	24.5 cu. in./lb.	7,930 psi 35,100 psi ¹	445,000 psi	2.45 %	13,660 psi 30,700 psi ¹	468,000 psi	11,550 psi	121,400 psi	133°F (56°C)	Clear Yellow
EpoxAmite™ 102	102 Medium	3A:1B	100A:29B	650 cps	22 min.	90 min.	10-15 hrs.	80	1.11 g/cc	25 cu. in./lb.	8,180 psi 26,800 psi ¹	450,000 psi	3.15 %	12,220 psi 28,500 psi ¹	423,000 psi	10,970 psi	122,000 psi	120°F (49°C)	Clear Yellow
EpoxAmite™ 103	103 Slow	3A:1B	100A:28.4B	650 cps	55 min.	180 min.	20-24 hrs.	80	1.10 g/cc	25.2 cu. in./lb.	7,910 psi 27,000 psi ¹	452,000 psi	2.63 %	12,300 psi 20,700 psi ^A	429,000 psi	10,500 psi	104,000 psi	127°F (53°C)	Clear Yellow
EpoxAmite™ HT	High Temperature	N/A	100A:33B	650 cps	60 min.	180 min.	24 hrs.	80	1.10 g/cc	25.2 cu. in./lb.	6,500 psi 32,100 psi ¹	342,000 psi 2,150,000 psi ¹	2.3 %	12,325 psi 20,700 psi ¹	429,000 psi 2,216,000 psi ¹	16,600 psi	168,000 psi	300°F (149°C) ⁵	Clear
EpoxAmite™ WHITE 101	101 Fast	N/A	100A:20B	3,400 cps	20 min.	45 min.	10-15 hrs.	83	1.25 g/cc	22.2 cu. in./lb.	5,130 psi 24,700 psi ¹	627,000 psi	0.8 %	8,770 psi 29,000 psi ¹	465,000 psi ¹	16,290 psi	116,000 psi	136°F (58°C)	White
EpoxAmite™ WHITE 102	102 Medium	N/A	100A:23B	2,800 cps	62 min.	120 min.	20-24 hrs.	85	1.23 g/cc	22.5 cu. in./lb.	5,600 psi 30,700 psi ¹	557,000 psi	1.2 %	8,350 psi 31,600 psi ¹	446,000 psi ¹	11,960 psi	114,000 psi	133°F (56°C)	White

Castable Epoxy Resins

Product Name	Hardener	A:B Mix Ratio by Weight	Mixed Viscosity (ASTM D-2393)	Pot Life (ASTM D-2471)	Cure Time @ 73°F/23°C	Shore Hardness (ASTM D-2240)	Specific Gravity (ASTM D-1475)	Specific Volume (ASTM D-792)	Ultimate Tensile (ASTM D-638)	Tensile Modulus (ASTM D-638)	Tensile Elongation (ASTM D-638)	Flexural Strength (ASTM D-790)	Flexural Modulus (ASTM D-790)	Compressive Strength (ASTM D-695)	Compressive Modulus (ASTM D-695)	Shrinkage (ASTM D-2566*)	Heat Deflection Temp (ASTM D-648)	Color
EpoxAcast™ 650	101 Fast	100A:12B	7,000 cps	20 min.	1 hour	93 ³	1.52 g/cc	18.22 cu. in./lb.	6,000 psi	1,503,000 psi	0.42 %	5,890 psi	710,000 psi	16,350 psi	142,600 psi	0.001 in./in.	129°F (54°C)	Off White or Black
EpoxAcast™ 650	102 Medium	100A:13B	7,000 cps	90 min.	4 hrs.	93 ³	1.52 g/cc	18.22 cu. in./lb.	6,000 psi	1,503,000 psi	0.42 %	5,890 psi	710,000 psi	16,350 psi	142,600 psi	0.001 in./in.	129°F (54°C)	Off White or Black
EpoxAcast™ 650	103 Slow	100A:14B	7,000 cps	3.5 hrs.	24 hrs.	93 ³	1.52 g/cc	18.22 cu. in./lb.	6,000 psi	—	0.42 %	5,890 psi	710,000 psi	16,350 psi	142,600 psi	0.001 in./in.	129°F (54°C)	Off White or Black
EpoxAcast™ 650	High Temperature	100A:10B	5,000 cps	3 hrs.	24 hrs. ²	93 ³	1.52 g/cc	18.22 cu. in./lb.	6,900 psi	1,079,000 psi	0.82 %	10,850 psi	775,000 psi	15,980 psi	134,400 psi	0.007 in./in.	187°F (86°C) ⁵	Off White or Black
EpoxAcast™ 655	101 Fast	100A:10B	23,000 cps	30 min.	3 hrs.	90 ⁴	1.66 g/cc	16.7 cu. in./lb.	4,810 psi	2,040,000 psi	0.54 %	7,660 psi	1,403,000 psi	12,500 psi	125,500 psi	0.0006 in./in.	135°F (57°C)	Grey
EpoxAcast™ 655	102 Medium	100A:11B	23,000 cps	75 min.	9 hrs.	90 ⁴	1.66 g/cc	16.7 cu. in./lb.	4,810 psi	2,040,000 psi	0.54 %	7,660 psi	1,403,000 psi	12,500 psi	125,500 psi	0.0006 in./in.	135°F (57°C)	Grey
EpoxAcast™ 655	103 Slow	100A:12B	23,000 cps	3.5 hrs.	24 hrs.	90 ⁴	1.66 g/cc	16.7 cu. in./lb.	4,810 psi	2,040,000 psi	0.54 %	7,660 psi	1,403,000 psi	12,500 psi	125,500 psi	0.0006 in./in.	135°F (57°C)	Grey
EpoxAcast™ 655	High Temperature	100A:8B	12,000 cps	4 hrs.	24 hrs. ²	90 ⁴	1.64 g/cc	16.5 cu. in./lb.	6,000 psi	7,200,000 psi	0.50 %	N/A	N/A	15,700 psi	270,000 psi	0.001 in./in.	225°F (108°C) ⁵	Grey
EpoxAcast™ 670 HT	High Temperature	100A:16B	6,000 cps	3 hrs.	24 hrs. ²	90 ⁴	1.15 g/cc	24.1 cu. in./lb.	4,500 psi	332,000 psi	0.65 %	11,000 psi	254,000 psi	13,000 psi	101,400 psi	0.002 in./in.	252° F (122° C) 350° F (177° C) ⁵	Beige
EpoxAcast™ 690		100A:30B	280 cps	5 hrs.	24 hrs.	80 ⁴	1.10 g/cc	25 cu. in./lb.	6,630 psi	572,000 psi	1.8 %	10,980 psi	410,000 psi	9,610 psi	91,300 psi	0.002 in./in.	115°F (46°C)	Clear
EpoxAcast™ 692 Deep Pour		100A:40B	370 cps	12 hrs.	72 hrs.	80 ⁴	1.08 g/cc	25.7 cu. in./lb.	4,585 psi	378,000 psi	3.1 %	6,780 psi	203,000 psi	5,777 psi	82,000 psi	0.007 in./in.	100°F (38°C)	Clear



Technical Reference Chart

Epoxy

All values measured after 7 days at 73°F/23°C
¹ Testing conducted on a 6 ply/10 oz. laminate after 7 days at 73°F (23°C).
² ASTM D1475
³ If post cured according to heat post curing schedule.

Epoxy Coatings

Product Name	Hardener	A:B Mix Ratio by Volume	A:B Mix Ratio by Weight	Mixed Viscosity (ASTM D-2393)	Pot Life (ASTM D-2471)	Thin Film Working Time	Thin Film Tacky Recoat Time	Thin Film Tack Free Time	Cure Time @ 73°F/23°C	Shore D Hardness (ASTM D-2240)	Barcol Hardness (ASTM D-2240)	Specific Gravity (ASTM D-1475)	Specific Volume (ASTM D-792)	Ultimate Tensile (ASTM D-638)	Flexural Modulus (ASTM D-790)	Compressive Strength (ASTM D-695)	Shrinkage (ASTM D-2566*)	Heat Deflection Temp (ASTM D-648)	Color
EpoxAcoat™ GREY	101 Fast	5A:1B	100A:15B	Light Paste	20 min.	40 min.	60 min.	4 hrs.	16 hrs.	85	87	1.43 g/cc	19.4 cu. in./lb. ¹	26,000 psi	30,000 psi	24,000 psi	0.00015 in./in.	133°F (56°C)	Grey
EpoxAcoat™ NEUTRAL	101 Fast	5A:1B	100A:15B	Light Paste	20 min.	40 min.	60 min.	4 hrs.	16 hrs.	85	87	1.43 g/cc	19.4 cu. in./lb. ¹	26,000 psi	30,000 psi	24,000 psi	0.00015 in./in.	133°F (56°C)	Neutral
EpoxAcoat™ RED	101 Fast	5A:1B	100A:15B	Light Paste	20 min.	40 min.	60 min.	4 hrs.	16 hrs.	85	87	1.43 g/cc	19.4 cu. in./lb. ¹	26,000 psi	30,000 psi	24,000 psi	0.00015 in./in.	133°F (56°C)	Red
EpoxAcoat™ WHITE	101 Fast	5A:1B	100A:15B	Light Paste	20 min.	40 min.	60 min.	4 hrs.	16 hrs.	85	87	1.43 g/cc	19.4 cu. in./lb. ¹	26,000 psi	30,000 psi	24,000 psi	0.00015 in./in.	133°F (56°C)	White
EpoxAcoat™ HT	High Temp	N/A	100A:18B	Light Paste	40 min.	75 min.	4 hrs.	N/A	24 hrs.	85	N/A	N/A	N/A	N/A	N/A	N/A	N/A	133°F (56°C) 284°F (140°C)*	Dark Red
EPSILON™	101 Fast	N/A	100A:20B	Variable	15 min.	45 min.	60 min.	2 hrs.	16 hrs.	75	N/A	1.16 g/cc	23.9 cu. in./lb. ¹	N/A	N/A	N/A	N/A	N/A	Beige
EPSILON™	102 Medium	N/A	100A:25B	Variable	30 min.	120 min.	180 min.	5 hrs.	24 hrs.	75	N/A	1.14 g/cc	24.3 cu. in./lb. ¹	N/A	N/A	N/A	N/A	N/A	Beige
Epsilon™ PRO	N/A	2A:1B	100A:44B	4,000 cps	22 min.	35 min.	3 hrs.	4 hrs.	16 hrs.	65	N/A	1.11 g/cc	25.0 cu. in./lb. ¹	N/A	N/A	N/A	N/A	N/A	Clear Amber
Plasti-Paste™ EPOXY	N/A	2A:1B	2A:1B	Paste	40 min.	60 min.	—	16 hrs.	—	80	N/A	1.0 g/cc	27.73 cu. in./lb. ¹	3,320 psi	2,273,000 psi	7,700 psi	< 0.001 in./in.	160°F (71°C)	Off-White
Tarbender™	N/A	2A:1B	100A:41B	1,100 cps	45 min.	2 hrs.	6 hrs.	8 hrs.	16 hrs.	75	N/A	1.09 g/cc	25.4 cu. in./lb. ¹	N/A	N/A	N/A	N/A	N/A	Clear
XTC-3D™	N/A	2A:1B	100A:42B	350 cps	10 min.	20 min.	90 min.	2 hrs.	3.5 hrs.	80	N/A	1.09 g/cc	25.1 cu. in./lb. ¹	N/A	N/A	N/A	114,000 psi	133° F (56°C)	Clear (Slightly Yellow In Thick Sections)

Epoxy Putties

Product Name	A:B Mix Ratio by Volume	A:B Mix Ratio by Weight	Mixed Viscosity (ASTM D-2393)	Pot Life (ASTM D-2471)	Cure Time @ 73°F/23°C	Shore D Hardness (ASTM D-2240)	Specific Gravity (ASTM D-1475)	Specific Volume (ASTM D-792)	Ultimate Tensile (ASTM D-638)	Flexural Modulus (ASTM D-790)	Compressive Strength (ASTM D-695)	Shrinkage (ASTM D-2566*)	Heat Deflection Temp (ASTM D-648)	Color
Free Form™ AIR	1A:1B	1A:1B	Dough	30 min. @1.5" 60 min. @3/8" 120 min. @1/8"	24 hrs.	50	0.45 g/cc	61.6 cu. in./lb. ²	N/A	N/A	N/A	N/A	140°F (60°C)	Grey
Free Form™ AIR FAST	1A:1B	1A:1B	Dough	6 min. @1.5" 8 min. @3/8" 10 min. @1/8	24 hrs.	60	0.45 g/cc	61.6 cu. in./lb.	N/A	N/A	N/A	N/A	145°F (63°C)	Grey
Free Form™ AIR Fire Safe	1A:1B	N/A	Dough	30 min. @1.5" 60 min. @3/8" 120 min. @1/8	24 hrs.	73	0.8 g/cc	34.6 cu. in./lb.	N/A	N/A	N/A	N/A	140°F (60°C)	Grey
Free Form™ AIR HT	2A:1B	2A:1B	Dough	90 min. @1.5" 2.5 hrs. @3/8" 3 hrs. @1/8	16 hours	55	0.51 g/cc	54.31 cu. in./lb.	N/A	N/A	N/A	N/A	300°F (149°C) 400°F (204°C) ³	Grey
Free Form™ Habitat™ Black	1A:1B	1A:1B	Dough	60 minutes	16 hours	85	1.6 g/cc	17.3 cu. in./lb. ²	N/A	N/A	3,480 psi	N/A	160°F (74°C) 212°F (100°C) ³	Black
Free Form™ Habitat™ Fire Safe™	1A:1B	1A:1B	Dough	90 minutes	16 hours	85	1.44 g/cc	17.3 cu. in./lb. ²	N/A	N/A	N/A	N/A	160°F (74°C) 212°F (100°C) ³	Grey
Free F orm™ Habitat™ Flex FR	1A:1B	1A:1B	Dough	90 minutes	24 hours	90	1.55 g/cc	17.9 cu. in./lb. ²	N/A	N/A	N/A	N/A	160°F (74°C) 212°F (100°C) ³	Light Brown
Free Form™ SCULPT	1A:1B	N/A	Putty	1.5 hours	24 hours	80	1.33 g/cc	20.73 cu. in./lb. ²	N/A	N/A	N/A	<0.001 in./in.	150°F (65°C)	Grey
Habitat Cast N Coat™	1A:1B	1A:1B	13,500 cps	85 minutes	16 hours	85	1.51 g/cc	18.35 cu. in./lb. ²	N/A	N/A	N/A	N/A	131°F (55°C)	Tan