MTB-2103 Thick Pour Casting Epoxy

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MTBJZJ®

MTB-2103 Thick Pour Casting Epoxy

MTBJZJ® It is designed to be poured thick and works amazingly for filling and thick pours on very large voids in raw wood slab tops, such as river tables,side tables,coffee tables,benches,stools, consoles,shelves,omplements,lamps,lights,craftgiftsandsoon.

MTB-2013 Casting resin is unique because normal casting resin can only be poured in thickness of 1/8" per coat but MTB-2103 Casting resin can be poured up to 2"-4" thick depending on the size and mass of your project.

It is designed to be slow curing so heat will not be generated and "over cook" the epoxy.

You can use our metallic powder additives, glitter, mica, or base color tints to color and tint our MTB-2103. With a longer cure time which can cause the metallic powders to settle, look softer and more toned down.

We have got below color PIGMENTS for your otpions,
- •Liquid Epoxy Compatible Pigment Pastes
- •Pearl Metallic Pigment Powders
- •Translucent Tinting Pigments

Features

- •Non-toxic
- •100% Solid
- •VOc Free
- •Solvent Free
- •Crystal Clear
- •Epoxy Resin and hardener,mix ratio of 2:1
- •Thick Pour to 2"-4"

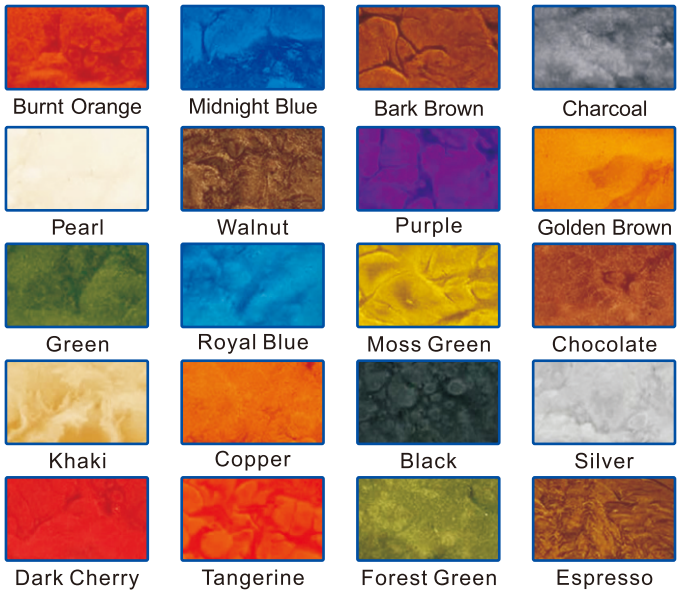
Technical Data Sheet

Item	Epoxy Resin(A)	Epoxy Hardener(B)
Appearance	Liquid	Liquid
Color	Transparent	Transpareny
Viscosity@25 C (mpa.s)	3000-3500	300-350
Mix Ratio	2:1	
Hardness (Shored)	82-85	
Solid Content	100%	
Operation Time	50-60mins@25 C	
Curing Time	12hrs@25 C， 8hrs@40 C	
Cured Time	48hrs@25 C	
Polished Time	48hrs@25 C	
Shelf Life	12 Months	
Package	1.5Gallons/unit,3gallons/unit, 15kgs/unit,accept OEM&ODM	

COVERAGE DATA

Item	Thickness	Covrage
1.5Gallons Kit	2"(50mm)	1.2 sq.ft
3Gallons Kit	4"(100mm)	1.2 sq.ft

SAMPLE COLOR CHART



A:B=2:1,1.5Gallons Kit

A:B=2:1,3Gallons Kit

A:B=2:1,15Kgs Kit

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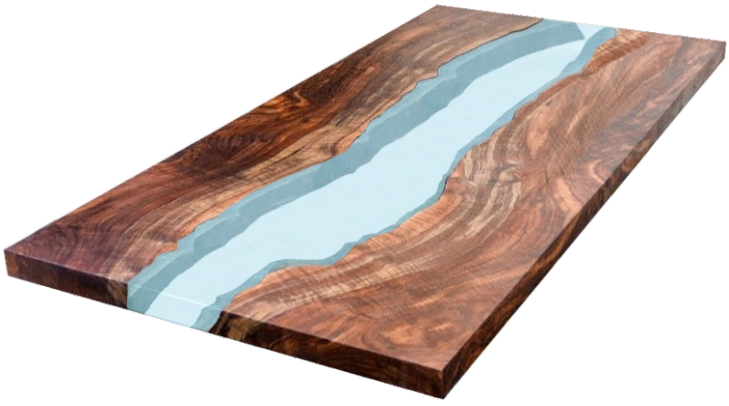
River Table & Bar Tops with MTB-2103

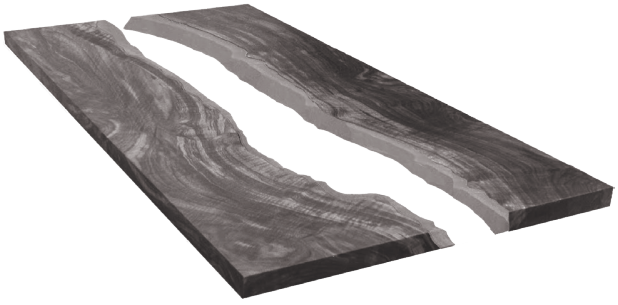
River table & bar tops with large resin filled voids have become very popular. Unfortunately, this type of project can be a little intimidating for those who have limited wood working, casting and epoxy coating knowledge or skills. The following information is offered as a guide only to help eliminate some of those concerns, simplify and speed up the process. We recommend using a combination of MTB-2103 Thick Pour Clear Casting Epoxy for filling cracks or voids, along with MTB-3309 High Gloss Finish as the final top coat. Read all instructions before proceeding and consider a test sample first to familiarize yourself with the process. If you have any questions, consider contacting us before starting.



INSTRUCTIONS:

1. IMPORTANT: Check the moisture content of each wood slab. To avoid warping and other moisture related issues, the moisture content of wood slabs should be 15% or less. If possible, use a moisture meter to check, or from the back of each slab drill small holes into the center of each wood piece. Use a ¼" or similar size bit and immediately after drilling inspect the wood shavings for moisture. It would be advisable to check several areas of each slab. If wood shavings are just slightly moist, you should be ok to proceed. If shavings are wet, it would be advisable to allow the slabs to continue to dry in a warm, but not hot environment and away from direct sunlight. Depending on the thickness and type of wood, slabs can take two or more years to completely dry.

2. **PREPARATION:** Once the slabs are sufficiently dry, plane, level and sand the slab pieces as necessary. Remove all loose bark or glue in place. If using an adhesive to attach the bark, allow it to completely dry or cure before proceeding.



3. SEALING: All edges must be sealed to stop bubbles from escaping while filling voids with resin. Most hard and soft woods absorb resin readily and expel air as they do. This can create chimney like bubbles in the resin and can be difficult if not impossible to stop. To prevent this situation from occurring, you must seal the wood surface. To do so, elevate wood pieces if necessary, mix a small batch of MTB-3309 per package instructions, and apply to all edges with a nylon dis-posable brush. Be gentle when applying so that the resin mixture does not become foamy with too much agitation. If it does, remove this material with a lint free cloth moistened lightly with Isopropyl alcohol and reapply. Once all edges are coated with *a thin layer (no build), just enough product to wet the surface,* allow the resin to set for 8 hours. Repeat this process until all edge surfaces have a slight glossy appearance. Flat or dull areas are an indication that these areas are not sealed and will require additional thin applications.

4. PREPARING VOID AREAS:

A. Heavy polypropylene tape such as Tuck tape can be used to seal off cracks or small voids.*Cured epoxy will not stick to it.*Apply to back of slabs, press firmly to remove trapped air pockets between tape and wood surface.

B. CONTAINMENT BOX: Large tops with voids may require additional steps such as a containment box made from products such as white melamine particleboard or similar material. Depending on the type of material used, a mold release, paste wax such as Trewax or heavy polypropylene tape such as Tuck tape must be applied to the melamine particleboard to prevent the resin from adhering to it. We recommend you test the mold release, paste wax or tape prior to filling voids with resin. In addition, we recommend you clamp slab pieces in place preventing them from shifting while filling areas in containment box.

C. CONTAINMENT PANEL: Per the illustration on the following page, use melamine particleboard or similar material to contain resin. Depending on the type of material used, a mold release, paste wax such as Trewax or heavy polypropylene tape such as Tuck tape must be applied to the melamine surface to prevent the resin from adhering to it. We recommend you test the mold release, paste wax or tape prior to filling void with resin. Once this is done, flip the slabs over face side down on level work surface and arrange. Apply a bead of silicone sealant along inside edges as shown in illustration on page 2. Press the particleboard down tight against the silicone sealant and secure with screws every 4 to 6 inches. Once the slab pieces are secured, flip the melamine particleboard/slab unit over, face side up. Tape or seal exposed ends, joints and seams to prevent leakage.

5. MEASURING VOIDS: These irregular shaped areas can be difficult to measure accurately. One method is to fill small voids with dried rice, then measure the rice used in a measuring container. Another method is to measure the length, width and depth of the void (approximate area). Example - 72" length x 8" width x 1.5" depth = 864 sq inches. Divide this number by 231 to convert the area to gallons. For example 864 sq inches / 231= 3.74 gallons.

6. Protect work surface and area with plastic drop sheet.

7. Place slab/panel on level work surface, elevate if necessary and level. Depending on your project piece, you may require clamps to hold pieces securely while filling voids with resin.

8. Clean the wood surface with a lint free cotton cloth moistened lightly with isopropyl alcohol. This will help to remove all fine dust and containments.

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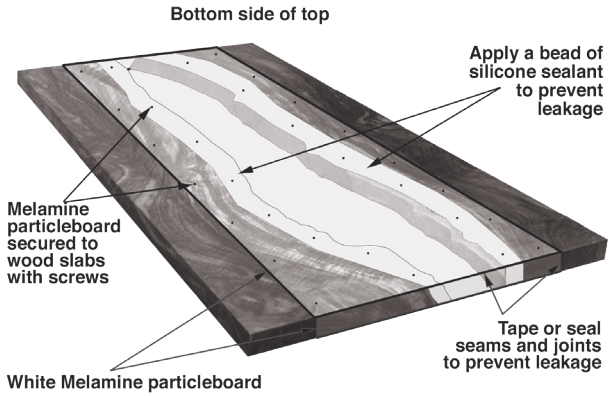
FILLING VOIDS WITH EASYCAST:

MTB-2103 performs best at 75° F / 25° C. Resin/hardener bottles should feel slightly warm to the touch, if they feel cool, they must be warmed by placing them in warm tap water (not hot) for 5 to 10 minutes prior to using. If bottles become overheated, allow them to cool before using. Never mix hot resin and hardener together! Mixing when cold will often result in cloudy casts contain-ing microscopic bubbles.



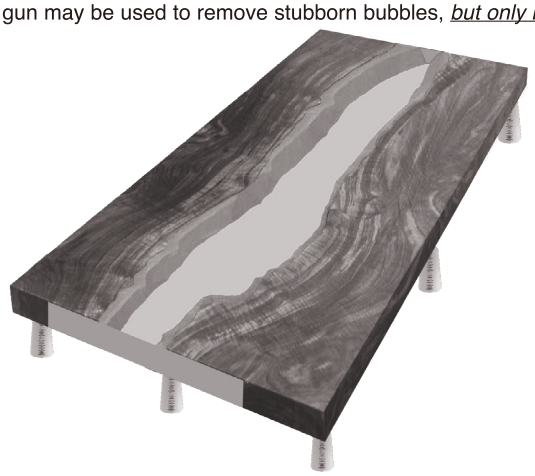
(pressed firmly onto bead of silicone sealant to remove trapped air)

IMPORTANT: *When using MTB-2103 fill voids in multiple layers with a maximum depth of 2-4" per layer. Allow each layer to cure for 8 hours (do not pour deeper as the resin/hardener mixture may overheat and discolor). If using MTB-3309 to fill voids, keep layers to 1" or less and lightly degas 30 to 40 minutes after pouring, but only if necessary, avoid overheating the resin/ hardener mixture, which may discolor.*

1. MEASURE: Carefully measure equal amounts of resin and hardener into a smooth sided, flat bottom, wax free measuring container. *Do not vary the 2to 1 ratio for any reason! Failure to measure equal amounts of resin and hardener will result in soft or sticky castings. Do not simply pour the contents of both bottles, which due to viscosity differences may not result in a 2 to 1 ratio, always measure! Due to rapid heat build up with large mixes, do not mix more than 3 gallon at a time.*

2. DOUBLE MIXING (REQUIRED): For MTB-2103 to chemically blend, it must be mixed together in two stages. *Warning: Never use an electric drill with a mixing attachment to mix this product. This type of mixing almost always results in an incomplete and cloudy mix.*With the resin and hardener measured together in one container, use a flat stir stick or paint paddle and mix contents for two full minutes. During mixing, use the stir stick/paint pad-dle to scrape the sides and bottom of your mixing container. Occasionally scrape the mixture from the stir stick/paint paddle back into the solution. After two to three full minutes of mixing, pour the contents from the first container into a second container, then using a new stir stick/paint paddle, mix the contents of the second container another minute, again scraping sides of container and stir stick. *Important, only pour from the second container, never from the rest. Optional: Add Epoxy Resin based Transparent Dye/Metallic Pigments /Glitters/to color mix, add only enough to achieve the desired color. Note, too much colorant can result in a slightly softer cure.* Once blended, immediately pour into voids, do not hesitate!

3. BUBBLES: MTB-2103 has been formulated to self-degas within a few minutes of pouring under most casting conditions. A propane torch or heat gun may be used to remove stubborn bubbles, *but only if necessary.* Don't be tempted to remove bubbles just for the sake of it. *For best results and clarity allow MTB-2103 to self-degas. Excessive degassing can overheat the resin/ hardener mixture, which may result in discoloration. In extreme cases, overheating will cause the resin/hardener mixture to gas up internally resulting in a cloudy, hazy effect.*



4. Allow the last layer of MTB-2103 to cure for 48 hours at 75 F / 25 C

5. REMOVING MELAMINE PARTICLEBOARD: Flip top over, remove screws, then insert a putty knife between particleboard and top. Carefully pry pieces apart.

6. SANDING: Where necessary, sand wood and cured resin with 120 grit sand paper to start with, followed by fine grit paper as required. After sanding, clean surface with a lint free cloth lightly moistened with isopropyl alcohol. *Note, sanding marks will normally disap-pear once coated with MTB-3309 High Gloss Epoxy Top Coating.*

7.FINAL COAT: Use MTB-3309 as your final surface coating and pay close attention to the package instructions. Seal all exposed wood surfaces per the MTB-3309 instruction sheet. MTB-3309 is a waterproof, chemical and heat resistant epoxy coating which will chemically bond to MTB-2103, resulting in a clear seamless and durable finish. One or more layers may be applied to create a deep, clear glass like finish.To prevent MTB-3309 drips along the outside bottom edge, you can apply vinyl or polypropylene tape 1/8" in from edge. Approximately one hour after the coating has been applied, carefully remove tape with drip accumulation. If necessary, wipe this edge with lint free cloth moistened lightly with isopropyl alco-hol. This will help to remove any residue or resin strands from removing tape. We recommend you wear rubber glove, as this process can be a little messy.

8. REMOVING DRIPS: While liquid, scrape drips from bottom edge or sand drips once fully cured *(72 hours).* If sanding, be careful to sand towards your project, *not away from.* Sanding outward may cause the coating to chip along the edge. With a soft lint free cotton cloth, moisten lightly with water, remove all sanding dust from surface.

9. ADDITIONAL PROTECTION: For added protection, you may want to consider an application of paste wax on the cured surface,This added step will help prevent fingerprints and smudges, as well as stop items from sticking to the new surface. Apply and buff per package instructions.