

flow RESINS

Technical Data Sheet

Issue Date: 01/10/2021

Product Name:

EASY FLOW

Product Description:

EASY FLOW is an ultra-clear and easy to use general purpose casting system ideal for casting small to medium sized objects. EASY FLOW is perfect for timber projects such as filling timber voids and creating smaller river tables and boards. It is also excellent for casting into silicone moulds to make homewares or jewellery, as well as embedding objects. It is suitable for pouring thinner layers up to 10mm thick (at room temperatures of 25°C or below).

Product Highlights:

Very low yellowing, low viscosity, great thermal stability at temperatures 20°C to 70°C, self-releases air bubbles and has good mechanical properties.

Physical Properties:

Part A

Viscosity at 25°C	mPa.s 500 - 1000
Specific Gravity at 25°C (g/cm ³)	1.1 - 1.15
Colour	Clear liquid

Part B

Viscosity at 25°C	mPa.s 200 - 260
Specific Gravity at 25°C (g/cm ³)	1.0 - 1.05
Colour	Clear liquid

Handling Properties:

Mix Ratio - Part A : Part B (by volume)	100 : 50
Pot Life (200g Sample) @ 25°C	15 - 25 minutes
Peak Exotherm (200g Sample) @ 25°C	110°C
Demould Time	12 - 24 hours
Full Cure	7 days
Hardness	85-90D

Instructions:

Ensure timber is dry and free from oils, solvents, dust, silicones etc. When using EASY FLOW as a river table resin, prior to pouring mix a small volume and paint on the raw inside edges of the timber. This seals the raw edge negating air bubbles from forming on the surface.

Mix enough Part A and Part B by volume exactly to ratio for the initial pour.

Pour a **maximum** of 10mm thickness at any one time. Allow to exotherm (heat) and cool back down to room temperature (minimum 2 hours) prior to a second pour. If layers are thicker than 10mm, epoxy can generate excessive heat resulting in shrinking and cracking.

Allow to cure when desired thickness is reached. Belt or orbital sand to achieve a smooth, level surface. Use ART FLOW as a high gloss, self-levelling coating or timber oil after sanding.

Extra care MUST be taken to ensure thorough mixing of Part A and Part B. Ensure casting is performed in a well-ventilated area as some vapours will be released at these curing temperatures. PPE is recommended. Please refer to the safety data sheet for more information.

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Handling Precautions:

This Part A and Part B combination has been formulated with the objective of being as safe as possible however in common with most epoxy resins and hardeners, consistent skin contact with the uncured materials should always be avoided. Materials will become very hot during curing (up to 160°C).

Do not touch in under the specified demoulding time as burns to the skin may occur. Our testing is based on a 200g sample size. Larger amounts of resin and hardener will get hotter during curing, consequently there is potential for shrinking and cracking during the curing process. It is for this reason that we recommend that castings are no larger than 10mm in thickness. Ensure all casting is performed in a well ventilated area as some vapours will be released at these curing temperatures. Please refer to the safety data sheet for more information.

Storage:

Store the components in a dry place at 18 to 25°C, in tightly sealed original containers.

Disclaimer:

The data presented in this leaflet are in accordance with the present state of our knowledge and does not absolve the user from carefully checking all supplies immediately on receipt. We reserve the right to alter product constants within the scope of technical progress or new developments. The recommendations made in this leaflet should be checked by preliminary trials because of conditions during processing over which we have no control, especially where other companies' raw materials are also being used. Recommendations for use do not constitute a warranty, either expressed or implied, of the fitness or suitability of the product for a particular purpose.

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