

**Zepoxy Glass Cast Plus** is a retarded clear epoxy casting system, which offers a long open time for precise article placement and complete bubble removal. It has inbuilt UV inhibitors as well as excellent visual properties. It also avoids high exothermic reaction and the resulting shrinkage after curing.

## TECHNICAL DATA

Property	Test Method	Result
Appearance Part A	Visual	low viscosity, clear liquid
Appearance Part B	Visual	low viscosity, clear liquid
Mix ratio (Part A: Part B)	Theoretical	100: 44
*Flash Point	ASTM D 93	>117°C
Coverage per kg	Theoretical	1 SFT@ 10mm thick
Recommended maximum pouring thickness	-	25mm above 1 kg 70mm below 1 kg

\*Typical results under laboratory conditions.

## CURING PROFILE

	390g mass @ 70 mm thick	1800g mass @ 25 mm thick
*Working time @ 30°C	5 hours	3.5 hours
*Hardening time	24 hours	24 hours
*Full Cure	7 days	7 days

\*Typical results under laboratory conditions.

## NOTE:

At higher mixing quantities of 5-10 kg please ensure epoxy is poured soon after mixing and that the thickness of 25mm is not exceeded. At 40°C working time will be reduced to half so pouring should be planned accordingly.

## MIXING

The mixing ratio must be accurately followed to achieve perfect results. It is not possible to change the ratio which would result in the epoxy not drying properly and lower mechanical properties. Pour the hardener first and then the resin. The mixed components should be thoroughly mixed for 3-4 minutes to ensure an even consistency. To avoid development of bubbles slowly mix for 5-10 mins. Once the epoxy is mixed and poured gently pass warm air from a heat gun or hair dryer on slowest speed setting, this will assist in removal of any bubbles generated during mixing.

## PACKAGING

Zepoxy Glass Cast Plus is available as follows:

1.44 KG Set	Part A: 1 KG Part B: 440g
14.4 KG Set	Part A: 10 KG Part B: 4.4 KG
43.2 KG Set	Part A: 30 KG Part B: 13.2 KG

## HEALTH AND SAFETY

Dispose containers of the materials as per local laws, rules, and regulations. Use gloves, safety masks and other safety apparel as per health and safety laws. For further assistance, please refer to the MSDS of the product for further health and safety information.