

## RECOMMENDATIONS

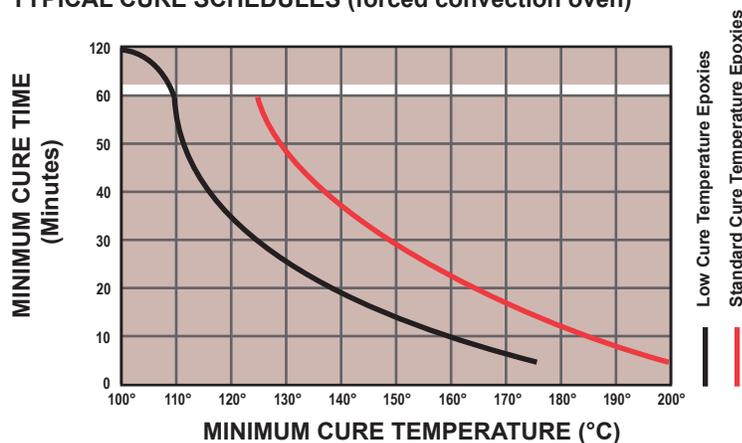
### CURE REQUIREMENTS

Best results are obtained by using a forced convection oven preheated to the appropriate cure temperature. We suggest 300°F (150°C) as a good starting point for most applications.

Please refer to MSI supplied specification sheets or cure schedule labels for recommended cure schedules for specific epoxy systems. Allowances should be made for oven recovery time and component mass, including loading trays and fixtures.

For production purposes, adequate cure schedules should be determined and strictly adhered to. The cure schedules listed on data sheets or cure labels are for the epoxy only. Place thermocouples throughout the oven to determine the effects of component mass. The time required for all thermocouples to reach cure temperature should be added to MSI's listed cure schedules. Also, we strongly recommend adding 5 to 10 minutes to the determined cure times as a precaution to ensure adequate cure.

### TYPICAL CURE SCHEDULES (forced convection oven)



### STORAGE

Preforms should be stored in a cool dry area. An air-conditioned office environment is best but not absolutely necessary. We do not recommend refrigeration, as this will cause condensation if improperly handled. The preforms should be kept in closed containers when not in use.

### CURING EQUIPMENT

The consistency of the final seal depends mainly upon three factors: (1) the consistency of the component being sealed, (2) the consistency of the epoxy preform, and (3) the consistency of heat transfer (i.e., oven). Factors (1) and (2) are close toleranced and should not be the cause of inconsistencies. Therefore, the oven system will require the closest attention. We recommend the use of a mechanical convection (forced air) oven. This type of oven allows for fastest recovery and the most consistent means of heat transfer. If a static air oven is used to cure epoxy, MSI's recommended cure schedules should be doubled or increased according to the results of qualification tests. The oven should be calibrated at least once a year.

### SAFETY

Preforms are for industrial use only. Avoid inhalation of vapors at elevated temperatures. Complete exhaust of fumes and adequate ventilation should be used. Suitable respiratory protection is suggested where exhaust facilities may not be adequate. Follow good housekeeping practices. Avoid contact with eyes and prolonged or repeated contact with skin. Wash hands after use. Read MSDS for additional safety information.