Specialty Resins
2612 Kersten Court, Kalamazoo MI 49048
Phone: (269) 462-9256
website: www.specialtyresin.com

TECHNICAL DATA SHEET

EPOX-IT 80

Epox-It 80 is a multi-purpose high gloss clear epoxy resin. Epox-It 80 is used for coating bar tops, tabletops, coating countertops, encapsulation, resin art, resin painting, fiberglass laminating, casting clear models, prototypes, jewelry, figurines, etc.. This is a two part professional grade clear epoxy resin that will produce a super gloss finish on a variety of surfaces. Instructions Included with every order.

PRODUCT FEATURES

- 1:1 mix ratio by volume
- Direct from Manufacturer (always fresh!)
- Self-leveling, water and blush resistant
- Crystal clear finish
- High gloss and easy to use
- Made in the U.S.A.
- Complies with FDA CFR 177.2600 (Indirect Food)

PRODUCT SPECIFICATIONS	
Mix Ratio by Volume	1 Part Resin : 1 Part Hardener
Mix Ratio by Weight	100 A to 83 B
Mixed Viscosity	2600 cps
Work Time (100 gram mass)	25-30 minutes
Tack Free Time	4-6 hours
Demold Time	18-24 hours
Full Cure Time	3 days
Ultimate Shore Hardness	D81
Heat Deflection Temperature	130F
Tensile Strength (psi)	8000
Elongation Strength (in/in)	1-3%
Color	Clear

BEFORE USE: Thoroughly read Safety Data Sheets, product labels and the “SAFETY” section in this Technical Data Sheet.

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IMPORTANT: PLEASE NOTE

- It is critical that your frame or mold is watertight. Frames should be built out of material that can easily dissipate heat.
- This product should not be poured directly over an oil-based paint or stain, as oil and epoxy do NOT mix. There should be a definitive barrier between the two products. We suggest applying a water-based clear coat over the oil-based product. If the water-based clear coat leaves a high gloss or shine, we suggest scuffing the surface with 320-grit to allow the epoxy to properly adhere. Once sanded, clean the surface thoroughly with Isopropyl Alcohol 99%. Then you can apply the epoxy.
- This product is not intended for permanent outdoor use or direct UV exposure. It does contain UV inhibitors to help resist yellowing, but all epoxy products will eventually begin to yellow. This includes the base resin, curing agent, as well as the finished cured products.
- This product may be used to embed or encapsulate items for viewing and display. Porous items will need a seal coat to prevent bubbles from occurring. We suggest applying a thin coat of Epox-It as a seal coat.
- If you wish to embed paper decals, bottle caps, or other objects under a tabletop surface, those objects need to be bonded to the surface with craft glue or a thin coat of Epox-It. Paper products must be sealed prior to applying the resin as the resin could soak in and ruin the paper product. We recommend a solution of 4 parts white glue and 1 part water or Mod Podge to seal the paper.
- When mixing the resin and hardener, any cloudiness should clear up. If the product appears cloudy or is not crystal clear, contact our customer support team before applying to your final project.
- This product can be mixed with pigment powders and liquid dyes to achieve your desired color. Do not mix any oil or water-based products with the resin. When in doubt, test a sample batch to ensure you can achieve your desired color without issues.

BEFORE YOU BEGIN

Work Environment: The ideal working temperature is around 65-75°F in a clean, dry, dust-free environment. Avoid working in high humidity. If you are pouring in large volumes of 2 or more gallons, we suggest keeping room temperature closer to 65°F. We highly recommend keeping fans on your project to help dissipate heat.

Coverage: You can use the coverage calculator on our website to determine the volume of mixed resin that you will need before you begin your project. Please remember, this is not an exact science, as each project is different and each substrate will absorb the epoxy differently. As the product fills the cracks and crevices in your mold, the level may drop. Be prepared to add more epoxy as needed. The calculator does not take into account embedded objects. It is always best to have more than enough material on hand to ensure completion of your project.

Seal Coat: A thin seal coat may be necessary when working with a porous surface or object. Some surfaces may contain both air and moisture that can contaminate the finish. We suggest applying a thin coat of Epox-It as a seal coat. Other water-based clear coats may also be used. To ensure proper adhesion, we suggest scuffing the surface of the epoxy or clear coat with 320-grit once cured. Do NOT use over an oil-based paint or stain.

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Materials: Be prepared with all necessary materials and tools before beginning your project. These items might include (but are not limited to) two-part resin kit (Parts A and B), graduated mixing containers, clean stir sticks or power mixer, gloves, torch or heat gun, drop cloth, casting molds, etc.

MIXING & POURING

Step 1: Prepare 1 part Base Resin (Part A) and 1 part Curing Agent (Part B) by liquid volume. Pour the Curing Agent first and then the Base Resin into a clean, smooth-sided container large enough to hold all of the liquid, allowing room for mixing without spillage. Use graduated mixing containers help to ensure properly measured amounts of Part A and B. Any variance in this mix ratio may result in curing issues.

Step 2: The material must be mixed thoroughly for at least 5 minutes. Be sure to scrape the sides, corners and bottom of container as you mix. Be careful not to whip excessive air into the mixture. If mixing a gallon, use a power mixer set to "hand speed". For smaller quantities, use stir sticks. Do not mix more than 3 gallons at one time. If you need to mix several batches, be sure to use a clean, dry container for each batch. Using the same container may lead to curing issues.

Step 3: Pour the mixed resin into the mold or onto surface of project. Do NOT scrape out the last of the resin onto your project as unmixed epoxy on the sides or bottom of the container could contaminate your project, leading to curing issues. We recommend pouring no more than 1/8” per application, depending on mass poured.

Step 4: To remove air bubbles that have risen to the surface of the poured resin, use a heat gun or torch in a sweeping motion across the surface, holding the heat source approximately 6-10 inches away from the surface until no bubbles remain. Avoid heating any one spot for too long so as to prevent any distortions in the finish.

Step 5: Curing times can vary greatly by project, depending on mass and temperature. Work time ranges between 25-30 minutes, and cure time is 72 hours Do not use or place any items on your project during this time.

Step 6 (optional): If you are going to make a second pour, the first pour should be firm but tacky to the touch (roughly 4-6 hours). If you wait until the surface is well cured, a light sanding is suggested before the recoat to ensure proper adhesion. We suggest scuffing the surface with 320-grit. Once sanded, clean the surface thoroughly with Isopropyl Alcohol to remove any dust and debris.

CLEAN UP & DISPOSAL

Tools can be cleaned with isopropyl alcohol 99% or a residue-free cleaner. Do not use soap and water.

Dispose of product and container according to Federal, State and local regulations. Store any remaining product in the original bottles, tightly sealed and locked up in a cool, dry environment.

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SAFETY

Safety: Before use, thoroughly read Safety Data Sheets and product labels. Follow safety precautions and directions.

Resin: Keep out of reach of children. Avoid breathing vapors. Use with adequate general or local exhaust ventilation to minimize exposure levels. If needed, a NIOSH-approved respirator with organic vapor cartridge may be used. If inhaled, remove victim to fresh air and keep at rest in a position comfortable for breathing. Wear impervious gloves, such as butyl rubber or nitrile rubber. Wash skin thoroughly with soap and water after handling. Take off contaminated clothing and wash it before reuse. If skin irritation occurs, get medical help. Wear eye protection, such as chemical safety glasses/googles. If in eyes, rinse cautiously with water for several minutes, removing contact lenses if present and easy to do. If eye irritation persists, get medical help.

Hardener: Keep out of reach of children. Do not eat, drink, or smoke when using this product. If swallowed, rinse mouth and get medical help. Use with adequate general or local exhaust ventilation to minimize exposure levels. If needed, a NIOSH-approved respirator with organic vapor cartridge may be used. If inhaled, remove victim to fresh air and keep at rest in a position comfortable for breathing. Wear impervious gloves, such as butyl rubber or nitrile rubber. Wash skin thoroughly with soap and water after handling. Wear eye protection, such as chemical safety glasses/googles. If in eyes, immediately rinse with water for several minutes, removing contact lenses if present and easy to do. If eye irritation persists, get medical help.

WARNING: THE EPOXY CURE REACTION IS VERY EXOTHERMIC. Do not apply in thicknesses greater than the recommended maximum application thickness for the product. DOING SO CAN CAUSE WARPING AND EVEN A FIRE.

DISCLAIMER: The information contained herein is considered accurate; however, Specialty Resins makes no warranty regarding its accuracy. The user must determine the suitability of the product for the intended use and accepts all risk and liability associated with that use.