



## Beginners Notes

This product provides professional results when applied correctly. Take your time, and be aware of these common problems often encountered by first time users.

1. Always make sure that your mixing container is clean and your measuring device is accurate. This product requires that you mix at a 2 : 1 ratio by volume. **Any** variance from this can cause FlowCast to stay soft and not fully cure.
2. This product requires **thorough** mixing, typically between 2 - 3 minutes. (Avoid excessive whipping, which can introduce air bubbles into the epoxy). 4L batches can require up to 6 - 7 minutes of mixing. Beginners should not attempt to mix more than 4L liters total per batch: we recommend smaller 2L batches until you are comfortable with how the product works.
3. When both components are poured together and stirring begins, the mixture will turn a cloudy white. This indicates areas in which the two parts have not fully combined. Continue to mix until all signs of cloudiness and small white swirls have disappeared completely (typically 2 - 3 minutes of thorough mixing).

4. Be sure to scrape the sides of your mixing container and the stick during the 2 - 3 minutes of mixing. If unmixed epoxy remains on the side of the container or the stick it will cause wet spots on your finished product.

5. While pouring FlowCast, **never** scrape the container to remove every last drop. No matter how thoroughly you mix, there will always be traces of unmixed epoxy on the sides of the container which can result in wet spots.

## Application Instructions

**Volume Calculation:** To calculate your required volume, simply multiply the length x width x depth of your pour. Use an average measurement for uneven sides. While FlowCast® will not shrink during curing under normal conditions, we recommend adding an additional 5% to your calculated volume. This ensures the target pour depth is met by addressing resin that fills cracks and voids in the wood. [Check out the user friendly volume calculator on our website!](#)

**Metric Example:** 61cm x 15.2cm x 3.8cm + 5% = 3700cm<sup>3</sup> (÷ 1000 = **3.7L**)

**Bonds to:** Wood, Metal, Concrete, Granite, Stainless Steel, Laminate, Formica, Bamboo, Leather, Ceramic, Fiberglass, Plastic, & much more.

**Mixing Instructions:** In a clean, dry container; combine (by volume) 2 parts resin with 1 part hardener, and mix thoroughly for 5 minutes. Add color or metallic pigments as desired and mix until evenly dispersed.

**Step 1: Seal Coating Objects:** We recommend using our UVPoxy for seal coats and thin coating as FlowCast has a very low exothermic reaction, making it unsuitable for thin coats. Using a foam brush, apply a thin layer of UVPoxy to any porous object or surface to be encapsulated. This thin layer will seal pores in the object, preventing bubbles from forming during the pour. Allow 4 - 8 hours between sealcoat and pour. Keep in mind that seal coating may compromise adhesion in some situations as the epoxy cannot penetrate as deeply into the surface or object and is therefore not advisable in all situations.

**Step 2 - The Pour:** Working area should be clean & dry, and free of dust and insects. Settling dust can cause blemishes on the glossy surface. FlowCast can be poured 13 - 38mm thick per layer. The chemical reaction of curing epoxy releases heat. For pours of 12L volume or more, multiple thinner layers/pours may be necessary to prevent overheating. Fans blowing across the curing epoxy are also strongly recommended to help dissipate heat. For best adhesion between layers, wait 48 hours between pours (until the previous layer has set but is still tacky to touch). If the previous layer is no longer tacky, sand with 220 grit sandpaper and wipe down before pouring another layer. FlowCast may slowly fill cracks and voids in your mold, causing the level to drop. Be prepared to add more epoxy as needed.

**See SDS and TDS sheets available on our website for more info**

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