

CLEAR CAST A

Hardener CLEAR CAST B - Clear epoxy coating system

- Clear very high-gloss topcoat and varnish
- New formula: no CMR, no VOC
- 21% biobased carbon on the resin part*
- Replaces the previous formulation (index 2)



Transparent depth. High-gloss protection. Up to 3 mm in a single coat.

* Ratio of the number of biobased carbon atoms to the total number of carbon atoms.

Technical data reproduced from the manufacturer's datasheet V3 dated 11.05.2026.

CLEAR CAST A / B

Application and mixing

Introduction

The new CLEAR CAST system replaces the previous formulation (index 2). The two systems are independent; their resins and hardeners are not interchangeable.

CLEAR CAST A / B is a clear epoxy coating system formulated to produce coatings on surfaces requiring a high-end finish for indoor exposure, such as floors, countertops and art pieces.

This system is particularly well suited to creating a sense of depth while ensuring long-lasting protection for the coated surface. Its thick consistency enables a single-coat finish in layers up to 3 mm thick.

On wood or other porous materials, it is recommended to work while temperatures are decreasing so that air is not released while CLEAR CAST A / B is curing. To avoid air release and entrapment on porous materials, apply a layer of 1010 / 1014 water-based epoxy primer.

For a longer operating time, the VLE A/B system is recommended.

Mixing ratio

The mixing ratio must be followed accurately. It must not be changed, as this would result in lower mechanical properties. The mixture must be thoroughly stirred to ensure full homogeneity.

System	CLEAR CAST A / B
Mixing ratio by weight	2 / 1
Mixing ratio by volume	2 / 1

Application

- Use the products at a temperature close to 18-25 °C to facilitate mixing and reinforcement impregnation.
- Lower temperatures increase mixture viscosity and gel time, although the resin will not crystallize at low temperatures.
- Higher temperatures reduce mixture viscosity and pot life.
- Apply CLEAR CAST A / B preferably by squeegee or brush. Sand, clean and degrease the substrate before applying the varnish.
- Average consumption is 1.1 kg/m² for a 1 mm thickness.
- To optimise the coating: prepare 400-500 g/m² of resin/hardener mixture for a single coat; first apply approximately 100 g/m² with a brush to wet the surface and prevent trapped microbubbles; immediately apply the remainder, cross-brushing to spread the film evenly; do not work the film for too long so that it can level itself.

CLEAR CAST A / B

Physical characteristics and reactivity

Biobased carbon content

References or mix	CLEAR CAST A	CLEAR CAST B	CLEAR CAST A / B
Biobased carbon mass content	21%	0%	13%

Ratio of the number of biobased carbon atoms to the total number of carbon atoms.

Physical characteristics

CLEAR CAST A	CLEAR CAST B	Mix
Opalescent liquid	Slightly yellow to colourless transparent liquid	Colourless opalescent liquid

Density at 23 °C	CLEAR CAST A	CLEAR CAST B
Component density	1.13	1.05
Mix density	-	1.10

ISO 1675, ±0.05 tolerance

Viscosity at 23 °C (mPa.s)	CLEAR CAST A	CLEAR CAST B
Component viscosity	1645	571
Mix viscosity	-	936

ISO 12058, ±15% tolerance

Reactivities

System	CLEAR CAST A / B
Gel time on 70 mL at 23 °C* (4 cm high)	1 h 40 min
Time at exothermic peak on 70 mL at 23 °C	1 h 07 min
Temperature at exothermic peak on 70 mL at 23 °C	57.9 °C
Gel time on 1 mm film at 23 °C**	3 h 55 min

CLEAR CAST A / B

Curing and post-curing

Reticulation and post-curing

In order to obtain the maximum thermo-mechanical properties, the recommended curing cycle must be respected. The table below shows Shore hardness and glass-transition temperatures according to the curing cycle.

System / cycle	Property	CLEAR CAST A / B
24 h at 23 °C	Shore hardness	82 A / 40 D
48 h at 23 °C	Shore hardness	62 D
7 d at 23 °C	Shore hardness	69 D
16 h at 60 °C	Shore hardness	76 D
16 h at 60 °C	Tg	39 °C
	Tg max	45 °C

Tg measured by DSC at 10 °C/min, inflexion point.
Shore D hardness measured at 23 °C according to ISO 868.

The post-curing cycles shown were selected to reach the maximum potential of the system. Depending on part size, oven performance and hardener used, shorter post-curing cycles may lead to fully cured parts.

Please contact the technical service for assistance with post-curing cycles.

CLEAR CAST A / B

Health and safety

Health and safety

Safety Data Sheets are available for all hazardous products. Ensure that the correct SDS is available before use. The information below corresponds to CLEAR CAST A SDS version 4.x and CLEAR CAST B SDS version 2.x.

1 Resin part



Signal word: Warning

Hazard statements:

H315 - Causes skin irritation.
H317 - May cause an allergic skin reaction.
H319 - Causes serious eye irritation.
H411 - Toxic to aquatic life with long lasting effects.

Precautionary statements:

P102 - Keep out of reach of children.
P202 - Do not handle until all safety precautions have been read and understood.
P280 - Wear protective gloves/protective clothing/eye protection/face protection.
P301+P310 - IF SWALLOWED: Immediately call a POISON CENTER or doctor/physician.
P303+P361+P353 - IF ON SKIN (or hair): Remove contaminated clothing. Rinse skin with water/shower.
P305+P351+P338 - IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses if easy to do. Continue rinsing.
P405 - Store locked up.
P501 - Dispose of contents/container in accordance with applicable regulation.
EUH205 - Contains epoxy constituents. May produce an allergic reaction.

2 Hardener part



Signal word: Warning

Hazard statements:

H302+H332 - Harmful if swallowed or if inhaled.
H314 - Causes severe skin burns and eye damage.
H317 - May cause an allergic skin reaction.
H318 - Causes serious eye damage.
H412 - Harmful to aquatic life with long lasting effects.

Precautionary statements:

P102 - Keep out of reach of children.
P202 - Do not handle until all safety precautions have been read and understood.
P271 - Use only outdoors or in a well-ventilated area.
P273 - Avoid release to the environment.
P280 - Wear protective gloves/protective clothing/eye protection/face protection.
P301+P330+P331 - IF SWALLOWED: rinse mouth. Do NOT induce vomiting.
P304+P340 - IF INHALED: Remove victim to fresh air and keep at rest in a comfortable position.
P303+P361+P353 - IF ON SKIN (or hair): Remove contaminated clothing. Rinse skin with water/shower.
P305+P351+P338 - IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses if easy to do. Continue rinsing.
P405 - Store locked up.
P501 - Dispose of contents/container in accordance with applicable regulation.

CLEAR CAST A / B

Packaging, transport and storage

Packaging

- Plastic jerrycan kit of 1 kg + 0.5 kg
- Plastic jerrycan kit of 4 kg + 2 kg
- Plastic drum kit of 30 kg + 15 kg
- Drum kit of 200 kg + 4 x 25 kg
- IBC kit of 1000 kg + 500 kg

Transport and storage

Keep containers sealed and away from heat and cold, preferably between 10 °C and 30 °C in a well-ventilated area. Products are guaranteed in their original packaging; check the expiry date on the label.



The data in this document are reproduced from the manufacturer's tests and are believed to be accurate. Resinas Castro S.L. accepts no responsibility for misuse of the product; users must verify suitability for their application.



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