

SO-FLEX™ II

Flexibilizer for Urethane Rubber



www.smooth-on.com

PRODUCT OVERVIEW

SO-FLEX™ II is a **phthalate free** softening agent that will lower the cured durometer of a variety of Smooth-On flexible polyurethane products. The following charts indicate the effect **SO-FLEX™ II** has on fully cured (7 days) PMC™-121/50, Vytaflex™ 30 and Reoflex™ 20 urethane rubbers when added as a percentage of the total mix.

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™ II by weight: For best results, you should use an accurate scale to properly use SO-FLEX™ II with PMC™-121/50. SO-FLEX™ II 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™ II - 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™ II as indicated below.

Parts B	Parts SO-FLEX™ II	Mix Thoroughly	Parts A	Shore A* Hardness
100	0	Mix	100	50
100	10	Mix	100	44
100	20	Mix	100	39
100	40	Mix	100	31

*Shore A hardness after 7 days.

Softening Vytaflex™ 30 with SO-FLEX™ II - Normally, Vytaflex™ 30 cures to a hardness of Shore A 30. Vytaflex™ 30 can be made softer and more flexible by adding different percentages of SO-FLEX™ II as indicated below.

Parts B	Parts SO-FLEX™ II	Mix Thoroughly	Parts A	Shore A* Hardness
100	0	Mix	100	30
100	10	Mix	100	27
100	20	Mix	100	20
100	40	Mix	100	16

*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 Reoflex™ 20 with SO-FLEX™ II - Normally, Reoflex™ 20 cures to a hardness of Shore A 20. Reoflex™ 20 can be made into a much softer and more flexible 'gel' type material by adding different percentages of SO-FLEX™ II as indicated below.

Parts B	Parts SO-FLEX™ II	Mix Thoroughly	Parts A	Shore A* Hardness
100	0	Mix	100	20
100	10	Mix	100	17
100	20	Mix	100	13
100	40	Mix	100	6

*Shore A hardness after 7 days.

Note: At 40 parts SO-FLEX™ II, softened Reoflex™ 20 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.