

Mixing Instructions

1. Pre-heat **INSULCAST 140MT** to 50°C to enhance flow and air release.
2. Stir contents thoroughly until all filler is dispersed.
3. Measure out required amount of **INSULCAST 140MT**. Weigh into it 3-4 parts of **INSULCURE 11B** per 100 parts of **INSULCAST 140 MT**.
4. Mix thoroughly being sure to scrape sides and bottom of mixing container.
5. Where void-free castings are required, de-air for 2-5 minutes at 29 in. Hg.
6. Pour into mold or cavity.

Cure Schedule

- INSULCURE 11B -** Fast Cure - 120°C for 2 hours.
Small Mass - 95°C for 2-3 hours plus 1 hour @120°C.
Large Mass (greater than 5 lbs.) - 65°C for 4 hours plus 2 hours @120°C.
- Post Cure:** 150°C for 4 hours (for service temperature above 150°C).

Date 08/2006

IMPORTANT:

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HEALTH CAUTION:

Avoid breathing possible fumes, mists and vapors which can cause severe respiratory damage. Use of NIOSH approved breathing apparatus is required for more than minimal exposure. Always work in areas with adequate ventilation to allow dissipation of polyamine and other chemical fumes, and where applicable, solvent fumes. Use of goggles, protective garments, rubber gloves, protective cream is required. If material gets into eyes, flush thoroughly with clean water for twenty (20) minutes; then seek medical treatment. Avoid skin contact. Material can cause contact dermatitis. Always wash exposed areas immediately, using warm water and soap, followed by rinsing with clean water. Observe all safety precautions. It is important when using solvent based materials or solvents to keep away from open flame or ignition source.

**PLEASE REFER TO MATERIAL SAFETY DATA SHEET FOR FURTHER FIRST AID INFORMATION.
FOR CHEMICAL EMERGENCY, CALL CHEMTREC (DAY OR NIGHT) 800 424-9300.**