

## FLEX FORM 70

### SEMI-RIGID EPOXY ARCHITECTURAL FORMLINER/ DECORATIVE MOLDING COMPOUND

**LOW ODOR**  
**100% SOLIDS/SOLVENT FREE**  
**MOISTURE INSENSITIVE**

**V.O.C. FREE**  
**SIMPLE MIX RATIO (1-1)**  
**REDUCED HEALTH HAZARD**

#### GENERAL INFORMATION

FLEX FORM 70 is a 100% solids, self-leveling, primerless, odorless epoxy formliner/ molding compound. The product cures to a semi-rigid rubber-like resiliency which provides excellent toughness and mold life. The low viscosity of FLEX FORM 70 allows architectural pre-casters to design and form the most intricate patterns.

#### PRODUCT CHARACTERISTICS

Color	Light Grey
Mix Ratio	1-1 by volume
Mixed Viscosity, cps	3,000 (ASTM D-2196)
Working Time @ 72 °F, minutes	40
Gel Time @ 72 °F, minutes	60
Weight per gallon	10.6 (ASTM D-792)
Density, lbs./cubic inch	0.0459 (ASTM D-792)
Hardness, Shore A	70 (ASTM D-2240)
Tensile Strength, psi	440 (ASTM D-412)
Elongation @ Break, %	88 (ASTM D-412)
De-mold Time	
@ 72 °F	4 hours (minimum)
@ 150 °F	2 hours (minimum) (varying with mold size)

## MIXING

Mix the resin (Part A) and the hardener (Part B) for 2-3 minutes with a slow speed (500 rpm or less) drill and Jiffy mixer (mixing paddle). If you need less than a full kit, do not attempt to "eyeball" the mixture. Accurately measure the resin (1 part) and hardener (1 part) by volume.

FLEX FORM 70 has a work life of 40 minutes at 72 °F.

## APPLICATION

Temperature below 50 °F will inhibit the cure, resulting in a sticky surface. The material should be stored at 60-90 °F prior to use.

Proper mold preparation must be done to insure a successful cast. Wood or porous templates must be sealed before use. Copps Armorgard 505 Form Coating is recommended to seal the templates. Apply a quality wax to all surfaces of the pattern. Polish the wax to a high gloss (hardening the surface). Apply a high quality mold release agent. Immediately pour the FLEX FORM 70 into the pattern.

## COVERAGE

21.8 in.<sup>3</sup>/lb.  
43.6 in.<sup>2</sup>/lb. @ ½ in. thick

## SAFETY

The flash point of FLEX FORM 70 is above 200 °F. This product does not contain the dangerous isocyanates. FLEX FORM 70 is not moisture sensitive. Opened or partially used containers do not need to be nitrogen covered. Simply close the cover and re-use as needed.

Please refer to Material Safety Data Sheets before using this product.

## CLEAN-UP

FLEX FORM 70, before it has hardened, can be removed from tools with Copps Enviro-Kleen solvent or isopropyl alcohol.

## WARRANTY AND DISCLAIMER

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