SHAPE MEMORY POLYMER

POTTING AND CURING CONDITIONS
MOLDING INSTRUCTIONS

1. Products
   MP-25xx Series (Tg 25°C)       MP-45xx Series (Tg 45°C)
   MP-35xx Series (Tg 35°C)       MP-55xx Series (Tg 55°C)

   Each product consists of two liquid types: A: Resin, B: Hardner

2. Potting and Curing Conditions

   (a) Preparation
      • Dry liquid A and B for more than 1 hour at less than 50 Torr.
      • Dry the die for more than 1 hour at 70°C.

   (b) Potting
      • Place liquid A and B into vacuum chamber of less than 50 Torr.
      • Mix liquid A and B, stirring for 30 sec. at 60 rpm.
      • Immediately after stirring, pot the mixed solution to the die.
      • After confirming that the solution flows into the die completely, discharge the vacuum.

   (c) Curing and Removal
      • Curing by heat
      • Removal from Die
(c) Curing and Removal
- Remove the die from vacuum chamber to the temperature and place into chamber.
- Cure the material for 1 – 2 hours at 70 °C.
- Remove the finished product from the die.
- If necessary, cure an additional 1 – 2 hours at 70 °C.

(d) Cleaning
- Methylene chloride is recommended.

<table>
<thead>
<tr>
<th>Grade</th>
<th>Mixing Ratio</th>
<th>Viscosity (cps/25°C)</th>
<th>Specific Gravity</th>
<th>Pot life*2</th>
</tr>
</thead>
<tbody>
<tr>
<td>MP - 2510</td>
<td>A 100  B 100</td>
<td>135  220</td>
<td>1.066  1.216</td>
<td>5'00&quot;</td>
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<tr>
<td>MP - 3510</td>
<td>A 100  B 100</td>
<td>1,410  290</td>
<td>1.066  1.216</td>
<td>4'30&quot;</td>
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<tr>
<td>MP - 4510</td>
<td>A 100  B 100</td>
<td>1,280  200</td>
<td>1.066  1.218</td>
<td>3'30&quot;</td>
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<tr>
<td>MP - 5510</td>
<td>A 40  B 60</td>
<td>150  60</td>
<td>1.062  1.215</td>
<td>6'00&quot;</td>
</tr>
</tbody>
</table>

*1 A = Resin, B = Hardner
*2 100gr/25C Curing time