

EasyCast

Clear Casting Epoxy

DANGER:

CONTACT WITH HARDENER MAY CAUSE PERMANENT EYE DAMAGE. MAY BE HARMFUL BY SKIN CONTACT OR BREATHING VAPORS OR MISTS. CONTACT WITH RESIN MAY PRODUCE ALLERGIC REACTION BY INGESTION, INHALATION OR SKIN CONTACT. CONTACT MAY CAUSE EYE/SKIN IRRITATION.

PRECAUTIONS: AVOID INHALATION, INGESTION, EYE AND SKIN CONTACT. WEAR PROTECTIVE GLOVES AND GOGGLES. DO NOT WEAR CONTACT LENSES. DO NOT TAKE INTERNALLY. USE ONLY IN ADEQUATE VENTILATED AREA. USE WINDOW EXHAUST FAN OR OTHER SUITABLE EQUIPMENT TO REMOVE VAPORS AWAY FROM THE WORK AREA. WASH WITH SOAP AND WATER AFTER USE. KEEP CONTAINER TIGHTLY CLOSED WHEN NOT IN USE.

KEEP OUT OF REACH OF CHILDREN

SIGNS AND SYMPTOMS OF OVEREXPOSURE:

SKIN CONTACT: Irritation, dryness and flaking. After sensitization, hives or rashes.

EYE CONTACT: Irritation, redness or eye watering.

INHALATION: Irritation. After sensitization allergy type symptoms with possible breathing difficulties. May cause Central Nervous System (CNS) depression. Evident by headache, dizziness or nausea.

INGESTION: Irritation. Large quantities may cause nausea and vomiting. May cause Central Nervous System (CNS) DEPRESSION. Evident by headache, dizziness or nausea.

EMERGENCY AND FIRST AID PROCEDURES:

EYE CONTACT: Remove any contact lenses and flush eyes for 15 minutes with water. Hold eyelids open to ensure complete flushing. CONTACT A PHYSICIAN IMMEDIATELY.

SKIN CONTACT: Remove contaminated clothing/shoes and wipe excess from skin. Flush skin with water. Follow by washing with soap and water. If irritation occurs GET MEDICAL ATTENTION. Do not reuse clothing until cleaned. Contaminated leather articles, including shoes cannot be decontaminated and should be destroyed to prevent reuse.

INHALATION: Leave the area to obtain fresh air. If breathing has stopped, give artificial respiration then oxygen if needed. If difficulty breathing or other symptoms continue CALL A PHYSICIAN.

INGESTION: DO NOT INDUCE VOMITING. CALL A PHYSICIAN IMMEDIATELY or the Poison Control Centre. If patient is conscious give 300 – 500mls of water for dilution effect only. Do not give anything by mouth to an unconscious or convulsing person.

WHAT IS EASYCAST?

EasyCast is a reactive clear casting epoxy. It's solvent free and low odour. It can easily be coloured, tinted or combined with fillers to create faux granite or metallic castings. These characteristics make it ideal for casting and embedding up to 170mls (maximum) per pour. *Due to heat build up and discolouration, do not attempt to cast more than 170mls at one time.*

TOOLS NEEDED

- 1: Plastic measure/mixing cups (do not use wax coated cups as the wax may break off and contaminate your mix).
- 2: Wood stir sticks.
- 3: Disposable craft brushes.
- 4: Wax paper or plastic sheet to protect work surface.

MOULDS

Polypropylene or polyethylene resin moulds are designed for use with Clear Casting Epoxy due to their self releasing characteristics. Rubber moulds made from latex, urethane or silicone can be used if treated with Castin'Craft Mould Release/Conditioner. **WARNING:** *Due to the strong bonding properties of EasyCast, only use plastic moulds designed for resin casting. Other moulds such as chocolate, soap or candle moulds are generally not useable even with a good mould release. If you're not sure test a spot on the mould such as the back side.*

MOULD PREPARATION

1: Determining mould capacity: Occasionally plastic moulds state the size of the mould cavity. However rubber (latex, urethane and silicone) moulds do not. To determine the amount of material required, fill mould first with water then carefully pour this water into a measuring cup.

CAUTION: *Some rubber moulds may absorb water. This water can cause a cloudy or milky appearance in your finished piece. Make sure your moulds are thoroughly dry before using.*

2: Prepare all moulds with Castin'Craft Mould Release/Conditioner per package instructions. Rubber moulds require two applications. If two applications are not applied you may not be able to remove your cast pieces once cured.

WORK AREA AND SURFACE

- 1: For best results your work area and surface should be between 21°C and 29°C.
- 2: Work surface should be dry level and free of dirt or dust.
- 3: Protect work area with a plastic drop sheet, wax or newspaper.

INSTRUCTIONS

EasyCast was designed for a maximum single cast of 170mls or less. *Due to heat build up and discolouration, do not attempt to cast more than 170mls at one time.*

1. **IMPORTANT:** EasyCast performs best at 24°C. EasyCast bottles should feel slightly warm to the touch, if they feel cool, they must be warmed by placing them in warm tap water (not hot) for 5 to 10 minutes prior to using. If bottles become overheated allow them to cool before using. Never mix hot resin and hardener together! Mixing EasyCast when cold will result in cloudy cast with microscopic bubbles.

2. **MEASURE:** **Carefully measure equal parts of resin and hardener into a straight sided, flat bottom, wax free measuring container.** **WARNING: Do not vary the 1 to 1 ratio for any reason! Failure to measure equal amounts of resin and hardener will result in soft or sticky castings.** *Do not simply pour the contents of both bottles and expect to get properly measured amounts, always measure.*

3. **DOUBLE MIXING:** For EasyCast to chemically blend, it must be mixed together in two stages. With the resin and hardener measured, use a stir stick and mix together for two full minutes. During mixing, use the stir stick to scrape the sides and bottom of your mixing container. Occasionally scrape the mixture from your stir stick back in to the solution. After two full minutes of mixing, pour the contents from the first container into a second container. **Using a new stir stick,** mix the contents of this second container another minute, again scraping sides of container and stir stick. Pour immediately from this second container.

4. **BUBBLES:** EasyCast has been formulated to self degas within a few minutes of pouring under most casting conditions. However adding fillers such as granite or metallic powders can result in a cloudy bubble filled mixture. These bubbles will slowly rise to the surface of your cast. If needed use a hair dryer and pass heated air quickly over the EasyCast surface to remove bubbles. Be careful excess heat can melt or warp plastic moulds.

5. **CURE:** For best results cast pieces should cure at temperatures between 21°C and 29°C. Curing time will vary depending on room temperature and thickness of cast. Thin castings will take longer than thick castings. Normal cure for castings 2.5mm thick is 24 hours for soft cure, 72 hours for hard cure.

6. **DEMOULDING:** Rigid type plastic moulds can usually be twisted slightly to break the cast pieces free. Pushing in from the back side of the mould will also help. Note: Do not attempt to de-mould pieces that have not cured for a minimum of 24 hours. You may damage your casting by doing so.

7. **TRIM & SAND EDGES:** Edges can be trimmed with a knife or sanded if needed. Use 150 grit or finer sandpaper to remove excess material. A file, sander or Dremel tool can be used for shaping and carving completely cured castings.

8. **CLEAN UP:** While liquid the material can be cleaned from tools with solvents such as Acetone. Use warm water and liquid soap to clean from skin. NEVER USE SOLVENTS TO CLEAN EASYCAST FROM YOUR SKIN.

TECHNIQUES.

Faux Marble:

Faux Marble is easily created with the addition of 3 or more contrasting colours of Castin'Craft Opaque Pigments. Experimenting with the following process will enable you to perfect colour combinations and marbling techniques. Some colour combinations to consider are:

Green Marble: use green, white and a touch of black.

White Marble: use white with a touch of black.

Brown Marble: use brown, white and a touch of black.

Pink Marble: use pink (red blended with white), white and a touch of grey (white blended with black).

1. Mix EasyCast per package instructions.
2. Divided mixed EasyCast into three containers.
3. Add a single colour to each container and blend. NOTE: Add just enough pigment to colour mix and not more!
4. Pour all three coloured mixes into one container. Stir lightly once or twice to swirl colours together, then immediately pour into mould. TIP: Avoid over mixing which can muddy colours.

Translucent Glass Effect: Use Castin'Craft Transparent Colours

1. Mix EasyCast per package instructions.
2. Add transparent dye to mixed EasyCast approximately one drop of dye per 30mls of EasyCast. Less or more can be used for varying shades. Dye colours can be blended to create additional colours.
3. Blend then immediately pour into mould.

Faux Metal: Use metallic powders.

1. Mix EasyCast per package instructions.
2. Add metallic powder to mixed EasyCast, approximately ¼teaspoon per 220mls. Less or more can be used for varying effects.
3. Mix well to ensure all powder is blended, then immediately pour into mould.

Faux Granite:

Castin'Craft Granite Powders mixed with EasyCast produce dramatic granite like results. Custom colours or marbling can be created by combining granite powders. Castin'Craft Granite Powders appear white but change colour immediately when EasyCast is added. TIP: *Adding more granite powder will give you a stronger more dense granite effect. Be careful, adding too much granite powder can result in a stiff mixture which is hard to pour.*

1. EasyCast per package instructions.
2. Measure granite powder into plastic measuring cup.
3. Add an equal amount of mixed EasyCast to the granite powder.
4. Stir mixture slowly to avoid airborne dust from powder then pour into mould.
5. Releasing air bubbles from surface of cast: If needed use a hair dryer and pass heated air quickly over the surface. Be careful, excess heat can melt or warp plastic moulds.

CASTING EMBEDMENTS.

Photos, prints, fabric etc must be pre-sealed with two coats of white craft glue to prevent pieces from turning transparent. Delicate items such as dried flowers should be sealed with two coats of a fast drying acrylic spray. Wood pieces can be sealed with EasyCast of white craft glue however this must be done and cured before embedding to prevent air from escaping from the wood piece which will in turn create bubbles in your casting. Solid non porous objects such as seashells, coins, stone, plastic etc do not require a seal coat. If you're not sure, test a sample piece first.

POLISHING & BUFFING.

Occasionally some EasyCast pieces may require cut polishing to remove imperfections, sanding marks or to change the surface to a semi-gloss or matte finish. NOTE: *EasyCast when polished will not develop a high gloss or wet look as per the original surface.* For a high gloss surface, consider recoating the cast piece with EasyCast or EnviroTex Lite.

1. Hand Polishing: Use Rottenstone rubbing compound for a semi-gloss finish or Pumice rubbing compound for a matte finish. Follow the package instructions for applying with water. Both items can be purchased from your local paint or hardware store.
2. Buffing: Cast pieces can be buffed on a buffing wheel using abrasives for plastics. Contact your local supplier of buffing equipment and buffing compounds for details on buffing plastics.

TROUBLE SHOOTING.

1. Soft & Sticky Castings: Is a result of improper mixing or inaccurate measurements of resin and hardener. These soft or sticky castings will unfortunately have to be disposed of. Prevention: Do not guess at the proper ratio or just empty the two bottles into your mixing container. Use a proper measuring device and measure equal portions of resin and hardener. Always double mix as per the instructions. Note: Inadequate measuring and mixing is the most common reason for imperfect results.
2. Tiny Bubbles/Cloudy Clear Castings: This is a result of mixing cold EasyCast. Prevention: Warm EasyCast as stated in the instruction prior to using.
3. Easy Cast set before completely poured. This is the result of mixed EasyCast left setting in a mixing container too long after mixing. Prevention: Always pour EasyCast immediately once mixed.
4. Cloudy Resin: Due to the purity of EasyCast resin, a clouding or settling of the resin may occur from storing in cold conditions. This is a normal process and does not affect the outcome of this produce. Should this occur, simply set the resin container in hot tap water until clear. Allow to cool before using. Prevention: Store in warm area and off of cold floors.

COMPATIBILITY ISSUES:

EasyCast casting epoxy can be safely applied to cured polyester casting resin. CAUTION: Do not attempt to pour polyester casting resin over EasyCast. Polyester casting resin will attack and soften EasyCast.

Castin'Craft Casting Products Include:

Opaque Pigments - Red, Yellow, Green, Blue, Brown, Black, White & Pearlescent

Transparent Dyes - Red, Yellow, Green, Blue & Amber

Granite Powder - Sierra Grey, Mojave Sand, Adirondack Brow, Black Quartz, Desert Mauve, Dakota Red, Appalachian Green & Glacier Blue

Mould Release/Conditioner

Plastic resin & knob moulds

EASYCAST KNOB – BOOKLET

"EasyCast Knobs" 20 page full colour Book. This book covers 10 decorative casting techniques with dozens of projects for creating your own decorative kitchen, bathroom or furniture knobs.

WARRANTY.

The recommendations given here serve only as a guide. Because of variable of temperature, humidity, types of moulds, colorants and embedments, we cannot guarantee results. Our liability is limited to the replacement price of the product.

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