



11720 Main Street
Fredericksburg, Virginia 22408
540.940.6698
info@squeezeyourtrigger.com
www.squeezeyourtrigger.com

TECHNICAL DATA SHEET

MACH 5

DESCRIPTION:

MACH 5 is a 100% solids, self-leveling, primer-less, odorless, water-clear coating often used for seal coats, artworks, and other projects that require multiple layers in a short amount of time. MACH 5 Epoxy can be used anywhere a hard, durable, crystal clear coating is needed. MACH 5 Epoxy will cure to a clear, glass-like finish. MACH 5 Epoxy has been enhanced with a UV absorber and a HALS (hindered amine light stabilizer) to help lessen the effects of UV light, protect against loss of gloss, cracking, and chalking, and reduce yellowing.

ADVANTAGES:

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

APPLICATION GUIDELINES:

MACH 5 is usually applied in multiple stages (see Application Section). Maximum pour depth is 1/8". You must not vary or deviate from the instructed mixing ratios. Failure to follow the proper mixing ratios will result in weak spots or 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/insects.

HANDLING & PHYSICAL PROPERTIES:

RESIN VISCOSITY, cP or mPa.s	13,500	ASTM 2196
RESIN DENSITY	9.7	ASTM D 1475
HARDENER VISCOSITY, cP or mPa.s	1,805	ASTM 2196
HARDENER DENSITY	8.1	ASTM D 1475
MIX RATIO (A/B), pbv (pbw)	1/1 (1.2/1)	
COLOR	Clear	
MIXED VISCOSITY, cP or mPa.s	3,360	ASTM D 2196
WORKING TIME, minutes	7	
GEL TIME, minutes (100 grams) @ 77°F	14	ASTM D 2471
ACCEPTING OF ADDITIONAL LAYERS, hours	1	
THRU-CURED (hours)	10-14	
HARDNESS, Shore D	82 D	ASTM D 2240





TECHNICAL DATA SHEET

MACH 5

11720 Main Street
Fredericksburg, Virginia 22408
540.940.6698
info@squeezeyourtrigger.com
www.squeezeyourtrigger.com

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. Use conventional surface preparation methods for hard-to-bond substrates (e.g., PE, PP, etc.).

MIXING:

The storage temperature of MACH 5 will significantly affect the ease of mixing, application and curing time. For best results, MACH 5 Epoxy should be stored at 60-80 °F for at least 24 hours before use. Before blending Resin and Hardener, stirring may be necessary, especially in the case of filling materials. 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. For room temperature cure systems, once the Resin and Hardener are mixed, an exothermic reaction occurs, developing some heat that accelerates the curing process. The viscosity of such a self-heating system first decreases and then increases at the end of the GEL TIME until the material gels. At this moment, the temperature of the product keeps rising, and in the case of large batches can result in overheating with unpleasant fumes and smoke.

APPLICATION INSTRUCTIONS:

MACH 5 is generally applied with a foam brush/roller or squeegee and is typically applied in stages. In the first stage, apply a thin layer of material to seal your substrate and prevent air bubbles from forming in future pouring coats. The second stage requires thicker "flood coats," which are each applied at 1/8". The number of flood coats needed will depend on your specific application, but one to three is typical. Subsequent 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 (isopropyl alcohol or acetone), is necessary before applying any subsequent layer. A heat gun or torch may be applied after your pour is complete and the material is still liquid if bubbles are present. If a torch is used, ensure the flame never comes in direct contact with the epoxy. Use smooth strokes 6-12 inches above the material.

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

BallistiX Coatings & Sealers gives no warranty, express or implied, and all products are sold upon condition that purchasers will make their own tests to determine the quality and suitability of the product. BallistiX Coatings & Sealers shall be in no way responsible for the proper use and service of the product. The information given in this publication is considered to be accurate and reliable and is provided as a service only. Physical properties shown are typical. Actual properties are dependent on curing conditions and degree of cure. Any information or suggestions given are without warranty of any kind and purchasers are solely responsible for any loss arising from the use of such information or suggestions. No information or suggestions given by us shall be deemed to be a recommendation to use any product in conflict with any existing patent rights.

