



## Curing Agent Ratio Chart

100:11-12 with **INSULCURE 9** - Fast cure and small castings  
100:23-25 with **INSULCURE 44** - Larger castings  
100:12-18 with **INSULCURE 13** - Fastest cure  
100:17-19 with **INSULCURE 11B** - High Service Temperature  
100:25-35 with **INSULCURE 20** - Medium Castings

## Cure Schedule

**INSULCURE 9:** Overnight at room temperature (24 hrs. @ 25°C)  
**INSULCURE 44:** Overnight at room temperature (24 hrs. @ 25°C)  
**INSULCURE 13:** 2-3 hrs. @ 25°C  
**INSULCURE 11B:** 3 hrs. @ 100°C  
**INSULCURE 20:** 16-20 hrs. @ 75°F

## Storage Requirements

This product contains lightweight glass microballoons which have a tendency to float toward the top of the container during shipment and storage. The product must be re-mixed well prior to use. Store material in a cool dry place.

## Limitations

Do not pre-heat material during use or before material has gelled. Pre-heating will lower the viscosity and cause excessive phase separation of the glass microballoons. Some phase separation is normal as the material gels but will be more noticeable in the black version.

**Date** 08/2006

### **IMPORTANT:**

The following supersedes any provision in your company's forms, letters and papers. ITW POLYMER TECHNOLOGIES makes NO WARRANTY, WHETHER EXPRESSED OR IMPLIED, INCLUDING WARRANTIES OF MERCHANTABILITY OR OF FITNESS FOR A PARTICULAR PURPOSE FOR THIS PRODUCT. No statements or recommendations contained in the product literature are to be construed as inducements to infringe any relevant patent, now or thereafter in existence. UNDER NO CIRCUMSTANCES SHALL ITW POLYMER TECHNOLOGIES BE LIABLE FOR INCIDENTAL, CONSEQUENTIAL OR OTHER DAMAGES FROM ALLEGED NEGLIGENCE, BREACH OF WARRANTY, STRICT LIABILITY OR ANY OTHER THEORY, ARISING OUT OF THE USE OR HANDLING OF THIS PRODUCT. The sole liability of AMERICAN SAFETY TECHNOLOGIES for any claims arising out of the manufacture, use or sale of its products shall be to refund the buyer's purchase price, provided such products have been demonstrated in ITW POLYMER TECHNOLOGIES sole opinion, to justify such refund.

### **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.**