



Triathane™3 Handling Guide

This guide provides tips, advice, and answers to questions about the Triathane™3 (CLV 1H-1095A/B/C) system.

Storage

- Always store the Triathane system in a cool dry place (18-27°C).
- After each use purge the air inside the containers with a dry gas like nitrogen or argon. Depending on the amount of head space, it is recommended to purge for 15-60 seconds.

Handling

- Ensure all equipment is cleaned and moisture free before handling Triathane.
- Optimal conditions
 - Ambient Temperature: 22-25°C
 - Ambient Humidity: < 30%
- Avoid using intermediate containers for dispensing Triathane.
- Dispense materials directly into mixing vessel according to the provided mix ratio chart for the desired hardness.
- Always dispense Parts A and B before dispensing Part C into the same container.
- Parts A and B do not have to be mixed prior to dispensing Part C.

Mixing Techniques

○ Hand mixing

- Mix vigorously, scrap the sides and bottom of vessel to ensure all material is mixed thoroughly.

○ Mechanical Mixing

- Hand drill

- > Mix thoroughly by moving the mixing blade throughout the mixing container

- Stand mixer

- > Set mix time in accordance to pot life for desired hardness
- > Use vacuum whenever possible to remove bubbles

- Vortex Mixing

- > Set mix time in accordance to pot life for desired hardness

Degassing

- Ensure vacuum strength is 29-30" Hg
- Practical degas = lowest possible bubbling
- Degas immediately after mixing
- 3 minutes of degassing for batches up to 1kg is typically sufficient

Molds/Demold/Curing

• Molds

- Ensure all molds are cleaned and moisture free.
- Preheating molds can help with flow and demold time.
- Use closed molds for best results.
- Cover open molds with any dry material like cardboard.

• Temperature

- For best results heat is recommended for gelling and curing.
- Keep curing temperature consistent for the full length of cure.
 - **ie.** If curing at room temperature, avoid heated post cure and vice-versa
- Maximum continuous heat cure temperature of 85°C.

• High Temperature Setting

- Do not exceed 110°C for more than 1 hour.
- After demolding immediately place part at desired curing temperature for remainder of cure time.