



# THE COMPLEAT SCULPTOR

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## KICK-IT Cure Accelerator

KICK-IT Cure Accelerator is an additive designed to “accelerate” the cure time of certain Smooth-On liquid urethane rubber products without significantly affecting the ultimate physical properties. This allows for much faster removal (demold) of a part or rubber mold from the original model. ***The accelerator is added to by weight to Part B and should be thoroughly mixed into Part B before adding Part A.***

Note: Adding the accelerator drastically reduces the pot life (time you have to mix and pour material) of the liquid rubber product.

Example: To reduce the demold time of PMC-724 from 16 hours to 2 hours, add 10 grams of accelerator to 1000 grams of PMC-724 Part B. Mix thoroughly for one minute, making sure that you scrape the sides and bottom of your container several times. Next, add 100 grams of Part A and mix thoroughly for one minute, again making sure that you scrape the bottom and sides of your container several times. Do not delay between mixing and pouring, as your pot life is about 5 minutes. In two hours, the rubber mold can be removed from the original model.

Smooth-On Mold Rubber	% Cure Accelerator Added by Weight To Part 'B'	Pot Life In Minutes	Demold Time In Hours	Approximate Shore A Value
PMC-724	0.3 %	10	3	40
	1.0	5	2	40
PMC-726	0.3 %	10	3	60
	1.0	5	2	60
PMC-121/30	5.0 %	15	4	27
	10.0	10	3	30
PMC-121/50	5.0 %	12	3	50
	10.0	8	2	50
PMC-744	5.0 %	15	3	45
	10.0	10	2	45
PMC-780	5.0 %	25	5	80
	10.0	15	4	80

Because no two applications are quite the same, a small test application to determine suitability for your project is recommended if performance of this material is in question.

Technical Support Hotline: 212-367-7561

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