

Resin System R1 + H1

Casting a 10x10x10 cm cube

The resin and all necessary materials (mold, tools, etc.) should be at a temperature of 16–25 °C. It's best to leave them overnight in the room where you'll be working on the project. Any damp or cold environment will affect the final result. The room must be as free of dust and dirt as possible.

Quantity calculation:

The cube measures 10x10x10 cm = 1 dm³ = 1 liter, which corresponds to approximately 1.2 kg of resin system. Our recommendation, item number: 940138-G

Mixing ratio:

100 parts resin R1 / 38 parts hardener H1



Preparation: Resin

1. Weigh the resin and hardener precisely and carefully—preferably using a kitchen scale (pay close attention to the mixing ratio)—and mix them together.
2. Be sure to mix slowly to prevent bubbles from forming.
3. Once you have thoroughly mixed the resin and hardener, pour the mixture into a second container and mix again to ensure that no unmixed resin remains—this is known as “double potting.”



Processing

The mold into which you pour the mixed resin system can be made of various materials, such as silicone, wood, or plastic. You should use a release agent to remove the cube from the mold without damaging it.

For a 10x10x10 cm cube, you should pour in two stages. When pouring any synthetic resin, always observe the maximum pour height to prevent overheating during the curing process.

If you want to create even taller or larger objects, you'll need to pour in multiple stages.



Resin System R1 + H1

Casting a 10x10x10 cm cube

The following always applies:

Allow the resin of the first layer to reach stage B (approx. 9–10 hours) of curing.

The B stage means that the resin has hardened but is still tacky. To determine whether this stage has been reached, touch the resin with a gloved finger; if it leaves a mark that does not stick to the glove, it has reached the B stage, and you can proceed to the next step of the casting process.

If you allow the resin to cure past the B stage (i.e., if you miss the B stage), the resin will not chemically bond with the next layer. In that case, you'll need to sand it down with coarse sandpaper to create a bond with the new layer.



Properties written on paper and encased in R1 H1 epoxy resin.

This information is based on our current knowledge and experience.

However, we provide it without any obligation. It is intended to inform you about our products and their possible applications and is therefore not intended to guarantee specific product properties or their suitability for a particular purpose, nor does it constitute complete instructions for use. We reserve the right to make changes in line with technical progress and operational developments. The use and processing of our products in accordance with our instructions take place outside our control and are the sole responsibility of the user. The user remains responsible for verifying the suitability and possible applications for the intended purpose. We welcome suggestions for improvement and reports of errors.

Stand 06/2026