



CLEAR EPOXY MASS CASTING



Product Highlights

- Low viscosity formulation for mass casting and encapsulating applications.
- Ideal for thick cross sections (up to 1" thick) to reduce exotherm and shrinkage.
- Designed with a low viscosity and long work time to minimize trapped bubbles.
- 100% solids, two component system.
- Resists scratching, blushing, and yellowing.
- Cast parts and coatings will cure bubble free without the need to degas the mixture.

Mixing Properties:	Part A	Part B
Mix Ratio (Parts by Weight)	100	40
Mix Ratio (Parts by Volume)	100	50
Color	Clear	Clear
Viscosity @ 77F	8,000	30
Mixed Viscosity @ 77F	470	
Specific Gravity @ 77F (mixed)	1.15	
Gel Time @77F	8 - 10 hours	
Demold Time	24 hrs (varies based on mass)	
Visual color of cured parts	Clear	

Surface preparation

- When applying to wood or porous surfaces, always make sure to apply a very thin epoxy seal coat to the surface and allow it to cure before applying more epoxy. The skim coat will prevent air bubbles coming out of the wood and getting suspended in the epoxy.
- Clean any molds or dammed areas thoroughly with acetone or denatured alcohol to remove dust, oil, sap, or other contaminants that can affect the final product.
- Check dams and molds for possible leaks. Use silicone caulk in corners to prevent leakage.
- Use sheathing tape, Tyvec tape, or release agent on the inside of the mold to prevent the epoxy from adhering to the dam or mold.
- Ensure that the mold/surface is level as the epoxy will self-level.

Instructions for use

- For best results, product should be applied at 70° - 80°F. The surface and epoxy materials should be maintained at this temperature for 24 hours before and after application.
- A thin seal coat should be applied over the objects to be embedded. Delicate objects may need to be sealed with an alternate clear sealer to protect them. Once the seal coat has set, additional flood coats may be applied up to 1/8" thick.
- Precise measurement of part A and part B is the first critical step in a good mix
- Thoroughly mix the two sides:
 - Once the two parts have been combined make sure that you stir the product vigorously for 3-5 minutes and scrape the side walls and bottom to make sure that all the product in the cup is being included in the mixture.
 - If you don't feel like you are getting a good mix you can pour the mixed material into a second cup after you are done stirring and scraping to help ensure the two sides have been completely combined.
 - Dyes, colorants, mica, or special effects additives can be added or mixed in as desired before pouring.
- When pouring larger products such as slabs or tables, do not exceed 1" to prevent excessive heat and subsequent yellowing.
- Step pouring with multiple layers will achieve the best results. When the previous layer has cooled, but soft enough to indent, pour the next layer over the top. If the previous layer has cured completely, lightly scuff with a scotch-brite pad and clean with denatured alcohol before applying the next layer.
- Although this product is resistant to yellowing, it is not recommended for continuous exposure to UV light as finished may slowly lose their gloss or discolor over time.

Safety Handling

- Do not use this product until the SDS has been read and understood.
- Work in well ventilated areas using gloves, eye protection and clothing protection.
- Avoid contact to the skin and eyes.
- Avoid clothing contamination.
- Wash thoroughly after handling.
- These products may cause skin and respiratory allergic reactions.
- Consult the material safety datasheet for complete precautions with this product.

If Contact Occurs:

- Eyes: Immediately flush with water for at least 15 minutes. Call a physician.
- Skin: Immediately wash with soap and water. Remove contaminated clothing. Do not use solvents to wash skin. Seek medical attention if allergic reaction occurs.
- Ingestion: If swallowed, call a physician immediately. Remove stomach contents by gastric suction or induce vomiting only as directed by medical personnel.

Notice:

The information contained in this tech data sheet is considered accurate. However, no warranty is expressed or implied regarding the accuracy of the data, the results to be obtained from the use thereof, or that any such use will not infringe upon a patent. User shall determine the suitability of the product for the intended application and assume all risk and liability whatsoever in connection therewith.