

# EasyCast® – Clear Casting Epoxy

## WHAT IS EASYCAST®?

EasyCast® is a reactive clear casting epoxy. It's solvent free and low odor. It can easily be colored, tinted or combined with fillers to create faux granite or metallic castings. These characteristics make it ideal for casting and embedding up to 6 ounces (maximum) per pour. Due to heat build up and discoloration, do not attempt to cast more than 6 ounces at one time. For larger casts, use Castin'Craft® Polyester Casting Resin.

## TOOLS NEEDED:

1. Plastic measure / mixing cups (do not use wax coated cups as the wax may break off and contaminate your mix).
2. Wood stir sticks
3. Disposable craft brushes
4. Wax paper or plastic sheet to protect work surface.

## MOLDS:

Polypropylene or polyethylene resin molds are designed for use with Polyester Casting Resin or Clear Casting Epoxy due to their self releasing characteristics. Rubber molds made from latex, urethane or silicone can be used if treated with Castin'Craft® Mold Release / Conditioner. **WARNING:** Due to the strong bonding properties of EasyCast®, only use plastic molds designed for resin casting. Other molds such as candy, soap or candle molds are generally not useable even with a good mold release. If you're not sure, test a spot on the mold, such as the back side.

## MOLD PREPARATION:

1. Determining mold capacity: Occasionally plastic molds state the size of the mold cavity. However rubber (latex, urethane and silicone) molds generally do not. To determine the amount of material required, fill mold first with water, then carefully pour this water into a measuring cup. **CAUTION:** Some rubber molds may absorb water. This water can cause a cloudy or milky appearance in your finished piece. Make sure your molds are thoroughly dry before using.
2. Prepare all molds with Castin'Craft® Mold Release/Conditioner per package instructions. Rubber molds require two applications. If two applications are not applied, you may not be able to remove your cast pieces once cured.

## WORK AREA AND SURFACE:

1. For best results, your work area and surface should be between 70° F / 21° C and 85° F / 29° C.
2. Work surface should be dry, level and free of dirt or dust.
3. Protect work area with a plastic drop sheet, wax or newspaper.

## INSTRUCTIONS:

EasyCast® was designed for a maximum single cast of 6 ounces or less. Due to heat build up and discoloration, do not attempt to cast more than 6 ounces at one time. For larger casts, use Castin'Craft® Polyester Casting Resin.

**1. IMPORTANT:** EasyCast® performs best at 75° F / 24° C. EasyCast® bottles should feel slightly warm to the touch, if they feel cool, they must be warmed by placing them in warm tap water (not hot) for 5 to 10 minutes prior to using. If bottles become overheated, allow them to cool before using. Never mix hot resin and hardener together! Mixing EasyCast® when cold will result in cloudy casts with microscopic bubbles.

**EXACTLY  
1 part Resin.**



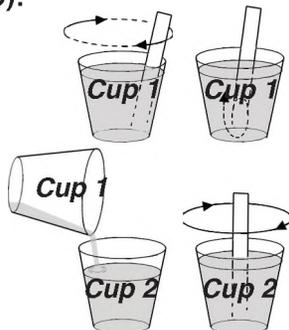
**Then add to that  
EXACTLY 1 part  
Hardener by  
volume (not weight).**



**2. MEASURE:** Carefully measure equal amounts of resin and hardener into a straight sided, flat bottom, wax free measuring container. **WARNING:** Do not vary the 1 to 1 ratio for any reason! Failure to measure equal amounts of resin and hardener will result in soft or sticky castings. Do not simply pour the contents of both bottles and expect to get properly measured amounts, always measure!

## 3. DOUBLE MIXING (REQUIRED):

For EasyCast® to chemically blend, it must be mixed together in two stages. With the resin and hardener measured, use a stir stick and mix together for two full minutes. During mixing, use the stir stick to scrape the sides and bottom of your mixing container. Occasionally scrape the mixture from your stir stick back into the solution. After two full minutes of mixing, pour the contents from the first container into a second container. Using a new stir stick, mix the contents of this second container another minute, again scraping sides of container and stir stick. Pour immediately from this second container.



**4. BUBBLES:** EasyCast® has been formulated to self-degas within a few minutes of pouring under most casting conditions. However adding fillers such as granite or metallic powders can result in a cloudy, bubble filled mixture. These bubbles will slowly rise to the surface of your cast. If needed use a hair dryer and pass heated air quickly over the EasyCast® surface to remove bubbles. Be careful, excess heat can melt or warp plastic molds.

**5. CURE:** For best results, cast pieces should cure at temperatures between 70° F / 21° C and 85° F / 29° C. Curing time will vary depending on room temperature and thickness of cast. Thin castings will take longer than thick castings. Normal cure for castings 1" thick is 24 hours for soft cure, 72 hours for hard cure.

**6. DE-MOLDING:** Rigid type plastic molds can usually be twisted slightly to break the cast pieces free. Pushing in from the back side of the mold will also help. Note: Do not attempt to de-mold pieces that have not cured for a minimum of 24 hours. You may damage your casting by doing so.

**7. TRIM & SAND EDGES:** Edges can be trimmed with a knife or sanded if needed. Use 150 grit or finer sandpaper to remove excess material. A file, sander or Dremel tool can be used for shaping and carving completely cured castings.

**8. CLEAN UP:** While liquid, the material can be cleaned from tools with alcohol or solvent. Use warm water and liquid soap to clean from skin. **NEVER USE SOLVENTS OR ALCOHOL TO CLEAN EASYCAST® FROM YOUR SKIN.**

## TECHNIQUES:

**FAUX MARBLE:** Faux marble is easily created with the addition of 3 or more contrasting colors of Castin'Craft® Opaque Pigments. Experimenting with the following process will enable you to perfect color combinations and marbling techniques. Some color combinations to consider are:  
Green Marble, use green, white & touch of black.  
White Marble, use white with a touch of black.  
Brown Marble, use brown, white and a touch of black.  
Pink Marble, use pink (red blended with white), white and a touch of grey (white blended with black).

1. Mix EasyCast® per package instructions.
2. Divide mixed EasyCast® into three containers.
3. Add a single color to each container and blend. **NOTE:** Add just enough pigment to color mix and no more!
4. Pour all three colored mixes into one container. Stir lightly once or twice to swirl colors together, then immediately pour into mold. **TIP:** Avoid over mixing which can muddy colors.

## TRANSLUCENT GLASS EFFECT:

Use Castin'Craft® Transparent Dyes.

1. Mix EasyCast® per package instructions.
2. Add transparent dye to mixed EasyCast®, approximately one drop of dye per ounce of EASYCAST®. Less or more can be used for varying shades. Dye colors can be blended to create additional colors.
3. Blend, then immediately pour into mold.

## FAUX METAL:

Use metallic powder available at most craft and art stores.

1. Mix EasyCast® per package instructions.
2. Add metallic powder to mixed EasyCast®, approximately 1/4 teaspoon per 8 ounces. Less or more can be used for varying effects.
3. Mix well to ensure all powder is blended, then immediately pour into mold.

## CASTING EMBEDMENTS:

Photos, prints, fabric, etc., must be presealed with two coats of white craft glue (ULTRA-SEAL®) to prevent pieces from turning transparent. Delicate items such as dried flowers should be sealed with two coats of a fast drying acrylic spray (EnviroTex® Spray Sealer). Wood pieces can be sealed with EasyCast® or white craft glue, however this must be done and cured before embedding to prevent air from escaping from the wood piece, which will in turn create bubbles in your casting. Solid non porous objects such as seashells, coins, stone, plastic, etc., do not require a seal coat. If you're not sure, test a sample piece first.

## POLISHING & BUFFING:

Occasionally some EasyCast® pieces may require cut polishing to remove imperfections, sanding marks or to change the surface to a semi-gloss or matte finish. **NOTE:** EasyCast® when polished will not develop a high gloss or wet look as per the original surface. For a high gloss surface, consider recoating the cast piece with EasyCast® or EnviroTex Lite®.

1. Hand Polishing: Use Rottenstone rubbing compound for a semi-gloss finish or Pumice rubbing compound for a matte finish. Follow the package instructions for applying with water. Both items can be purchased from your local paint or hardware store.
2. Buffing: Cast pieces can be buffed on a buffing wheel using abrasives for plastics. Contact your local supplier of buffing equipment and buffing compounds for details on buffing plastics.

# TROUBLE SHOOTING:

**Soft & Sticky Castings:** Is a result of improper mixing or inaccurate measurements of resin and hardener. These soft or sticky castings will unfortunately have to be disposed of. Prevention: Do not guess at the proper ratio or just empty the two bottles into your mixing container. Use a proper measuring device and measure equal portions of resin and hardener. Always double mix as per the instructions. Note: Inadequate measuring and mixing is the most common reason for imperfect results.

**Tiny Bubbles / Cloudy Clear Castings:** This is a result of mixing cold EasyCast®. Prevention: Warm EasyCast® as stated in the instructions prior to using.

**EasyCast® set before completely poured:** This is the result of mixed EasyCast® left setting in a mixing container too long after mixing. Prevention: Always pour EasyCast® immediately once mixed.

**Cloudy Resin:** Due to the purity of EasyCast® resin, a clouding or settling of the resin may occur from storing in cold conditions. This is a normal process and does not affect the outcome of this product. Should this occur, simply set the resin container in hot tap water until clear. Allow to cool before using. Prevention: Store in warm area and off of cold floors.

## COMPATIBILITY ISSUES:

EasyCast® casting epoxy can be safely applied to cured polyester casting resin. CAUTION: Do not attempt to pour polyester casting resin over EasyCast®. Polyester casting resin will attack and soften EasyCast®.

## CASTIN'CRAFT® CASTING PRODUCTS INCLUDE:

- Opaque Pigments - Red, Yellow, Green, Blue, Brown, Black, White & Pearlescent.
- Transparent Dyes - Red, Yellow, Green, Blue & Amber.
- Mold Builder® latex rubber for making your own molds.
- Mixing Cup Set (includes 6 - 10 oz. plastic graduated measure mixing cups, 6 stir sticks and 3 craft brushes).
- Polyester Clear Casting Resin.
- Mold Release / Conditioner.
- EasyMold® Silicone Putty.
- EasyMold® Silicone Rubber.

## OTHER ETI PRODUCTS TO LOOK FOR:

- Envirotex Jewelry Resin®
- Envirotex Jewelry Clay®
- Ultra-Seal® Multi-purpose Sealer Glue.

## Health and Safety Information

**WARNING: MAY PRODUCE ALLERGIC REACTION BY SKIN CONTACT. MAY CAUSE SKIN IRRITATION. EXPOSURE MAY CAUSE SKIN DAMAGE. MAY BE HARMFUL IF SWALLOWED. CAUSES SEVERE EYE AND SKIN IRRITATION. MAY PRODUCE ALLERGIC REACTION BY SKIN CONTACT.**

**PRECAUTIONS: Avoid inhalation, ingestion, eye and skin contact. Wear protective gloves and goggles. Use window exhaust fan or other suitable equipment for a well ventilated work area. Keep container tightly closed when not in use.**

**KEEP OUT OF THE REACH OF CHILDREN.**

**Hardener contains: Isophorone diamine. Resin contains: Bisphenol A/ epichlorohydrin resin and aliphatic and aromatic glycidyl ethers.**

**Contact a poison control center for more health information.**  
**FIRST AID: ORAL: If resin is swallowed, induce vomiting. If hardener is swallowed, do not induce vomiting. CALL PHYSICIAN IMMEDIATELY!**  
**EYES: Severe irritant to eyes. In case of eye contact, flush thoroughly with water for 15 minutes and get prompt medical attention. SKIN: Wash immediately with soap and rinse thoroughly with water. Do not use solvents or alcohol to remove product from skin. INHALATION: Move to fresh air. If not breathing, administer CPR, If breathing is difficult, get medical attention.**

**For a POISON EMERGENCY call: 1-800-222-1222**

## WARRANTY:

The recommendations given here serve only as a guide. Because of variables of temperature, humidity, types of molds, colorants and embedments, we cannot guarantee results. Our liability is limited to the replacement price of the product

**Conforms to ASTM D-4236**



**PROJECT IDEAS:** For the latest in project ideas and techniques, visit our web site: <http://eti-usa.com> or our blog site at <http://resincrafts.blogspot.com/>



**Made in USA**



South Bay Depot Rd, Fields Landing, CA. 95537  
(707) 443-9323 [www.eti-usa.com](http://www.eti-usa.com) [mail@eti-usa.com](mailto:mail@eti-usa.com)

330000000 ES USA