



## Use Instructions

1. Measure out required amount of epoxy and curing agent.
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.

## Cure Schedule: Insulcure 24:

**Insulcures 9,12,13**– Cure at room temperature for 4-8 hours. Full properties after 24 hours.

**Insulcures 20, 24, 26**– Cure overnight at room temperature. Can be accelerated by modest temperature, like 51°C (125°F) for 4-6 hours. For small masses or coatings, cure overnight at room temperature followed by 2 hours at 51°C (125°F). Insulcure 32 and 33 requires slightly longer cure.

**Insulcure 11B** – Masses under ½ lb. – 2-3 hours at 70°C, followed by 2-3 hours at 100°C. Masses to 2 lbs. – 2-3 hours at 60°C, followed by 2-3 hours at 100°C. Masses greater than 2 lbs. – overnight at room temperature, followed by 2 hours at 75°C, then 1 hour at 100°C.

## Cured Properties

All Insulcasts cured with prescribed amount of Insulcure 9 and Insulcure 11B – denoted as 501/9 or 501/11B

	<u>501/9</u>	<u>502/9</u>	<u>504/9</u>	<u>501/11B</u>	<u>502/11B</u>	<u>504/11B</u>
SERVICE TEMP.,°C:	105°	105°	105°	155°	155°	155°
HEAT DEFLCT. TEMP.,°C:	105°	85°	71°	155°	155°	155°
COMPRESSIVE STRGTH,psi:	16,000	14,000	15,000	17,000	15,600	15,000
TENSILE STRGTH,psi:	11,500	10,700	12,000	12,000	11,000	11,000
DIELECTRIC STRGTH, volt.mil:	450	425	425	470	435	435
DIELECTIRC CONSTANT, 1KHz:	4.2	4.0	4.0	4.0	4.0	4.2
VOLUME RESIST., ohm-cm:	2x10 <sup>15</sup>	2x10 <sup>15</sup>	2.6x10 <sup>15</sup>	1x10 <sup>15</sup>	1x10 <sup>15</sup>	1x10 <sup>15</sup>

Substituting other Insulcures for 9 would have the following effects:

<b><u>Insulcure 12</u></b>	For slightly lower operating and heat deflection temperature.
<b><u>Insulcure 13</u></b>	Slightly lower physical properties due to increased hardness. Shorter Potlife.
<b><u>Insulcure 20</u></b>	Lower heat deflection temperature. Improved mechanical and thermal shock. Longer pot life.
<b><u>Insulcure 24</u></b>	Much lower heat deflection temperature. Depending on ratio used, tremendously improved mechanical and thermal shock. Very much longer pot life. Much higher viscosity.
<b><u>Insulcure 26</u></b>	Much lower heat deflection temperature. Depending on ratio used, tremendously improved mechanical and thermal shock. Even longer pot life than Insulcure 24.

**Date** 08/2006

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