



WE HIGHLY RECOMMEND TESTING A SMALL TEST AREA OR SAMPLE PIECE BEFORE BEGINNING YOUR FINAL PROJECT.

Top 3 Issues That Lead to Poor Results

1. Incorrect mixing ratios and incomplete mixing lead to uncured, tacky areas on your project. It is critical that you measure at a 2:1 mix ratio by liquid volume and mix for a full 5 minutes while scraping the sides and bottom of container while mixing.
2. Because this is such a thin material, it is important that you have a watertight frame. Any cracks /crevices/holes need to be sealed prior to pouring to prevent leaking, and ultimately losing product.
3. Working with Pourable Plastic requires an optimal work environment at a temperature between 65-75°F. NOTE: When pouring larger volumes, 2+ gallons at a time, lower temperatures are preferred to allow the heat to dissipate. Fans are highly recommended for larger pours.

Safety Precautions

Causes serious eye and skin irritation. May cause allergic skin reaction. Harmful if swallowed. Toxic to aquatic life with long lasting effects. Use this product only in a well-ventilated area with protective gloves and eye protection. Do not eat, drink, or smoke when using this product. Do not expose product to direct sunlight. When mixed together in mass, this material can generate excessive heat; handle with caution. Refer to the SDS for detailed safety information.

This material is for professional use only, using adequate ventilation and protection from eye and skin exposure. Any information supplied with this material is given in good faith but should be verified by the end user as to the suitability of the material for their application. The warranty of this material shall be limited to the replacement of defective material.

Frequently Asked Questions

Q: Why is my project still tacky? How do I fix it?

A: The epoxy should feel well cured after 72 hours, however, full cure and maximum hardness can take up to 7 days, depending on mass and temperature. If it is still tacky, this is likely due to incomplete or inaccurate mixing. Contact our customer support team for assistance.

Q: My project warped or cracked. Why did this happen?

A: It is likely that the epoxy was unable to dissipate heat properly and an accelerated reaction occurred. It is critical that you bring the room temperature down to 65-70°F when pouring in large volumes of 2 or more gallons at a time. We suggest pouring thin layers of 1.5" for larger quantities. If pouring more than 5 gallons at a time, thin pours of 1" or less may be necessary to prevent excessive heat generation.

Q: Crystallization appears in my bottles. Can I still use this product?

A: If your bottles arrive cold, are stored in a cool environment, or if you notice crystallization, you must allow the epoxy to acclimate to room temperature (65-75°F) prior to mixing/pouring. Contact our customer support team for more info.

Q: Is this product food safe?

A: Because it is up to the end user to properly mix, pour and cure the epoxy, each mixture/application would have to be assessed individually.

Q: How do I add swirls in the epoxy or keep the pigment powder from settling?

A: Because this is such a slower curing product, you may need to go back in later in the curing process, right before the product sets, to add swirls or to keep the pigment powder suspended. You might need to play with the timing, as each project will cure at a different rate, depending on mass and temperature. Gel time can vary but usually occurs between 18-24 hours after pouring.

Thank You For Your Purchase!

At Incredible Solutions, we are dedicated to providing our customers with exceptional customer service. Please feel free to reach out with any questions regarding the use of our epoxy. More information available at <http://incrediblesolutionsonline.com>



Instructions For: Pourable Plastic Clear Clear Casting Resin

Please read this entire instruction sheet before beginning your project. If you still have questions, please contact us for assistance. We are here to help!

**More Information Available:
<https://incrediblesolutionsonline.com>**

IMPORTANT: PLEASE NOTE

- Pourable Plastic is a casting resin/deep pour epoxy that can be poured up to 2" thick in small quantities. Larger pours (3 or more gallons) may be poured in layers of 1.5" or less. When pouring more than 5 gallons at one time, layers of 1" or less may be necessary to prevent excessive heat generation. We highly recommend using fans on your project to help combat overheating.
- This product should not be used for coating applications or thin pours less than ½".
- Room temperature should be between 65-75°F when mixing, pouring and curing. When pouring in masses over 2 gallons, we suggest staying at the lower end of that temperature range.
- Because this is such a thin material, it is critical that your frame or mold is watertight. Frames should be built out of material that can easily dissipate heat.
- This product is very slow curing, which allows for thicker pours. Cure times vary by project as it largely depends on mass and temperature. Gel time can range from 18-24 hours, and cure time from 36-72 hours.
- We do not recommend pouring over bark, as bark can hold excessive air and moisture.
- 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 our Table Top Epoxy 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 Table Top Epoxy. 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 Curing Agent and Base Resin, 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 Table Top Epoxy 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.

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.

LET'S GET STARTED: MIXING & POURING

Step 1: Prepare 2 parts Base Resin (Part A) and 1 part Curing Agent (Part B) by liquid volume (100 A to 44 B by weight). 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 2" 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" 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. Gel time ranges between 18-24 hours, and cure time may range between 36-72 hours. Full cure and maximum hardness can require up to 7 days. 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 48 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 99% to remove any dust and debris.

CLEAN UP & DISPOSAL

Tools can be cleaned with T-12, 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.