

# PERFECT CAST

ULTRA-CLEAR EPOXY RESIN

Rigid

Perfect Cast / Rigid is a solvent free, liquid epoxy resin system specifically designed as a crystal clear, ultra high-gloss shallow casting that will self-level, and cure at room temperature. The system has excellent air release and UV stability.

Perfect Cast / Rigid is designed to be poured directly into Knot Holes or Cracks in Timber. Up to 20mm thicknesses can be achieved in a single pour. Multiple pours in 10mm increments can be used for River Table applications. A deep gloss surface can be achieved that does not require polishing, and pigments and dyes can be added to the system to produce a variety of colours.

## MIX RATIO

100 parts resin to 43 parts hardener by weight  
2 part resin to 1 part hardener by volume

**Note:** Care should be taken when dispensing and mixing. Do not attempt to control the cure time by altering the hardener ratio.

## DEPTH

Up to 20mm thicknesses can be achieved in a single pour. Multiple pours in 10mm increments can be used for River Table applications.

## UNCURED PROPERTIES

	Resin	Hardener
Physical State	Clear Liquid	Pale Yellow Liquid
Viscosity mPas @ 25°C	198	1847
Specific Gravity g/ml@ 25°C	1.10	1.02

## CURE CHARACTERISTICS

Pot Life -100g @ 25°C (in air)	59 minutes
Thin film open time @25°C	24 hours
Cured to Solid State	7 days
Cure to maximum strength @25°C	7 days
Mixed viscosity @ 25°C	292
Shore 'D' Hardness @25°C	81
Glass Transition Temperature (Tg) (24h @ ambient + 16h @ 40°C)	41°C

## APPLICATION

Cover working area with cardboard or plastic. The surface to be coated should be dry and free from contaminants. Wear latex or nitrile gloves to measure 2 parts of Part A Resin and 1 part Part B Hardener by volume. Use clean plastic containers or wax-free paper containers.

Pour Part A and Part B into a larger container. Use a flat mixing stick to stir the two ingredients together for at least 4 minutes - longer in cooler temperatures. Take care to stir the material slowly, so air entrapment is kept to a minimum.

Perfect Cast / Rigid is self-levelling. Pour directly into Knot Holes or Cracks. For larger projects, pour from one end of the void to the other.

For best results apply at temperatures between 15°C to 30°C and at below 85% humidity.

Air bubbles may form on the surface. Air Bubble release is greatly enhanced by the use of a heat gun or gas torch. Hold the torch 15 cm - 20 cm away from the surface and sweep the torch continuously across the surface for a few seconds. If the flame is held in one spot it will distort the surface or may cause damage to the substrate.

The mixture should be cured in a warm, dust free area. Place a cover or box over the item while curing.

**Perfect Cast / Rigid is not to be thinned under any circumstances, as it has been formulated to optimal viscosity for this specific application.**

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## CLEAN UP

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Clean the equipment with lacquer thinner, acetone, or alcohol. Follow safety warnings on solvents, and provide adequate ventilation. Clean epoxy hardener residue with warm soapy water.

DO NOT dispose of resin or hardener in a liquid state. Waste resin and hardener can be mixed and cured (in small quantities) to a non-hazardous inert solid.

## STORAGE

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Perfect Cast / Rigid Resin and Hardener will keep for 2 years if kept in original containers at room temperature (15°C to 32°C) and out of direct sunlight. Containers should be tightly sealed to prevent moisture absorption.

## HEALTH AND SAFETY

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Perfect Cast / Rigid Resin and Hardener have moderate sensitising potential, and should be kept out of the eyes and off the skin.

- Use with good ventilation and adequate safety equipment including impervious gloves and safety glasses.
- If skin contact occurs, remove contaminated clothing immediately, and wash the affected area thoroughly with water, avoiding the use of solvents except in the case of massive contamination.
- If eye contact occurs, immediately flush with running water for at least 15 (fifteen) minutes and seek medical advice.

- Do not eat, drink or smoke when using this product.

- If swallowed:

**Resins** - DO NOT induce vomiting, and contact a doctor or the Poisons Information Centre.

**Hardeners** - DO NOT induce vomiting, give plenty of milk or water and contact a doctor or the Poisons Information Centre.