



CLEAR FLEX 50 & 95

Water Clear Urethane Rubber

PRODUCT OVERVIEW

Clear Flex 50 and Clear Flex 95 are water white clear urethane liquid rubber compounds designed for applications that require absolute clarity and resistance to sunlight. Low viscosity ensures easy mixing and pouring. Clear Flex 50 and 95 cure at room temperature with negligible shrinkage. Cured castings are clear, flexible and **UV STABLE** (will not yellow). Vibrant colors and color effects are achieved by adding pigments.

Applications include making clear-cut molds, model reproductions, decorative cast pieces, special effects, prototype parts.

CAUTION: NOT FOR HOME USE. THIS PRODUCT IS FOR INDUSTRIAL USE ONLY. Proper ventilation, A NIOSH Approved Respirator and Protective Clothing are required to minimize the risk of inhalation and dermal sensitization. If breathing is affected or a dermal rash develops, immediately cease using this product and seek medical attention. Read MSDS before using.

TECHNICAL OVERVIEW

<i>Key Values:</i>	<i>~Mixing Ratio</i>	<i>~ Shore Hardness</i>	<i>~ Pot Life.</i>	<i>~Gel Time</i>
Clear Flex 50	50 Parts A to 100 Parts B by weight (1 A : 2 B)	50A*	25 minutes	40 minutes*
Clear Flex 95	100 Parts A to 150 Parts B by weight (1 A : 1.5 B)	95A*	25 minutes	40 minutes*

Properties:	Viscosity			Elongation			
	(A+B Mixed)	G/CC	Cu. In./Lb.	Tensile Strength	At Break	Tear Strength	Shrinkage
Clear Flex 50	250 cps	1.04	26.8	250 psi	500%	25 psi	.0015 in./in.
Clear Flex 95	250 cps	1.04	26.8	2,500 psi	175%	200 psi	.0028 in./in.

*Cure time depends on casting thickness and configuration. See "Curing" section on reverse side of this bulletin.

Preparation

Some Materials Must Be Sealed . . . To prevent adhesion between the rubber and model surface, models made of porous materials (gypsum plasters, concrete, wood, stone, etc.) must be sealed prior to applying a release agent. The best sealer for sealing porous materials is **Superseal** (Available from TCS, Inc). **Spray shellac** is suitable for rough contours. **Modeling clays** that contain sulfur (Roma Plastalina) or moisture must also be sealed. Allow sealer to dry thoroughly.

Applying A Release Agent

Applying A Release Agent . . . A release agent is necessary to facilitate demolding when casting into or over most surfaces. Use a release agent made specifically for mold making. A liberal coat of release agent should be applied onto all surfaces that will contact the rubber. **~IMPORTANT:** To ensure thorough coverage, lightly brush the release agent with a soft brush over all surfaces of the model. Follow with a light mist coating and let dry for 30 minutes.

Measuring

If Casting Into Mold Rubber – If using Mold Max silicone rubber, no release agent is necessary.

If silicone mold is newly made, post cure rubber at 150°F / 65°C for 6 hours & let cool prior to casting Clear Flex. Casting into platinum cure silicones is not recommended because of inhibition potential. If casting into Smooth-On urethane rubber, apply Universal Mold Release to the mold surface prior to casting Clear Flex.

Measuring . . . IMPORTANT: Stir Part B thoroughly before dispensing. The correct mix ratios for Clear Flex 50 and Clear Flex 95 are listed above. Dispense the required amount of Part A into a mixing container. Weigh out the appropriate amount of Part B and combine with Part A.

IMPORTANT: Shelf life of product is drastically reduced after opening. Immediately replace container lids after dispensing. Use remaining product as soon as possible. Purging opened containers with **XTEND-IT™** dry gas blanket (available from TCS, Inc or your distributor) before re-sealing will significantly extend shelf life of unused product.

Mixing & Pouring

Materials should be stored and used in a warm environment (72° F / 23° C). **Important: Pre-Mix the Part B before using.** After dispensing equal amounts of Parts A and B into mixing container, mix thoroughly for at least 3 minutes making sure that you scrape the sides and bottom of the mixing container several times. **If Mixing Large Quantities** (16 lbs./7 kg. or more) at one time, use a mechanical mixer (i.e. Squirrel Mixer or equal) for 3 minutes followed by careful hand mixing for one minute as directed above. Then, pour entire quantity into a new, clean mixing container and do it all over again. If coloring or filling Clear Flex 50 or Clear Flex 95, add filler or pigment dispersion to Part B and mix thoroughly before adding Part A.

If **vacuum degassing** prior to pouring, subject mixture to 29 inches of mercury in a suitable vacuum chamber for 2 -3 minutes or until mixture rises, breaks and falls. Allow for 3 to 4 times volume expansion in mixing container.

Pouring . . . If casting Clear Flex 50 or Clear Flex 95 into a rubber mold, pour mixture in a single spot at the lowest point of the mold. If encapsulating an object, do not pour the mixture directly over the object. Let the mixture seek its level. A uniform flow will help minimize entrapped air.

For Best Results . . . Best results are obtained using a **pressure casting technique**. After pouring the mixed compound, the entire casting assembly (mold, dam structure, etc.) is placed in a pressure chamber and subjected to 60 PSI (4.2 kg/cm²) air pressure for at least two hours.

Casting Thickness

Curing

Post Curing

Post Curing . . . Castings will cure faster and achieve maximum physical properties and heat resistance if Clear Flex 50 or Clear Flex 95 is post cured. Post curing is recommended if castings are thin or low mass concentration. Castings should be post cured in a mold or support structure.

Post Cure Schedule: Allow the material to cure for 6 - 8 hours at room temperature followed by 16 hours at 150 - 160 F (65 - 72 C). Allow casting or part to cool to room temperature before demolding.

For most applications, room temperature curing (70 F/ 22 C) for 24 - 48 hours is adequate. Castings will reach ultimate physical properties at room temperature in 5 - 7 days. Castings removed from mold before

12 hours may exhibit a tacky surface that can be eliminated by exposing casting to 150 F / 65 C for

4 - 6 hours. If you are pouring less than 1/4 in./ .64 cm of material, the casting should be heat post cured.

Safety First

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

Be careful. Clear Flex 50 and Clear Flex 95 Parts A are modified aliphatic diisocyanates. Vapors, which can be significant if the material is heated or sprayed, cause lung damage and sensitization. Use only with adequate ventilation. Contact with skin and eyes may cause severe 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. Refer to MSDS. Part B is irritating to the eyes and skin. Avoid prolonged or repeated skin contact.. Remove from skin with soap and water. If contaminated, flush eyes with water for 15 minutes and seek immediate medical attention. Use only with adequate ventilation

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

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