

99 Clear Casting Resin

Overview: #99 Clear Castin Resin is ideal for poured castings. Larger castings have been achieved through multiple pours and slight catalyst adjustments. It may be used with our colored pigments for opaque castings.

This resin exhibits extremely low shrinkage when catalyzed at 1/2% MEKP.

Available in quarts, gallons, five gallon pails and drums as well as resin/hardener kits.

Features & Benefits:

- Low shrinkage will minimize warping
- Low viscosity allows an outstanding air release and meets California rule 50 and SCAQMD 1162
- UV stabilized and will resist yellowing
- Specially promoted, resists yellowing and water white when cured
- Designed for small or large castings

Typical Cure Schedule:

	#99	Test Method
Gel Time at 77°F	17 Min*	18-050
Total Time to Peak	45 Min*	18-050
Peak Exotherm	280°F	18-050

*Version 10 catalyzed with 1.25cc of 46709

Typical Product Properties:

	#99	Test Method
Viscosity	450 Cps/mPas*	18-021 / ASTM D 2196-86
Thixotropic Index	N/A	18-021 / ASTM D 2196-86
Specific Gravity	1.15 G/CM3	18-030 / ISO 2811-2001
Weight % NV	66%	18-001 /B070
Color	Water-White	18-043

*Brookfield LVF # @60

Typical Mechanical Properties:

Properties at 25°C/77°F	1/8"/3.2 MM Clear Casting	Test Method
Barcol Hardness 934-1	37	ASTM D 2583-99
Heat Distortion Temperature (HDT)	71°C / 160°F	ASTM D 785
Tensile Strength	10,000 Psi	ASTM D 638-02
Tensile Strength	69 Mpa	ISO 527-1993
Flexural Strength	12,000 Psi	ASTM D 790-80
Flexural Strength	83 Mpa	N/A

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Mixing Directions: Shake well before using. #99 can be handled at both high and low catalyst levels depending on the casting size. For small castings, add #69 MEKP HARDENER in a ratio of 1%. For large castings, the hardener may be reduced to 0.5%. A 50 gram casting with 0.8% MEKP HARDENER at 77°F will begin to harden in about 20 minutes. Full cure will occur in about 24 hours.

At cooler temperatures, the mixture will take longer to harden and at warmer temperatures it will take less time. The ratio of hardener may be adjusted to compensate for temperatures. Do not add more than 2% or less than 0.5% hardener. Do not attempt to use this resin when temperatures are below 55°F. Mix only small quantities when temperatures are above 85°F as hardening will occur very rapidly.

Never apply in direct sunlight. Mix in clean glass, paper, plastic or metal containers. Do not use foam containers. Mix no more than you can use before the resin starts to harden. Do not return mixed (catalyzed) resin to container.

Safety and Handling: #99 Clear Polyester Casting Resin contains ingredients which could be harmful if mis-handled. Contact with skin and eyes should be avoided and necessary protective equipment and clothing should be worn. Individuals should wash with soap and water before eating, or drinking. Individuals should observe conditions of good industrial hygiene and safe working practice. For more detailed instructions on handling, please see the MSDS sheet.

All containers should be properly labeled to prevent accidental ingestion or improper disposal. Individuals should reseal any partly used material back in the container. Store under cool, dry conditions away from open flames and high temperatures. For more detailed instructions on storage, please see the MSDS sheet.