Name: River Table Epoxy

100 % Solids, Two-Part Epoxy
Very long Pot-life, Low Mixed viscosity, Room temperature cure
User-Friendly 2:1 Mix Ratio

PRODUCT GENERAL INFORMATION:

R 114-42/8-442 is a VAC free, room temperature cure system designed for casting thick sections of extremely clear epoxy.

HANDLING PROPERTIES @ 77°F FOR 100g MASS

	PART A	PARTB	AlB(/C) BLEND		
	A-112	B-442			
Mix Ratio, pbv	2.0	1			
Mix Ratio, pbw	2.3	1			
Appearance	Liquid	Liquid	Liquid		
Color	Clear	Clear	Clear		
Density	9.2	8.2	8.9	lb/gal	ASTM D 1475
Viscosity	750	120	450	cP	
Gel Time @ 77°F			4h		ASTM D 2196
Cure Schedule	7-10 d @ 72-77°F		1440.0	min	ASTM D 2471

PHYSICAL PROPERTIES

Hardness, Shore Scale	82	D	ASTM D 2240

The above test results are typical and cannot be considered as product specifications

SURFACE PREPERATION

Maximum adhesion is obtained when surfaces to be bonded are free of oil, grease, rust, and other contaminants. For hard to bond substrates (e.g. PE, PP, etc.) use conventional surface preparation methods.

MIXING

Before blending Resin and Hardener stirring may be necessary, especially in case of filled materials.

Place PART A (Resin) and PART B (Hardener) into a clean cylindrical container according to the specified MIX RATIO. Mix the blend thoroughly to ensure complete mixing. Drill mixing with Jiffy blade is recommended. In case of hand mixing, periodically scrape the walls and the bottom of the container to avoid unmixed material which will result in soft spots after curing.

For room temperature cure systems, once the Resin and Hardener are mixed together an exothermic reaction takes place developing some heat which accelerates the process of cure. The viscosity of such a self-heating system first decreases then, at the end of the GEL TIME, increases until the material gels. At this moment the temperature of the product keeps rising, and in the case of large batches can result in overheating with unpleasant fumes and smoke.

Do not mix more material than you are able to apply in one step.

This material has an approximate set time of 24-30 hours @ 25°C

The uncured epoxy can be removed from tools and equipment with isopropyl alcohol, xylene, or mineral spirits.

Avoid breathing vapors. Forced local exhaust is recommended to effectively minimize the exposure. NIOSH approved, organic vapor respirators and forced exhaust are recommended in confined areas, or when conditions (heated polymers, sanding, etc.) may cause high vapor concentrations. Do not weld on, burn, or torch any epoxy material. Hazardous vapor is released when an epoxy is burned. Avoid contact with skin and eyes. Wash skin with soap and water if contact occurs. If eye contact occurs flush with water for 15 min and get medical attention. Read and understand all cautions on can labels and Material Safety Data Sheets before using this material.

This product has 12 month shelf life if stored in a dry warm place at 60-80°F in original sealed containers. Lower temperature (below 60°F) may cause a partial crystallization of the resin. If crystallization has occurred, heat the resin in its original container placing it into another container with hot water. Change water to keep it hot for a few hours. Cool down to 77°F. If viscosity of the resin is still higher than specified, repeat the procedure.

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