

# TAP Plastics CLEAR-LITE Casting Resin

TAP Clear-Lite Casting Resin is a water-clear polyester resin which cures with the addition of MEKP Catalyst. This resin remains tacky where it is exposed to air and to some kinds of flexible molds. Castin' Craft Resin Spray can be used to treat tackiness. See Product Bulletin 4, "How to use Clear-Lite Casting Resin" for more information, especially if you are using a flexible mold. Every casting is different and requires experimentation for best results.

## Instructions to mix resin • Single Layer Casting: Read CAUTIONS (see below) and Instructions before starting project.

When catalyst is added to resin a chemical reaction begins, creating heat which cures (hardens) the resin. Measure resin into a graduated UNWAXED mixing cup and add the appropriate amount of catalyst (see chart below). DO NOT add excessive catalyst, it may cause casting to fracture due to overheating. MIX THOROUGHLY for approximately 60 seconds, scraping sides and bottom of mixing container. Pour into mold and allow to harden completely before removing. Curing (hardening) time depends upon amount of catalyst used, thickness of the casting, room and resin temperature, humidity, and amount of color added. DO NOT RETURN CATALYZED RESIN TO CAN. Keep can tightly capped when not in use. Castings over 1/2" thick can generate excessive heat. Experiment first with reduced catalyst to prevent cracking and over heating

**Multiple Layer Casting or Embedding:** Casting embeddings can be a fun and exciting hobby; however, it does require a certain level of skill that develops with experience. Do NOT embed any item that cannot be replaced until you have perfected the casting-embedding technique. Embedding objects in plastic resin involves making a casting of 2 or more layers with embeddings between layers. Generally, you work in reverse when embedding objects. Pour first layer of catalyzed resin into mold (which becomes the top or face of casting). Allow to gel until firm enough to support the embeddings (20-30 minutes). Catalyze second batch of resin and stir. To minimize trapping air, dip embeddings into the catalyzed resin; set in place face down on the first gelled layer. Pour balance of catalyzed resin over embeddings. If embeddings are not yet covered or if you want a colored background, pour a third clear or colored layer after the second layer has gelled. Embedments can be placed in several levels to create a floating appearance. After final layer has been poured, allow casting to harden completely before removing from the mold. After cure spray back of casting with Castin' Craft Resin Spray for a hard, tack-free surface cure. Casting Resin may also be used with fiberglass reinforcements to make decorative panels, place mats, etc. STORE IN A COOL PLACE. Castings over 1/2" thick generate an excessive heat. Experiment first with reduced catalyst to prevent cracking to over heating.

## CATALYST CHART

### Single Layer Casting

Layer Thickness	Drops of Catalyst Per Oz of Resin
1/8"	15
1/4"	8
1/2"	6
3/4"	5
1"-1 1/2"	4

### Multiple Layer Casting

Layer	Drops of Catalyst Per Oz of Resin
1st	5
2nd	4
3rd	3
4th	2
5th+	2

### Proportions are based on room and resin

temperature of 70°F. Because of variables in temperature, humidity, size, type of molds, and embeddings, we cannot guarantee results.

Experiment and develop ratio best suited for your project. 3-dimensional molds will vary greatly in amount of catalyst required depending on total volume being poured and depth of pour.

**WARNING:** Flammable Liquid! Skin Sensitizer and Eye Irritant.  
**KEEP OUT OF REACH OF CHILDREN.**

**CAUTIONS:** Harmful if swallowed. Keep away from heat sparks and open flame. Avoid contact with skin and breathing of vapor or spray mist. Do not take internally. Close container after each use. Use Only With Adequate Ventilation.

**WARNING:** Use of this product will expose you to chemicals known to the State of California to cause cancer.

### FIRST AID:

**Eyes** • Flush with copious amounts of water for 15 minutes. Seek immediate medical aid.

**Skin** • Wash with soap and water. Set medical attention if irritation persists.

**Inhalation** • Remove victim from exposure. If victim is unconscious, administer artificial respiration or oxygen. Seek medical aid.

**Ingestion** • **DO NOT INDUCE VOMITING** (aspiration hazard). Seek immediate medical aid.

*For more information, see our instructional videos at [tapplastics.com](http://tapplastics.com).*

### WARRANTY

TAP products are manufactured to quality specifications, however they should be tested to determine their suitability for your application. Since we have no control over working conditions or methods, our liability does not exceed the value or replacement of this product. TAP Resin products are guaranteed for six months from date of purchase or nine months from code date on container.