

DIPON LuminaCast 2 Coaster Cast — low-viscosity epoxy resin for coasters, trays and embedding

Document	Issued	Version
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Mixing ratio	Pot life	Thickness per pour
2 : 1 by weight	approx. 35 min	1-15 mm

1. Identification

Item	Detail
Trade name	DIPON LuminaCast 2 Coaster Cast
Type	two-component epoxy casting system (part A resin + part B hardener)
Manufacturer	DIPON.DE Removable Automotive Coatings GmbH & Co. KG, Ringofenstr. 39, D-44287 Dortmund, Germany
Supplier for the Czech Republic	RESIN TABLE s.r.o., Dr. Stojana 351, 765 02 Otrokovice, Czech Republic
Pack sizes	1.5 · 3 · 7.5 · 15 · 30 kg (weight of the A + B mix) — this data sheet applies to all pack sizes

2. Description and intended use

A highly transparent resin with a viscosity of **290 mPa·s** and up to 15 mm per pour. Fast recoating — **the next layer can be poured after just 1 to 2 hours** — makes it a system for layered work and small-series production.

- coasters, trays and table accessories
- jewellery and castings in silicone moulds
- embedding objects where high clarity is required
- laminating glass and carbon fibre fabrics

Compatible substrates: wood, concrete, glass, metal, glass and carbon fibre fabrics, natural stone, silica sand, marble, granite. It can be coloured with all DIPON alcohol inks, resin pastes and effect pigments.

Formulation: UV absorbers and n-HALS stabilisers, amines with a reduced tendency to yellow, high resistance to carbamate formation, a crystallisation-stable recipe and bio-based ingredients. Free of SVHC and CoRAP substances.

3. Technical data

Parameter	Value
Mixing ratio	2 : 1 by weight (A : B)
Pot life	approx. 35 min (23 °C, 200 g, 5 mm)
Time to peak exotherm	approx. 80 min (23 °C, 200 g, 20 mm)
Layer thickness (20 °C)	1-15 mm
Viscosity, part A (23 °C)	730 ± 50 mPa·s
Viscosity, part B (23 °C)	290 ± 50 mPa·s
Material temperature A + B	20-24 °C
Ambient temperature	20-25 °C

Parameter	Value
Minimum batch size	90 g
Recoat / next layer	approx. 1-2 h (20 °C)
Demoulding	approx. 16-24 h (23 °C, 10-15 mm)
Hardness after 7 days (23 °C)	Shore D 81
Heat resistance	approx. 69 °C
Shrinkage	< 0.1 %
VOC content (EU)	0 %
Density of the mix	approx. 1.07 kg/l (derived from the SDS)

Source: manufacturer's technical data sheet (DIPON). Pot life is the time in which the mixed material reaches 40 °C. The density of the mix is derived from the densities of the components in section 9 of the SDS.

4. Physical properties of the components

Property	Part A — resin	Part B — hardener
Physical state, colour	liquid, clear	liquid, clear
Odour	characteristic	amine-like
Density (20 °C)	1.14 g/cm ³	0.949 g/cm ³
Viscosity	730 mPa·s dyn. (20 °C)	250 s (DIN 53211/4, 20 °C)
pH (20 °C)	—	12.4
Boiling point	> 200 °C	> 200 °C
Flash point	> 100 °C	> 100 °C
Miscibility with water	limited	complete

Source: manufacturer's safety data sheets, version 1 of 14 February 2024, section 9. Part A is the same product across the whole LuminaCast range.

5. Processing

- **Condition the material.** Material at 20-24 °C, room at 20-25 °C. Cold resin stays thick and carries bubbles.
- **Prepare the substrate.** Dry, clean, free of grease. Seal wood with a thin coat beforehand so that it does not release air.
- **Weigh to the gram** at a ratio of 2 : 1 by weight. Do not measure by volume — the densities of the parts differ. An inaccurate ratio leaves a permanently under-cured, tacky surface.
- **Never mix in the shipping container.** The manufacturer warns that mixing directly in the bottles or canisters results in **incomplete cure** of the whole batch.
- **Mix twice for 3-4 minutes** at up to 300 rpm. Mix → pour into a clean container → mix again; scrape the residue from the walls of the old container into the middle of the new one.
- **Pour slowly** into the lowest point of the mould and let the resin flow out.
- **Release the air.** Remove the remaining bubbles with a heat gun or a torch from a safe distance, in short passes.
- **Leave it undisturbed** at a stable temperature, protected from dust and draughts.

Cleaning of tools: acetone or universal thinner immediately after use. Once cured, the resin can only be removed mechanically.

6. Consumption

Length × width × height of the casting in cm ÷ 1000 × 1.07 = required mass in kg. Add **10-15 %** for material left in the container and for inaccuracies of the mould.

7. Food contact

The formulation contains no substances from the SVHC list or the CoRAP list. According to the manufacturer's declaration, **fully chemically cured** material may come into contact with food. The material reaches its final properties after 7 days at 23 °C — until then the reaction is still in progress.

8. Safety

Both components are classified as hazardous. **Read the safety data sheets before use**; they are available for download with the product.

	Part A	Part B
Classification	Skin Irrit. 2 · Eye Irrit. 2 · Skin Sens. 1 · Aquatic Chronic 2	Skin Corr. 1 · Eye Dam. 1 · Acute Tox. 4 (oral) · Skin Sens. 1 · Aquatic Chronic 2
Pictograms	GHS07 · GHS09	GHS05 · GHS07 · GHS09
Signal word	Warning	Danger
Hazard statements	H315, H319, H317, H411	H302, H314, H317, H411
UFI	CE20-C03K-J00M-CEAT	4H00-60WU-T00Q-TWHD

Source: manufacturer's safety data sheets, version 1 of 14 February 2024, sections 2.1 and 2.2.

Wear protective gloves and eye protection, work in a well-ventilated area, avoid breathing vapours and mists, avoid release to the environment and keep out of reach of children. **Part B is corrosive** — wear goggles or a face shield when dispensing it. **Epoxy resins are skin sensitisers**: repeated contact may cause a lasting allergy.

9. Storage and disposal

- Keep containers tightly closed and dry, away from frost and direct sunlight; store at room temperature.
- Uncured material and contaminated packaging are hazardous waste — do not pour into drains.
- Allow residues to cure; cured resin is inert and is disposed of under local regulations.

The information reflects our present knowledge and the manufacturer's documentation. It is not a legally binding assurance of properties; processing conditions are beyond our control. Carry out your own trial before production use.