

Product Name	A:B Mix Ratio by Volume	A:B Mix Ratio by Weight	Mixed Viscosity ASTM D-2393	Pot Life ASTM D-2471	Handling Time @ 73°F/23°C	Shore D Hardness ASTM D-2240	Specific Gravity (g/cm ³) ASTM D-1475	Specific Volume (in ³ /lb) ASTM D-1475	Ultimate Tensile ASTM D-638* (except †ASTM D-412)	Tensile Modulus ASTM D-638*	Elong. 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 Temp (°F/°C) ASTM D-648*	Compressive Modulus ASTM D-695*	Shrinkage (in/in) ASTM D-2566*	Color
Smooth-Cast® 45D	1A:1B pbv	100A:93B pbw	250 cps	5 min.	30 min.	45D	1.10	25.2	1,560 psi	N/A	100%	N/A	N/A	N/A	N/A	N/A	0.007	Translucent White
Smooth-Cast® 57D	1A:1B pbv	100A:93B pbw	300 cps	3 min.	30 min.	57D	1.05	26.4	2,420 psi	N/A	100%	N/A	N/A	N/A	N/D	N/A	0.012	Translucent White
Smooth-Cast® 60D	1A:1B pbv	100A:93B pbw	430 cps	5 min.	30 min.	60D	1.05	26.4	2,420 psi	22,000 psi	100%	410 psi	9,610 psi	1,100 psi	N/D	4,710 psi	0.0125	Translucent White
Smooth-Cast® 61D	1A:1B pbv	100A:93B pbw	430 cps	7 min.	60 min.	61D	1.05	26.4	2,420 psi	16,400 psi	20%	350 psi	8,800 psi	950 psi	N/D	4,100 psi	0.0125	Translucent White
Smooth-Cast® 65D	1A:1B pbv	100A:93B pbw	120 cps	2.5 min.	10-15 min.	65D	1.05	26.4	2,400 psi	90,000 psi	20%	2,690 psi	75,100 psi	3,680 psi	120°F (50°C)	57,700 psi	0.01	White
Smooth-Cast® 66D	1A:1B pbv	100A:93B pbw	120 cps	7 min.	60 min.	66D	1.05	26.4	2,400 psi	90,000 psi	20%	2,690 psi	75,100 psi	3,680 psi	120°F (50°C)	57,700 psi	0.01	Grey
Smooth-Cast® 300Q	1A:1B pbv	100A:90B pbw	80 cps	30 sec.	4-5 min.	70D	1.05	26.4	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	White
Smooth-Cast® 300	1A:1B pbv	100A:90B pbw	80 cps	3 min.	10 min.	70D	1.05	26.4	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	White
Smooth-Cast® 305	1A:1B pbv	100A:90B pbw	80 cps	7 min.	30 min.	70D	1.05	26.4	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	White
Smooth-Cast® 310	1A:1B pbv	100A:90B pbw	80 cps	15-20 min.	3-4 hrs.	70D	1.05	26.4	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	White
Smooth-Cast® 320	1A:1B pbv	100A:90B pbw	80 cps	3 min.	10 min.	70D	1.05	26.4	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	Off-White
Smooth-Cast® 321	1A:1B pbv	100A:90B pbw	80 cps	7-9 min.	30 min.	70D	1.05	26.4	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	Off-White
Smooth-Cast® 322	1A:1B pbv	100A:90B pbw	80 cps	10-20 min.	2-4 hrs.	70D	1.05	26.4	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	Off-White
Smooth-Cast® 325	1A:1B pbv	115A:100B pbw	100 cps	2.5 min.	10 min.	72D	1.07	25.9	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	Clear Amber
Smooth-Cast® 326	1A:1B pbv	115A:100B pbw	100 cps	7-9 min.	60 min.	72D	1.07	25.9	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	Clear Amber
Smooth-Cast® 327	1A:1B pbv	115A:100B pbw	100 cps	10-20 min.	2-4 hrs.	72D	1.07	25.9	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	Clear Amber
SC ONYX® FAST	1A:1B pbv	120A:100B pbw	100 cps	2.5 min.	10-15 min.	80D	1.09	27.7	5,840 psi	246,000 psi	4%	8,280 psi	246,000 psi	8,760 psi	250°F (121°C)*	77,400 psi	0.01	Black
SC ONYX® SLOW	1A:1B pbv	120A:100B pbw	100 cps	5 min.	90 min.	80D	1.09	27.7	7,660 psi	374,000 psi	3%	10,230 psi	286,000 psi	11,400 psi	212°F (100°C)*	97,900 psi	0.012	Black
Smooth-Cast® 380	1A:1B pbv	1A:1B pbw	1,140 cps	6 min.	60 min.	82D	1.74	15.9	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	Tan
Smooth-Cast® 385	N/A	1A:5B pbw	3,000 cps	20 min.	2 hrs.	85D	1.60	17.3	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	Beige
TASK® 2	1A:1B pbv	115A:100B pbw	150 cps	7 min.	60 min.	80D	1.12	24.7	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	White
TASK® 3	1A:1B pbv	115A:100B pbw	150 cps	20 min.	90 min.	80D	1.12	24.7	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	White
TASK® 4	N/A	100A:100B pbw	250 cps	20 min.	16 hrs.	83D	1.167	23.9	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	Ivory
TASK® 5	1A:1B pbv	1A:1B pbw	600 cps	3 min.	15 min.	77D	1.10	25.2	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	Tan
TASK® 6	1A:1B pbv	1A:1B pbw	800 cps	7 min.	75 min.	75D	1.07	25.9	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	Tan
TASK® 7 - Flame Out®	1A:1B pbv	104A:100B pbw	200 cps	2.5 min.	10 min.	73D	1.20	23.1	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	White
TASK® 8	1A:1B pbv	120A:100B pbw	100 cps	2.5 min.	10-15 min.	80D	1.09	25.4	5,840 psi	246,000 psi	4%	8,280 psi	271,000 psi	8,760 psi	263°F (129°C)*	77,400 psi	0.01	Off-White
TASK® 9	1A:1B pbv	115A:100B pbw	300 cps	7 min.	60 min.	85D	1.14	24.3	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	Clear Amber
TASK® 11 (C-1509)	N/A	100A:100B pbw	2,000 cps	20 min.	16 hrs.	60D	1.12	24.7	2,500 psi	N/A	100%	N/A	N/A	N/A	N/A	N/A	0.0024	Milky Amber
TASK® 12	N/A	100A:44B pbw	2,400 cps	20 min.	16 hrs.	60D	1.08	26	2,700 psi	N/A	300%	N/A	N/A	N/A	N/A	N/A	0.001	Clear Amber
TASK® 13 (C-1515)	N/A	100A:120B pbw	800 cps	3 min.	20 min.	95A, 50D	1.15	24.1	1,800 psi	N/A	125%	N/A	N/A	N/A	N/A	N/A	0.005	Black
TASK® 14 (C-1520)	N/A	100A:120B pbw	800 cps	10 min.	45 min.	95A, 50D	1.15	24.1	1,800 psi	N/A	125%	N/A	N/A	N/A	N/A	N/A	0.0035	Black
TASK® 15	N/A	75A:100B pbw	600 cps	6 min.	60 min.	75D	1.12	24.7	2,720 psi	126,000 psi	20%	5,620 psi	170,000 psi	5,450 psi	117°F (47°C)	60,000 psi	0.0042	Opaque White
TASK® 16	N/A	1A:2B pbw	1,400 cps	6 min.	90 min.	80A/30D	1.08	25.6	2,264 psi†	N/A	233%†	N/A	N/A	N/A	N/A	N/A	0.0025	Light Yellow
TASK® 18 (C-1508)	N/A	26A:100B pbw	4,400 cps	20 min.	16 hrs.	88D	1.57	17.6	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	Metal Gray
TASK® 21	2A:1B pbv	2A:1B pbw	500 cps	6 min.	60 min.	75D	1.07	25.9	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	White
Feather Lite®	1A:1B pbv	1A:1B pbw	410 cps	8.5 min.	2 hrs.	58D	0.67	41.3	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	Beige
Plasti-Paste®	1A:3B pbv	41A:100B pbw	Paste	8-10 min.	90 min.	70D	1.16	23.9	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	Off-White
Plasti-Paste® II	1A:2B pbv	62A:100B pbw	Paste	10 min.	90 min.	70D	1.00	27.7	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	Off-White
SMASH!® Plastic	1A:1B pbv	1A:1B pbw	900 cps	5 min.	90 min.	80D	1.036	26.7	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	0.0001	Clear
Shell Shock® Fast	1A:4B pbv	1A:5B pbw	3,000 cps	3 min.	60 min.	85D	1.60	17.3	3,100 psi	435,000 psi	0.4%	7,150 psi	980,000 psi	9,000 psi	135°F (57°C)	500,000 psi	0.0006	Beige
Shell Shock® Slow	1A:4B pbv	1A:5B pbw	3,000 cps	8 min.	5 hrs.	85D	1.60	17.3	3,100 psi	435,000 psi	0.4%	7,150 psi	980,000 psi	9,000 psi	135°F (57°C)	500,000 psi	0.0006	Beige
Simpact® 60A	1A:1B pbv	100A:94B pbw	1,100 cps	4 min.	2 hrs.	60A	1.08	25.7	990 psi†	N/A	400%†	N/A	N/A	N/A	N/A	N/A	0.007	White
Simpact® 85A	N/A	85A:100B pbw	1,100 cps	4 min.	2 hrs.	85A	1.09	25.4	1,573 psi†	N/A	164%†	N/A	N/A	N/A	N/A	N/A	0.007	Off-White
EZ~Spray® StyroCoat®	1A:1B pbv	N/A	Variable	2 sec.	60 min.	80D	1.12	24.7	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	Off-White
EZ~Spray® Plastic	1A:1B pbv	N/A	Variable	2 sec.	3 hrs.	75D	1.11	25.0	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	Off-White
Crystal Clear® 200	N/A	100A:90B pbw	600 cps	20 min.	16 hrs.	80D	1.036	26.7	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	Clear
Crystal Clear® 202	N/A	100A:90B pbw	600 cps	9 min.	90 min.	80D	1.036	26.7	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	Clear
Crystal Clear® 204	N/A	100A:90B pbw	600 cps	2 hrs.	48 hrs.	80D	1.036	26.7	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	Clear
Crystal Clear® 206	N/A	100A:90B pbw	600 cps	4.5 hrs.	7 days	80D	1.036	26.7	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	Clear
Crystal Clear® 220	N/A	100A:75B pbw	675 cps	22 min.	overnight**	85D	1.07	25.9	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	Clear
Crystal Clear® 221	N/A	100A:75B pbw	675 cps	75 min.	overnight**	85D	1.07	25.9	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	Clear

* Values measured after material has been post cured as directed by product technical bulletin

** Material requires post-cure

Smooth-On Urethane Plastic

Technical Reference Chart


www.smooth-on.com

	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 A Hardness (ASTM D-2240)	Specific Gravity (g/cc) (ASTM D-1475)	Specific Volume (cu. in./lb.)	Die C Tear Strength (ASTM D-624)	Tensile Strength (ASTM D-412)	Shrinkage (in./in.)	Elongation at Break % (ASTM D-412)	Color
VytaFlex® Series	VytaFlex® 10	1A:1B pbv	1A:1B pbw	3,100 cps	30 min.	24 hrs.	10A	1.00	27.9	38 pli	200 psi	<0.001	1,000%	Off-White
	VytaFlex® 20	1A:1B pbv	1A:1B pbw	1,000 cps	30 min.	16 hrs.	20A	1.00	27.7	60 pli	200 psi	<0.001	1,000%	Clear Amber
	VytaFlex® 30	1A:1B pbv	1A:1B pbw	1,800 cps	30 min.	16 hrs.	30A	1.02	27.3	78 pli	500 psi	<0.001	1,000%	Off-White
	VytaFlex® 40	1A:1B pbv	1A:1B pbw	2,000 cps	30 min.	16 hrs.	40A	1.03	26.9	82 pli	522 psi	<0.001	660%	Off-White
	VytaFlex® 45	1A:1B pbv	1A:1B pbw	2,000 cps	30 min.	16 hrs.	45A	1.04	26.4	100 pli	886 psi	<0.001	900%	Off-White
	VytaFlex® 50	1A:1B pbv	1A:1B pbw	2,000 cps	60 min.	16 hrs.	50A	1.04	26.7	102 pli	588 psi	<0.001	400%	Off-White
ReoFlex® Series	VytaFlex® 60	1A:1B pbv	1A:1B pbw	2,000 cps	60 min.	16 hrs.	60A	1.04	26.6	136 pli	880 psi	<0.001	480%	Off-White
	ReoFlex® 20	1A:1B pbv	1A:1B pbw	1,800 cps	30 min.	16 hrs.	20A	1.01	27.3	60 pli	200 psi	<0.001	1,000%	Off-White
	ReoFlex® 30	1A:1B pbv	1A:1B pbw	1,500 cps	30 min.	16 hrs.	30A	1.01	27.5	82 pli	450 psi	<0.001	1,000%	Off-White
	ReoFlex® 40	1A:1B pbv	1A:1B pbw	1,500 cps	30 min.	16 hrs.	40A	1.02	27.2	85 pli	490 psi	<0.001	1,000%	Off-White
	ReoFlex® 50	1A:1B pbv	1A:1B pbw	2,000 cps	50 min.	16 hrs.	50A	1.01	27.4	120 pli	580 psi	<0.001	435%	Off-White
	ReoFlex® 60	1A:1B pbv	1A:1B pbw	1,800 cps	50 min.	16 hrs.	60A	1.04	26.7	132 pli	782 psi	<0.001	581%	Off-White
PMC® Series	PMC®-121/30	1A:1B pbv	1A:1B pbw	1,800 cps	30 min.	16 hrs.	30A	1.04	26.7	75 pli	400 psi	<0.001	1,000%	Clear Amber
	PMC®-121/50	1A:1B pbv	1A:1B pbw	1,400 cps	30 min.	16 hrs.	50A	1.04	26.7	85 pli	350 psi	<0.001	500%	Clear Amber
	PMC®-724	N/A	1A:10B pbw	4,000 cps	20 min.	16 hrs.	40A	1.38	20.1	90 pli	600 psi	<0.001	700%	Off-White
	PMC®-726	N/A	1A:10B pbw	3,000 cps	25 min.	16 hrs.	60A	1.36	20.4	100 pli	600 psi	<0.001	400%	Light Tan
	PMC®-744	2A:1B pbv	2A:1B pbw	3,400 cps	15 min.	16 hrs.	44A	1.01	27.5	90 pli	300 psi	<0.001	400%	Beige
	PMC®-746	2A:1B pbv	2A:1B pbw	1,200 cps	15 min.	16 hrs.	60A	1.03	26.9	100 pli	700 psi	<0.001	650%	Amber**
	PMC®-770	2A:1B pbv	2A:1B pbw	3,000 cps	30 min.	16 hrs.	70A	1.04	26.5	200 pli	750 psi	<0.001	750%	Light Amber
	PMC®-780	2A:1B pbv	2A:1B pbw	2,000 cps	25 min.	48 hrs.	80A	1.02	27.2	200 pli	900 psi	<0.001	700%	Light Amber
Brushable	PMC®-790	2A:1B pbv	2A:1B pbw	3,000 cps	20 min.	48 hrs.	90A	1.07	25.9	300 pli	2,000 psi	<0.001	550%	Clear Amber
	Brush-On® 35	1A:1B pbv	100A:67B pbw	Brushable	20 min.	16 hrs.	35A	1.29	21.5	57 pli	335 psi	<0.001	1,000%	Grey-Green
	Brush-On® 40	1A:1B pbv	100A:125B pbw	Brushable	20 min.	16 hrs.	40A	1.17	23.7	60 pli	300 psi	<0.001	1,000%	Off-White
	Brush-On® 50	1A:1B pbv	100A:125B pbw	Brushable	20 min.	16 hrs.	50A	1.17	23.7	80 pli	500 psi	<0.001	400%	Off-White
	Brush-On® 60	1A:1B pbv	100A:125B pbw	Brushable	20 min.	16 hrs.	60A	1.18	23.5	80 pli	630 psi	<0.001	400%	Off-White
	EZ-Mix® 40	1A:1B pbv	100A:95B pbw	Brushable	18 min.	16 hrs.	40A	1.025	27.0	67 pli	420 psi	<0.001	577%	Grey
Specialty	UreCoat®	N/A	100A:10B pbw	Brushable	8 min.	16 hrs.	70A	1.05	26.4	256 pli	503 psi	<0.001	876%	Translucent Amber
	EZ~Spray® 45	1A:1B pbv	N/A	Sprayable	20 min.	16 hrs.	45A	1.025	27.0	100 pli	510 psi	<0.001	375%	Light Blue
	Econ® 60	1A:1B pbv	1A:1B pbw	1,400 cps	6 min.	4 hrs. / 16 hrs.*	60A	1.04	26.7	85 pli	350 psi	<0.001	500%	Translucent Amber
	Econ® 80	1A:1B pbv	100A:90B pbw	1,200 cps	13 min.	6 hrs. / 24 hrs.*	80A	1.06	26.2	77 pli	955 psi	0.0014	127%	Translucent
	Clear Flex® 30	1A:1B pbv	100A:94B pbw	750 cps	15 min.	16 hrs.	30A	1.03	26.9	54 pli	725 psi	0.002	675%	Clear
	Clear Flex® 50	N/A	1A:2B pbw	250 cps	25 min.	16 hrs.	50A	1.04	26.8	25 pli	250 psi	0.0015	500%	Clear
	Clear Flex® 95	N/A	1A:1.5B pbw	250 cps	25 min.	16 hrs.	95A	1.04	26.8	200 pli	2,500 psi	0.0028	175%	Clear
	Formlastic™ 48	1A:1B pbv	100A:118B pbw	3000 cps	25 min.	24 hrs.	48A	1.14	24.3	98 pli	700 psi	<0.001	1250%	Off-White
	Formlastic™ 60	1A:1B pbv	100A:118B pbw	3000 cps	40 min.	24 hrs.	60A	1.14	24.3	98 pli	1025 psi	<0.001	1000%	Off-White
	Compat™ 45	1A:1B pbv	85A:100B pbw	2600 cps	25 min.	16 hrs.	45A	1.12	24.7	101 pli	629 psi	<0.001	772%	Off-White
KX Flex™ 60	1A:1B pbv	1A:1B pbw	800 cps	2.5 min.	24 hrs.	60A	1.15	24.1	N/A	1800 psi	0.005	125%	Off-White	
KX Flex™ 90	N/A	100A:120B pbw	800 cps	2.5 min.	24 hrs.	90A	1.15	24.1	N/A	1800 psi	0.005	125%	Off-White	

** Color may vary from batch to batch

* Refers to Handling Time / Cure Time at 73° F / 23° C.

Smooth-On Urethane Rubber Technical Reference Chart



Tin-Cure Silicone Rubber

Platinum-Cure Silicone Rubber

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 A Hardness (ASTM D-2240)	Specific Gravity (g/cc) (ASTM D-1475)	Specific Volume (cu. in./lb.) (ASTM D-1475)	Die B Tear Strength (ASTM D-624)	Tensile Strength (ASTM D-412)	Shrinkage (in./in.) (ASTM D-2366)	Elongation at Break % (ASTM D-412)	Useful Temperature Range	Color
Mold Max® 10	N/A	100A:10B pbw	15,000 cps	45 min.	24 hrs.	10A	1.15	24.1	100 pli	473 psi	0.001	529%	-65°F/-53°C to 400°F/205°C	Light Pink
Mold Max® 10T	N/A	100A:10B pbw	14,000 cps	45 min.	24 hrs.	10A	1.09	25.4	87 pli	405 psi	0.0025	586%	-65°F/-53°C to 400°F/205°C	Translucent
Mold Max® 14NV	N/A	100A:10B pbw	7,500 cps	40 min.	4 hrs.	14A	1.12	24.7	87 pli	490 psi	0.002	600%	-65°F/-53°C to 400°F/205°C	White
Mold Max® 15T	N/A	100A:10B pbw	20,000 cps	45 min.	24 hrs.	15A	1.08	25.6	94 pli	490 psi	0.002	600%	-65°F/-53°C to 400°F/205°C	Translucent
Mold Max® 20	N/A	100A:10B pbw	25,000 cps	45 min.	24 hrs.	20A	1.18	23.5	110 pli	555 psi	0.001	512%	-65°F/-53°C to 400°F/205°C	Light Pink
Mold Max® 25	N/A	100A:5B pbw	25,000 cps	60 min.	24 hrs.	25A	1.18	23.5	130 pli	577 psi	0.001	375%	-65°F/-53°C to 400°F/205°C	Purple
Mold Max® 27T	N/A	100A:10B pbw	30,000 cps	45 min.	24 hrs.	27A	1.11	25.0	110 pli	575 psi	0.002	400%	-65°F/-53°C to 400°F/205°C	Translucent
Mold Max® 29NV	N/A	100A:10B pbw	10,000 cps	40 min.	6 hrs.	29A	1.17	23.7	96 pli	417 psi	0.002	361%	-65°F/-53°C to 400°F/205°C	Yellow
Mold Max® 30	N/A	100A:10B pbw	25,000 cps	45 min.	24 hrs.	30A	1.18	23.5	125 pli	577 psi	0.002	300%	-65°F/-53°C to 400°F/205°C	Pink
Mold Max® XLS® II	N/A	100A:10B pbw	30,000 cps	40 min.	24 hrs.	30A	1.22	22.7	110 pli	550 psi	0.001	375%	-65°F/-53°C to 400°F/205°C	Blue
Mold Max® 40	N/A	100A:10B pbw	45,000 cps	45 min.	24 hrs.	40A	1.14	24.3	120 pli	550 psi	0.004	250%	-65°F/-53°C to 400°F/205°C	Mint Green
Mold Max® 60	N/A	100A:3B pbw	20,000 cps	40 min.	24 hrs.	60A	1.45	19.1	63 pli	398 psi	0.0015	132%	-65°F/-53°C to 560°F/294°C	Red
Mold Max® Stroke®	N/A	100A:10B pbw	Brushable	30-45 min.	16 hrs.	30A	1.18	23.5	125 pli	577 psi	0.002	300%	-65°F/-53°C to 400°F/205°C	White
OOMOO® 25	1A:1B pbv	100A:130B pbw	4,250 cps	15 min.	75 min.	25A	1.34	20.6	40 pli	240 psi	0.0025	250%	-65°F/-53°C to 400°F/205°C	Light Blue
OOMOO® 30	1A:1B pbv	100A:130B pbw	4,250 cps	30 min.	6 hrs.	30A	1.34	20.6	40 pli	240 psi	0.0025	250%	-65°F/-53°C to 400°F/205°C	Lavender
Poyo® Putty 40	20A:1B pbv	100A:6B pbw	Putty	3-5 min.	30 min.	40A	1.30	21.3	85 pli	450 psi	0.003	250%	-65°F/-53°C to 400°F/205°C	Light Pink
Mold Star® 15 SLOW	1A:1B pbv	1A:1B pbw	12,500 cps	50 min.	4 hrs.	15A	1.18	23.5	88 pli	400 psi	<0.001	440%	-65°F/-53°C to 450°F/232°C	Green
Mold Star® 16 FAST	1A:1B pbv	1A:1B pbw	12,500 cps	6 min.	30 min.	16A	1.18	23.5	88 pli	400 psi	<0.001	440%	-65°F/-53°C to 450°F/232°C	Blue-Green
Mold Star® 19T	1A:1B pbv	1A:1B pbw	11,000 cps	3 min.	12 min.	19A	1.08	25.6	90 pli	420 psi	<0.001	470%	-65°F/-53°C to 450°F/232°C	Translucent
Mold Star® 20T	1A:1B pbv	1A:1B pbw	11,000 cps	6 min.	30 min.	20A	1.08	25.6	90 pli	420 psi	<0.001	470%	-65°F/-53°C to 450°F/232°C	Translucent
Mold Star® 30	1A:1B pbv	100A:96B pbw	12,500 cps	45 min.	6 hrs.	30A	1.12	24.7	88 pli	420 psi	<0.001	339%	-65°F/-53°C to 450°F/232°C	Blue
Mold Star® 31T	1A:1B pbv	1A:1B pbw	11,000 cps	5 min.	23 min.	31A	1.08	25.6	90 pli	423 psi	<0.001	400%	-65°F/-53°C to 450°F/232°C	Translucent
Dragon Skin® FX Pro	1A:1B pbv	1A:1B pbw	18,000 cps	12 min.	40 min.	2A	1.062	25.0	61 pli	288 psi	<0.001	763%	-65°F/-53°C to 450°F/232°C	Translucent
Dragon Skin® 10 NV	1A:1B pbv	1A:1B pbw	6,000 cps	15 min.	75 min.	10A	1.07	25.8	90 pli	400 psi	<0.001	663%	-65°F/-53°C to 450°F/232°C	Translucent
Dragon Skin® 10 Very Fast	1A:1B pbv	1A:1B pbw	23,000 cps	4 min.	30 min.	10A	1.07	25.8	102 pli	475 psi	<0.001	1,000%	-65°F/-53°C to 450°F/232°C	Translucent
Dragon Skin® 10 Fast	1A:1B pbv	1A:1B pbw	23,000 cps	8 min.	75 min.	10A	1.07	25.8	102 pli	475 psi	<0.001	1,000%	-65°F/-53°C to 450°F/232°C	Translucent
Dragon Skin® 10 Medium	1A:1B pbv	1A:1B pbw	23,000 cps	20 min.	5 hrs.	10A	1.07	25.8	102 pli	475 psi	<0.001	1,000%	-65°F/-53°C to 450°F/232°C	Translucent
Dragon Skin® 10 Slow	1A:1B pbv	1A:1B pbw	23,000 cps	45 min.	7 hrs.	10A	1.07	25.8	102 pli	475 psi	<0.001	1,000%	-65°F/-53°C to 450°F/232°C	Translucent
Dragon Skin® 20	1A:1B pbv	1A:1B pbw	20,000 cps	25 min.	4 hrs.	20A	1.08	25.6	120 pli	550 psi	<0.001	620%	-65°F/-53°C to 450°F/232°C	Translucent
Dragon Skin® 30	1A:1B pbv	1A:1B pbw	20,000 cps	45 min.	16 hrs.	30A	1.08	25.7	108 pli	500 psi	<0.001	364%	-65°F/-53°C to 450°F/232°C	Translucent
Smooth-Sil® 935	N/A	100A:10B pbw	40,000 cps	45 min.	24 hrs.	35A	1.18	23.5	115 pli	650 psi	<0.001	300%	-65°F/-53°C to 450°F/232°C	Blue
Smooth-Sil® 936	N/A	100A:10B pbw	21,000 cps	60 min.	24 hrs.	36A	1.21	22.9	110 pli	550 psi	<0.001	170%	-65°F/-53°C to 450°F/232°C	Blue
Smooth-Sil® 940	N/A	100A:10B pbw	35,000 cps	30 min.	24 hrs.	40A	1.18	23.4	100 pli	600 psi	<0.001	300%	-65°F/-53°C to 450°F/232°C	Pink
Smooth-Sil® 945	1A:1B pbv	1A:1B pbw	30,000 cps	25 min.	6 hrs.	45A	1.24	22.3	120 pli	700 psi	<0.001	320%	-65°F/-53°C to 450°F/232°C	Purple
Smooth-Sil® 950	N/A	100A:10B pbw	35,000 cps	45 min.	18 hrs.	50A	1.24	22.3	155 pli	725 psi	<0.001	320%	-65°F/-53°C to 450°F/232°C	Blue
Smooth-Sil® 960	N/A	100A:10B pbw	30,000 cps	45 min.	16 hrs.	60A	1.25	22.2	110 pli	650 psi	<0.001	270%	-65°F/-53°C to 450°F/232°C	Green
Sorta-Clear® 12	1A:1B pbv	1A:1B pbw	6,000 cps	40 min.	12 hrs.	12A	1.07	25.9	80 pli	320 psi	<0.001	590%	-65°F/-53°C to 450°F/232°C	Translucent
Sorta-Clear® 18	N/A	100A:10B pbw	21,000 cps	60 min.	24 hrs.	18A	1.08	25.6	80 pli	425 psi	<0.001	545%	-65°F/-53°C to 450°F/232°C	Translucent
Sorta-Clear® 37	1A:1B pbv	1A:1B pbw	35,000 cps	25 min.	4 hrs.	37A	1.08	25.6	105 pli	600 psi	<0.001	400%	-65°F/-53°C to 450°F/232°C	Translucent
Sorta-Clear® 40	N/A	100A:10B pbw	35,000 cps	60 min.	16 hrs.	40A	1.08	25.6	120 pli	800 psi	<0.001	400%	-65°F/-53°C to 450°F/232°C	Translucent
Rebound® 25	1A:1B pbv	1A:1B pbw	Brushable	20 min.	6 hrs.	25A	1.14	23.5	102 pli	515 psi	<0.001	690%	-65°F/-53°C to 450°F/232°C	Orange
Rebound® 40	1A:1B pbv	1A:1B pbw	Brushable	20 min.	6 hrs.	40A	1.14	23.5	106 pli	486 psi	<0.001	324%	-65°F/-53°C to 450°F/232°C	Green
EcoFlex® Gel	1A:1B pbv	1A:1B pbw	9,300 cps	15 min.	2 hrs.	000-35	0.98	28.0	N/A	N/A	<0.001	1,000%	-65°F/-53°C to 450°F/232°C	Translucent
EcoFlex® 00-10	1A:1B pbv	1A:1B pbw	14,000 cps	30 min.	4 hrs.	00-10	1.04	26.6	22 pli	120 psi	<0.001	800%	-65°F/-53°C to 450°F/232°C	Translucent
EcoFlex® 00-20	1A:1B pbv	1A:1B pbw	3,000 cps	30 min.	4 hrs.	00-20	1.07	26.0	30 pli	160 psi	<0.001	845%	-65°F/-53°C to 450°F/232°C	Translucent
EcoFlex® 00-30	1A:1B pbv	1A:1B pbw	3,000 cps	45 min.	4 hrs.	00-30	1.07	26.0	38 pli	200 psi	<0.001	900%	-65°F/-53°C to 450°F/232°C	Translucent
EcoFlex® 00-33AF	1A:1B pbv	1A:1B pbw	3,000 cps	45 min.	4 hrs.	00-33	1.07	26.0	38 pli	200 psi	<0.001	900%	-65°F/-53°C to 450°F/232°C	Translucent
EcoFlex® 00-35 FAST	1A:1B pbv	1A:1B pbw	3,500 cps	2.5 min.	5 min.	00-35	1.07	26.0	38 pli	200 psi	<0.001	900%	-65°F/-53°C to 450°F/232°C	Off-White
EcoFlex® 00-50	1A:1B pbv	1A:1B pbw	8,000 cps	18 min.	3 hrs.	00-50	1.07	25.9	50 pli	315 psi	<0.001	980%	-65°F/-53°C to 450°F/232°C	Translucent
EcoFlex® 5	1A:1B pbv	1A:1B pbw	13,000 cps	1 min.	5 min.	5A	1.07	25.8	75 pli	350 psi	<0.001	1,000%	-65°F/-53°C to 450°F/232°C	Translucent
3030 SLIDE®	1A:1B pbv	1A:1B pbw	3,000 cps	45 min.	16 hrs.	00-30	1.07	26.0	38 pli	200 psi	<0.001	900%	-65°F/-53°C to 450°F/232°C	Translucent
Body Double® Standard Set	1A:1B pbv	1A:1B pbw	Brushable	5 min.	20 min.	25A	1.17	23.7	100 pli	525 psi	<0.001	500%	-65°F/-53°C to 450°F/232°C	Purple
Body Double® Fast Set	1A:1B pbv	1A:1B pbw	Brushable	90 sec.	7 min.	25A	1.17	23.7	105 pli	450 psi	<0.001	500%	-65°F/-53°C to 450°F/232°C	Aqua Green
Body Double® SILK	1A:1B pbv	1A:1B pbw	Brushable	6 min.	20 min.	25A	0.91	30.4	N/A	N/A	<0.001	N/A	-65°F/-53°C to 450°F/232°C	Green
Equinox® 35 Fast	1A:1B pbv	1A:1B pbw	Putty	1 min.	7 min.	35A	1.25	21.3	140 pli	520 psi	0.0003	430%	-65°F/-53°C to 450°F/232°C	Light Purple
Equinox® 38 Medium	1A:1B pbv	1A:1B pbw	Putty	4 min.	30 min.	38A	1.25	21.3	140 pli	520 psi	0.0003	430%	-65°F/-53°C to 450°F/232°C	Light Purple
Equinox® 40 Slow	1A:1B pbv	1A:1B pbw	Putty	30 min.	5 hrs.	40A	1.25	21.3	140 pli	520 psi	0.0003	430%	-65°F/-53°C to 450°F/232°C	Light Purple
EZ~Spray® Silicone 20	1A:1B pbv	1A:1B pbw	11,000 cps	3 min.	20 min.	20A	1.08	25.6	100 pli	495 psi	<0.001	470%	-65°F/-53°C to 450°F/232°C	Translucent Green
EZ~Spray® Silicone 22	1A:1B pbv	1A:1B pbw	11,000 cps	5 min.	45 min.	22A	1.08	25.6	102 pli	490 psi	<0.001	450%	-65°F/-53°C to 450°F/232°C	Translucent Green
EZ~Spray® Silicone 35	1A:1B pbv	1A:1B pbw	12,000 cps	1.5 min.	1 hr.	35A	1.15	24.1	92 pli	490 psi	<0.001	415%	-65°F/-53°C to 450°F/232°C	Purple
EZ~Brush® Vac Bag Silicone	1A:1B pbv	1A:1B pbw	20,000 cps	30 min.	3.5 hrs.	20A	1.08	25.7	120 pli	550 psi	<0.001	364%	-65°F/-53°C to 450°F/232°C	Translucent Green
Solaris® Clear Encapsulant	1A:1B pbv	1A:1B pbw	1,200 cps	240 min.	24 hrs.	15A	0.99	28.1	N/A	180 psi	<0.001	290%	-149°F/-100°C to 400°F/205°C	Clear
Rubber Glass®	1A:1B pbv	1A:1B pbw	150 cps	120 min.	16 hrs.	33A	0.97	28.6	N/A	N/A	<0.001	N/A	N/A	Clear
Encapso® K	1A:1B pbv	1A:1B pbw	150 cps	120 min.	16 hrs.	33A	0.97	28.6	N/A	N/A	<0.001	N/A	N/A	Clear

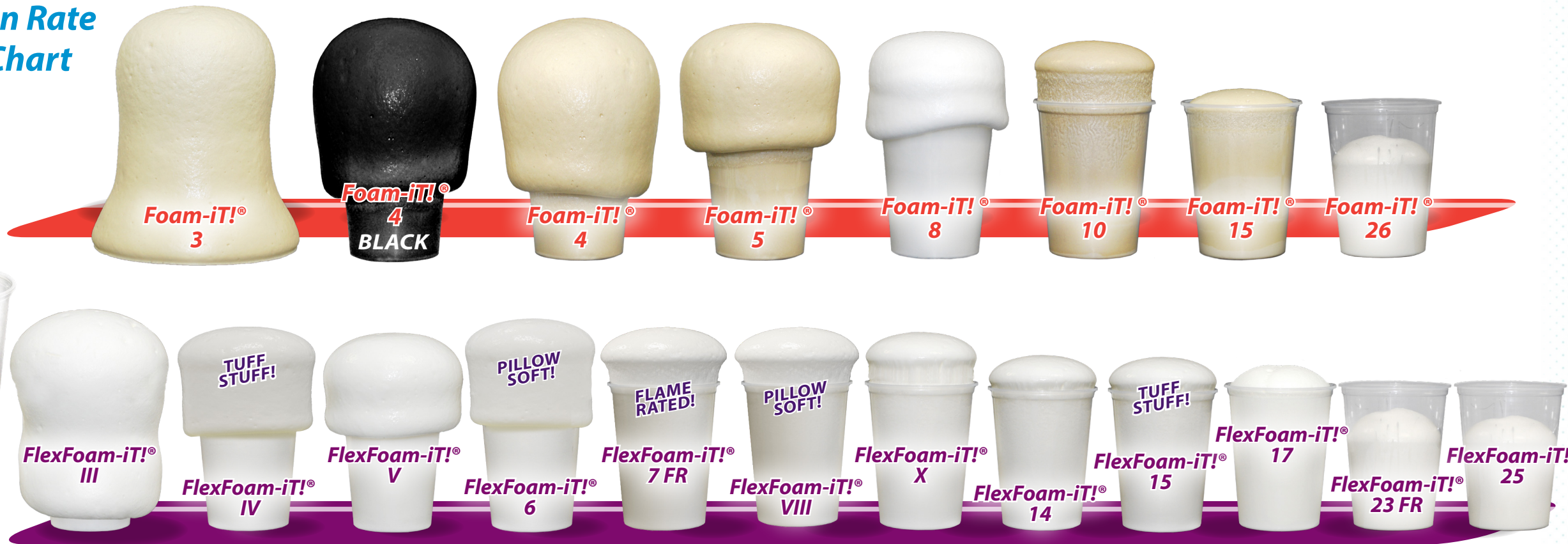
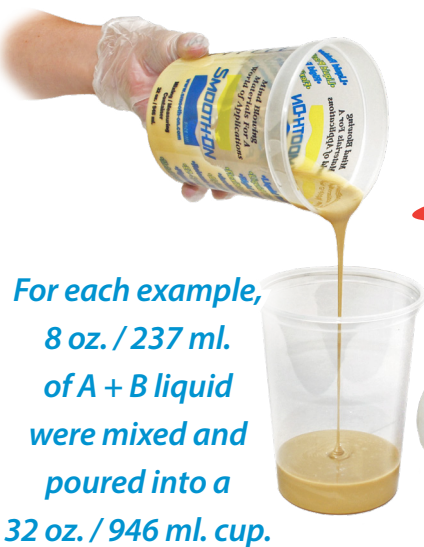
Smooth-On Silicone Rubber

Technical Reference Chart



Product Name	A:B Mix Ratio By Volume	A:B Mix Ratio By Weight	Mixed Viscosity (ASTM D-2393)	Pot Life (Cream Time) (ASTM D-2471)	Handling / Tack-Free Time	Cure Time	Specific Gravity (g/cc) Average (ASTM D-1475)	Specific Volume (Cu. In./lb.)	Lbs./Cubic Foot	Kgs./Cubic Meter	Approx. Volumetric Expansion	Color
Rigid Foams Foam-iT!® 3	1A:1B pbv	100A:87B pbw	200 cps	1 min.	20 min.	2 hrs.	0.05	504	3 lb/ft ³	48 kg/m ³	18 times	Beige
Foam-iT!® 4	1A:1B pbv	100A:87B pbw	300 cps	1.5 min.	20 min.	2 hrs.	0.06	420	4 lb/ft ³	64 kg/m ³	14 times	Beige
Foam-iT!® 4 Black	1A:1B pbv	100A:87B pbw	300 cps	1.5 min.	20 min.	2 hrs.	0.06	420	4 lb/ft ³	64 kg/m ³	14 times	Black
Foam-iT!® 5	1A:1B pbv	100A:87B pbw	300 cps	1.5 min.	20 min.	2 hrs.	0.08	315	5 lb/ft ³	80 kg/m ³	10 times	Beige
Foam-iT!® 8	N/A	2A:1B pbw	300 cps	1.5 min.	20 min.	2 hrs.	0.13	194	8 lb/ft ³	128 kg/m ³	8 times	Off White
Foam-iT!® 10	1A:1B pbv	100A:87B pbw	400 cps	1.5 min.	20 min.	2 hrs.	0.16	157	10 lb/ft ³	160 kg/m ³	6 times	Beige
Foam-iT!® 10 SLOW	1A:1B pbv	100A:87B pbw	400 cps	3.5 min.	1 hr.	4 hrs	0.16	157	10 lb/ft ³	160 kg/m ³	6 times	Beige
Foam-iT!® 15	1A:1B pbv	100A:87B pbw	500 cps	1.5 min.	20 min.	2 hrs.	0.24	105	15 lb/ft ³	240 kg/m ³	4 times	Beige
Foam-iT!® 26	1A:1B pbv	100A:90B pbw	500 cps	1.5 min.	20 min.	2 hrs.	0.42	60	26 lb/ft ³	416 kg/m ³	2 times	White
EZ~Spray® Foam	1A:1B pbv	N/A	400 cps	13 sec.	10 min.	10 min.	0.128	144	8 lb/ft ³	128 kg/m ³	7 times	Tan
Flexible Foams FlexFoam-iT!® III	1A:2B pbv	57.5A:100B pbw	1,000 cps	35 sec.	25 min.	2 hrs.	0.05	504	3 lb/ft ³	48 kg/m ³	15 times	White
FlexFoam-iT!® IV	N/A	80A:100B pbw	1,000 cps	30 sec.	45 min.	2 hrs.	0.06	420	4 lb/ft ³	64 kg/m ³	13 times	White
FlexFoam-iT!® V	1A:1B pbv	105A:100B pbw	1,000 cps	50 sec.	45 min.	2 hrs.	0.08	315	5 lb/ft ³	80 kg/m ³	11 times	White
FlexFoam-iT!® 6	1A:1B pbv	105A:100B pbw	1,000 cps	35 sec.	60 min.	2 hrs.	0.09	280	6 lb/ft ³	96 kg/m ³	10 times	White
FlexFoam-iT!® 7 FR	1A:1B pbv	100A:88B pbw	1,000 cps	35 sec.	60 min.	2 hrs.	0.11	229	7 lb/ft ³	110 kg/m ³	8 times	White
FlexFoam-iT!® VIII	1A:2B pbv	52.6A:100B pbw	1,000 cps	35 sec.	25 min.	2 hrs.	0.13	194	8 lb/ft ³	128 kg/m ³	8 times	White
FlexFoam-iT!® X	1A:1B pbv	105A:100B pbw	1,000 cps	50 sec.	45 min.	2 hrs.	0.16	157	10 lb/ft ³	160 kg/m ³	6 times	White
FlexFoam-iT!® 14	1A:2B pbv	100A:190B pbw	1,000 cps	60 sec.	45 min.	2 hrs.	0.22	114	14 lb/ft ³	220 kg/m ³	4 times	White
FlexFoam-iT!® 15	1A:2B pbv	100A:185B pbw	1,000 cps	2 min.	90 min.	4 hrs.	0.24	115	15 lb/ft ³	240 kg/m ³	4 times	White
FlexFoam-iT!® 17	1A:2B pbv	100A:185B pbw	1,000 cps	60 sec.	30 min.	2 hrs.	0.27	93	17 lb/ft ³	270 kg/m ³	3.5 times	White
FlexFoam-iT!® 23 FR	N/A	85A:100B pbw	1,000 cps	90 sec.	60 min.	2 hrs.	0.37	68	23 lb/ft ³	370 kg/m ³	2 times	White
FlexFoam-iT!® 25	N/A	1A:2B pbw	1,000 cps	90 sec.	25 min.	2 hrs.	0.4	63	25 lb/ft ³	400 kg/m ³	2 times	White
EZ~Spray® FlexFoam	1A:1B pbv	N/A	1,000 cps	10 sec.	10 min.	15 min.	0.11	252	7 lb/ft ³	110 kg/m ³	7 times	White
Soma Foama® 15	2A:1B pbv	100A:47B pbw	10,000 cps	30 sec.	20 min.	1 hr.	0.24	115	15 lb/ft ³	240 kg/m ³	4 times	White
Soma Foama® 25	1A:1B pbv	1A:1B pbw	10,000 cps	90 sec.	20 min.	1 hr.	0.40	69	25 lb/ft ³	400 kg/m ³	2-3 times	White

Foam Expansion Rate Comparison Chart



*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.

Smooth-On Rigid & Flexible Foams

Technical Reference Chart

Product Name	Hardener	A:B Mix Ratio by Volume/Weight	Mixed Viscosity ASTM D-2393	Pot Life ASTM D-2471	Thin Film Working Time	Cure Time @ 73°F/23°C	Shore D Hardness ASTM D-2240	Specific Gravity (g/cm³) ASTM D-1475	Specific Volume (in³/lb) 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 (°F/°C) ASTM D-648	Color
EpoxAmite® 101	101 Fast	4A:1B pbv 100A:24B pbw	1,000 cps	11 min.	30 min.	6-8 hrs.	84D	1.13	24.5	7,930 psi* 35,100 psi**	445,000 psi*	2.45%*	13,660 psi* 30,700 psi**	468,000 psi*	11,550 psi*	121,400 psi*	133° F*/ 56° C*	Clear Yellow
EpoxAmite® 102	102 Medium	3A:1B pbv 100A:29B pbw	650 cps	22 min.	90 min.	10-15 hrs.	80D	1.11	25	8,180 psi* 26,800 psi**	450,000 psi*	3.15%*	12,220 psi* 28,500 psi**	423,000 psi*	10,970 psi*	122,000 psi*	120° F*/ 49° C*	Clear Yellow
EpoxAmite® 103	103 Slow	3A:1B pbv 100A:28.4B pbw	650 cps	55 min.	180 min.	20-24 hrs.	80D	1.10	25.2	7,910 psi* 27,000 psi**	452,000 psi*	2.63%*	12,300 psi* 20,700 psi**	429,000 psi*	10,500 psi*	104,000 psi*	127° F*/ 53° C*	Clear Yellow
EpoxAmite® HT	HT High Temp	100A:33B pbw	650 cps	60 min.	180 min.	24 hrs.	80D	1.10	25.2	6,500 psi* 32,100 psi**	342,000 psi* 2,150,000 psi**	2.3%*	12,325 psi* 20,700 psi**	429,000 psi* 2,216,000 psi**	16,600 psi*	168,000 psi*	300° F*/ 149° C*	Clear
EpoxAmite® White	101 Fast	100A:20B pbw	3,400 cps	20 min.	45 min.	10-15 hrs..	83D	1.25	22.2	5,130 psi* 24,700 psi**	627,000 psi*	0.8%*	8,770 psi* 29,000 psi**	465,000 psi*	16,290 psi*	116,000 psi*	136° F*/ 58° C*	White
EpoxAmite® White	102 Medium	100A:23B pbw	2,800 cps	62 min.	120 min.	20-24 hrs..	85D	1.23	22.5	5,600 psi* 30,700 psi**	557,000 psi*	1.2%*	8,350 psi* 31,600 psi**	446,000 psi*	11,960 psi*	114,000 psi*	133° F*/ 56° C*	White

* Values measured after 7 days at 73°F/23°C. ** Denotes testing conducted on a 6 ply/10 oz. laminate after 7 days at 73°F/23°C.

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	Hardness ASTM D-2240	Specific Gravity (g/cm³) ASTM D-1475	Specific Volume (in³/lb) 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 (in/in) ASTM D-2566*	Heat Deflection Temp (°F/°C) ASTM D-648	Color
EpoxAcast® 650	101 Fast	100A:12B pbw	7,000 cps	20 min.	1.0 hr.	93 ^B	1.52	18.2	6,000 psi	1,503,000 psi	0.42%	5,890 psi	710,000 psi	16,350 psi	142,600 psi	0.001	129° F/54° C	Off-White or Black
EpoxAcast® 650	102 Medium	100A:13B pbw	7,000 cps	90 min.	4.0 hrs.	93 ^B	1.52	18.2	6,000 psi	1,503,000 psi	0.42%	5,890 psi	710,000 psi	16,350 psi	142,600 psi	0.001	129° F/54° C	Off-White or Black
EpoxAcast® 650	103 Slow	100A:14B pbw	7,000 cps	3.5 hrs.	24 hrs.	93 ^B	1.52	18.2	6,000 psi	1,503,000 psi	0.42%	5,890 psi	710,000 psi	16,350 psi	142,600 psi	0.001	129° F/54° C	Off-White or Black
EpoxAcast® 650	HT High Temp	100A:10B pbw	5,000 cps	3.0 hrs.	24 hrs.*	93 ^B	1.52	18.2	6,900 psi	1,079,000 psi	0.82%	10,850 psi	775,000 psi	15,980 psi	134,400 psi	0.007	187° F/86° C**	Off-White or Black
EpoxAcast® 655	101 Fast	100A:10B pbw	23,000 cps	30 min.	3.0 hrs.	90 ^D	1.66	16.7	4,810 psi	2,040,000 psi	0.54%	7,660 psi	1,403,000 psi	12,500 psi	125,500 psi	0.0006	135° F/57° C	Grey
EpoxAcast® 655	102 Medium	100A:11B pbw	23,000 cps	75 min.	9.0 hrs.	90 ^D	1.66	16.7	4,810 psi	2,040,000 psi	0.54%	7,660 psi	1,403,000 psi	12,500 psi	125,500 psi	0.0006	135° F/57° C	Grey
EpoxAcast® 655	103 Slow	100A:12B pbw	23,000 cps	3.5 hrs.	24 hrs.	90 ^D	1.66	16.7	4,810 psi	2,040,000 psi	0.54%	7,660 psi	1,403,000 psi	12,500 psi	125,500 psi	0.0006	135° F/57° C	Grey
EpoxAcast® 655	HT High Temp	100A:8B pbw	12,000 cps	4.0 hrs.	24 hrs.*	90 ^D	1.64	16.5	6,000 psi	7,200,000 psi	0.50%	N/A	N/A	15,700 psi	270,000 psi	0.001	225° F/108° C**	Grey
EpoxAcast® 670 HT	HT High Temp	100A:16B pbw	6,000 cps	3.0 hrs.	24 hrs.*	90 ^D	1.15	20.5	4,500 psi	332,000 psi	0.65%	11,000 psi	254,000 psi	13,000 psi	101,400 psi	0.002	252° F/122° C 350° F/177° C**	Beige
EpoxAcast® 690	Clear	100A:30B pbw	200 cps	5.0 hrs.	24 hrs.	80 ^D	1.10	25.0	6,630 psi	572,000 psi	1.8%	10,980 psi	410,000 psi	9,610 psi	91,300 psi	0.002	115° F/46° C	Clear

* 24 Hours followed by: Heat cure for 2 hrs. at 175°F/80°C, then 3 hrs. at 300°F/150°C. ** If post cured according to heat post curing schedule. ^B Barcol 935 Hardness (ASTM D2240) ^D Shore D Hardness (ASTM D2240)

Smooth-On Epoxy Technical Reference Chart



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 (g/cm³) ASTM D-1475	Specific Volume (in³/lb)	Ultimate Tensile ASTM D-638	Flexural Strength ASTM D-790	Compressive Strength ASTM D-695	Shrinkage (in/in) ASTM D-2566*	Heat Deflection Temp (°F/°C) ASTM D-648	Color
EpoxAcoat® RED	101 Fast	5A:1B pbv	100A:15B pbw	Light Paste	20 min.	40 min.	60 min.	4.0 hrs.	16 hrs.	85D	87	1.43	19.4*	26,000 psi	30,000 psi	24,000 psi	0.00015	133° F/56° C	Red
EpoxAcoat® GREY	101 Fast	5A:1B pbv	100A:15B pbw	Light Paste	20 min.	40 min.	60 min.	4.0 hrs.	16 hrs.	85D	87	1.43	19.4*	26,000 psi	30,000 psi	24,000 psi	0.00015	133° F/56° C	Grey
EpoxAcoat® WHITE	101 Fast	5A:1B pbv	100A:15B pbw	Light Paste	20 min.	40 min.	60 min.	4.0 hrs.	16 hrs.	85D	87	1.43	19.4*	26,000 psi	30,000 psi	24,000 psi	0.00015	133° F/56° C	White
EpoxAcoat® NEUTRAL	101 Fast	5A:1B pbv	100A:15B pbw	Light Paste	20 min.	40 min.	60 min.	4.0 hrs.	16 hrs.	85D	87	1.43	19.4*	26,000 psi	30,000 psi	24,000 psi	0.00015	133° F/56° C	Neutral
EpoxAcoat® HT	HT High Temp	N/A	100A:18B pbw	Light Paste	40 min.	75 min.	4 hrs.	N/A	24 hrs.	85D	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 pbw	Variable	15 min.	45 min.	60 min.	2.0 hrs.	16 hrs.	75D	N/A	1.16	23.9*	N/A	N/A	N/A	N/A	N/A	Beige
EPSILON®	102 Med	N/A	100A:25B pbw	Variable	30 min.	120 min.	180 min.	5.0 hrs.	24 hrs.	75D	N/A	1.14	24.3*	N/A	N/A	N/A	N/A	N/A	Beige
EPSILON® PRO	N/A	2A:1B pbv	100A:44B pbw	4,000 cps	22 min.	35 min.	3 hrs.	4 hrs.	16 hrs.	65D	N/A	1.11	25.0*	N/A	N/A	N/A	N/A	N/A	Clear Amber
Tarbender®	N/A	2A:1B pbv	100A:41B pbw	1100 cps	45 min.	2 hrs.	6 hrs.	8 hrs.	16 hrs.	75D	N/A	1.09	25.4*	N/A	N/A	N/A	N/A	N/A	Clear
XTC-3D®	N/A	2A:1B pbv	100A:42B pbw	350 cps	10 min.	20 min.	90 min.	2 hrs.	3.5 hrs.	80D	N/A	1.09	25.1*	N/A	N/A	N/A	N/A	N/A	Clear
Plasti-Paste™ EPOXY	N/A	2A:1B pbv	2A:1B pbw	Paste	40 min.	N/A	60 min.	N/A	16 hrs.	80D	N/A	1.00	27.73	3,320 psi	9,186 psi	7,700 psi	<0.001	160° F/71° C	Off White

* Values measured after 7 days at 73°F/23°C.

** If post cured according to heat post curing schedule.

Epoxy Putties

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 (g/cm³) ASTM D-1475	Specific Volume (in³/lb)	Ultimate Tensile ASTM D-638	Flexural Strength ASTM D-790	Compressive Strength ASTM D-695	Shrinkage (in/in) ASTM D-2566*	Heat Deflection Temp (°F/°C) ASTM D-648	Color
Free Form® Air	N/A	1A:1B pbv	1A:1B pbw	Dough	30 min. @1.5" 60 min. @3/8" 120 min. @1/8"	N/A	N/A	N/A	24 hrs.	50D	N/A	0.45	61.6 [†]	N/A	N/A	N/A	N/A	140° F/60° C	Grey
Free Form® Air HT	N/A	2A:1B pbv	2A:1B pbw	Dough	90 min. @1.5" 2.5 hrs. @3/8" 3 hrs. @1/8"	N/A	N/A	N/A	16 hrs.	55D	N/A	0.51	54.31	N/A	N/A	N/A	N/A	400° F/204° C	Grey
Free Form® Air FS	N/A	1A:1B pbv	1A:1B pbw	Dough	30 min. @1.5" 60 min. @3/8" 120 min. @1/8"	N/A	N/A	N/A	24 hrs.	73D	N/A	0.8	34.6	N/A	N/A	N/A	N/A	140° F/60° C	Grey
Free Form® Air Fast	N/A	1A:1B pbv	1A:1B pbw	Dough	6 min. @1/2" 8 min. @3/8" 10 min. @1/8"	N/A	N/A	N/A	24 hrs.	60D	N/A	0.45	61.6	N/A	N/A	N/A	N/A	145° F/63° C	Grey
Free Form® Sculpt	N/A	1A:1B pbv	1A:1B pbw	Putty	1.5 hrs. @1 lb.	N/A	N/A	N/A	overnight	80D	N/A	1.33	20.7 [†]	N/A	N/A	N/A	<0.001	150° F/65° C	Grey
Free Form® Habitat® Black	N/A	1A:1B pbv	1A:1B pbw	Dough	60 min.	N/A	N/A	N/A	16 hrs.	85D	N/A	1.6	17.3 [†]	N/A	N/A	N/A	N/A	160° F/74° C 212° F/100° C**	Black
Free Form® Habitat® Fire Safe	N/A	1A:1B pbv	1A:1B pbw	Dough	90 min.	N/A	N/A	N/A	16 hrs.	85D	N/A	1.44	17.3 [†]	N/A	N/A	N/A	N/A	160° F/74° C 212° F/100° C**	Neutral
Free Form® Habitat® Flex FR	N/A	1A:1B pbv	1A:1B pbw	Dough	90 min.	N/A	N/A	N/A	24 hrs.	90A	N/A	1.55	17.9 [†]	N/A	N/A	N/A	N/A	160° F/74° C 212° F/100° C**	Light Brown
Free Form® Habitat® Cast N Coat™	N/A	1A:1B pbv	1A:1B pbw	13,500 cps	85 min.	N/A	N/A	N/A	16 hrs.	85D	N/A	1.51	18.35 [†]	N/A	N/A	N/A	N/A	131° F/55° C	Tan

* ASTM D792

†ASTM D1475

** If post cured according to heat post curing schedule.

Smooth-On Epoxy Technical Reference Chart

