

TECHNICAL DATA SHEET

Product Document: Deep-Pour-River-Table-Epoxy-Kit_TDS_EN.pdf

System Name: Deep Pour Epoxy Resin for River Table Kit (2-Component, 3:1 Weight Ratio)

Product Category: Epoxy Casting & Furniture Resin Systems

Deep Pour Epoxy Resin for River Table Kit is a two-component, 100% solids, low-exotherm casting epoxy system consisting of Part A epoxy resin and Part B amine hardener. Formulated with an extended pot life, it provides outstanding air release, excellent colour stability and superior yellowing resistance. After full cure, the system delivers a high-gloss, high-hardness surface with good flexibility for thick-section river-table casting, live-edge wood projects and artistic resin crafts.

Features:

Long working pot life / Convenient 3:1 mixing ratio by weight / 100% solids, low-odour formula / Excellent air-release performance / Superior colour stability and yellowing resistance / High-gloss, high-hardness cured surface / Good flexibility for wood-casting applications

Properties:

Property	Test Method	Units	Typical Value
General Liquid Properties			
Mix Ratio (Part A : Part B)	By Weight	—	3 : 1
Solids Content	ASTM D2369	%	100
VOC Content	EPA Method 24	g/L	< 10 (Low odour)
Part A — Resin			
Appearance	Visual	—	Clear transparent liquid
Colour	ISO 6271	APHA	≤ 50
Viscosity (25°C)	ASTM D445	mPa·s	1,000–2,500
Epoxy Equivalent Weight	Internal Test	g/eq	190–210
Specific Gravity	ISO 2811-1	g/cm ³	1.17
Part B — Hardener			
Appearance	Visual	—	Colourless transparent liquid
Viscosity (25°C)	ASTM D445	mPa·s	40–100
Amine Value	Internal Test	mg KOH/g	420 ± 20
Active Hydrogen Equivalent	Internal Test	g/eq	68
Mixed & Cured System Properties			
Pot Life (100 g mix, 25°C)	Internal Standard	h	6–10
Shore D Hardness (Fully Cured)	ASTM D2240 / ISO 868	Shore D	84

System Build-up & Recommended Application Conditions:

Layer / Parameter	Material / Specification	Key Remarks / Value
System Build-up & Recommended Application Conditions		
1. Wood Sealer Primer	Wood-penetrating epoxy sealer primer	Seal porous live-edge wood before pouring to reduce bubbles and resin absorption.
2. Deep-Pour Casting Layer	Deep Pour Epoxy Kit, A+B mixed 3:1 by weight	Recommended single-pour thickness: 15–20 mm. Use multiple pours for deeper casting.
3. Optional Protective Topcoat	Epoxy or polyaspartic PU clear topcoat	Improves scratch, stain and long-term yellowing resistance.
Ambient Temperature	15–30°C	20–25°C recommended
Wood Moisture Content	8–12%	Wood must be dry, clean and sound
Substrate Temperature	Minimum 3°C above dew point	Avoid condensation
Tack-Free Time (25°C)	Dependent on casting thickness	Maintain a dust-free curing environment
Full Cure Time (25°C)	7–14 days	Allow full cure before final service

Application Instructions:

1. Prepare the workpiece: keep wood dry and clean. Apply a wood sealer primer and allow it to cure before pouring.
2. Weigh Part A and Part B strictly at a 3:1 ratio by weight.
3. Mix at low speed (300–450 rpm) for 2–3 minutes. Scrape the sides and bottom of the container to obtain a homogeneous blend.
4. Pour slowly into the mould. Release trapped air carefully and complete pouring within the pot-life window.
5. For casting depths above 20 mm, use a staged multi-pour procedure.
6. Keep the work area dust-free throughout curing.

Cautions:

Do not mix by volume; use an electronic scale. Incorrect proportions may cause incomplete cure or a tacky surface. Avoid skin and eye contact, provide adequate ventilation, and wear suitable PPE. Do not add solvents or foreign diluents.

Storage & Packaging:

Store in original sealed containers in a cool, dry, well-ventilated place away from direct sunlight, heat sources, strong acids and strong alkalis. Shelf life under proper storage: 12 months. Standard packaging: 200 kg sealed iron drums. Project kit packaging: 20 L total-volume kit (Part A + Part B).

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