

Deep Casting Epoxy Resin

1. Overview

Manufactured by Sicomin in the France. Manufacturer's Brand Name: **Greencast 160**
Clear, UV Stabilised (slow to yellow compared to non-stabilised resins).

Cast in layers between 15 -100mm thick. (Will cure very slowly in castings below 15mm in cold weather and when ambient temperature exceeds 23°C the casting layer thickness should not exceed 80mm.)

Cured castings are hard and strong.

Bio-based resin system making it more environmentally friendly. 37% of resin (Part A) is manufactured from renewable plant material.

Not approved for food contact and not suitable for heat contact or exposure above 61°C.

Mixing ratio is 100 Resin : 42 Hardener by weight or 2 Resin : 1 Hardener by volume.

2. Safety and Health

- Epoxy Resins are an irritant to skin, eyes and mucous membranes.
- Avoid breathing fumes. As a minimum, use them in a well ventilated work area. The use of a respirator is strongly recommended and essential for larger projects and regular users.
- Avoid eye contact. Wear protective eyeglasses.
- Avoid skin contact. Wear rubber gloves and long sleeve shirt. Over time, skin contact can cause sensitisation (this basically means one can become allergic to the chemicals).
- Do not clean resin off your skin with solvents. This can accelerate penetration of harmful substances through your skin. Use soap and water to clean skin.
- Do not swallow. Keep out of reach of children.
- The harder (Part B) is corrosive and may cause severe eye damage and skin burns. It is a sensitizer that may cause dermatitis from skin contact and exposure to fumes.
- If sanding or machining cured resin then wear a dust mask to prevent dust inhalation.
- First Aid:
 - In the event of eye contact, wash eyes under running water for 15 minutes and get medical attention.
 - In the event of skin contact, wipe clean with white vinegar then wash with soap and water. Get medical attention if irritation develops.
 - If fumes are inhaled or if breathing becomes difficult, move to fresh air. Get medical attention if symptoms develop or persists.
 - If swallowed do not induce vomiting. Drink 1-2 glasses of water and seek medical attention.

3. Key Parameters

- A very high flow resin cast in layers between 10mm - 100mm thick (See dangers of heat below).
- Pot Life*: 1 hour (for 500g batch) at 20°C.
- Cure Time: Expect a cure time of 24 hours for thicker layers (80-100mm) and 48 hours for thinner layers (15mm – 20mm). Cure time of thin layers will be longer in cold weather.

*Pot Life

Larger volumes and containers with lower surface area reduce the pot life. The pot life will be reduced in hot weather. You can extend the pot life by pouring the mixed resin into flat trays. If you leave the resin too long it will start to thicken and air entrainment and heat generation will become a problem. Never leave mixed resin unattended as it can start to generate excess heat, give off toxic fumes and even become a fire danger. If this starts to occur then move the resin to a safe place outdoors and don't try to use it.

Don't mix more than you can use in a relatively short space of time.

4. Maximum casting thickness and dangers of heat

The curing chemical reaction between epoxy resin and hardener generates a significant amount of heat (exothermic chemical reaction). When this heat cannot escape it increases the temperature causing the epoxy to cure faster and generate even more heat. The higher temperature increases differential shrinkage in the casting which may lead to induced stress and cracking. A potentially massive build-up of heat can cause the epoxy to crack and discolour.

Uncontrolled exotherm may cause the epoxy to foam, smoke, give off dangerous vapours, crack and generate enough heat to melt its container or cause nearby items to catch fire.

- Never exceed the recommended maximum thickness or volume of a resin system as this may lead to overheating. Use mixed resin before it starts to thicken or increase in temperature.
- The maximum thickness applies to resin used at ambient room temperature of 23°C with relative humidity below 85%. Warmer temperatures will reduce pot life and may also influence the safe casting thickness. If temperatures are warmer than 25°C, reduce maximum casting thickness by 50% or as appropriately required to avoid excessive exothermic reactions.
- If you pour resin into a closed mould then the heat build-up will be greater than when using a flat open mould with a large surface area for the resin to lose heat. Reduce layer thickness when using relatively closed moulds.

The above tells you the dangers of casting too thick or with too high volume. Casting too thin for a specific resin system leads to slow hardening and it could take many days for a resin to harden in cold weather. This gives more time for pigments to settle and for amine blush to develop so it is definitely best to use a resin type that is most suited to the thickness you intend to cast. There is no limit to the number of layers that you can cast on top of each other.

5. Typical Applications

Used to create 'river tables' and poured into deep moulds to create castings. Excellent for adding pigments and colourants and for submerging medium size stones and crystals in resin creations.

6. Protecting surfaces

- Apply 3-4 coats of RAMWAX® or equivalent onto surfaces that you don't want the resin to adhere to. Apply wax, allow 15 minutes for solvents to evaporate, polish to a high gloss and then apply next coat of wax and do the same. Use a lint-free cloth (Important!).
 - If making a river table then coat the entire melamine box with wax for easy removal.

7. Equipment Required

- Two Plastic or metal containers. Containers must have smooth continuous sides for scraping. (Do not use foam or glass containers.)
- Scale (the two components of this resin system must be measured by weight and not volume).
- Stirring sticks with square edge and straight sides that reach to the bottom of all containers.
- Isopropyl alcohol (rubbing alcohol) for cleaning up. Remember that this is flammable.
- Ensure that all containers and tools are free from dust, grease and other contaminants.

8. Surface Preparation

- Ensure all surfaces are free of dust, oils and contaminants.
- Non-porous surfaces such as tiles and glass do not need priming or sealing.
- Porous surfaces (such as wood and cement) must be priming to sealed to prevent air bubbles being released from the surface when resin is applied. Sealing can be done by applying an initial thin layer of our [General Art Resin](#) or our [Counter Top & Shallow Casting Resin](#). Mix only sufficient resin to create this thin film which should be about 1.5mm thick. Wait 24 to 48 hours for this thin layer to cure and become hard.
- You can also prime to remove air from porous surfaces with a water-based paint. Never use an oil-based paint under resins.
- Apply wax to all surfaces that you require the cured resin to release from. See section above "Protecting Surfaces".

9. Mixing

Proper mixing is a key requirement for a successful resin project. Poor mixing will lead to defects which may often be cloudy streaks or patches in the cured resin. These defects cannot be removed.

It is better to measure the components of resin systems by weight rather than by volume.

- The ratio **by weight** of Resin and Hardener is **100 Resin : 42 Hardener**
 - e.g. 50g Resin with 21g Hardener.
- The ratio **by volume** of Resin and Hardener is **2 Resin : 1 Hardener**
 - e.g. 300ml Resin with 150ml Hardener.
- Accurately measure out Resin into the mixing container then measure out the Hardener.
- Stir together well for 3-5 minutes using a square edge stir stick. Include scraping of the sides and bottom of the mixing container several times. Do not mix in a manner that introduces air.

- Transfer entire content to a second clean mixing container and mix for another minute again scraping the sides. Failure to scrape sides sufficiently will lead to streaks.
- Your resin is now ready for pouring and it must be poured before it starts to get thick or hot.

Mixing can be done by hand or with a drill fitted with a mixing unit. Drill mixing can help mix larger quantities but should be set to low speed on a variable speed drill to avoid making a vortex that will pull in air. A drill mixer will not scrape the sides so manual mixing with scraping of side and bottom of the container is still required. If drill mixing introduces air, time will be required to allow the air to rise.

If the mix quantity is large it may start to thicken and/or generate heat prior to pouring. This indicates that curing is underway. The heat generated can reach dangerous levels. You can extend the pot life by pouring the mixed resin it into large flat trays where heat can more readily escape.

10. Adding liquid colourants or powder pigments

Bastion Paint Allure Liquid Colourants, Pearlescent Pigments and Glitter Powders stir in very easily. These can be added at any time. Some other pigment types do not mix in as easily and these should be mixed as follows: Put pigment into mixing container first then add Resin (Part A) to the pigment and mix. After that add Hardener (Part B) and stir. This way, the pot life is not reduced while mixing the pigment. Limit pigment / colourant to 6% of the total resin mass. Only use more if you have tested it.

11. Including rocks, stones and crystals

Wash these and dry them thoroughly. Porous items should be oven dried at 100°C for an hour and cooled before use. For larger items it is a good idea to dip them into mixed liquid resin to pre-coat them prior to pouring the liquid resin over them (this is because poured resin may not get underneath them).

12. Removing air with a propane torch

Torching to remove air shortly after pouring is important if air bubbles are present. Do not hold the torch closer than 8cm from the resin surface as too much torching will burn and discolour the resin. As this resin has a very high flow, air is not usually a problem.

13. Prevent dust contact during curing

Dust and air-borne debris are an enemy of all curing resins. Pour and allow to cure in a clean area. We recommend covering your pour with something like a sheet draped over a suspending frame. Do not cover with something that traps fumes or heat.

14. Adding subsequent layers

There is no limit to the number of layers that can be added. The bond between layers will be permanent and invisible. Allow resin to get hard and return to room temperature before adding a new layer. If a subsequent layer is added too soon it may overheat and crack.

If too much time passes before adding a subsequent layer (more than 72 hours) then the layers may delaminate. If more than 72 hours has passed then wash with soapy water, sand and wash again before applying the next layer.

- If amine blush develops you must wait until the resin is hard and then wash with soap and water, sand and wash again. Then allow for proper drying before applying a subsequent layer. Failure to do this will ruin your project. Amine blush can be identified as the surface being cured (hard and resisting fingernail indentation) but feeling tacky. A milky or “oil on water” appearance also indicate that amine blush is present.
- After any washing, always make sure that the resin has fully dried before pouring a subsequent layer.

15. Storage

Store in cool area. 23°C is the best storage temperature. Both resin components have a best before date.

16. Pouring into a mould

Pour mixture into a single spot at the lowest point of the mould or enclosure. Let the mixture seek its level. A uniform pouring flow will help minimise entrapped air.

17. Cleaning spills

The best chemical to clean small spills effectively is isopropyl alcohol. Rubbing alcohol and some hand sanitisers are fine. Clean spills as soon as possible before curing. Don't clean resin off your hands with these types of solvents; use soap or hand cleaner and water to clean skin.

18. Making a river table or similar item

Watch the following video: <https://www.youtube.com/watch?v=tTu8WkBdKbA>

Use melamine for the base and sides of box that will hold the resin in place.

Apply 2-4 coats of wax to surfaces that must be released. See section above "Protecting Surfaces". Pour mixed resin into prepared space. Measure the depth to ensure that no individual layer exceeds 100mm depth (limit layer thickness to 80mm until you are familiar with this resin and less in hot weather).

Torch carefully to remove air if required.

Allow 24-72 hours (resin must cool to room temperature and become hard) before adding the next layer.

Once the final layer is dry, a series of dry and wet sanding steps can be performed followed by polishing.

19. Useful Parameters

Mix Ratio By Weight	100 Resin : 42 Hardener
Mix Ratio By Volume (where A is Resin and B is Hardener)	2 Resin : 1 Hardener
Viscosity of Final Mixed Resin (ASTM D2393)	360 cps
Specific Gravity – Mixed (ASTM D1475)	1.131 g/cm ³
Pot Life of 500g at 20°C (ASTM D2471)	1 Hour
Cure Time (approximate for 90mm thick layer)	24 hours
Cure Time (approximate for 60mm thick layer)	36 hours
Colour	Clear
Shore D Hardness after 7 days @ 23°C (ASTM D2240)	80
Ultimate Tensile (NF EN ISO 527-2:2012)	38 MPa
Tensile Modulus (NF EN ISO 527-2:2012)	2150 MPa
Tensile Elongation (NF EN ISO 527-2:2012)	19%
Flexural Strength (NF EN ISO 178:2011)	59 MPa
Flexural Modulus (NF EN ISO 178:2011)	1940 MPa
Compressive Strength (NF EN ISO 604:2004)	65 MPa
Glass Transition Max Onset (NF EN ISO 11357-1:2016)	61°C

20. How to calculate the amount required

We recommend using a scale and resin mass as this is normally more accurate than using volume.

For a roughly square or rectangular shape multiply as follows:

Resin required in kg = Surface length in m x Surface width in m x required resin film thickness in mm x 1.13

For a roughly circular shape multiply as follows:

Resin required in kg = 3.14 x Circle radius in m x Circle radius in m x required resin film thickness in mm x 1.13

Example

If your rectangular surface is 60cm x 20cm and you require a film thickness of 65mm

Resin required in kg = 0.6m * 0.20m * 65mm * 1.13
= 8.81kg of resin

(If you select to measure out the components using volume then don't multiply by 1.13:

Resin required in Litres = 0.60m * 0.20m * 65mm
= 7.80L of resin

Now work out how much of Resin and how much of Hardener you need to give you the total requirement of 8.81kg

Ratio for this resin is 100 Parts Resin to 42 Parts Hardener PBW (PBW = parts by weight).

To get 8.81kg total resin:

kg Resin required = 8.81/142 * 100 = 6.204kg (or 6204g)

kg Hardener required = 8.81/142 * 42 = 2.606kg (or 2606g)