

Mixing Instructions

1. Weigh out required amount of **INSULCAST 148 LV BLK** and add:
10 parts **INSULCURE 109** per 100 parts **INSULCAST 148 LV BLK**, OR
18 parts **INSULCURE 11B** per 100 parts **INSULCAST 148 LV BLK**
2. Mix curing agent in thoroughly, scraping both the sides and bottom of the container to insure proper blending.
3. Evacuate for 2-5 minutes if void-free castings are required.
4. Pour into cavity or mold, etc.

Cure Schedule

- INSULCURE 9:** At room temperature (25°C.) for 4-8 hours
Improved cure can be obtained with a post cure of 2 hours at 100°C.
Full properties after 24 hours
- INSULCURE 11B:** Masses 1/2 lb. or under - 2 hours at 70°C.
Post Cure - 2 hours at 100°C.
Masses to 2 lbs. - 2 hours at 60°C.
Post Cure - 2 hours at 100°C
Masses over 2 lbs. overnight at room temp. (25°C)
Post Cure - 2 hours at 75°C or 1 hour at 100°C.

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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.**