

## Application

Deep casting truly water clear high UV Resistant resin, that provides a deep water pool effect. Tintable for a blue water effect and castable to around 40 mm in one pour. Ideal for river resin tables of all sizes, backlit benchtops and feature entrance doors.

River resin is formulated for deep casting work, ranging from 15 mm to 40 mm. Wood requiring knot hole and crack filling, of up to 15 mm, is best achieved using Solid Cast 606 Clear Casting Epoxy Resin. This resin poured out over a flat wood surface will also achieve a 1 mm deep extra hard glassy finish equal to 50 coats of varnish.

## Directions:

Note. Gradual thickening occurs during the curing process and can capture air bubbles rising out of the crevices of a natural wood edge. To avoid this occurring, pre-seal natural wood edges with a liberal coating of Solid Cast 606 Clear Casting Epoxy Resin. Plus note, River Resin resin and hardener require pre-conditioning with warmth prior to using. Pre-warm both components to around 60° C. This will dissolve any crystals that may have formed due to cold storage plus any transport air bubbles will be released resulting in greater clarity. Allow the components to drop to 25° C before mixing. Use scales to weigh out 100 parts resin to 40 parts hardener, into a straight sided mixing container. The batch mix size can be up too 16 kg for mixing in an open pail or bucket. Blend with a paint mixer using a power drill on slow speed. Mix evenly for several minutes until an even clear mix is achieved. Air bubbles will quickly rise out once poured.

## Pouring

The mixed material should be poured out a few centimeters above the river resin cavity. Allow time for the resin to slowly flow along the cavity. The depth of a pour should be between 15 mm and 40 mm to create an effective safe exotherm reaction temperature. Allow 5 minutes for the resin to fully fill out the cavity then further top up if necessary.

River resin has a low exotherm providing two hours working time at 25° C and 40% humidity. A touch dry cure will occur in around two days, during this period, a second mix can be poured on top giving chemical crosslink. Full cure requires two further days prior to sanding the surface. Note: Curing should be at a constant 25° C with a minimum drop down temperature of 20° C.

Sanding back surplus resin is the next step. A belt sander with 80 grit paper quickly cuts back the cured epoxy resin. Next switch to an orbital sander using 80 grit paper. Subsequently continue with 120, 180, 240, 320 grit papers. Further clarity and glass like surface appearance is dependent on how finely the surface is finished. Advanced finishing requires sanding with 500, 800 and 1500 papers. This can be water assisted wet and dry paper sanding. Once all sanding is finished, apply a wood finishing oil to the entire wood and river resin surfaces. This will give a satin finish to the entire piece. A further step can be buffering with an automotive fine cut and polish compound. This will give the entire surface a polished finish, it's all a matter of choice.