



WHATSUP TECHNICAL QUESTION PHONE:+905557476680 (ONLY CHAT) PLEASE FIRST SAFE DATA SHEET BEFORE USING IN PACKAGE !

ARC CRYSTAL CLEAR CASTING AND HOBBY SUPER GLOSS RESIN KIT

ARC TABLE TOP RESIN KIT 2:1 MIX RATIO(VOLUME) IS HIGH QUALITY ULTRA CLEAR CASTING RESIN FOR MULTI PURPOSE ART AND HOBBY APPLICATION IN FURNITURE,ART, JEWELERY ,CRAFTS, TABLE COVERING, WITH LOW EXOTHERMIC HEAT AND EXTRA UV THAT RESISTS YELLOWING..

- Ultra Crystal Clear Resin and Hardener
- Eco friendly Resin Kit – Non toxic and Non solvent
- 100% Solid
- Self –Leveling system
- Extremely Durable
- Extra UV
- Superior Air Release qualities
- Impact Resistant
- Excellent Color Stability- non yellowing stability in years
- Easy to use
- High-Gloss Waterproof Finish
- Perfect surface flatness and Wonderful strenght

It can be casted middle thickness and cures to glass-water like with allowed bubbles easily escape.

HOW DO WE HAVE A GOOD APPLICATION ?

1-Working Conditions is very important to Access !!!

Firstly, all materials and working conditions should be maintained at a constant 60°F-75°F. Epoxies

like cool temperature between application to geletion.When cool, it's thicker and sets slower. When warm, it's thinner and sets faster. When you are working above 75°F, arc deep pour system may set too quickly and exotherm (become too hot) which could cause it to yellow, distort, shrink or crack.

1-MIX RESIN AND HARDENER !

- You must mix resin and hardener in a clean dry container (preferentially choose the large container to width because with this detail you can extend the POT-LIFE time so you can won to much work time)
- **Measure 3 parts A VOLUME (RESIN) and 1 part B VOLUME (HARDENER)**
- Mix 3-8 minutes (Its changable to users) and you must sure to mix homogeneous.
- Transfer to second large container Allow to rest for any bubbles to rise the top and escape.
- Generally we dont suggest a heat gun for bubbles because there is a small but important rules in physics, if you give hot to air, volume of air is increase which you give hot so they can be seed so Please **CHOOSE YOUR CASTING –COVERING AREA 60°F- 65°F AND THEN OUR RESIN SYSTEM ALLOW THE BUBBLES EASILY ESCAPE IN FIRST ONE HOUR.**

2- ALWAYS MIX HOW MUCH DO YOU NEED !

- Be sure that how much do you need because firstly do you measure need quantity in below formüle and **KNOW THE CAST THICHNESS** and again sure that dont wait much as to POT LIFE (waiting time in container after mix).

3- HOW MUCH INCHE CAN YOU CAST FOR ALL POUR ?

This is very important topic for quality clear casting . It is depending on many factors like shop or workplace temperature , resin and hardener temperature , mixing quantity , mould and product design, resin area etc. The main strategy is that if you cast in cold area you can apply thick , if your area is hot , you must decrease the thickness and You must know the epoxy character which brand you use. For ARC TABLE TOP, you can cast or covering **1 ‘ (inch) maximum per pour.**

(This is our main difference which you can not find in any brand)

4- WHAT SHOULD WE PAY ATENTION ABOUT SURFACE AND CHOOSE WOOD ETC ?

Especially you mus pay atention to choose dry wood or what kind of cast objects. The wood moisture must be under % 15 , if you dont measure this, please apply a seal coat the wood 1-2 time with same resin and hardener mixing with brush etc , its means you can isolate the wood with wood inside mositure and bubbles.And of course your all surface and materials must be clean and free of contamination. You can use sand paper from 80 to 240 grit paper for clean the surface ..

5- HOW CAN WE CAST HIGH THICKNESS WITH LAYER ON LAYER ?

The maximum casting depth of ARC TABLE TOP is 1” for all layer, but deeper castings can be achieved by step pouring multiple layers. Each layer **MUST** be allowed to cool to room temperature (60-80°F) before adding additional layers. Once cooled, you can pour the next layer without additional surface prep all the way up until you can no longer indenta fingernail

into the previous coat. No sanding necessary. Warmer temperatures will set faster, and cooler temperatures will set slower. Large batches of mixed epoxy will also cure much more quickly than small batches. The average times for all layer gelation and waiting time in below ;

ROOM TEMPERATURE	MIX QUANTITY	THICKNESS	MUST WAITING TIME BETWEEN LAYERS
50-60 °F	0-2 GALLON	0-0.5"	4-6 HOURS
60-80 °F	2-4 GALLON	0.5"- 1"	6-8 HOURS

6- POT-LIFE-WORKING TIME AND CURING TIME

Epoxy is a mass and temperature sensitive material. The gel time (time it takes the mixed epoxy resin and hardener to initially harden up) can vary drastically depending on any number of factors such as mixing mass, material temp, ambient temp, mixing time, speed of mixing, speed of application, casting and coating thickness, etc. A table shows a 4-6 hour gel time at 80°F in a 0-1 gallon kit, but will set up much faster if warmer or left sitting for an extended time in a larger mass. The more you mix up, and the warmer it is, the faster it will gel. That being said, 10- 15 minutes is all it should take to carefully mix and pour. If the mixed epoxy starts to heat up in your mixing bucket, apply immediately.

CURING TIME :

ROOM TEMPERATURE	MIX QUANTITY	THICKNESS	GELATION TIME	CURING TIME
50-60 °F	0-2 GALLON	0,5"	4-6 HOURS	48-72 HOURS
60-80 °F	2-4 GALLON	0.5"- 1"	6-8 HOURS	36-60 HOURS

Keep in mind that epoxy is mass and temperature sensitive. Thin castings and cooler working conditions will cure slower, and thick castings and hotter working conditions will cure faster.

7- FINISHING THE SURFACE AND POLISHING

If you prefer the wood parts of your table to have a natural finish, contrasting against the glossy high-shine resin parts then you will need to sand or machine the whole surface of the table and then polish the resin up to a full gloss.

Once the surface of your table is flat, you will need to use a hand-held sander (orbital or dual action) to sand and smooth the surface of the wood and resin. Start with the most coarse grit abrasive and work up to the finer papers through the grits. We would suggest the following grits - 120, 240, 400, 800, 1200, 1500 and finishing on 2000-3000.

Although the surface of the wood will quickly become very smooth, it is really important to take time on the resin to make sure that all scratches from the previous grit have been

completely removed by

the current grit before progressing on to the next one. If you don't do this, you will find that when you polish the resin at the end of the process, you will see shiny scratches left by earlier grits in the sanding process.

We generally recommend MIRKA PAST AND MIRKA 8-10 POLISH is designed to be highly polishable, however the resin is very tough and requires a high quality polishing compound and a power polisher in order to finish it to a high gloss.

When polishing MIRKA POLARSHINE 35 we suggest starting from at least a 3000 grit abrasive paper finish. We recommend POLARSHINE 8-10 polishing compound to polish the POLARSHINE 35 because it is a fast-cutting compound designed specifically for hard-wearing plastics like epoxy resin. Additionally, NW1 uses a special low-drag formula which reduces heat build-up whilst polishing.

Nonetheless, if you do start to feel heat building up in the resin when polishing you should stop or move on to another area.