

Pliable Optimized Wear -



Storage

Material is shipped in vacuum sealed 2 pounds batches (enough for 1-2 typical size bits) inside of labeled jars with lids. Do not open jar or vacuum pack until immediately prior to first use. Store at approximately 40° F which is a typical refrigerator temperature. Do not freeze. Keeping material cold prevents separation of binder. Shelf life when unopened at 40° F is at least 6 weeks.

Handling

Always wear rubber gloves when handling material. It is not harmful or toxic, but this helps prevent drying and cross-contamination. Material can be used cold, but is much more pliable when warm. Remove from refrigerator and allow to warm to room temperature. Manually knead to speed warming and ensure uniform consistency. There may be traces of greenish liquid, which is binder separating and can be kneaded back in. Do not force heat with hot water or heat gun.

Use

When ready to place in mold, open vacuum pack only enough to allow access to needed material. The less air exposure the better as far as pliability and being savable for later. Preform material as needed by rolling to form ropes or cutting into suitable chunks for accurate placement. Recommended maximum layer thickness is 1/4". Press material into mold manually. Make sure to fill fine features by using metal or plastic rods, spatulas, or other tools to press firmly into mold. Once formed into mold, use a fork or other similar tool to form a non-planar interface so as to maximize bonding with matrix powder. Work steadily once vacuum package is open and finish placing material in one sitting. Minimize air exposure of unused material at all times. When finished, seal the remaining material in vacuum pack as tight as possible. Use clips, zip-ties, twisties, or place in a sealable plastic bag and evacuate air before sealing. Replace sealed bag into labeled jar and replace in refrigerator. Although immediate backfilling and mold furnacing can usually be done, heating rate variations arising from bit size, infiltration processing equipment and practices can be excessive. Recommended best practice is to dry the material prior to furnacing to minimize effects of binder outgassing. Suitable methods include allowing to stand, placing in a convection oven at 250° F, or using a low temperature heat gun the slower and more uniformly the material is dried, the better. Although shrinkage and mold pull away are usually negligible due to the low binder content of the material, backfilling with matrix powder prior to drying further minimizes dimensional changes and allows more temperature leeway for the drying process, common mold preheating practices after completing mold loading work well.

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