LIQUID GLASS

LIQUID GLASS 10K HYPER HD

Technical Data Sheet Reviewed: 18.01.2026

DESCRIPTION

LIQUID GLASS 10K HYPER HD is a unique slow curing epoxy resin system perfect for creating water-clear castings with amazing clarity. It is specifically designed for deep pouring and large castings from 20mm to 100mm thick with minimum exotherm (heat generation). Presents excellent adhesion to most substrates and cohesion on multiple layers. Contains anti-yellowing UV additives. An extremely useful advantage is its very low sensitivity to humidity. It is easily tinted with the wide range of colorants LIQUID GLASS COLOR. LIQUID GLASS 10K HYPER HD allows you to experience resin in a whole new way, a unique new addition to our range of LIQUID GLASS products.

ADVANTAGES

- Incredible transparency like crystal clear water
- Amazing clarity
- Slow curing
- Low exothermic reaction
- Very low viscosity for easy penetration and less foaming
- High resistance to UV radiation
- Excellent adhesion and bonding strength
- Excellent mechanical properties
- Excellent moisture, temperature and chemical resistance
- Mild reaction, allowing better defoaming and thicker castings
- Reduced effect of low temperatures and humidity while curing
- Castings from **20mm to 100mm** depending on the total mass.
- Can be colored with **LIQUID GLASS COLOUR**

APPLICATIONS

- Recommended for high thickness castings.
- Recommended for furniture, mostly river tables.
- Wood and resin projects such as lamps, serving platters, bowls, solid cast blocks of wood and resin.
- Clear castings such as sculptures, figurines etc.
- Encapsulations of dried flowers, stones, models and much more.

INSTRUCTIONS FOR USE

You must pay close attention to the quantity and the way of mixing the 2 components. Danger of high temperatures due to exothermic reaction.

1. Temperature and humidity requirements: ambient **temperature 20ºC – 28ºC** and **humidity up to 50-55%** (use of a dehumidifier is recommended).
2. All surfaces must be dry and clean from dust and grease.
3. Make sure that the materials used for stirring and dosing containers are clean and moisture free.
4. Using a spatula, mix quantities **by weight at the ratio written on the package**.
5. It is advisable to use a precision scale.
6. Stir well for 3-5 minutes the 2 components with a spatula or a low-speed electric drill, very slowly to avoid foaming in the mixture.
7. Mix small quantities each time since the mixture will start hardening rapidly. The larger the quantity mixed and the higher the temperature, the faster the rate of acceleration of the curing due to the exothermic reaction. Extreme care is required at temperatures above 28ºC and below 15ºC. Recommended working time 1 - 2 hours up to 4 - 5 hours at lower temperatures. Always monitor the temperature of the mix.
8. If you apply the material in layers make sure that each layer is applied after curing of the previous layer to avoid line creation and reduced transparency.
9. For large epoxy resin molds, you will want to use sturdy, flat materials such as high-density polyethylene or melamine combined with self-adhesive tapes and nylon sheets. For smaller objects, you will want to use silicone or small plastic containers to achieve the correct shape.
10. Apply the material into the mould making sure that there is no leak. Use silicone to seal all joints.
11. During curing, dust, high temperatures, air flows (e.g air condition) and very importantly high humidity should be avoided.
12. Any air bubbles can be removed using a needle, a hair drier, a heat gun, a butane torch, or barbecue jet type lighter. Please use caution when using a flame! Do not use heat source on one spot for extended time. It is recommended to have a fire extinguisher nearby.
13. Initial curing time 12 - 16 hours, and final curing is achieved in 8 - 10 days depending on layer thickness and room temperature.
14. Following full curing one can machine – sand the cured object using different grades of sandpaper from coarse to fine which will lead to a glass like finish for the sanded areas.

CAUTION

- Humidity and wood chemicals affect the chemical process resulting in bubbles. Special care should be paid to applications with wood where it is difficult to measure humidity. In such applications the wooden surface must be primed with LIQUID GLASS in one or two thin layers. If any bubbles appear on the surface, sand and prime again the surface.
- It is recommended not to mix large quantities of material. Cast the material immediately after mixing and monitor

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temperature. If overheating of the material is observed - severe thickening, do not use. High temperature accelerates exothermic reaction and traps bubbles while mixing the material.

- If casting over 50mm, continuous temperature monitoring and / or casting in successive layers is recommended.
- Due to the nature of the material, direct and prolonged exposure of the polymerized LIQUID GLASS to ultraviolet (UV) radiation may cause the surface to yellow. This effect is significantly mitigated by applying LIQUID GLASS UV PROTECT VARNISH, which provides protection against yellowing caused by solar UV radiation, as well as against scratches.
- Lightweight objects must be fastened (secured to their intended position) to avoid floating or moving until final curing.
- In case of severe overheating with possible smoke release, spray the surface with water to lower the temperature.
- Close lids firmly after use and do not change lids between containers.
- All tests should be carried out before final application.
- Suitable for use by professionals or experienced users.
- Please contact our technical support for any technical assistance.

COLOURING LIQUID GLASS

You can color LIQUID GLASS with **LIQUID GLASS COLOUR** colorants of your choice: **LIQUID GLASS COLOUR TRANSPARENT** to preserve transparency in your LIQUID GLASS creation, **LIQUID GLASS ULTRA TINT** for an opaque colored result or choose **LIQUID GLASS COLOUR EFFECT** to add a metallic or pearl effect. It is certain that whatever your choice is, **LIQUID GLASS COLOUR** colorants will offer an exceptional color effect to your creations. It takes a lot of care to achieve the desired result. The colorants are very concentrated. 1-3 drops may be enough for coloring 50gr of final product.

Instruction for use: Add just a few drops of colorant in component A (resin). Stir well to blend using a spatula or a tongue depressor. Special attention must be given to the bottom and sides of the container. Add part B (hardener) and mix well.

Caution: Too much colorant (>2% of total mixture weight) will inhibit the cure of the resin. Colorants may be used to color an entire casting or can be used in a top, middle, or bottom layer to create depth or other effects. Keep in mind that colored resin in your mixing container will look much darker than when poured into a thinner area. It is recommended that the final tint and hardening of the mixture is tested before the application.

COVERAGE

~1,1kg/m^2/mm layer thickness ±5%

CLEANING

Tools and adhesive residues should be cleaned right after use with nitro solvent. After the material has hardened it can be removed using **MERCOLA STRIPP & CLEAN** paint stripper.

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TECHNICAL CHARACTERISTICS

Component A
Base: Modified Epoxy resin with UV filters
Form: Low viscosity liquid
Odor: Characteristic
Color: Transparent
Specific Gravity:1.060 kg/m^3 25ºC (ASTMD 4052)
Ignition point:>150ºC

Component B
Base: Polyamine
Form: Liquid
Odor: Characteristic
Color: Transparent
Specific Gravity:1.015 kg/m^3 25ºC
Ignition point: >90ºC

MIXED PRODUCT (20ºC - 100gr A+B)
Mixing ratio: **Written on package**
Maximum layer height: 10cm
Open time: 1 – 5h
Initial curing – gel time: 12 - 16h
Ready to handle: 3 days
Final curing: 8 - 10 days
Application temperature: 15ºC – 30ºC

STORAGE

Products should be stored in a dry and cool place at a temperature of 5ºC -35ºC, away from sources of ignition. Protect from humidity and direct sunlight.

SHELF LIFE

24 months from the production date in the above mentioned storage conditions. The product should remain in the original unopened packaging bearing the manufacturer's batch number.

PACKAGING

SETS (A+B) of 1kg, 3kg, 12kg, 24kg, 300kg, 1.000kg. Other packaging options available upon request.

HEALTH AND SAFETY INFORMATION

Consult recent products Safety Data Sheet before use.

The directives contained in this technical data sheet are the result of our long experience from real life applications and the research testing of our research and development laboratory and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications, which are beyond our control, we cannot accept any responsibility for the results obtained. In every case it is recommended to carry out preliminary experiments. We are liable only for our products for being free from faults and of consistent quality. Users are responsible for complying with local legislation and for obtaining any required approvals or authorizations. The present edition of this technical datasheet automatically cancels any previous ones concerning the same product.

TECHNICAL SUPPORT
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MONDAY TO FRIDAY 8:00 - 16:00

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