



Product Data Sheet

Pox Cast “Water Clear”

Pox Cast “Water Clear” is clear epoxy deep casting resin.

Description

Pox Cast “Water Clear” is a low viscosity, two-part, water-clear, UV resistant, self degassing developed for clear deep casting epoxy resin.

Recommended Uses

Pox Cast “Water Clear” finishes used for:-

- River tables / knot holes
- Wood and resin combination furniture
- Clear castings / sculptures / figurines
- Encapsulations

key features

- Excellent UV resistance
- Super transparent constituents (water clear)
- Poured thicknesses from (2.5 cm up to 5 cm) but is recommended for castings (3.5 cm deep) per layer
- Hard wearing and highly polishable!
- Excellent impact strength
- Environment friendly (odor free and no solvent)
- Natural air bubble release without the need for degassing

Technical Specification

Mix ratio by weight :	100 A : 30 B
Color	Water clear
Solids Content	100 %
Specific gravity	1.1 ± 0.02
Working time	Approx. 2 h (at 23 °C)
Substrate temp.	Min 10 °C , max 30 °C
Initial Curing time	Approx. 36 h (at 23 °C)
Fully cured	7 days (at 23 °C)
Hardness, Shore D	> 80



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How to use

Surface preparation:

• The surface must be clean, dry, and free of dust. The all damaged areas, cracks and surface irregularities must be repaired and smoothed.

Mixing:

• It is important to remember that this cast has a limited work time (Approx. 3 h at 23 °C). Therefore it is wise to check and make sure everything is in order before starting the mixing sequence.

• Stir the contents of part A with an electrical stirrer. Add part B to part A completely for 2 – 3 minutes with a low speed stirrer until a homogenous mix is achieved. Be careful not to introduce any air bubbles while mixing until a uniform consistency is obtained. Afterwards the mixture is left to rest for approx. 10 minutes, then pouring **Pox Cast “Water Clear”** in prepared surface.

• The tables below can be used to look up some common mix sizes A & B components by weight.

Mix Ratio Examples

A	B	Total
100	30	130
200	60	260
300	90	390
400	120	520
500	150	650
600	180	780
700	210	910
800	240	1040
900	270	1170
1000	300	1300

Processing conditions:

- Temperature-The optimal processing temperature is about 20 °C. Raising the temperature by 10 °C halves the pot life and doubles the reactivity
- Air humidity – The relative air humidity during processing should not exceed **65 %**.
- Like all reactive resin systems the casting quantity is limited by the generated reaction heat (exothermal reaction): often a lower curing temperature (e.g. at an ambient night temperature lower than 20 °C) can counteract too great an exothermal reaction.
- Leave the ready mixture on a flat surface for 48 hours. Please do not mix or otherwise move the product.

Cleaning

Cleaning all tools and equipments immediately after use with acetone or cellulose thinners.

Health and Safety

- Use gloves and breathing mask when applying.
- Apply forced ventilation in confined spaces.
- Skin splashes to be removed with hand cleanser, soap and water.
- Eye splashes to be removed with plenty of water.
- If ingested seek medical advice.

The knowledge and the test results on this TDS are prepared due to the manufacturers experience. The results may differ the processing conditions



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Packages

Kits (A+B): 0.6 kg & 1 kg & 1.3 kg & 6.5 kg

Storage

- The resins and hardeners can be stored at least 12 months in their carefully sealed original containers.
- The resins and hardeners may crystallize at temperatures below +15 °C.
- The crystallization is visible as a clouding or solidification of the contents of the container.
- Before processing, the crystallization must be removed by warming up.
- Slow warming up to approx. 30 - 40 °C in a water bath or oven and stirring or shaking will clarify the contents of the container without any loss of quality.
- Use only completely transparent products.
- Before warming up, open containers slightly to permit equalization of pressure.
- Caution during warm-up ! Do not warm up over an open flame!
- While stirring up use safety equipment (gloves, eyeglasses, respirator)