

# SILICONES

## and more



### Characteristics

- crystal
- UV resistant
- Designed for easy use
- Can be cast to layer thickness of at least 10 mm
- Low viscosity (liquid)
- Can be molded without vacuum draw.

## Polyester Clear Set

This resin is ideal for encapsulating objects, but you can also make cast small shapes with it.

### Description

This two-component casting resin is colourless and transparent like water. This resin is UV stabilized. Of course, even this material will over time yellow slightly under the influence of UV. This product consists of an A component (polyester resin dissolved in styrene) and the B component Methyl Ethyl Ketone Peroxide (in our shop polyester ketone peroxide). This resin is very fluid and suitable for the encapsulating of objects you want to keep. The result is a very hard crystal clear plastic.

### Technical data

Mixing ratio (weight)	[A: B]	100: 1.5-2.5 (two is best)
Processing time at 1% peroxide at 20°C	[Min]	30-45
De-mould time @ 20 °C *	[Hours]	More than 2 hours, depending on thickness and temperature
Color (UV-resistant)	[-]	Bright but discolores slightly over time
Viscosity @ 20 ° C	[MPa s]	900
Density after curing	[G / ml]	1.22

\* Full cure @ 20 ° C after a few days. Please note that touching the casting before it is completely cured might leave finger prints.

### processing

Add the A and B components in the proper weight parts together (100: 1.5-2.5) and mix the components well. For smaller castings, we recommend adding some more harder (2 to 2.5%) in larger castings just slightly less (1.5 to 2%)

Pour the mixed product with a constant and thin jet into the mold. Take care not to entrap air. Excessive heat in castings of more than 15mm thickness can be prevented by pouring several successive layers (allow to the layer set before the following layer is added). De-mould only after the specified time has elapsed or better yet after several days. The thermal and mechanical properties will develop rapidly, but it is possible to improve the thermal behavior by post curing the casting for 2 hours at 60 °C for every 2 cm of thickness. It is recommended to process the products at 20 °C and to pre-heat the mold to 40 °C. After the cast has de-aired you can place it in an oven at 40 °C to speed up the curing process.

### Important

Always work in a well ventilated area and use protection gloves and safety goggles.

### packing

Polyester Clear is a kit. The two components are thus both included in the set.

### Durability

Properly sealed and stored out of direct sunlight around 15 -25°C the shell life is at least 6 months.

### safety

The products in liquid form are harmful to health. Skin contact with one or both of the components must be prevented. Prolonged or frequent use of this product will cause vapors to be irritating to your respiratory system. When handling this product, wear protective gloves. Always work in a well ventilated area. For further information see Safety Data Sheet.