

Mixing Instructions

1. Weigh out required amount of **INSULCAST 510 Part A**.
2. Measure out appropriate amount of **INSULCAST 510 Part B, B-1 or SC-1**:
Use **Part B**: Large casting up to 1 lb.
Use **Part B-1**: Small, thin-walled castings up to 1/2lb.
Use **Part SC-1**: Very large castings up to 5 lbs.
3. Mix thoroughly, scraping both the sides and bottom of the container to insure proper blending.
4. Evacuate @ 29 in Hg to insure void-free castings.
5. Pour into cavity or mold.

Cure Schedule

- Part B: Allow to gel at room temperature (25°C) plus post cure 1-2 hours at 50°C to 60°C.
- Part B-1: Overnight at room temperature (24 hours @25°C)
- Part SC-1: 24-48 hours at room temperature (25°C)
Do not heat or post cure.

Storage Requirements

Note: **INSULCAST 510** Part A is an extremely pure epoxy resin and may crystallize at temperatures below 25°C, to a solid mass. This is normal and expected. To reliquefy, warm open container at 50°C to 65°C and cool to room temperature prior to use.

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.**

