

DIRECTIONS

READ ALL INSTRUCTIONS CAREFULLY BEFORE USING THIS PRODUCT

SUGGESTED MATERIALS NEEDED

- Stir sticks, spatula (or mixing paddle and drill gun)
- Mix and measure buckets (minimum of 3 recommended)
- Squeegee or foam brush for spreading the epoxy
- Drop cloth or plastic sheeting for easy clean up
- Disposable Gloves
- Safety protection

INFORMATION TO KEEP IN MIND

Inaccurate measuring or improper mixing are the most common causes of poor results. This product **MUST** be used in a 2:1 ratio by volume and thoroughly mixed. For best results, mix resin and hardener in one bucket and transfer to a clean bucket and mix again. Ideal working temperature is 77 degrees.

STEP 1

Using the Coverage Chart, determine the amount of epoxy you will need for your project.

STEP 2

Ensure your working environment is clean, dry and at least 70 degrees for best results. Lay down a plastic sheeting below your project for a safe, easy cleanup. Make sure your surface is completely level, as the epoxy will self-level.

STEP 3

Seal Coat: Be sure to clean the surface with Isopropyl Alcohol 90%+ and apply a thin coat of mega clear with a brush. Let it get tacky before our deep pour. If the seal layer is fully cured, for best results, lightly sand the surface with 320 grit sandpaper and clean with Isopropyl Alcohol 90%+ and then pour the deep pour.

STEP 4

Mixing Deep Pour: Measure 2 parts Resin to 1 part Activator and pour into a clean, dry bucket or cup. Stir the mixture for at least 5 minutes with either a stir stick (if mixing with a stir stick, do not mix more than 1 quart) or a drill mixer set to low. Ensure you are not whipping air into your epoxy. Be sure to scrape the sides and bottom to ensure all of your epoxy is properly mixed.

STEP 5

Transfer contents to a new, clean, dry bucket or cup and continue mixing for 3 more minutes to ensure proper mixing, again scraping sides and bottom.

STEP 6

Pour mixture directly into your mold at your desired depth, with a minimum depth of 0.5" and a maximum depth of 4".

STEP 7

Use a heat source, like a heat gun to remove any air bubbles. Start at 6" minimum above the surface and sweep back and forth until no bubbles remain. Do not leave the heat gun over the surface too long, as to prevent surface distortions.

STEP 8

Allow the surface to cure, up to 72 hours in a dust-free environment. The epoxy will start to get tacky after 24 hours but do not disturb for 72 hours to ensure a proper cure.

COVERAGE CHART

Lamination Thickness	2 sq ft	4 sq ft	8 sq ft	10 sq ft
1/2"	2.5 qts	5 qts	5 gal	7.8 qts
1"	1.25 gal	2.5 gal	10 gal	15.6 gal
2"	2.5 gal	5 gal	20 gal	31.25 gal
4"	5 gal	10 gal	40 gal	62.5 gal

CAUTION



- Do not expose the product to direct sunlight.
- Keep container closed to prevent contamination.
- May cause eye and skin irritation. Use this product only in a well-ventilated area with protective gloves and eye protection.
- Do not eat, drink or smoke while using this product.
- When mixed in very large masses, this product can generate excessive heat. Handle with caution.
- Dispose of containers and contents in accordance with all Federal, State and Local regulations.

FAQS

HOW LONG DO I HAVE TO MIX IT?

You need to stir it with by hand for a minimum of 5 minutes, scraping the sides and bottom thoroughly throughout while mixing. When pouring, we do not recommend scraping the sides. Doing so can risk mixing in unmixed, unincorporated epoxy into your pour, thus creating curing issues.

HOW LONG DOES IT TAKE TO CURE?

The product will begin to harden within the first 12-24 hours, in ideal conditions, but takes 24-72 hours to completely cure, dependent upon conditions like constant temperature, humidity, mass and airflow.

CAN I MIX PIGMENT/DYE/MICA POWDER?

You can mix nearly all alcohol dye's, mica powders, and liquid pigments with our product, not to exceed 12% of total volume. However, we do not recommend acrylic based colorants as they can negatively react with the epoxy.

CAN I ADD ANOTHER LAYER TO THE SURFACE?

Yes! Simply wait until the pour is tacky and nearly hard and pour your next layer. If the product is already hard, lightly sand with 240 grit sandpaper and wipe it down with Isopropyl Alcohol 90% or higher before adding additional layers, which helps with the adhesion between the two layers.

CAN I APPLY IT OVER WOOD, CONCRETE AND COUNTERTOPS?

Absolutely! With any surface, you want to ensure the surface is clean and dry before applying. As always, we recommend a seal coat before applying thicker coats.

CAN I PAINT OVER THE EPOXY?

Yes, once it is completely cured, you can paint over the top of it.

DO YOU NEED TO APPLY A SEAL COAT?

We recommend a seal coat, which is a very thin coat of MegaClear applied to the surface to prevent air bubbles and any residual moisture from the substrate getting into your thick pour. Make sure that the pour surface on your substrate is properly sealed.

IT'S COLD AND THE EPOXY IS REALLY THICK, WHAT DO I DO?

Under 65 degrees, our epoxy may start to thicken up. You may even see some crystallization. Don't worry, the epoxy is perfectly fine! Before mixing, bring a pot of water up to a steady 75-80 degrees, and then put each bottle of epoxy in there until they come up to temp between 75-80 per bottle. Do not mix first and then bring up to temp. Once the epoxy is up to temp, you can now begin the mixing process.

HOW THICK CAN I POUR IT?

You can pour up to 4" thick per pour, depending on ambient temperature and total mass. Much thicker than most competitors! The mass for a 4" pour varies depending on temperatures and conditions. If you have never poured a deep pour at 4", we suggest you try it on a smaller scale to understand how it will cure in your particular environment.

HOW CLEAR IS YOUR EPOXY?

Our epoxies are the clearest Epoxy on the market with breathtaking clarity and long lasting beauty.

CAN I USE THIS ON TOP OF AN OIL BASED STAIN?

No, epoxy will not adhere to oil based stains.

WHAT IF I CHIP THE EPOXY?

Not a problem. This is easily fixed by rough sanding the area, clean the area with isopropyl alcohol, and then repour more of our epoxy. Let that cure. Sand down to desired surface, and then buff to your desired shine.

COLD WEATHER EPOXY WARNING

Using epoxy in colder weather can pose its own challenges. With dropping temps, it is extremely important to ensure your epoxy, and your project, stay within the recommended temperature range during the curing process. Failing to do so will result in much slower cure times, no curing, or unusual amounts of bubbles and clarity issues due to thicker epoxy.

TIPS FOR DEALING WITH COLDER WEATHER

- ALWAYS pour in a temperature controlled environment with an ambient temperature of 70°F - 84°F, depending on pour volume.
- If epoxy is thick, warm epoxy bottles in warm water and bring to between 72°F and 75°F. Remove from water bath, dry bottles and follow pouring instructions.
- If you have trouble with ambient room temps, try using a temp controlled heat mat under your mold. Be safe, and keep it between 70°F and 75°F.
- Temperatures affect cure times, so a warmer product will cure faster than a colder product. Be sure to plan accordingly.

WARM WEATHER EPOXY WARNING

Using epoxy in warmer weather can pose its own challenges. With rising heat, it is extremely important to ensure your epoxy, and your project, stay cool during the curing process. Failing to do so will result in much quicker cure times, severe cracking, extreme shrinking, unusual amounts of bubbles and clarity issues.

TIPS FOR DEALING WITH WARMER WEATHER

- Never pour outside if you can help it, and especially when the temperature is above 84°F.
- Pour in a temperature controlled environment with an ambient temperature of 70°F - 84°F.
- Elevate your mold off of a flat surface to create airflow underneath. This allows the epoxy to properly exotherm and
- release heat without overheating.
- Additionally, you can use fans to further circulate cooler air within your pour space to assist with any potential overheating.