



## In short

Resion UV Cast is a transparent, UV stabilised epoxy resin for casting. Curing agents are available for different casting heights from 25 to 75mm.

## Applications

For casting of jewelry, art objects, tables, pyramids, orgonite, statues, technical objects, etc. Resion V Cast can be coloured with various inks and pigments, giving various effects.

## Properties

- Easy to use
- UV stabilised
- Very clear
- Long working time
- Different curing agents for different casting heights
- Good de-airation
- Wide array of possibilities

## Guide to use

Mix the epoxy resin (A component) with the curing agent (B component). Mix both components thoroughly, scraping sides and bottom of the container multiple times. When desired, the mixture can be poured into a second container, and mixed again (2-pot mixing method). This will dramatically lower the risk of soft spots in the end result. The epoxy is now ready for use.

Pour the epoxy in the mould. Pour slowly and in the lowest part of the mould.

ensure the temperature is between 16 and 25 degrees Celsius. The maximum casting thickness is dependent on various factors, of which temperature is the dominant factor.



## Technische gegevens

|                                     | Resion UV Cast 25 | Resion UV Cast 50 | Resion UV Cast 75 |
|-------------------------------------|-------------------|-------------------|-------------------|
| Maximum casting height <sup>1</sup> | 25 mm             | 50 mm             | 75 mm             |
| Mixing ratio (by weight):           | 100:60            | 100:30            | 100:43            |
| Mixing ratio (by volume):           | 100:66            | 100:35            | 100:50            |
| Working time <sup>2</sup>           | ca. 45 minutes    | ca. 3 hours       | ca. 5 hours       |
| Curing time at 23 degrees C         | 48 hours          | 72 hours          | 7 days            |

<sup>1</sup> Casting height is depending on temperature. Please see the table in this datasheet..

<sup>2</sup> Mixing large amounts of epoxy shortens working time.

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## Casting height

The casting height is dependent on temperature. Main focus is the maximum temperature achieved. If the temperature gets too high there is a risk of cracking, yellowing or surface distortion.

Below some tests we have conducted:

| Temperature | Maximum casting height |                   |                   |
|-------------|------------------------|-------------------|-------------------|
|             | Resion UV Cast 25      | Resion UV Cast 50 | Resion UV Cast 75 |
| 15 degrees  | ca. 3 cm               |                   | ca. 10 cm         |
| 20 degrees  | ca. 2 cm               |                   | ca. 5 cm          |
| 25 degrees  | ca. 1,5 cm             |                   | ca. 3 cm          |

**Higher temperature:** faster cure

**Lower temperature:** slower cure

**Larger amount or thicker layer:** faster cure

**Smaller amount, or thinner layer:** slower cure

## Tips

- Prime wood with the RESION UV Cast 25 to prevent air escaping the wood. Repeat if necessary. When in doubt, ask for advice.
- Maintain a constant temperature when using the epoxy and during curing to prevent surface distortion. Maintain a minimum temperature of 12 degrees.
- After pouring, let the resin settle for approx 10 minutes. Use a heat gun or a gas burner to remove surface bubbles. Keep a 10-15cm distance and keep moving to prevent heat up of the resin. Removing bubbles goes fast. There is no need to torch for long times. Torching for longer times causes surface distortion.
- The epoxy will be thinner at higher temperatures. This makes it easier for air bubbles to rise to the surface.
- Spilled resin can be cleaned up using solvent wipes, acetone or vinegar.

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## Safety

Use nitril gloves and safety goggles. Use a respirator in areas with insufficient ventilation. Read the MSDS for more information.

## Storage and shelf life

Store dry and away from sunlight. Close containers after use to prevent oxidation. Avoid UV light.

When stored in these conditions, shelf life is at least 1 year. Epoxy can yellow under the influence of light and oxygen. This does not affect the technical properties. In practice epoxy has a virtual unlimited shelf life, if a certain amount of yellowing is acceptable.

## Mixing

It is of the utmost importance that the right mixing ratio is achieved. When in doubt use scales to measure the epoxy. Put an empty mixing cup on the scale and zero the scale. Add component A and calculate the right amount of B. Zero the scale again and add the right amount of B. For ease of working we have a list of possible mixing ratios on the following pages.

When both components are in the mixing cup, mix them thoroughly and long enough. Our recommendation is to scrape sides and bottom, mix, scrape sides and bottom again, etc. This process takes at least 2 minutes, longer for larger amounts. When in doubt pour the epoxy in a second mixing cup, scrape the first one empty, and mix the second cup again. The epoxy is now ready for use.



| Mixing ratio Resion UV Cast 25 (100:60 by weight) |             |             |
|---|-------------|-------------|
| Total   | A component | B component |
| 16 gr   | 10 gr       | 6 gr        |
| 40 gr   | 25 gr       | 15 gr       |
| 80 gr   | 50 gr       | 30 gr       |
| 120 gr  | 75 gr       | 45 gr       |
| 192 gr  | 120 gr      | 72 gr       |
| 240 gr  | 150 gr      | 90 gr       |
| 320 gr  | 200 gr      | 120 gr      |
| 640 gr  | 400 gr      | 240 gr      |
| 800 gr  | 500 gr      | 300 gr      |
| 1600 gr   | 1000 gr     | 600 gr      |
| 3200 gr   | 2000 gr     | 1200 gr     |

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| Mixing ratio Resion UV Cast 50 (100:30 by weight) |             |             |
|---|-------------|-------------|
| Total   | A component | B component |
| 65 gr   | 50 gr       | 15 gr       |
| 130 gr  | 100 gr      | 30 gr       |
| 260 gr  | 200 gr      | 60 gr       |
| 390 gr  | 300 gr      | 90 gr       |
| 520 gr  | 400 gr      | 120 gr      |
| 650 gr  | 500 gr      | 150 gr      |
| 1300 gr   | 1000 gr     | 300 gr      |
| 2600 gr   | 2000 gr     | 600 gr      |
| 6,5 kg  | 5 kg        | 1,5 kg      |
| 13 kg   | 10 kg       | 3 kg        |

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| Mixing ratio Resion UV Cast 75 (100:43 by weightt) |             |             |
|--|-------------|-------------|
| Total  | A component | B component |
| 143 gr   | 100 gr      | 43 gr       |
| 286 gr   | 200 gr      | 86 gr       |
| 429 gr   | 300 gr      | 129 gr      |
| 572 gr   | 400 gr      | 172 gr      |
| 715 gr   | 500 gr      | 215 gr      |
| 1430 gr  | 1000 gr     | 430 gr      |
| 2860 gr  | 2000 gr     | 860 gr      |
| 7150 gr  | 5000 gr     | 2150 gr     |
| 14,3 kg  | 10 kg       | 4,3 kg      |
| 28,6 kg  | 20 kg       | 8,6 kg      |
| 42,9 kg  | 30 kg       | 12,9 kg     |

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