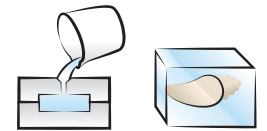


# ecopoxy®

## FLOWCAST KIT

### THE SAFEST EPOXY AVAILABLE!



Designed for  
Casting & Molding

## Application Instructions:

### Beginners Notes:

This material leaves professional results when applied correctly so take your time and make sure you are aware of these common problems we have seen 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 to 1 ratio by volume, any variances from this can cause the FlowCast to stay soft and not fully cure.
2. This product requires **THOROUGH** mixing, typically between 4 to 5 minutes of mixing without excessive whipping of the mixture (whipping will introduce air bubbles into the epoxy). Mixing 4 liters at a time can require up to 6 to 7 minutes of mixing. Beginners should never attempt to mix more than 4 liters total per batch, 2 liters per batch is suggested until you are comfortable with how the product works.
3. After the two components are poured together and stirring begins the mixture will turn a cloudy white color, this represents areas in which the epoxy has not fully combined. You must continue to mix until all signs of cloudiness and tiny white lines have completely disappeared (typically takes 4-5 minutes of thorough mixing).
4. Always scrape the sides of your mixing container and also the stick during the 4-5 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 onto a surface **NEVER** scrape the container to remove every last drop, no matter how thorough you mix there will always be an unmixed drop on the side of the container that will leave a wet spot.

**Mix Ratio:** 2:1 (by volume)

**Work Time:** 8 hours\*

**Cure Time:** 72 hours\*

**Set to Touch:** 48 hours\*

**Temperature:** 21-27°C (70-80°F)

**Clean Up Solution:** Isopropyl/Denatured Alcohol

**Storage Temp:** 10-25°C (50-77°F)

Recommended

**Pour Depth:** 6-38mm (1/4 - 1.5") Per Layer\*.

Do not exceed 25mm (1") per layer for pours over 20L.

\*Varies depending on temperature, humidity, and pour depth.

**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.

### Application Instructions:

**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 step 2, allow 4 - 8 hours between sealcoat and pour. It is important keep in mind that sealcoating 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 6-38mm thick (1/4" - 1.5") 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). If the previous layer is no longer tacky, sand with 220 grit sandpaper and wipe down before pouring another layer. FlowCast may shrink up to 1% while curing under normal conditions and it may also slowly fill cracks and voids in your mold, causing the level to drop. Be prepared to add more epoxy as needed.

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



Visit us online for detailed instructions, tips, and other info.

See SDS for more information.

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