DEEP POUR 1

100% Solids, UV Resistant, Crystal-Clear Casting Epoxy

Technical Data Sheet

Description

The MAJESTIC DEEP POUR 1 is a two-component (3A:1B) epoxy system designed for casting applications providing a crystal-clear, UV resistant premium finish. It offers a quicker curing than the MAJESTIC DEEP POUR 2 for the same pour volume. The product is VOC-free, 100% solids and is virtually odor free. This product can be poured at thick levels (1 inch or more) while keeping a crystal-clear look. Thickness above 1 inch can be achieved depending on the total volume and the shape of the pour. It displays excellent air release and color retention capabilities. It also possesses superior mechanical properties.

Uses and Substrates

The MAJESTIC DEEP POUR 1 provides excellent results for the most demanding applications:

+ River tables
+ Wood crafting
+ Crystal clear encapsulation
+ Bonds to wood, metals, concrete, plastics, fiberglass, paint, granite, laminate (see Laminate/Formica Application section), Artwork, fabrics, etc.

Advantages

+ Excellent UV resistance
+ Crystal clear
+ Quicker curing than the MAJESTIC DEEP POUR 2 for the same pour volume
+ Ultra-low viscosity, very nice glossy finish
+ Environment and health friendly (100% solids, VOC-free and no solvent)
+ Food safe
+ Virtually odor free
+ Easy application with ultra-long pot life and working time
+ Ideal for casting, can also be used for small encapsulation applications
+ Good elongation and excellent abrasion resistance
+ High resistance to amine blush and contamination (fish eyes)
+ Excellent for letting out bubbles, even with thick layers
+ Impermeability / low moisture sensitivity
+ High density of the product prevents dirt penetration resulting in low maintenance post application

Application Data

Mix Ratio	3A : 1B
Packaging	1 US gallon kit
Color	Clear, Metallic Colors
Shelf Life	One year, in original unopened factory pails under normal storage conditions.
Application temp	20°C / 68°F
Cure Time	**20°C / 68°F and 30% Rel. Hum.**
Working Time	5 h
Tack Free (1 in.)	42 h
Tack Free (15 mils)	42 h

Technical Properties

Hardness ASTM D2240	80 Shore D
Solids Content	100%
DE 500 hr ASTM 3424	5
Viscosity	Clear 150 +/- 50 cps
VOC Content	0 g/l

Surface Preparation

Surface should be clean, dry and free of grease, oil, paint, curing agents or any contaminants that may inhibit proper adhesion. Ensure the surface is free of contaminants, and the pores are open to allow the product to penetrate. To open the pores of a substrate it must be sanded prior installation, except for encapsulation applications. When applying on non-conventional substrates, proper adhesion and compatibility tests must be performed.

If the product is applied over an existing epoxy flooring system that has been cured for a period longer than 24 hours, it should be sanded with proper equipment. A mechanical bound to a sanded surface is required and the pores of the existing coating must be opened for better adhesion. Vacuum dust and properly wipe the surface prior applying the MAJESTIC DEEP POUR 1. Conduct adhesion tests if there is a doubt about surface preparation.

Mixing

Mix three parts of A and one part of B together at low speed in a separate container. The mixing container must be clean and free of any outside particle.

When a low-speed drill is used, mix thoroughly for a minimum of three minutes, until a completely homogeneous mixture is obtained. The speed of the drill must not exceed 300-450 rpm to minimize the entrapment of air. It is recommended to activate the mixer in the reverse mode after the first 90 seconds for the liquid

to mix from the bottom of the mixing can to the top. Make sure to scrape sides and bottom of the mixing container so no unmixed material remains. Only mix the quantity of product required depending on the pot life and the working time required.

If the mixing is done by hand mixing needs to be done for 4-5 minutes. When you mix by hand, never mix more than 0,5 gallon at a time, ideally mix one quart at a time. Mixing quantities can be larger for experienced users. Mixing also needs to be completed until there is no more cloudiness in the mix. When pouring the material, never scrape the sides of the mixing container where there is unmixed material. Unmixed material will create soft spot on your work piece.

Curing Time

The curing time of this product will depend on thickness and the shape of the volume poured. Curing times can differ significantly depending on the quantity poured at once, the shape sought and ambient temperature. When poured in large volumes and shape, epoxy create exothermic reactions. It is imperative that amount of epoxy sought for each application does not exceed a certain point where the exothermic reaction gets out of control. If the exothermic reaction gets out of control, epoxy temperature can reach a level above its boiling point. An exothermic reaction can create unwanted events such as an uneven surface, an amber color or even smoke. It is recommended to apply the product when room temperature is stable (close to 20°C / 68°F).

Experienced users can also cool down the product with fans. On the other hand, when applied at very low temperature, the product might not cure properly.

Seal the Pores

We recommend using the MAJESTIC TOP FLOW or MAJESTIC PRO or MAJESTIC BONDING PRIMER to seal the pores of the substrate. Proper sealing is necessary to ensure that the next coat (the flood coat) will be free of bubbles. The primer coat can be applied with a brush. It needs to be applied in a thin coat. The flood coat can be applied when the primer coat (the coat used to seal the pores) is past its tack free point. If the primer coat has been applied more than 24 hours, it is recommended to sand the primer coat prior applying the flood coat.

Application

Air and substrate temperature should be close to 20°C / 68°F during the pour and throughout the curing process. Make sure the working area is dust free. Make sure to prepare a screen to protect the surface once your work is completed since dust, particle and other objects could fall in the epoxy prior to complete cure. It is recommended to use a torch or a heat gun to burst bubbles that are forming at the surface of the film. This process will also flatten the surface.

Recoats - Multiple Pours

For best adhesion between pours, wait until the prior pour is set but still tacky. The second pour will require sanding if the initial pour is tack free. The surface should be sanded/abraded until a uniform dullness is achieved. There should be no gloss on the prior coating after vacuuming and before applying the next coat. Dust must be wiped out prior applying the next coat.

Square Footage

To calculate the square footage that will cover 1 US Gallon (3.78L) of material depending on the thickness, divide the number 1604 by the thickness sought in mils. One mil equals 1/1000 of an inch. For instance, if the thickness sought is 1 inch, the calculation is 1604 divided by 1000 mils which equals to 1.6 square feet per gallon.

Clean Up

Denatured alcohol is best suited for cleaning. Excess material (A and B) should be mixed together and allowed to cure. Cured product may be disposed of without restriction. Uncured material should be stored in a suitable and sealed container and may be disposed in accordance with provincial / state/ federal regulations.

IMPORTANT Limitations

Cannot be used for exterior applications even under a shaded area. When exposed to sun and weather changes to product will yellow faster and the surface will turn whitish. The film will also loose its mechanical and chemical resistance properties if used outside. The curing time of this product will depend on thickness and overall volume poured. Curing times can differ significantly depending on the quantity poured at once and the shape of the volume poured. If the overall volume poured at once is too large, an exothermic reaction will occur. An exothermic reaction can create unwanted events such as an uneven surface, an amber color or even smoke. It is also recommended to apply the product when room temperature is stable (close to 20°C / 68°F). If room temperature is too high, the product will create an exothermic reaction. If applied at a temperature which is too low, the product might not cure properly. We strongly recommend performing tests prior using the product. Heating the product to prevent bubbling could also create an exothermic reaction. Requires a dry substrate. This product should not be applied to substrates that show high levels of moisture/humidity.

Labsurface stands behind the quality of its products. However, Labsurface cannot guarantee final results since Labsurface has no control over surface preparation, operating conditions and application procedures. Customers are solely responsible to test Labsurface's products to determine if they perform as expected.

In order to meet our strict requirements, we are continuously testing our coatings and on occasion, formulations may be modified to improve certain properties within each coating. Information and data included in this reference document may not be up to date as of the date of reference.

Contact Labsurface for further information regarding the limitations of this product.

Refer to the most recent Material Safety Data Sheet prior using this product.

Available Colors

Clear, Metallic Colors

Labsurface

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