

Instructions For Use :

- With Catalyst 14 - powdered for paste applications.

1. Mix STYCAST 2762 FT in the container in which it is received.
2. Weigh out required quantity of STYCAST 2762 FT. For each 100 parts by weight of STYCAST 2762 FT, use 8 parts by weight of Catalyst 14. Mix the dry powdered Catalyst 14 into the resin at room temperature. Extreme care should be taken to insure thorough mixing. The resultant mixture is almost paste consistency. Typical room temperature viscosity is 100 Pa.s. It is stable for at least one day at room temperature. Slight improvement in pouring characteristics is obtained by warming to about 70°C.
3. Pour into mold or cavity. Vibration will improve flowability. For sealing applications, apply to the cleaned surfaces and squeeze out the excess. Cure for three hours at 120°C. For many applications this is adequate cure. For improved high temperature properties, cure for an additional three hours at 180°C.

- With Catalyst 17 - preferred for easy pourability.

1. Mix STYCAST 2762 FT in the container in which it is received. Mix Catalyst 17 in its container to assure uniformity.
2. For each 100 parts of STYCAST 2762 FT by weight, add 10 parts by weight of Catalyst 17. Catalyst 17 may be solid at room temperature. When warmed to about 65°C, it will become liquid. STYCAST 2762 FT can also be warmed to about 65°C to improve flowability. If desired, the catalyzed resin can be maintained at about 65°C. At this temperature, pot life is at least 2 hours. The item to be embedded and mold can also be preheated. Typical room viscosity is 40 Pa.s.
3. Pour. Cure at 3 hours at 120°C, followed by 3 hours at 180°C. This cure cycle is adequate for most applications. For large or extremely critical castings, cure overnight (about 16 hours) at 65°C, followed by 3 hours at 120°C and 6 hours at 150°C. A post cure may also be used - 16 hours at 180°C.

Storage Conditions :

The shelf life of this product is 18 months when stored in well-sealed, unopened containers at temperatures between 18°C and 25°C.

Safety Considerations :

It is recommended to consult the Emerson & Cuming product literature, including material safety data sheets, prior to using Emerson & Cuming products. These may be obtained from your local sales office.

(STYCAST® is a registered trademark of National Starch and Chemical Company)

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