

FireQuench® 1287 and 1288 Cure and Processing Conditions

**Note to avoid bubble formation a slow cure or cure under vacuum is recommended.*

Suggested Cure Method

- (1) Add catalyst to the resin and stir thoroughly (aprox 1 - 3 drops per 10-30 grams) More or less catalyst will slow or increase the rate of cure. (Note the appearance of an initial yellow color is normal and will disappear upon stirring and cure). (Note for the 1288 product, the initial milky appearance will disappear upon cure)
- (2) Pour the resin/catalyst mixture into a mold or spread it as a film and heat per the cure schedule below.
- (3) Increase heating to 90°C and hold for 1-2 hours to render a fully cured sample. Note that a flexible (rubbery) sample indicates undercure which may be suitable for some applications.

*The cure cycle can be modified by increasing or decreasing catalyst concentration and catalyst type.

| Temp (°C) /Time(Min) | Catalyst 6830 | Catalyst 6831 | Catalyst 6832 | Catalyst 6833 |
|-------------------------|---------------|-------------------|-------------------|--------------------|
| 70°C/30min | liquid | soft rubber | liquid | liquid |
| 70°C/45min | paste | medium rubber | thick liquid | liquid |
| 70°C/75min | soft rubber | hard rubber | soft rubber | liquid |
| 70°C/120min | hard rubber | clear glass | medium rubber | paste |
| 70°C/150min | hard rubber | clear glass | clear hard rubber | soft rubber |
| 70°C/180min | glass | clear glass | clear glass | medium rubber |
| 70°C/240min | glass | clear glass | clear glass | hard rubber |
| 80°C/30min | rubber | clear hard rubber | clear med. rubber | clear thick liquid |
| 80°C/45min | hard rubber | clear glass | clear hard rubber | clear paste |
| 80°C/75min | hard rubber | clear glass | clear glass | medium rubber |
| 80°C/120min | glass | clear glass | clear glass | hard clear rubber |
| 80°C/150min | glass | clear glass | clear glass | clear glass |

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