



Technical Data

M1047 M2053

CLEAR CASTING EPOXY

The New Standard

EPOXIES for
Laminating
Infusion
Tooling
Assembly

COMBINED FEATURES

Fomulated for use in pouring thick, clear castings of epoxy into wood cavities.

Ideal for clear, decorative castings, filling large voids and thick coatings.

Slow cure speed hardener allows additional pours to be applied between 2 and 4 hours at 72°F (22°C) without any surface preparation.

Cast up to 2" deep and retain clarity with slight amber tone. If poured into cracks in wood, the wood should be sealed first to prevent bubbles.

Bubble free coating can be acheived by quickly passing a propane torch or a light mist of denatured alcohol.

Clear system for a transparent, thick casting.

Shelf life is 3 years for resin and 2 years for hardener when properly stored¹.

HANDLING PROPERTIES

Property	Standard	Units	72°F (22°C)
Peak Exotherm- 1 Inch Cube	-	°F (°C)	115 (46)
Time to Peak Temperature		Minutes	70
Peak Exotherm- 2 Inch Cube	-	°F (°C)	280 (138)
Time to Peak Temperature		Minutes	40
Viscosity Mixed	ASTM D2196	cP	2,000
Viscosity (resin)	ASTM D2196	cP	8,400
Viscosity (hardener)	ASTM D2196	cP	800

MIX RATIO

Method	Resin:Hardener	Resin:Hardener
Weight	1.20:1	100:83.0
Volume	1.00:1	100:100.0

DENSITY

State	Temperature	Units	72°F (22°C)
Cured	72°F (22°C)	lb/gal (g/cc)	9.2 (1.1)
Resin	72°F (22°C)	lb/gal (g/cc)	9.68 (1.16)
Hardener	72°F (22°C)	lb/gal (g/cc)	7.93 (0.95)

THERMAL PROPERTIES

Measurement	Units	
Ultimate Tg via DSC	°F (°C)	100 (38)

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ISO9001:2008 Certified

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¹ Store PRO-SET® Epoxy resins and hardeners at room temperature in sealed containers until shortly before use. As with many high-performance epoxy resins, repeated exposure to low temperatures during storage may cause the resin to crystallize. If this occurs, warm the resin to 125° F and stir to dissolve crystals. Hardeners may form carbamation when exposed to CO₂ and moisture in the atmosphere for extended periods of time. Prevent carbamation by protecting hardeners from exposure until immediately prior to processing.

