



# RIVERCAST™

## Water-Like Resin For Deep Casting



RiverCast™ is an optically clear, very slow-setting epoxy casting resin suitable for deep and large casts (up to 50mm deep and <12 litres per pour). This water-like resin is great for creating river tables, resin furniture and large objects as it has a long working time of up to 10 hours (depending on size). It cures extremely hard and has excellent air removal properties. RiverCast™ is solvent-free, which makes it safe for incidental contact with food once fully cured. This resin has a mild odour.

### Key Advantages

- Very low viscosity
- Long working time
- Excellent bubble release
- UV-resistant
- VOC-free, solvent-free
- Nonylphenol-free
- Safe for food contact

### Recommended for

- Deep casting (up to 50mm and <12 litres per pour) of river tables, furniture & large objects

Mix Ratio (Resin : Hardener)	By weight - 2.2:1 By volume - 2:1
Mixed Viscosity (at 250g mixed mass)	800 - 1,100 mPa.s
Working Time (at 250g mixed mass)	Up to 10 hours
Curing Time	Hard cure: 3 - 4 days Full cure: 21 days
Heat Resistance* (Clear, Fully cured)	50 - 60°C (Higher for deeper casts)
Hardness* (Clear, Fully cured)	Shore 95D

\*The addition of pigments will lower the heat resistance and hardness

Note: RiverCast™ is best used for deep castings up to 50mm and <12 litres per pour. If you exceed the recommended amount, the resin may overheat and smoke. Hence, causing the surface to warp / crack. If you need to cast more than 50mm and >12 litres per pour, we recommend that you do it in layers.

**SHELF LIFE:** When stored under dry and cool conditions in sealed packaging, the resin has a shelf life of 2 years. Once opened, the shelf life is 1 year. However, resin does not actually expire. When it is reaching the end of its shelf life, it simply oxidises (turns yellow). Oxidised resin can still be used for pigmented resin pieces.

**SAFETY:** For professional use only. Keep out of reach of children. Follow product usage instructions included with the product and wear personal protective equipment. For more information on safety, please refer to the SDS available at resinplay.sg.

**NOTICE:** The technical specifications and information is given in good faith and based on our test results obtained but without warranty. The information may differ when the resin is used in different environments, when other additives or pigments are added, or due to any user or external-related factors. The application, use and processing of the products are beyond our control and Resin Play in respect of any sale of its products shall be determined by the terms of its conditions of sale.