

EPOX-Y CASTING

INSTRUCTIONS:

IMPORTANT:

CAREFULLY READ ALL INSTRUCTIONS BEFORE BEGINNING YOUR PROJECT

SamaN EPOX-Y CASTING is a high performance, 100% solids, two components, commercial grade - formulated for a long gel time and low exothermic heat buildup.

SamaN EPOX-Y CASTING can be poured up to a maximum thickness of 5" and it cures a crystal clear transparency. It is perfect for pouring river tables, ocean tables, fill in gaps, holes and cracks in your lumber, epoxy art and any other deep pour applications or casting in silicone molds. The product cures to a scratch-resistant, crystalline gloss finish.

This product is designed for indoor use.

SamaN EPOX-Y CASTING can be pigmented with any of our pigments to create a coloured epoxy. A combination of clear and coloured layer can be used to create depth in your projects.

Required material:

-3 graduated plastic or non-waxed paper containers with a smooth surface and a flat bottom.

-Mixing sticks

-Plastic spatula

-Disposable brush

-Wax paper, newspaper or roll of plastic

-Protective latex, vinyl or chemical resistant gloves

Recommended application conditions:

Wood moisture content must be less than 12%, room temperature between 18° C and 27° C (65° F and 81° F) relative humidity between 40% and 70%.

Mixing: Make sure products are at room temperature. If the resin (Part A) or the catalyst (Part B) is too cold, the product will be very thick and impossible to work with. In this case only, place the containers under hot tap water so the contents return to their normal liquid state. Allow to cool to room temperature before mixing.

It is imperative to accurately follow the instructions for measuring and mixing.

A poorly prepared mixture may give an imperfect, soft or sticky surface.

If the project requires coloration, only use SamaN water based stain.

Make sure the surface is completely dry before applying the EPOX-Y finish.

Before applying SamaN EPOX-Y on a polyurethane or acrylic varnish, lightly sand the surface with a 220 grit sandpaper and wipe down with acetone or alcohol.

If the surface has a solvent-based varnish or stain, test in a discreet area to see if it is compatible with EPOX-Y CASTING.

WORKING TIME: 2h. The EPOX-Y finish begins to harden as soon as it is mixed. It is therefore necessary to pour it immediately after mixing. The product must be applied within 2h after mixing; a longer delay and it will be unusable. NOTE: when the ambient temperature is above 21C (70F) this will reduce the working time.

GEL TIME: 12 hours @ 26C (79F). The resin and catalyst mixture produces heat, which speeds up the curing process. The greater the amount of the mixture, the greater the amount of heat will be released and the application time will be reduced. Mix in small portions to allow you enough time to properly apply the product. Test in a discreet area before applying the all the product.

CURE TIME: 24h @ 26C (79F). Cure time is dependant on mix volume and temperature. 100% hardened in 72 hours. Avoid contact with dust during the curing process

COMPATIBLE SURFACES: Wood, Steel, Concrete, Granit, Copper, Leather, Steel, Laminate, Formica, Bamboo, Artwork, Photos, Seashells, Fabrics, Paper, Dried Plants and much more.

Surface preparation:

Sand the surface with 120 or 150 grit paper. Vacuum the dust and wipe with a clean, dry cloth. The surface must be dry, clean, free of dust, wax, grease and moisture.

Preparation of the mixture:

CAREFULLY FOLLOW INSTRUCTIONS FOR MIXING.

THE MOST COMMON REASON FOR POOR RESULTS IS AN INADEQUATE MIXTURE.

Tips before mixing:

Do not use an electric mixer and never shake the product to mix as this will cause an excessive amount of bubbles.

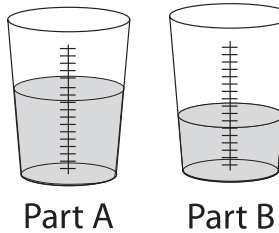
Seal the cavity with a thin layer of EPOX-Y CASTING before pouring a thick quantity, that will help reducing the amount of bubbles.

Before pouring the mixture: Protect the sides against the droplets with several layers of masking tape. Remove the masking tape once the product has hardened. It is also possible to remove the droplets with a scraper approximately 30 minutes after pouring the mixture.

1

MEASURE:

Pour **two** parts of Resin (**Part A**) and one part Hardener (**Part B**) Ratio 2:1



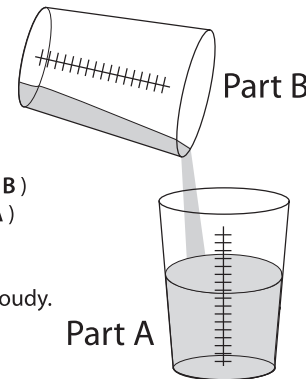
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COMBINE AND MIX:

Pour the measured Hardener (**Part B**) into the container of Resin (**Part A**)

GENTLY MIX FOR 2 MINUTES

or until the mixture is no longer cloudy.

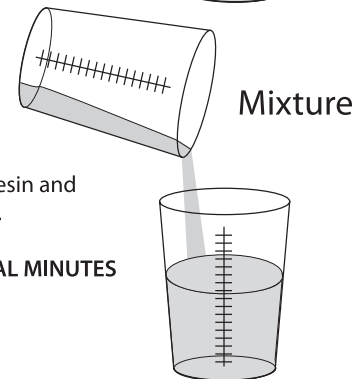


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TRANSFER AND MIX:

Finally put the mixture (Mixed Resin and Hardener) into a clean container.

GENTLY MIX FOR 2 ADDITIONNAL MINUTES



Application:

Pour the mixture onto the center of the surface to be covered and spread evenly with a spatula. For best results, spread the mixture in one direction over the entire surface. DO NOT continue spreading the mixture as it begins to harden, otherwise it will not self-level. It is recommended to apply EPOX-Y CASTING in 1/16" (1.6mm) thick layers minimum. Allow a dry time of at least 12 hours before applying additional layers of EPOX-Y CASTING.

Application on large surfaces:

If possible, seek help from someone to speed up the mixing step

The application includes 3 steps: Mix, Pour, Spread. Follow this process until the surface is completely covered.

Bubbles forming on the surface:

The majority of bubbles formed during mixing should naturally rise to the surface and then disappear once the mix is poured. However, since EPOX-Y CASTING is extremely thick it is usually necessary to help the process by gently blowing on it with the help of a hair dryer at the lowest setting to help bubbles rise to the surface and disappear. You must work quickly before the surface starts to dry, otherwise the bubbles will be trapped and form ripples on the hardened surface. **NOTE:** Do not point the hair dryer directly at the surface.

THICK POURS:

Allows for thick pours in 1 single application.

The thickness of pour depends upon the ambient temperature and the mix volume.

Drying time: Allow to dry 5 hours between coats. 100% hardened in 72 hours.

Avoid contact with dust during the curing process

VOC: 38,8 g/l

Cleaning: Clean tools with acetone/alcohol-based.

IMPORTANT: Wash your hands and skin thoroughly with soapy water after being in contact with EPOX-Y CASTING.

Surface maintenance:

Use the AquaShine cleaner.

Heat Resistance: - EPOX-Y CASTING can withstand temperatures of 50° C.

Always use a trivet mat to reduce the risk of surface discoloration.

Storage: Keep in a cool place. FREEZE/THAW stable

As the conditions under which our product is used is beyond our control, we only guarantee that it meets our quality standards and, if applicable, the manufacturer's liability is limited to the purchase price of the product.



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