



PT. Indowijaya Sakti Teguh

Jl. Pangeran Jayakarta 121/3-4, Jakarta Pusat

www.puffinpaint.com Telp : 021- 62313238

PUFFIN EPOXY CASTING CRYSTAL CLEAR

Two component polyamine cured epoxy solvent free coat which can be use for epoxy casting. This product is chemical resistant and designed for casting molds, figures, jewellery and some other applications.

1. Properties.

COLOR	Transparent clear
GLOSS LEVEL	gloss (75-85)
FILM THICKNESS, DRY (μm)	>1cm
FILM THICKNESS, WET (μm)	>1cm
THEORETICAL SPREADING RATE (M^2/L)	Base on thickness
SOLIDS (VOL %)	99% +/- 2
DENSITY (g/cm^3)	1
FLASH POINT	18°C \pm 2%
PRACTICAL COVERAGE	ALLOW APPROPRIATE LOSS FACTORS

2. Characteristics

Recommended for

Single epoxy casting

3. Usage.

1) Surface preparation:

To secure lasting adhesion to the subsequent product all surfaces shall be clean, dry and free from any contamination. Oil or grease should be removed.

2) Substrate Minimum Recommended :

The surface should be assessed and treated in accordance with Substrate minimum recommended

For carbon steel substrate : Sa 2½ (ISO 8501-1)

For concrete: Min Age of concrete 1 months with PH<9 , moisture content < 17

%. Clean, dry and free from any contamination.

For wooden substrate : Clean and dry surface. Surface contamination must be removed by detergents and fresh water cleaning.

For stainless steel: cleanliness and surface profile corresponding to Sa 2½, Fine G (ISO 8503-2) Cleanliness and surface profile corresponding to Sa 2½, Fine G (ISO 8503-2)

For Aluminum: The surface shall be hand or machine abraded with non-metallic abrasives or bonded fiber machine or hand abrasive pads to impart a scratch pattern to the surface and to remove all polish from the surface. Dry abrasive blast cleaning to SSPCSP 13/NACE No. 6.

For Galvanized steel: The surface shall be clean, dry and appear with a rough and dull profile. Light brush blasting using nonmetallic abrasive leaving a clean, rough and even pattern. Coated surfaces Clean, dry and undamaged compatible coating (ISO 12944-4 6.1) Clean, dry and undamaged compatible coating (ISO 12944-4 6.1)

For stone: Clean, dry and free from any contamination.

For coated substrate: clean, dry, free from any contaminations and undamaged compatibility coatings

3) Application:

Casting

4) Mixing ratio

Base A

2

Base B

1

Mixing potlife <10 minutes

5) Drying and Curing time:

Drying and curing times are determined under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

Walk-on-dry: Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

Dry to over coat, minimum: The shortest time allowed before the next coat can be applied.

Surface (touch) Dry:

The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness.

SUBTRATE TEMPERATURE (°C)	5	10	15	23	40
SURFACE DRY (hour)	24	15	7	5	3
DRY ON WALK (hours)	48	36	25	16	9
Dry to over coat, minimum (hours)	36	32	24	15	6
Dry to over coat, maximum (hours)	180	150	72	48	30
Dried/cured for service (days)	20	15	10	7	3

6) Product compatibility :

Depending on the actual exposure of the coating system, various primers and topcoats can be used in combination with this product.

Some examples are shown below.
Subsequent coat: Epoxy

4. Precaution

1) Ensure to clean the surface before application.

2) Health and safety :

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not inhale spray mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

3) Storage :

The product must be stored in accordance with national regulations. Keep the containers in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care. Shelf life at 23 °C : 24 Month(s)

5. Packing :

1kg, 5kg & 20kg set

