

PRODUCT OVERVIEW

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. **SO-FLEX®** can also be added to Vytaflex® 10 to create a urethane 'gel' type material as explained on the reverse side of this Technical Bulletin.

PROCESSING RECOMMENDATIONS

PREPARATION... Safety – Use in a properly ventilated area ("room size" ventilation). Wear safety glasses, long sleeves and rubber gloves to minimize contamination risk. Store and use products in a warm environment (73°F / 23°C). This product has a limited shelf life and should be used as soon as possible. Wear gloves and eye protection to minimize risk of contamination.

MEASURING & MIXING...

Use SO-FLEX® by weight: For best results, you should use an accurate scale to properly use SO-FLEX® with PMC®-121/50, PMC®-744, Vytaflex® 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.

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® as indicated below.

Part B	SO-FLEX®	Mix Thoroughly	Part A	Shore A* Hardness
50 g	0 g	Mix	50 g	50
50 g	20 g	Mix	50 g	43
50 g	40 g	Mix	50 g	35
50 g	50 g	Mix	50 g	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.

Part B	SO-FLEX®	Mix Thoroughly	Part A	Shore A* Hardness
50 g	0 g	Mix	100 g	45
50 g	20 g	Mix	100 g	40
50 g	40 g	Mix	100 g	35
50 g	50 g	Mix	100 g	30

*Shore A hardness after 7 days.

Safety First!

The Material Safety Data Sheet (MSDS) for this or any Smooth-On product should be read prior to use and is available upon request from Smooth-On. All Smooth-On products are safe to use if directions are read and followed carefully.

Keep Out of Reach of Children

BE CAREFUL

Use only with adequate ventilation. Contact with skin and eyes may cause irritation. Flush eyes with water for 15 minutes and seek immediate medical attention. Remove from skin with waterless hand cleaner followed by soap and water.

IMPORTANT - The information contained in this bulletin is considered accurate. However, no warranty is expressed or implied regarding the accuracy of the data, the results to be obtained from the use thereof, or that any such use will not infringe upon a patent. User shall determine the suitability of the product for the intended application and assume all risk and liability whatsoever in connection therewith.

Softening Vytaflex® 10 with SO-FLEX® - Normally, Vytaflex® 10 cures to a hardness of Shore A 10. Vytaflex® 10 can be made into a much softer and more flexible 'gel' type material by adding different percentages of SO-FLEX® as indicated below.

Part B	SO-FLEX®	Mix Thoroughly	Part A	Shore* Hardness
50 g	0 g	Mix	50 g	10A
50 g	10 g	Mix	50 g	00-62
50 g	20 g	Mix	50 g	00-50
50 g	50 g	Mix	50g	00-30

*Shore hardness after 7 days.

Note: The softened Vytaflex® 10 will be 'tacky' when cured. This tackiness can be eliminated by applying baby powder or talc to the surface of the cured rubber.



Call Us Anytime With Questions About Your Application.

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The new www.smooth-on.com is loaded with information about mold making, casting and more.