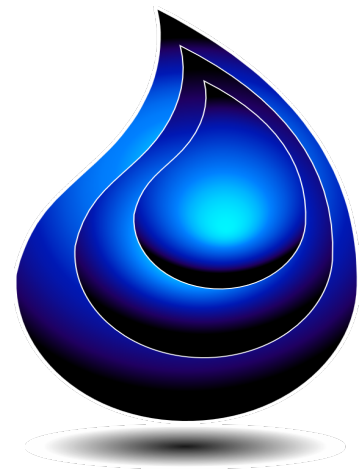


Technical Data Sheet

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Clear-eCast X016 Casting Epoxy

1. Introduction

Clear-eCast X016 Part A epoxy resin reacts rapidly with Clear-eCast X016 Part B hardener to form a water clear rigid epoxy.

2. Applications

Clear-eCast X016 has been formulated for use in coating and casting sections up to 25mm where a water clear, tough, rigid product is required. The long pot life of the mixed system allows it to be fully degassed if required.

PLEASE NOTE: In thick section this product becomes hot during cure. This can increase shrinkage and, if not degassed can result in slight expansion. Ensure moulds are made of a suitable material to withstand this temperature. If in doubt please contact Creative Resins.

3. Specification (Using Fast Part B)

Property	Minimum	Maximum	Units
Gel Time (100g 20°C)	3.5	4.5	Hours
Full Cure (100g 20°C)	4	5	Days
Hardness at full cure	75	85	Shore D

4. Mix Ratios

By Weight: **4.40** Parts A : **1.00** Part B Medium

By Volume: **3.46** Parts A : **1.00** Part B Medium

The components should be measured to an accuracy of 2% or better. Care should be taking when measuring by volume, as this is an inherently inaccurate method unless specific volumetric measuring equipment is used.

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5. Typical Properties

Property		Typical Value	Units
Colour	Part A	Clear viscous liquid	-
	Part B	Water Clear	-
	Mixed	Water Clear	-
S.G.	Part A	1.17	-
	Part B	0.92	-
	Mixed	1.1	-
Viscosity	Part A	21,000	mPas
	Part B	46	mPas
	Mixed (initial)	2,100	mPas
	Mixed (after 30m)	2,100	mPas
Gel Time (100g 20°C)		4	Hours
Demould Time (100g 20°C)		10	Hours
Full Cure (100g 20°C)		5	Days
Full Cure (100g 75°C)		7	Hours
Hardness at full cure		82	Shore D

6. Preparation of Components

Neither component requires preparation prior to use, and may be used directly from the tin.

7. Handling and Storage

The relevant Safety Data Sheets should be read carefully before using this material. Good housekeeping is important with this material as with all chemicals. Spillages should be wiped up immediately and containers wiped clean after use. The components should be stored in their original containers in a dry place at 5-25°C. Both components have a minimum shelf life of 12 months from the date of manufacture when stored correctly in unopened containers.

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8. Health and Safety

The Safety Data Sheet provides information on the health and safety aspects of this material. Please contact REP Ind Mat, if you do not have a Safety Data Sheet for each of the components of this material.

The Part A epoxy resin component is classified as IRRITATING to eyes and skin according to the requirements of the CHIP regulations. In addition it may cause sensitisation by skin contact. Care should be taken to avoid direct contact and gloves, goggles and impervious overalls should be worn.

The Part B hardener is classified as CORROSIVE. Part B is harmful in contact with skin, causes burns and may cause sensitisation by skin contact. Avoid direct contact by means of gloves, goggles and impervious overalls.

9. Suitability for Use

The information in this datasheet is given to the best of our knowledge and belief but without warranty or liability.

The user must establish the suitability of the material for the intended application by carrying out any appropriate tests.

Finished products produced from any batch of our materials must be subjected to comprehensive standards of quality control by the user.

10. Additional Information

Please note that this product has not been tested for all applications and it is strongly recommended that customers carry out adequate trials to determine the suitability of this material for the intended use.

No liability will be accepted for direct or consequential losses arising from the use of this material.

However any comments or suggestions relating to improving the processing or characteristics of this material will be very welcome.