

Armour Cast – Deep Cast Clear Epoxy Resin

Exotherm-controlled, clear casting resin

Description

Armour Cast - is a two-component, 100% solids, epoxy casting product that is specifically designed for casting and encapsulation. Its lower reactivity allows for casting up to 40 mm thick without the use of cooling tables where it cures to a crystal clear solid with minimal shrinkage.

Features

- Low exotherm, for thick pours
- Low viscosity for good penetration, levelling and air release
- Can be used with coloured and clear systems
- Crystal clear
- Excellent colour stability
- Impact resistant
- Good adhesion to hard and soft woods

Application

1. Ensure that mixing container and mixer are perfectly clean. A mixing container that is 50% bigger than the desired pour volume is recommended to avoid spillage. A helix paint mixer is especially suited.
2. Apply Solved Wax release agent to the mould to allow for easy mould release after curing.
3. Measure component A and B precisely. Variations to mix ratio may cause incomplete curing. The mix ratio is 3:1 (A:B) by weight or 2,5:1 (A:B) by volume. It is not recommended to mix more than 15 kg at one time.
4. Thoroughly mix the liquid components for at least 5 minutes. Add any colorants at this point. Scrape the sides of the mixing container every few minutes. The mixture will turn milky white at the start. It is important to continue mixing until all cloudiness disappears.
5. Allow the mixed product to stand for 15 minutes. Use a heat gun or butane torch to pop any bubbles that rise to the surface.
6. Pour the mixed product into the mould. Do not scrape the sides of the mixing container as may result in uncured spots in your final casting.
7. Cover the product so that dust and other debris don't settle on the epoxy surface as it is curing.
8. The product can be demoulded after 4 days when cured at ambient conditions are around 25 °C. It is important not to machine the epoxy product at this point as full cure will not have been achieved. Machining can only be done after 7 days when cured at 25 °C.

Specifications

Property	Unit	Component A	Component B
Solids content	%	100	100
Mix ratio by weight		3	1
Mix ratio by volume		2.5	1
Viscosity @ 25 °C	mPa.s	1200	60
Density	kg/litre	1.15	0.95
Limiting properties			
Maximum application temperature	°C	28	
Minimum application temperature	°C	18	

Maximum pour thickness	mm	40
Minimum pour thickness	mm	15

Mixed Properties		
Pot life (500 g) @ 25 °C	Hours	10+
Demould cure time @ 25 °C	Days	4
Full cure time @25 °C	Days	7
Hardness	Shore D	78-82
Tensile strength	MPa	65
Elongation at break	%	8
Compressive strength	MPa	300

Packaging		A	B
1,33 kg kit		1 kg	0.33 kg
6.67 kg kit		5 kg	1.67 kg
33.3 kg kit		25 kg	8,3 kg
Bulk		220 kg	190 kg

The information contained in this technical data sheet is to the best of our knowledge correct. NO
 GUARANTEE
 IS EXPRESSED OR IMPLIED. Users must satisfy themselves as to the efficacy of the product in their
 application