



# STAR Technology

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## 611-01

### EPOXY LAMINATING SYSTEM

#### APPLICATION PROCEDURE

Carefully weigh out appropriate amounts of resin and hardener into a clean container and mix until all streaks are gone. Scrape the sides and bottom frequently to ensure complete mixing.

NOTE: To obtain optimum service temperature follow the suggested curing schedule with thermocouple monitoring. Thermocouple monitoring equipment is recommended on all post cured tools. High temperature tools should be post cured prior to use. High temperature tools should be cured 50°F beyond anticipated use temperature.

CAUTION: Unmixed material from the sides or bottom of the container can cause soft spots or uncured areas in the completed tool. To prevent this, transfer the entire mixed contents to a second clean container and re-mix for a short time before using.

**Additional Cure Schedule** - If thermocouple monitoring equipment is not available then a longer step cure is a better choice, e.g.

*2 hours @ 150°F + 2 hours @ 200°F +*

*2 hours @ 250°F + 2 hours @ 300°F +*

*2 hours @ 350°F*

#### SAFETY PRECAUTIONS

For industrial use only. Keep away from children.

Refer to the Safety Data Sheets (SDS forms) pertaining to this product before using.

Avoid contact with skin or eyes. In the event of an eye splash or contact, immediately flush with cold water for 15 minutes and contact a physician. If skin contact occurs, wash with mild soap and water. The wearing of safety glasses with side shields and impervious gloves is recommended.

#### RESIN WARNING STATEMENT

Warning! Causes irritation. May cause allergic skin reaction. Avoid all contact with skin, eyes, and clothing. Wash thoroughly after handling.

#### HARDENER WARNING STATEMENT

Danger! Corrosive. Causes burns to eye and skin. May cause allergic skin and/or respiratory reaction or sensitization. Do not get in eyes, on skin or clothing. Keep container closed. Use with adequate ventilation. Wash thoroughly after handling.

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