



## Use Instructions

1. Weigh out required amount of **Insulcast 501** and add:  
13 parts **INSULCURE 9** per 100 parts **INSULCAST 501**, or  
18 parts **INSULCURE 11B** per 100 parts **INSULCAST 501**
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 9:** 24 hours @ room temperature (25°C)

**Insulcure 11B:** Masses 1/2 lb. or under: 2 hours @70°C Post Cure 2 hours @100°C  
Masses to 2 lbs: 2 hours @60°C Post Cure 2 hours @100°C  
Masses over 2 lbs: Overnight at room temperature (25°C)  
Post Cure 2 hours @75°C  
Plus 2 hours at 100°C

\*For optimum properties, post cure 1 hour 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.**