

Use Instructions

1. Premix **INSULCAST 333** in original container being certain to reincorporate any fillers that may have settled.
2. Weigh out required amount of **INSULCAST 333**.
3. Weigh into **INSULCAST 333**, the proper amount of curing agent according to the ratios indicated.
4. Mix thoroughly, being careful to scrape sides and bottom of container to ensure proper blending.
5. Evacuate for 2-5 minutes if void-free castings are required.
6. Pour into cavity or mold.

Cure Schedule

Insulcure 20: 8-12 hours at room temperature (25°) or 2 hours at 50°C.

Insulcure 11B: 2 hours at 100°C, (212°F) for masses less than 1/2 lb.

For masses above 1/2 lb. cure 2 hours at 80°C, (177°F) plus 2 hours at 100°C (212°F).

For optimum high temperature properties, post cure 1 hour at 150°C (302°F).

Storage Requirements

This product has a tendency to settle upon shipment or storage. The product should be re-mixed well prior to use. Store material in a cool dry place.

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.**