



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.

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

*Shore A hardness after 7 days.

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