

GENERAL INSTRUCTIONS FOR CASTING RESINS

Preparation

1. Material should be stored and used in a warm environment (72 F – 23 C).
2. All liquid urethanes are moisture sensitive and will absorb atmospheric moisture. Keep lids on containers when not in use at all times. Replacing the lids on the containers after dispensing product will help prolong the shelf life of the unused product.
3. Wearing eye protection, latex gloves, and long sleeve garments minimize skin contact and is highly recommended.

Mixing and Pouring

1. Shake both A & B sides first before you start to dispense.
2. Pour Part A & B in equal amounts by volume into mixing container.
3. Stir, slowly and methodically, when mixing the A & B together. Be sure to scrape the sides and the bottom to get all materials mixing in a uniform fashion (to do this an ice cream stick works fine).
4. Be careful when mixing not to splash.
5. **REMEMBER** you only have 180 seconds from when you mix the A & B together before your resin blooms and then starts to harden.
6. For best results, pour the resin on a single spot at the lowest point of the containment field. The resin will seek its level and this should minimize air entrapment.
7. De-Mold time will depend on size of part. Typically, with your 180 second gel time, you can de-mold within 5 to 10 minutes (please note that very small, thin parts will take longer).
8. This material can readily accept pigments.

Real World Gel Times With MPK-70 Casting Resin (180 Sec Gel Time)

The following are typical real world gel times you will get with this product when cast in various room temperatures.

ROOM TEMP	Gel Time in seconds +/- 10 secs
60 F	220 plus seconds
75 F	180 seconds (ideal conditions)
85 F	140 seconds
95 F	110 seconds
100 F plus	90 or less

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