

Klear Kote Epoxy

Application Instructions

ESTIMATING COVERAGE

1 gallon of mixed epoxy contains 231 cubic inches of volume; therefore will cover approx. 1.6 square feet at 1 inch thick and approx 6.5 square feet at ¼ inch thick, 13 feet at 1/8", and 26 feet at 1/16". Coverage must include surfaces, edges, and an extra 2% for run off on the edges.

SURFACE PREPARATION

Although it is not possible to address every type of surface the following is a generic guideline: Bare wood should be sealed with a thin coat of epoxy, decoupage articles should be tested for color fastness prior to application. When recoating an existing coating the coating should be scuff sanded and cleaned with a cleaning solvent. Denatured Alcohol is recommended. Be sure that the surface and the epoxy to be mixed are at the same temperature, preferably 70-85 deg. F.

PERSONAL PROTECTION

Read MSDS before opening. Wear latex gloves because liquid epoxies can sensitize the skin. Wear a plastic apron, epoxy can soak through your cloths and again sensitize your skin. **Most Important** - Wear safety glasses, liquid epoxy can be transmitted into your eyes through involuntary actions from your hands.

MIXING

Mixing is the most important part of the project. Improper mixing will cause soft or tacky spots in the surface. **First** be sure you are preparing to mix containers of Hardener and Resin, believe it or not mistakes happen, check the labels. Graduated mixing containers are recommended for measuring and mixing. Hand mixing with a paint type stir stick is recommended, mixes should not exceed 1.5 gal. Continual mixing including sweeping the sides and bottom of the mixing container while mixing should take approx 3 minutes. **It is best to use two containers for mixing.** Mix the product in one container for a period of 1-1/2 minutes, making sure you scrape the sides and bottom of the container to mix all the resins. After mixing in the first container pour the entire mix into the second container, scraping the entire product from the first container, mixing the product for another 1-1/2 minutes. **The reason for this is that no matter how complete the mix is, there are unmixed portions on the sides and bottom of the mixing container.** The product may cloud a little during mixing but will clear as mixing nears completion.

APPLICATION

Epoxy is self leveling; therefore the surface must be level for uniformity. The epoxy may be poured on the surface and spread with a plastic hand trowel.. It is not recommended to apply more than 1/8 in. thick per coat. Thick films are achieved through multiple coats. Once the epoxy is applied to the desired thickness tiny air bubbles will appear on the surface. Wait approximately 20 minutes after pouring. The bubbles need to be eliminated by passing the **low flame** of a propane torch systematically over the surface keeping the flame at least 3 inches from the surface. It will be necessary to repeat this process until the bubbles stop surfacing. You will now have a glass like surface.

CURE TIME

Cure times will vary with temperature and thickness. Klear Kote will be tack free in a 1/8 in film at 77deg, F in approximately 8 hrs and ready for service in 24 hrs.

Important note: Even though the film will appear hard the epoxy will not reach full cure for 14 days. **Therefore**, do not leave objects on the surface until fully cured. When used for bars or table tops any hot items like coffee cups hot plates etc .over 140deg.F will leave a ring or impression on most any epoxy. The use of saucers under cups and heat resistant pads under hot plates are recommended to preserve the finish.

IMPORTANT NOTES ABOUT EPOXY

Epoxies cure through chemical reaction. The chemical reaction generates heat, the greater the mass of epoxy the faster the reaction occurs. Pot life is measured with about 4oz. of epoxy @ 77deg.F. Therefore a stated 40 minute pot life is for that 4 ounces. A 1.5gal mix in a bucket will only have a 10-15 min pot life.

Epoxies will amber slightly when exposed to sunlight, even for only several hours and will chalk in exterior applications. For exterior application a top coat with a UV inhibited Urethane is recommended.

Blemishes caused by contaminants or suicidal insects can be sanded out and recoated without ruining clarity.

If this is your first experience with Epoxy-EXPERIMENT ON A SIMILAR SURFACE before making a big mistake. Even the pro's have bad days...