

RESIDENTIAL
& COMMERCIAL

INDUSTRIAL
& MARINE

ART
& CRAFT

SHIMICOAT
SURFACE SOLUTIONS



Pro Deep Cast Clear Epoxy

An Application Guide

Mixing:

Mix thoroughly for 2- 3 minutes manually or with mechanical mixer at low speed (750rpm Max).

If mixing smaller portions mix at a ratio of 1A:1B by weight or volume. For example, to prepare 2Lt mix, add 1,000mL (1Lt) of Part B (Curative or Hardener) into 1Lt (2,000mL) of Part A (Resin). If colour required, add SHIMI COLOURS to the kit and mix again thoroughly.

- Ensure surface to be coated is dry, moisture can cause blooming and delamination.
- Pot life is approximately 45 minutes, work within 30min to ensure easy flow application.
- SHIMI COLOURS, SHIMI METALLIC or SHIMI GLITTERS should be first added to Part A (Resin). Mix slowly using drill mixer on low speed. Mix for a few minutes to ensure completely homogenized without lump. Pour the bend into your tray and apply directly on the surface using the roller.
- Use steady long strokes and avoid overworking the roller or pushing your roller too quickly as this may trap air bubbles in the coating.
- Do not apply if the rain is expected within 24 hours of application.
- Not recommended for use below 10°C or above 35°C.
- Keep the pail sealed when not in use. Avoid application on hot surfaces.

Pro Cast River Table, deep Pour-On Crystal Clear Epoxy 1A:1B

SHIMICOAT offers a range of Clear Epoxy products which are industrial/commercial grade, 100% solid, in a two-pack kit labelled as "Part A and Part B". Part A contains *bisphenol A and epichlorohydrin* epoxy resin. Part B contains *Cycloaliphatic Amine* based curing agent.

Once, Part A is added to Part B, an exothermic chemical reaction occurs, generating heat to complete the curing process. All Epoxy products create heat during the hardening process. SHIMICOAT Pro Cast, River Table Clear Epoxy is slow curing, moderate and low heat generating product.

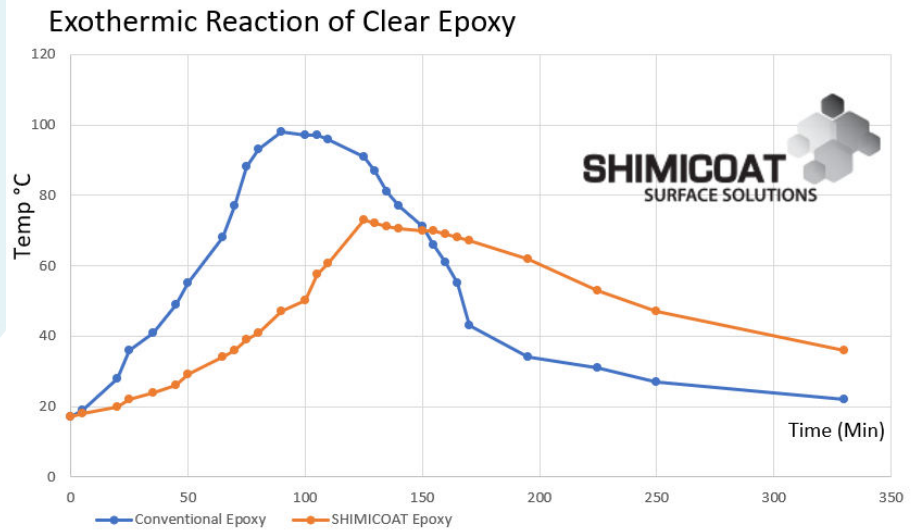
1. Once Part A is added to Part B, apply to your surface immediately, to cool it down.
2. The exothermic reaction of epoxy is resonated, if remains inside the pot, use and apply as soon as you can. Empty the mix onto your surface, mould, river table void or other objects to release heat.
3. Plan your mix to be as minimal as possible to enable you to manage application within 20min.
4. If your project requires large quantity of Epoxy in ONE Pour, use SHIMICOAT EpoCool (Max 10%) to dilute epoxy and reduce heat generation. This slows down the curing process and ensures more moderate curing process. Apply up to 25mm each pour.

 MATERIALS  CHEMICALS  RESINS  EQUIPMENT

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SHIMICOAT Pro Cast River Table Epoxy is a commercial grade casting epoxy resin for woodworkers and artisans allowing over 100mm of epoxy depth in a single pour! Pro Cast River Table is a one single pour save you money, time and effort! There's no need to multi-pour of thin layers and wait 24 hours for it to cure enough to add another layer of epoxy. No more sanding in between multiple batches of epoxy pours. SHIMICOAT Pro Cast River Table Epoxy cures to a crystal-clear appearance or can be tinted with our Pearlescent Powder Pigments

to a unique soft pearl luster. This super clear casting epoxy is unmatched with exceptional clarity and high gloss finish surface. It is a high-performance commercial grade epoxy resin designed for a 24-hour cure time with a slow exothermic heat buildup and cool down to eliminate cracking and shrinkage. Use for creative table making, woodworking, art projects and wood turning to add endless special effects to projects. SHIMICOAT Pro Cast River Table Epoxy is also perfect for casting and see-through encapsulation of objects in your favorite clear vessel. For thick epoxy object casting applications, SHIMICOAT epoxy will cast over 100mm provided correct use of EpoCool and HeatSink materials, which significantly reduces overheating risks.



Minimize air bubbles formation in Epoxy resin

The higher the viscosity of the resin, the more difficult it is for the bubbles to naturally pop- up out of the resin body depth. Resins with low viscosity, similar to water, are easier to degas naturally. In addition, the stirring technique is another important parameter to control. It is also highly advised to use a flat spatula. Avoid round wooden sticks. If using electric mixer, use low speed to avoid creating additional air bubbles. Use blow torch or heat-gun to release surface bubble soon after pouring. DO NOT use naked flame touch, if you have flammable liquid in your workshop. SHIMICOAT Pro Cast River Table Epoxy has high viscosity and especially in cold temperatures (<25°C) may require EpoCool (up to 10%) to thin the resin. Addition of EpoCool has also extra benefit which is very important such as sinking heat and cooling act. As the temperature of exothermic reaction of epoxy components rises, it causes EpoCool to evaporate and escape the system. This phenomenon results in lowering the temperature of Epoxy mass and slower curing process.

When using any flammable liquid into your epoxy blend, please avoid blow torch with naked flame. Safety is Paramount.

Application

When pouring Epoxy resin (Part A) and Hardener (Part B), ambient air temperature should ideally be between 10°C to 30°C, the cooler the better. Avoid working in high humidity. Work space should be dirt and dust free, no fan or air circulation. The product is self-levelling and shall be applied over a levelled and flat work surface.

The reaction of Epoxy resin, part A and Part B, is exothermic and generate heats. Use of Personal Protective Equipment are highly recommended:

- Safety Glasses or Goggles
- Disposable Plastic Gloves

As both epoxy liquids are clear, thorough mixing for a minimum of 3min is very important. Always pour Hardener (Part B) into mixing container first, then add the Resin (Part A). Hardener has a lower viscosity and will not stick to the mixing container sides and bottom as much as the resin (Part A) does, during mixing.

Stir with a paint stick or paddle mixer attached to a drill-mixer and mix at low RPM. Avoid whipping and the introduction of air. Scrape the mixing bucket sides and bottom to ensure complete mixing. For best results mix in one container then pour the mixture into the second clean container and thoroughly mix again followed by applying to your object.

Pot-Life: The mixed product inside the mixing container may begin to heat up after 30-40 minutes, shortening the valuable working time. Follow safety instructions at all times.

Slowly pour SHIMICOAT Pro Cast River Table Epoxy mix directly into a mold, casting vessel river table or void that you wish to fill. Continue pouring till you achieved the desired thickness and all mix is being transferred. Allow air bubbles to pop-up, use heat gun or butane blow torch to ensure no surface micro-bubble. Continue removing bubbles as needed up to 2 hours after final pour.

Cure Time:

The final epoxy pour may take 72 hours to reach full cure and ready for breaking out of the mould. Sanding and shaping can be done after 72 hours. Epoxy continues curing, over time and it normally reaches its optimal hardness after 7 days, however it continues to harden as it is aging.

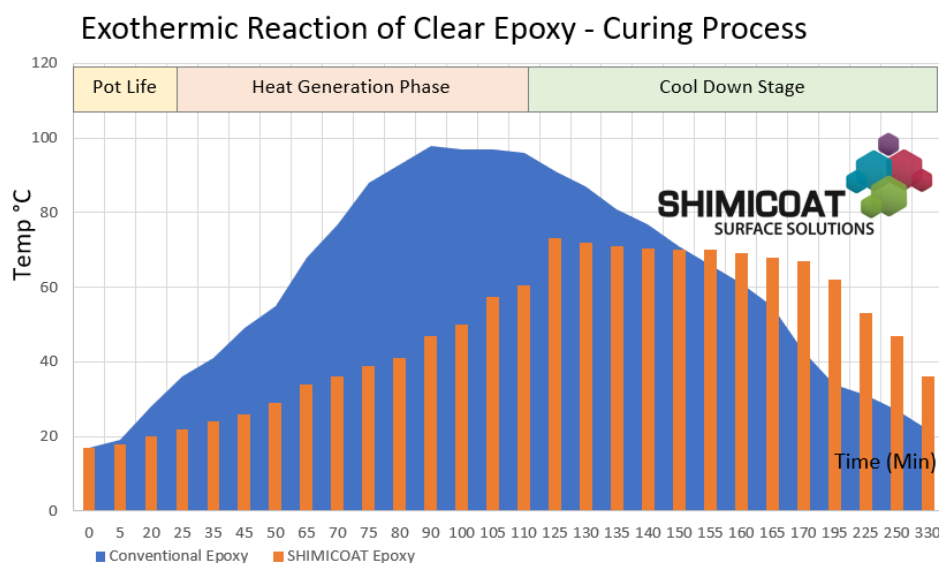
Additional Pours

If you need to make a second pour to increase thickness, the first pour should be touch-dry and preferably no longer than 48hours elapsed. Once the second pour is achieved, bubbles may need to be removed.

NOTE: If longer than 48 hours have elapsed between pours, scuff hardened epoxy surface with 120 grit or finer sand paper may assist to ensure ideal inter-coat adhesion.

Clean Up

EpoThin - Thinner & Diluent (Blend of Solvents)



Drying Times

Pro Deep Cast Clear Epoxy dries in 8-10 hours. High temperatures and windy conditions may speed the curing time. Full hardness is achieved after 7 days.

Temp °C	Pot Life (min)	Surface Dry (Hours)	Initial Cure (Hours)	Recoat Time (Hours)	Fully Cured (Days)
10°C	45	12	24	24	7 Days
20°C	40	10	18	18	7 Days
30°C	35	8	16	16	7 Days

WARNING

- Direct sunlight and UV radiation may result in chalking, colour variations and yellowing effect over time. For under direct sunlight, Polyaspartic, Polyurea or Polyurethane coating materials shall be used.

Storage

The products shall be stored out of direct sunlight and heat at all times. The shelf life of the product is 24 months, mix uniformly for 3 minutes prior to use.

DISCLAIMER

Material Safety Data Sheet, Technical and Environmental Data Sheet can be provided upon request.

The information provided in this document is guidance only and considering the uses of this product are beyond the seller's control, the product is sold without guarantees or warranties. Warranties and guarantees shall be governed by SHIMICOAT Standard Terms of Sale. The purchaser shall make its own tests to determine the suitability for their specific application, and Shimicoat Pty Ltd is taking no responsibility for misuse of the product. The purchaser assumes all risk of use and handling of this product. This product will be happily replaced or credited back if defective. Beyond this, Shimicoat Pty Ltd is not liable for any damages caused by this product or its use.

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The customer is not released from the obligation to conduct careful inspection and testing of supplied goods.