



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
<b>VytaFlex® 10</b>	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
<b>VytaFlex® 20</b>	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
<b>VytaFlex® 30</b>	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
<b>VytaFlex® 40</b>	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
<b>VytaFlex® 50</b>	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
<b>VytaFlex® 60</b>	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
<b>ReoFlex® 20</b>	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
<b>ReoFlex® 30</b>	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
<b>ReoFlex® 40</b>	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
<b>ReoFlex® 50</b>	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
<b>ReoFlex® 60</b>	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
<b>PMC®-121/30</b>	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
<b>PMC®-121/50</b>	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
<b>PMC®-724</b>	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
<b>PMC®-726</b>	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
<b>PMC®-744</b>	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
<b>PMC®-746</b>	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**
<b>PMC®-770</b>	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
<b>PMC®-780</b>	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
<b>PMC®-790</b>	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
<b>Brush-On® 35</b>	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
<b>Brush-On® 40</b>	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
<b>Brush-On® 50</b>	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
<b>Brush-On® 60</b>	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
<b>EZ-Mix® 40</b>	1A:1B pbv	100A:95B pbw	Brushable	18 min.	16 hrs.	40A	1.025	27.0	67 pli	420 psi	<0.001	577%	Grey
<b>UreCoat®</b>	N/A	100A:10B pbw	Brushable	8 min.	16 hrs.	70A	1.05	26.4	256 pli	503 psi	<0.001	876%	Translucent Amber
<b>EZ~Spray® 45</b>	1A:1B pbv	N/A	Sprayable	20 min.	16 hrs.	45A	1.025	27.0	100 pli	510 psi	<0.001	375%	Light Blue
<b>Econ® 60</b>	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
<b>Econ® 80</b>	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
<b>Clear Flex® 30</b>	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
<b>Clear Flex® 50</b>	N/A	1A:2B pbw	250 cps	25 min.	16 hrs.	50A	1.04	26.8	25 pli	250 psi	0.0015	500%	Clear
<b>Clear Flex® 95</b>	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
<b>Formlastic™ 48</b>	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
<b>Formlastic™ 60</b>	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

\*\* Color may vary from batch to batch

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

# Smooth-On Urethane Rubber

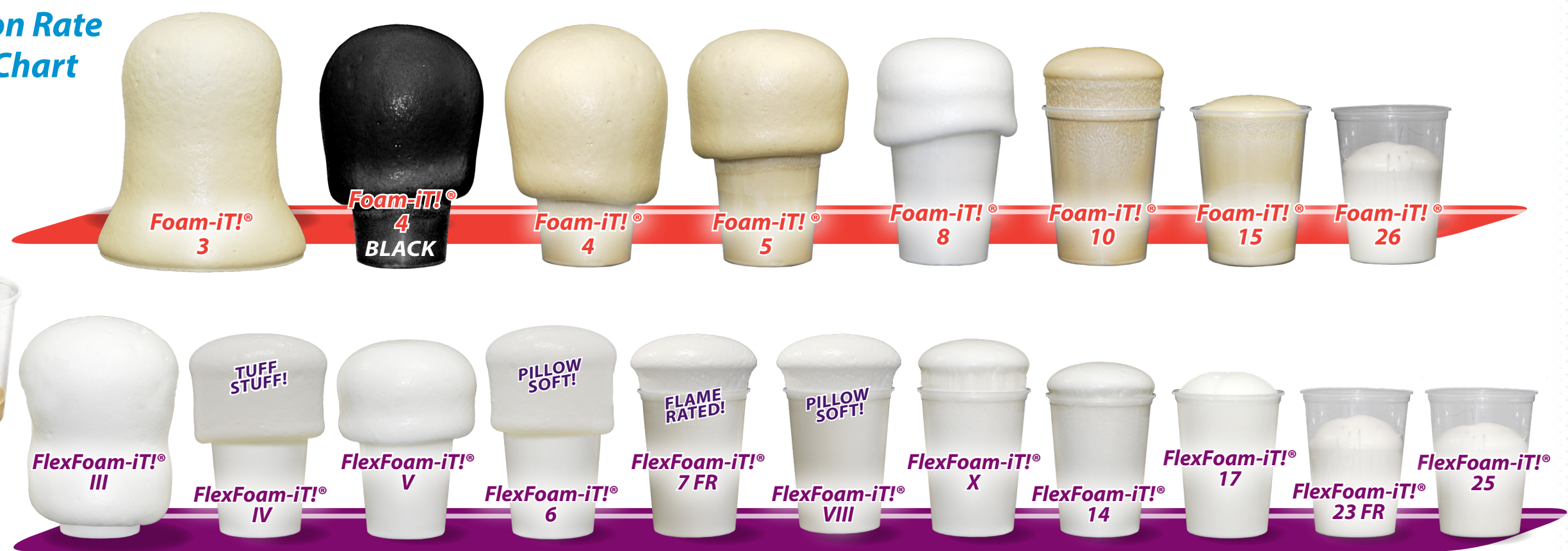
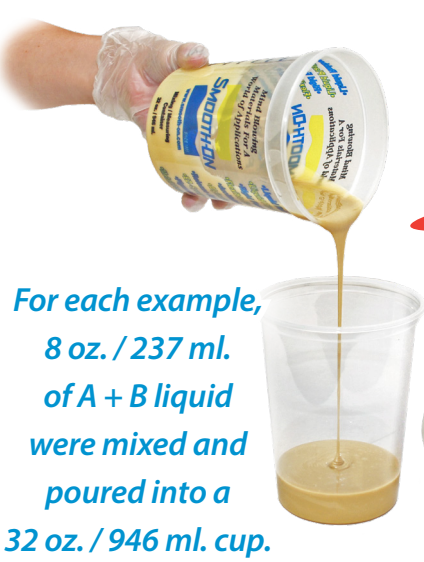
## Technical Reference Chart





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
<b>Rigid Foams</b> Foam-iT!® 3	1A:1B pbv	100A:87B pbw	200 cps	1 min.	20 min.	2 hrs.	0.05	504	3 lb/ft <sup>3</sup>	48 kg/m <sup>3</sup>	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 <sup>3</sup>	64 kg/m <sup>3</sup>	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 <sup>3</sup>	64 kg/m <sup>3</sup>	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 <sup>3</sup>	80 kg/m <sup>3</sup>	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 <sup>3</sup>	128 kg/m <sup>3</sup>	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 <sup>3</sup>	160 kg/m <sup>3</sup>	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 <sup>3</sup>	160 kg/m <sup>3</sup>	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 <sup>3</sup>	240 kg/m <sup>3</sup>	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 <sup>3</sup>	416 kg/m <sup>3</sup>	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 <sup>3</sup>	128 kg/m <sup>3</sup>	7 times	Tan
<b>Flexible Foams</b> 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 <sup>3</sup>	48 kg/m <sup>3</sup>	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 <sup>3</sup>	64 kg/m <sup>3</sup>	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 <sup>3</sup>	80 kg/m <sup>3</sup>	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 <sup>3</sup>	96 kg/m <sup>3</sup>	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 <sup>3</sup>	110 kg/m <sup>3</sup>	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 <sup>3</sup>	128 kg/m <sup>3</sup>	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 <sup>3</sup>	160 kg/m <sup>3</sup>	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 <sup>3</sup>	220 kg/m <sup>3</sup>	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 <sup>3</sup>	270 kg/m <sup>3</sup>	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 <sup>3</sup>	370 kg/m <sup>3</sup>	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 <sup>3</sup>	400 kg/m <sup>3</sup>	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 <sup>3</sup>	110 kg/m <sup>3</sup>	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 <sup>3</sup>	240 kg/m <sup>3</sup>	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 <sup>3</sup>	400 kg/m <sup>3</sup>	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.

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® 100	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® 100	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® 100	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 <sup>B</sup>	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 <sup>B</sup>	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 <sup>B</sup>	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 <sup>B</sup>	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 <sup>D</sup>	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 <sup>D</sup>	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 <sup>D</sup>	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 <sup>D</sup>	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 <sup>D</sup>	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 <sup>D</sup>	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.

<sup>B</sup> Barcol 935 Hardness (ASTM D2240)

<sup>D</sup> 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/cm <sup>3</sup> ) ASTM D-1475	Specific Volume (in <sup>3</sup> /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	1.49	18.5*	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	1.49	18.5*	26,000 psi	30,000 psi	24,000 psi	0.00015	133° F/56° C	Grey	
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.

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

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/cm <sup>3</sup> ) ASTM D-1475	Specific Volume (in <sup>3</sup> /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 <sup>†</sup>	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® 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 <sup>†</sup>	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 <sup>†</sup>	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 <sup>†</sup>	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 <sup>†</sup>	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 <sup>†</sup>	N/A	N/A	N/A	N/A	131° F/55° C	Tan	

\* ASTM D792

<sup>†</sup>ASTM D1475

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

# Smooth-On Epoxy Technical Reference Chart

