Technical Data Sheet

Product description
; Deep Pour Epoxy Resin is a low-viscosity, long pot-life casting system designed specifically for medium to large pours ranging from 4-7 inches in depth. Its formulation promotes exceptional clarity, tremendous bubble release, and minimal heat buildup, making it ideal for river tables, wood projects, and artistic castings. The resin incorporates upgraded raw materials that significantly improve resistance to yellowing, ensuring long-term visual stability. It mixes easily, accepts a wide range of pigments and metallic effects, and requires minimal torching due to its natural degassing behavior. When stored properly, the system maintains a one-year shelf life. Depending on thickness and environmental conditions, the product reaches full cure within 4 to 7 days.

Application Data	
Mix Ratio	2A:1B
Viscosity	450-700 cps
Density	8.7-8.9
Pot Life	17 hours -19 hours
Working Time	20 hours - 40 hours
Gloss	92-105
Shore D	75-80

Part A	
Viscosity	800-1200 cps
Density	8.9-9.25

Part B	
Viscosity	250-450 cps
Density	8-8.4

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Surface Preparation
: All surfaces must be clean, dry, and free of dust, oils, waxes, and other contaminants before application. Wood substrates should be fully dried and acclimated to the workspace to prevent moisture-related defects. Porous materials benefit from a thin seal coat of epoxy to prevent air release during the deep pour. Environmental conditions play a critical role in performance; humidity should remain below 60% throughout mixing and pouring, as excessive moisture can increase heat generation and introduce bubbles. The product should never be mixed or applied below 60°F, and if either component becomes too cold or too warm—particularly above 90°F—it should be allowed to return to room temperature naturally before use. Allowing the resin and hardener to stabilize ensures proper viscosity, clarity, and cure behavior.

Mixing
This system requires a 2:1 ratio by volume, combining two parts resin with one part hardener. Once the resin and hardener are measured, they should be mixed thoroughly for approximately five minutes, ensuring that the sides and bottom of the container are consistently scraped to achieve a uniform blend. After the initial mix, pigments, dyes, or metallic additives may be incorporated and blended for an additional two to three minutes. Care should be taken to avoid whipping air into the mixture, as slow, deliberate mixing produces the best clarity and reduces the need for post-pour bubble removal.

Application
: After mixing, the epoxy should be poured immediately into the prepared mold or cavity. This product is not intended for use as a thin coating or veneer and performs best when used for deep casting applications. For very large pours, it is recommended to reduce the ambient temperature to between 62-68°F and to limit individual batches to no more than 1.5 gallons to prevent excessive exothermic heat buildup. Once poured, surface bubbles can be removed with a heat gun or torch, though only minimal torching is typically required due to the resin's natural bubble-release properties. Gel time varies depending on depth, with deeper pours gelling more quickly. Demold time typically ranges from two to four days depending on environmental conditions and pour thickness, while recoat windows range from sixteen to forty-eight hours. Full cure is achieved within 4-7 days.

Limitations
This product is not suitable for thin, surface-level coating applications and should only be used for deep casting within the recommended pour range. It should not be mixed or applied in environments below 68°F or in conditions where humidity exceeds 60%, as improper environmental control can lead to excessive heat, bubbles, or incomplete curing. Large batch sizes or elevated temperatures may cause exothermic runaway, so temperature management and batch limitations are essential for safe and successful use. The resin and hardener should never be force-heated or cooled; instead, they must be allowed to reach room temperature naturally to maintain proper performance characteristics.