

Mixing Instructions

1. Warm **INSULCAST 141** to 40°-55°C and stir contents thoroughly, before to room withdrawing any material. If **INSULCURE 9** is used, allow **INSULCAST 141** to return temperature (25°C) prior to adding curing agent.
2. Weigh out the required amount of **INSULCAST 141**. Weigh out required amount of curing agent (see mix ratio).
3. Mix thoroughly, being certain to scrape sides and bottom of container.
4. De-air at 29 in. Hg for 10-15 minutes.
5. Pour into mold or cavity.

Cure Schedule

- INSULCURE 9:** 24 hours at room temperature (25°C), or 2 hours at 65°C.
- INSULCURE 11B:** 2 hours at 100°C, plus 2 hours at 125°C.
For service temperature above 150°C, post cure 2-3 hours at 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.