

Use Instructions

1. Pre-mix **INSULCAST 3254** in the original container prior to use to ensure consistency.
2. Weigh out required amount of **INSULCAST 3254**.
3. Measure the required amount of **INSULCURE 9** or **INSULCURE 11B**.
4. Mix thoroughly, scraping both the sides and bottom of the container.
5. Evacuate at 29 in Hg for 5-10 minutes to insure a void-free casting.
6. Pour into cavity or mold.

Cure Schedule

INSULCURE 9 – 16-24 hours at 25°C or 1 hour at 65°C.

INSULCURE 11B – 3-4 hours at 65°C with post cure 2 hours at 125°C.

Storage Requirements

This product has a tendency to settle upon shipment or storage. The product should be re-mixed well prior to use. The use of mechanical agitation or drum rollers may be necessary. Store material in a cool dry 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.**