



MACH 1

TECHNICAL DATA SHEET

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DESCRIPTION:

MACH 1 Epoxy is a 100% solids, self-leveling, primer-less, odorless, water-clear coating often used for tables, bar tops, artworks, & countertops. MACH 1 Epoxy can be used anywhere a hard, durable, crystal clear coating is required. Mach 1 Epoxy will cure to a clear, glass-like finish. Mach 1 Epoxy has been enhanced with a UV absorber and a HALS (hindered amine light stabilizer) to help lessen the effects of UV light to protect against loss of gloss, cracking, and chalking and to reduce yellowing.

ADVANTAGES:

Ideal 1:1 Mix Ratio
Extremely Tough Surface
High Gloss
Blush Resistant
Excellent Adhesion to Wood

APPLICATION GUIDELINES:

This product is usually applied in two stages (see Application Section). Maximum pour depth is 1/8". You must follow the instructed mixing ratios. Failure to do so will result in weak spots and partial curing. For best results, the material should be used at temperatures from 70°-80°F. Work areas should be clean and free from any dust or insects.

HANDLING & PHYSICAL PROPERTIES:

RESIN VISCOSITY, cP or mPa.s	11,000-15,000	ASTM 2196
RESIN DENSITY	9.6-9.8	ASTM D 792
HARDENER VISCOSITY, cP or mPa.s	500-750	ASTM 2196
HARDENER DENSITY	7.9-8.1	ASTM D 792
MIX RATIO (A/B), pbv (pbw)	1/1 (100/83)	
COLOR	Clear	
MIXED VISCOSITY, cP or mPa.s	2,700	ASTM D 2196
WORKING TIME, minutes	20	
GEL TIME, minutes (100 grams)	36	ASTM D 2471
SURFACE DRY (hours)	6-9	
THRU-CURED (hours)	10-14	
HARDNESS, Shore D	81	ASTM D 2240





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PRODUCT NAME

SURFACE PREPARATION:

In order to achieve superior adhesion, the substrate must be clean and free of all loose and foreign material. All oils, grease, waxes, or other contaminants must be removed before coating.

MIXING:

The storage temperature of MACH 1 Epoxy will significantly affect the ease of mixing, application, and curing time. For best results, MACH 1 Epoxy should be stored at 70-80 °F for at least 24 hours before use. Mix 1 part A (resin) to 1 part B (hardener) using a spatula or stir stick until uniform. Be sure to scrape the sides of the mixing container while mixing (any unmixed or partially mixed material will cause wet spots on the finished surface). DO NOT mix more material than can be used within the stated working time. REMEMBER - you will have less working time at higher temperatures.

APPLICATION INSTRUCTIONS:

MACH 1 Epoxy is generally applied with a foam brush/roller or squeegee and is typically applied in two stages. During the first stage, a thin layer of material is used to seal your substrate and prevent any bubbles from forming in future "flood coats." The second stage requires thicker "flood coats,"; generally applied at 1/8" thickness. The number of "flood coats" needed will depend on your specific application. However, one to three is typical. Additional coats can be applied as soon as the current layer has "tacked up." If your previous layer has fully cured, a very light sanding with a fine grit sandpaper, followed by a solvent wipe with isopropyl alcohol or acetone, is necessary before applying your next layer. A heat gun or torch should be used after the pour is complete and your material is still liquid. This will pop any remaining bubbles. If a torch is used, be sure the flame never comes into direct contact with the epoxy. Smooth strokes 6-12 inches above the material are all that is required.

SAFETY PRECAUTIONS:

Mix and pour in a well-ventilated area. Avoid contact with skin and eyes. If contact does occur, wash skin with soap and water and seek medical help. Read and understand all CAUTIONS on container labels and safety data sheets before using this material. Avoid breathing of vapors. Forced local exhaust is recommended to effectively minimize exposure. NIOSH approved, organic vapor respirators and forced exhaust are recommended in confined areas, or when conditions (such as heated polymers, sanding) may cause high vapor concentrations. **DO NOT WELD ON, BURN OR TORCH ON OR NEAR, ANY EPOXY MATERIAL. HAZARDOUS VAPOR IS RELEASED WHEN AN EPOXY IS BURNED.**

WARRANTY AND DISCLAIMER:

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