



COLD WEATHER EPOXY USE

Using epoxy in colder weather can pose its own challenges. With colder temperatures, it is extremely important to ensure your epoxy project stays 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

1. ALWAYS pour in a temperature controlled environment with an ambient temperature of 70°F - 84°F, depending on pour volume.
2. 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.
3. 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.
4. Temperatures affect cure times, so a warmer product will cure faster than a colder product. Be sure to plan accordingly.

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.



For more product information, please visit:
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INVISICLEAR™
PROFESSIONAL GRADE

FluidGlass™

1" DEEP POUR 24 HOUR CURE

2:1 EPOXY

RESIN & HARDENER
INSTRUCTIONS



WARM WEATHER EPOXY USE

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

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

READ ALL INSTRUCTIONS CAREFULLY BEFORE USING THIS PRODUCT

Fluid Glass 1" Deep Pour 24 Hour Cure is perfect for almost all substrates like wood, stone, cement, most metals, plastic, etc. Note: it does not adhere to any oil base stain. If you are unsure of adhesion to a substrate, sand the substrate first to create a mechanical bond.

SUGGESTED MATERIALS NEEDED

- » Stir sticks, spatula (or mixing paddle and drill)
- » Mix and measure buckets
- » Squeegee or foam brush for spreading the epoxy
- » Drop cloth or plastic sheeting for easy clean up
- » PPE – Personal Protective Equipment for Safety

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. Working temp- temperatures are between 70°-84°F.

fully cured, for best results, lightly sand the surface with 320 grit sandpaper and clean with Isopropyl Alcohol 90% +, and then pour the epoxy.

STEP 4:

Mixing Deep Pour 24: Measure 2 parts Resin to 1 part Activator and pour into a clean, dry bucket or cup. Stir the mixture for at least 6 minutes with a stir stick. 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, without scraping the sides. Up to 1" deep, at no more than 2 quarts volume per pour. However, greater depths can be reached by reducing your pour volume.

STEP 7:

Use a heat source, like a heat gun, to remove any surface air bubbles. Do not try to "work" bubbles out. This will actually cause more bubbles by heating the epoxy. 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 and overheating.

STEP 8:

Allow the surface to cure, up to 24 hours in a dust-free environment. The epoxy will start to get tacky between 8-12 hours but do not disturb for at least 24 hours to ensure a proper cure. If temperature is too cool, it may take longer to cure.

PRO TIPS

- » If you're new to epoxy, try mixing and pouring in smaller batches until you're comfortable to move onto bigger pours.
- » Elevate your mold off of your main surface (i.e. table) to allow airflow to assist in dissipating heat from the exothermic reaction.
- » Imprecise mixing and measuring are the most common reason for poor results. After Mixing, when pour-

ing, do not scrape the sides. This can include unmixed epoxy into your project that can have negative effects.

- » Keep in mind, the greater the volume used and/or the thicker your pour, the cooler the ambient temperature will need to be.
- » Use a fan to help with airflow, and reduce the heat caused by the exothermic reaction.

FAQs

HOW LONG DO I HAVE TO MIX IT?

You need to stir it by hand for a minimum of 6 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 8-12 hours in ideal conditions, but takes around 24 hours to completely cure. This is dependent upon conditions like constant temperature, humidity, mass and airflow.

CAN I MIX PIGMENT/DYE/MICA POWDER?

You can mix nearly all alcohol dyes, mica powders, and liquid pigments with our product, not to exceed 12%. 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.

DO YOU NEED TO APPLY A SEAL COAT?

We recommend a seal coat, which is a very thin coat of Invisiclear 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 sub-

strate is properly sealed. You can use our Invisiclear Table Top Epoxy to easily seal by applying with a paint brush.

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 1" thick per pour, depending on ambient temperature and total mass. Much thicker than most competitors! The mass for a 1" pour varies depending on temperatures and conditions. If you have never poured a deep pour at 1", we suggest you try it on a smaller scale to understand how it will cure in your particular environment.

HOW CLEAR IS THIS EPOXY?

It is the clearest epoxy on the market with unmatched 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.

CAN I PAINT OVER THE EPOXY?

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

WHAT ARE THE IDEAL AMBIENT TEMPERATURES WHEN WORKING WITH THIS EPOXY?

The ideal ambient temperatures are between 70°-84°F. This temperature varies due to each application being different. A good rule of thumb is that the more volume you are pouring, the lower the temperature should be.



DIRECTIONS

STEP 1:

Determine the amount of epoxy you will need for your project. Be sure to order Invisiclear Table Top Epoxy for a seal coat to ensure best results!

STEP 2:

Ensure your working environment is clean, dry and at least 70 degrees for best results. Lay down 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: If working with wood or any substrate added to the casting, be sure to clean the surface with Isopropyl Alcohol 90% + and apply your sealcoat with a brush, following all mixing directions for that product. Let it get tacky before pouring your deep pour. If the seal layer is