

## COATING SCHEDULE

### EPOXY CASTING



Substrate	Wood/veneer
Product Item	Furniture or handicraft
Positioning	Interior
Finishing System	Epoxy System
Gloss Level	High Gloss

Finishing Condition Recommended	
MC wood	8 - 12 %
Room humidity	Max 70 %
Room temp.	28 - 32° C

No	Application Step & Product Name	Mixing Ratio	Application Viscosity	CA [gr/m2]	Application Method	Drying Time Recommended
	<b>SUBSTRATE SANDING</b>				Sand Paper Grade # 180 – 240	
1	<b>SEALER</b> PROPAN EPOXY CAST EC-973 ECH-973 PS	200 100		20-30	BRUSH	4 Hours
	<b>SANDING</b>				Sand Paper Grade # 240	
2	<b>CASTING COLOR</b> PROPAN EPOXY CAST EC-973 ECH-973 PS EPOXY COLORANT	200 100 3-5			CASTING	4 Hours
	<b>SANDING</b>				Sand Paper Grade # 400	
3	<b>CASTING CLEAR</b> PROPAN EPOXY CAST EC-973 ECH-973 PS	200 100			CASTING	24 Hours
4	<b>BUFFING PROCESS</b>					

Main Features:

Easy to apply by casting

Good transparency

Odorless compare to Polyester Casting

Notes: Maximum thickness for every step of casting process is 2 cm

Surface Specification	Method	Result	Notes
Adhesion Test	ASTM D3359	Point 5B	Perfect
Blocking Resistance 2 psi	ASTM D2793-93A	Pass	Non Visible Mark
Hot and Cold Check	ASTM D1211	Pass	10 cycles