

PRODUCT DESCRIPTION

MPC-195 is a 100% solids, two component epoxy casting system. It is ideal for deep pour casting (2.5 inches maximum) for river tables, jewelry and embedding applications. Its long work time and low mixed viscosity helps avoid excess air entrapment and allows for excellent flow in tight crevices and around complex shapes. **MPC-195** exhibits superior UV stability and high film hardness compared to other epoxy casting products. It contains no VOC and when mixed/cured properly meets the requirements for direct food contact by the Canadian Food Inspection Agency.



AREAS OF APPLICATION

Casting river tables / Embedding and encapsulation / Casting jewelry and arts/crafts.



ENVIRONMENTAL APPROVALS/ CERTIFICATES

- Meets CFIA and USDA requirements for direct food contact / use in food plants.
- Conforms with LEEDv4 EQ credit: Low emitting materials SCAQMD Method 304-91 for architectural coatings.
- VOC content <100 g/L

PACKAGING AND RECOMMENDED THICKNESS

MPC-195 is offered in the following kit sizes:
 3-gallon kit 7.57 L resin (A) and 3.78 L hardener (B)
 Different packaging options are available open request.

Available in clear.
 Color pigment packs are offered in 16 oz jars (2 jars / 3-gallon kit)

Recommended Film Thickness / Coverage
 2.5" thickness (2500 mils) / 2 sq. ft. / per 3-gallon kit

PRODUCT PROPERTIES

Mix Ratio:	2 part resin A / 1 part hardener B by vol.		
Viscosity:	Resin 1400-1600 cps.		
ASTM D445-06	Hardener 100-200 cps.		
Solids by wt.:	100%		
Shelf Life:	1 year when stored in original, unopened packaging. Store dry at temperatures between 15°C to 30°C (59 °F to 86 °F).		
Working time on substrate:	60 minutes 21°C / 70°F @50% relative humidity		
Curing Schedule	10°C (50°F)	20°C (68°F)	30°C (86°F)
Dry to Touch	~96 hrs.	72 – 96 hrs.	~72 hrs.
Full Chemical Cure	~10 days	~7 days	~5 days
Product Application:	Pour mixed material into mold. Wait 15-20 minutes then lightly pass a propane torch over the surface at a 45-degree angle to help release any latent air bubbles. Clean equipment with appropriate solvent. Once the product has hardened, it may only be removed mechanically.		

Curing times are subject to variations determined by the ambient conditions, including air and substrate temperature, as well as relative humidity. It is imperative to shield the coating from moisture, condensation, and direct water exposure during the initial 24-hour curing period. If the recommended recoating time has exceeded 48 hours, it becomes necessary to sand the prior coat using a screed mesh to eliminate any glossy finish. Moreover, thorough cleaning by vacuuming is essential to eradicate any dust particles. The surface should exhibit a consistent matte appearance, entirely devoid of any gloss, following the cleanup process, before proceeding to apply the next coat.

SURFACE PREPARATION

Remove dust, dirt, grease, oil, and all other contaminants with proper cleaner/degreaser. All cracks, holes and irregularities must be repaired with a crack filler prior to applying the coating. A seal coat is recommended on very porous material to help prevent air bubble release during the curing process.

MIXING INSTRUCTIONS

Empty container B (hardener) and container A (resin) into a large mixing pail. Mechanically mix the combined product for a maximum of 1 minute using a low-speed drill (300-450rpm) to reduce air entrapment and to obtain a homogeneous mixture. Once the product is mixed proceed to application instructions. **Do not let the product sit in container as it will rapidly start to react and cure.**



TECHNICAL PROPERTIES

Compressive Strength, ASTM D695	11,900 psi
Hardness, Shore D ASTM D2240	80-85
VOC, ASTM D2369	0 g/L
GLOSS, ASTM D523	92.8 GU @ 60°

PRODUCT RESTRICTIONS

- Not recommended for application at temperatures below 10°C / 50°F or above 30°C / 86°F. An application below/above these temperatures will result in decreased product workability and cure times.
- Ambient humidity of the surroundings should not exceed 85% during application and during curing process.
- The substrate temperature must be at least 3°C (5.5°F) above measured dew point.
- Humidity content of substrate must be < 4% at time of application.
- Do not apply on porous surfaces where a transfer of humidity may occur during the application.
- Freshly applied product must be protected against moisture, condensation, and water for at least 48 hours.
- When properly mixed and cured, this epoxy system is safe for direct food contact. However, because the customer is responsible for mixing/pouring, each application would have to be assessed individually to say if it is 100% food safe.

DISCLAIMER AND WARRANTY

MPC warrants that our products are free from manufacture defects in accordance with our quality control procedures. Any products proven defective are limited to the replacement of defective products or refund of the purchase price as determined by MPC. Please contact your local MPC sales representative for more information and warranty requirements.

The information and recommendations contained in this technical data sheet are based on reliable test results according to MPC. The data mentioned are specific to the material indicated. If used in combination with other materials, the results may be different. It is the responsibility of the user to validate the information therein and to test the product before using it. MPC assumes no legal responsibility for the results obtained in such cases. MPC assumes no legal responsibility for any direct, indirect, consequential, economic or any other damages except to replace the product or to reimbursement the purchase price, as set out in the purchase contract.