

WiseBond

Please read the instructions and safety procedures before proceeding.

DEEP POUR RIVER TABLE INSTRUCTIONS

Required Items:

Tarp	60 Grit Sandpaper	Denatured Alcohol
Deep Pour Epoxy	Flat bar	Paddle Bit
3/8 Drill bit	Colorant	Fast Setting Thin Curing Epoxy
Fan	Mold Release Tape	Silicon/Caulk Gun
Blow Torch	~25, 1 1/2" Screws and Bit	3/4 Inch Plywood
	Disposable Brushes	Drill

Directions:

1. Safety

- Please be sure to read and follow all of the manufacturer's safety warnings before continuing.
- It is recommended to always wear safety glasses when mixing or pouring epoxy.
 - Respiratory protection - for example, disposable, cartridge, airline, half or full face
 - Eye protection – for example, spectacles/goggles, shields, visors
 - Hearing protection – for example, ear muffs and plugs
 - Hand protection – for example, gloves and barrier creams
 - Foot protection – for example, shoes/boots
 - Head protection – for example, helmets, caps, hoods, hats
 - Skin protection – for example, hats, sunburn cream, long-sleeved clothes

2. Prepping

- Cutting the slab about an inch larger than the desired finished dimensions ensures that you will have enough length and width to cover the desired finished size of the piece.
- Spreading a thin cure epoxy everywhere your deep pour epoxy will touch with a brush and a gloved hand will create a seal on the wood which is imperative. This is to prevent the deep pour from trying to seep into the wood which will create irreversible bubbling in the epoxy.
- Let dry completely. To cut down the dry time you can use a quick-setting epoxy.
- Take a bit of sandpaper to the sealed edge to scuff the epoxy to ensure adhesion to the epoxy.

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3. Building

- Smooth face plywood (The more plies the better) is a great material for making a mold. Ensure to make a box with sides about one inch taller, wider, and longer than the piece that you are putting into your mold as epoxy can shrink while curing. Screw the pieces together to ensure a tight overlapping fit.
- Seal all seams and corners with a quick-drying adhesive, caulk, or hot glue. Make sure to cover all inside seams and smooth across with a rag to wipe off excess to ensure that the wood can get all the way to the corner without obstruction.
- Line the box with a smooth moisture barrier such as WiseBond Epoxy Release Tape. This is a smooth tape made to resist moisture. Packing tape can work but may not adhere to the wood surface and may not stick to itself well, potentially allowing leaks. Smooth down with a plastic squeegee. Ensure to get tight into the corners and avoid wrinkling.

4. Placing

- Place your cut, sealed, and scuffed wood carefully into your mold so as to not rip the tape which could cause potential leaking.
- Use pieces of scrap wood or plywood, wrapped in moisture barrier tape, and place them about 15 - 20 inches apart on the top of the wood near the edge of the mold. Using "C" clamps tighten from the taped block to under the table to ensure that the wood does not float when epoxy is poured in. Wider tables may need a bar going across the whole width of the table.

Notes:

- Resin-A and Hardener-B liquid temp should be between 65°F and 77°F before mixing.
- The workspace air temp should be no warmer than 77°F
- If the A and B are cooler than 65°F, warm the closed containers in hot tap water

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6. Mixing

- Calculate the amount of epoxy needed by measuring the void that you are filling to get the board feet of the void. Take the board footage and multiply it by 2.4 which will get you the amount of epoxy you need. Add 15% - 25% of waste for shrinkage and over-pouring.
- Pour part B into the mixing bucket first since it is less viscous. This will ensure that your resin is mixed correctly and will not stick to the sides of the bucket as easily.
- Pouring the epoxy starting with part B is one way to ensure your epoxy is properly mixed as Part B is less viscous in comparison to Part A. Mix parts A and B in a 5-gallon bucket (not going over 2 kits or 3 gallons in one bucket) with a drill and paddle mixer on a medium setting for 6 minutes to ensure a proper mix. With a paint mixer and the paddle mixer scrape the bottom and sides often to pull up any epoxy that is not mixed fully.
- After the 6 minutes of mixing add the colorant by mixing very slowly. Checking constantly with a small clear plastic cup for color correctness.

Notes:

- Avoid mixing too fast which will whip air bubbles into the mixture!
- The product in a mixing container may last 2-3 hours before beginning to gel. The product may heat up after 45-60 minutes.
- Pouring excessive amounts of epoxy will increase the risks of curing and drying defects.

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7. Pouring

- Once mixed thoroughly in the bucket ensure that your wood is placed in the mold and clamped securely. Pour the epoxy slowly into the mold and be cautious so as to not trap any bubbles in open cavities.
- Use a heat gun or butane torch very quickly over any bubble that rises to the surface of the epoxy.
- Check every 15 minutes and repeat the bubble popping until no more bubbles are observed.

8. Curing

- Hard cure will take 72 hours depending on air temp, pour depth, width, length, and overall epoxy mass. Sanding and shaping can be done after this time. Wait 7 days for light use. The product will continue to harden for up to 30 days for a full hard cure.

9. Removing

- WiseBond Deep Pour Epoxy is designed to be a slow setting to avoid excess heat and cracking.
- After 72 hours of drying, you are able to remove your table from the mold.
- Remove all screws from the sides and gently pry the sides away from the table.
- Using a crowbar or something similar lift the table off the bottom of the mold.

10. Finishing

- To finish your piece select the finish that you are wanting to use and read the instructions for that specific finish in the WoodSlabs.com Instruction Packet.

Notes:

- If more than 2" of river depth is needed, allow the product to cure for 18-24 hours (hardtack) before pouring additional layers. If layering epoxy, where more than 24 hours have elapsed between pours, scuff with 220 grit sandpaper between each layer pour to ensure adhesion.

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