

MASTER-CAST 1-2-1 (FR67)

OPTICALLY CLEAR ARTWORK & CASTING RESIN



PRODUCT:	An ambient temperature curing, solvent free – high build – high gloss – U.V stabilised transparent epoxy coating / casting Resin	
APPLICATION:	By pouring, brush or roller	
VISCOSITY:	23°C (73°F)	25°C (77°F)
Resin:	6 500 – 6 800 mPa.s	5 500 – 5 600 mPa.s
Hardener:	2 200 – 2 300 mPa.s	1 900 – 2 000 mPa.s
Mixed Viscosity:	4 400 – 4 700 mPa.s	3 700 – 3 900 mPa.s
COLOUR:	Resin:	Clear – Transparent
	Hardener:	Clear – Transparent
SPECIFIC GRAVITY:	23°C (73°F)	
Resin:	1.11 – 1.15 g/cm ³	
Hardener:	0.94 – 0.96 g/cm ³	
MIXING RATIO:	By Weight	By Volume
	100 parts Resin	100 parts Resin
	90 parts Harder	100 parts Hardener
COVERAGE: (applied 0.5 mm thick)	1 m ² per 0.5 litre mixed resin (based on a self-levelling layer of 0.5mm thick).	
PRACTICAL WORKING TIME: (250 g mixed resin):	23°C (73°F) 10 – 15 Minutes	25°C (77°F) 10 – 12 Minutes
GELTIME: (250 g mixed resin) (5 mm casting) (2 mm coating)	23°C (73°F) 20 – 25 Minutes 55 – 60 Minutes 65 – 70 Minutes	25°C (77°F) 20 – 21 Minutes 50 - 55 Minutes 55- 60 Minutes
SETTING TIME: (250 g mixed resin): (5 mm castings) (2 mm coating)	23°C (73°F) 26 – 27 Minutes 4 – 4½ Hours 4½ - 5 Hours	25°C (77°F) 24 – 25 Minutes 3½ - 4 Hours 4 – 4½ Hours
TOUCH DRY	23°C (73°F) 6 – 7 Hours	25°C (77°F) 5½ - 6 Hours

HARDNESS: (Cured 24 Hours / 25°C (77°F) Hardness at 60°C (140°F)	Shore D: 75 – 78 Shore D 30 – 35
MINIMUM APPLICATION TEMPERATURE:	10°C (50°F)
HEAT RESISTANCE:	Suitable for applications up to 50°C (122°F)
TENSILE STRENGTH: (Din 53455)	40 MPa
FLEXURAL STRENGTH: (Din 53452)	65 MPa
COMPRESSIVE STRENGTH AT YIELD:	(Din 53454) 24 MPa
ELONGATION:	9 %
IMPACT STRENGTH: (Din 53453)	3.5 kJ/m ²
CHEMICAL RESISTANCE:	Good: resistance against water Fair: resistance against diluted acids and alkalines Poor: resistance against most solvents (individual tests are recommended).
PROPERTIES AND USES:	Master-Cast 1-2-1 Resin produces an optically clear, high gloss and tough coating with good impact and abrasion resistance. The excellent clarity and transparency makes the resin system particularly suitable for the protection and decoration of: <ul style="list-style-type: none">• Artwork (paintings, sculptures and layered collage)• Wood and timber artifacts• Clocks, pictures and puzzles• Tabletops and bar counters• Badges, emblems and jewellery manufacture• Flower-setting and paperweights Further applications include: <ul style="list-style-type: none">• Doming and Decoupage• Electronic encapsulating and Potting• Reinforced composites and fiberglass lamination• General adhesive and bonding applications
STORAGE STABILITY	Stored under dry and cool conditions in sealed packaging: 12 months.
TOXICITY:	Non-toxic at ambient temperatures, very low skin irritation potential. However we always recommend good industrial hygiene is observed (wearing gloves, long-sleeved clothing, adequate ventilation, no eating, drinking or smoking during resin mixing and application).
NOTICE:	The technical specification and/or our technical advice, whether verbal, in writing or by trials, is given in good faith and based on our test results obtained but without warranty. It does not release the user from the obligation to test the products supplied by us or any third party as to the suitability for the intended application.
NOTICE: (CONT/...)	The application, use and processing of the products are beyond our control and Eli-Chem Resins Ltd's legal obligation in respect of any sale of its products shall be determined by the terms of its conditions of sale.