



## Instructions For Use

**Room Temperature Cure with INSULCURE 9:** Stir **INSULCAST 3258** in its original container before using until uniform. Mix in appropriate ratio of desired curing agent as described above by weight and stir thoroughly. Pot life will vary from 40 minutes up to as long as an hour depending on amount of curing agent mixed in. Pour mixture into mold coated with release agent. Use vacuum only where necessary. Cure at room temperature for 4-6 hours. A mild post cure of 1-2 hours at 150°F will hasten attainment of optimum properties, and speed up demolding time.

**Elevated Temperature Cure with INSULCURE 19:** Stir **INSULCAST 3258** as described above and mix in 10 parts of **INSULCURE 19** per 100 parts **INSULCAST 3258** by weight. Pot life is 2-3 hours. Pour mixture into mold and use vacuum if necessary for bubble free castings. Cure at 200°F for 3 hours for masses of less than 1/2 lb. For masses greater than 1/2 lb. cure at 175°F for 2 hours followed by 200°F for 2 hours.

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.**