

DATE <u>16/8/61</u>	TMC SPECIFICATION NO. S-598	
SH. _____ OF _____		
COMPILED BY _____	TITLE: <u>Stycast 1090 Potting Compound</u>	JOB _____
APPROVED <u>[Signature]</u>	R.W.J.	

Ref.: GL-120

- Materials:
- a) Resin : Stycast 1090.
 - b) Catalyst : Catalyst # 9
 - c) Release Agent : Mold release 122 S.

Instructions for Curing.

1. Mix Stycast 1090 thoroughly in the can in which it is received.
2. Weigh out the quantity required. Add 9% Catalyst #9 by weight. Mix thoroughly. (Viscosity can be lowered by warming the resin slightly. This, however, will shorten "pot life!") "Pot life" of the catalyzed resin at room temperature is about 30 minutes.
3. Pour into mold or cavity. Mold Release 122S will prevent adhesion. (Vacuum evacuation will remove trapped air, and is recommended for high quality embedments. It is often convenient to remove trapped air from the resin prior to pouring into mold, and then again evacuate briefly when in the mold.)
4. Allow to stand at room temperature for about 4 hours. Removal from the mold is possible prior to that time if the casting is hard. Cure is fully completed at room temperature within 24 hours.
5. During curing, keep the resin cool. For quantities over 100 gms this may require partial immersion in water.