



## Cure Schedule

### Dipped Units

6 - 8 hours @ 95°C – lowest shrinkage

3 - 5 hours @ 105°C

2 - 3 hours @ 120°C plus **Post Cure** 1-2 hours @ 105°C-115°C - Lowest shrinkage

\* Post cure 2 hours @ 150°C for optimum high temperature properties.

## Storage Requirements

One component epoxies are pre-catalyzed and have a limited shelf-life. Storage at elevated temperatures will result in a shortened shelf-life and premature gelation. Store material in a cool 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.**