



## 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**. Weigh out 100 parts of **INSULCAST 3254** into a clean container add 22 parts **INSULCURE 137**.
3. Mix thoroughly, scraping both the sides and bottom of the container.
4. Vacuum degassing is optional and will generally not be necessary due to the low viscosity of the **INSULCAST 3254**. If required vacuum at 29 in Hg for 5-10 minutes to insure a void-free casting.
5. Pour into cavity or mold.
6. Allow to cure at room temperature, or slightly above.

## Cure Schedule

**INSULCURE 137** – 16-24 hours at 25°C or 1 hour at 65°C.

**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.**

Formerly Norcast 3254/ Norcure 137