

EPOXY ON WOOD





COMPLETE GUIDE TO USING EPOXY RESIN ON WOOD



ROCK-HARD EPOXY RESIN



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ROCK-HARD EPOXY RESIN

Introducing Industrial Clear

“Our goal was to develop an epoxy resin that cures to a **hard**, beautiful finish while prioritizing user **safety**.”

Hey there, we're Dave and Rebecca Zak and we love solving problems by creating things. We designed **ArtResin®**, the original safe epoxy resin for artwork, and Industrial Clear, our solution for projects that require even more **strength** and **durability**. Designed to handle the toughest of jobs, Industrial Clear offers an exceptionally **clear**, **rock hard**, **food safe** and **chemical resistant** finish. Industrial Clear is ideal for table tops, bar tops, charcuterie boards and serving trays.

With an **easy-to-use** formula, it's **safe** to use in any space you prefer, whether it's your workshop, garage, shed, or even at the family dinner table.

You've worked hard on your projects, and you deserve a resin that works just as hard to showcase them. We believe Industrial Clear will help you achieve great things. Give it a try and let us know what you think!

Dave & Rebecca Zak





ROCK-HARD EPOXY RESIN

The Rock Hard Difference

Industrial Clear gives your project a gorgeous, long-lasting finish.

Whether you're working on wood projects, boat building, or protecting surfaces like concrete floors, counters, tables, or bar tops, Industrial Clear cures into a **clear, rock hard coating that resists scratches and damage** from everyday use. Its strength and durability also make it an excellent option for manufacturing and industrial applications.

When prepared according to the label instructions and fully cured, Industrial Clear has an impressive **Shore D rating of 83** and a **tensile strength of 7100 psi** (ASTM D638). This means it's an incredibly strong and durable epoxy that won't easily bend, with just the right amount of flexibility to prevent cracking.

Once cured, Industrial Clear is **highly resistant to high heat, oils, gasoline, bleach, most cleaners, and chemicals**. With Industrial Clear, your project will look beautiful and remain well-protected for years to come.



HIGH HEAT TOLERANCE



CHEMICAL RESISTANT

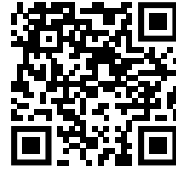


MACHINABLE
• DRILL
• SAND
• CUT



SHORE HARDNESS SCALE

Visit our **Technical Data Sheet**
industrialclear.com/techdata



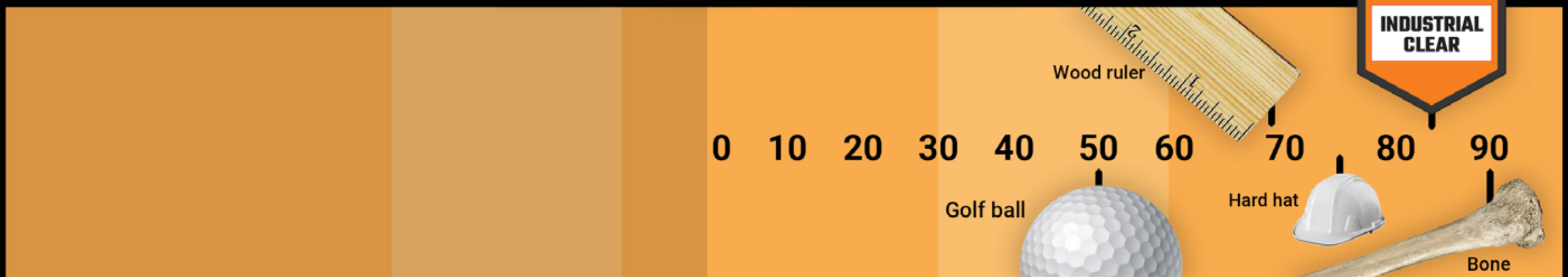
SHORE 00



SHORE A



SHORE D





ROCK-HARD EPOXY RESIN

Safety Matters

Industrial Clear's safe formula lets you focus on your project with peace of mind.

Industrial Clear's formula contains **no solvents or diluents**, doesn't have a noxious odor, and releases **no fumes or VOCs**. As long as you're working in a well-ventilated space, no respirator is required. Being **non-flammable**, you won't need to worry about fires if you are working in a space with a gas heater.

Industrial Clear is free from ingredients that can harm your eyes or skin, so unlike other tabletop epoxies, you won't find skull & crossbone or corrosive warnings on our label or Safety Data Sheet. Of course, epoxy is sticky so we always recommend wearing gloves.



Industrial Clear Is Food Safe

Industrial Clear has passed worldwide food safety standards and is **safe to use as a food contact surface** when prepared according to the label directions. Use it to coat serving trays, charcuterie boards, bar tops, counters or any other items intended for contact with food.

Avoid cutting directly on the cured surface to prevent scratches, but if they occur, sand down the surface, pour a fresh coat of Industrial Clear and your piece will look as good as new.

Visit our Safety Data Sheet

industrialclear.com/sds



A NOTE ON TINTED RESIN:

Adding materials like colorant to the original Industrial Clear formula may compromise its food safety designation. For tinted resin projects meant for contact with food, apply a final top coat of clear Industrial Clear.



FDA 21CFR175.300







ROCK-HARD EPOXY RESIN

How To Choose Wood

Industrial Clear enhances the natural beauty of wood and protects it for years to come.

Industrial Clear looks great on cross section slabs of walnut, maple, cherry or ash, but the key is to **choose wood with a grain and color that you love.**

Don't underestimate **the beauty of wood with wormholes, knots, cracks, holes and burls.** In fact, Industrial Clear takes these natural imperfections and turns them into eye-catching design elements. Industrial Clear also stabilizes wood by filling holes and cracks and provides long-term protection to live edges.

Start with clean, dry wood.

If you're working with a lot of wood, a **moisture meter** is a good investment. Aim for a moisture reading of 12% or less (although this can vary depending on the type of wood you use).



Moisture meter

We suggest getting kiln-dried wood from a reliable supplier. Air drying is another, more cost-effective method but one that takes longer, typically **one year per inch of wood thickness.**

No matter where you source your wood, store it indoors in a dry and climate-controlled environment to avoid moisture related epoxy issues.



Wet wood

MOISTURE IN WOOD CAN CAUSE:

- a cloudy cure
- poor adhesion
- expansion and contraction of the wood with changing weather, causing even a strong epoxy like Industrial Clear to crack. Luckily, cracks can be filled and re-coated with more epoxy.





ROCK-HARD EPOXY RESIN

Supplies List

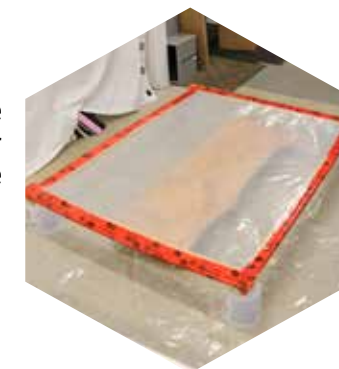
Here are the basic tools to get started:

Measuring cup with graduated lines and mixing buckets: larger is better to prevent splashes

Plastic drop sheets to protect your worktop and floor



Dust cover large enough to cover your piece



Paper towel or rags for spills and clean up

Sheathing and painters tape to seal the bottom of holes in the wood and protect the bottom from drips



Propane torch head with flame spreader attachment to remove bubbles. The BEST tool for the job.

Level to ensure a level surface

Wood Shims: to help make wood level

Spray bottle of alcohol for clean up

Pumice hand cleaner: Apply to dry hands, and wipe off with a rag.

Gloves: Resin is sticky so have several pairs on hand. If your gloves get too sticky just get new ones.



A stir stick with a flat edge to scrape the sides and bottom of the container

Toothpicks to remove dust or to pop stray bubbles

Jagged tooth spreader to spread out resin on surface while leaving resin behind

Industrial Clear epoxy resin: Determine the exact amount you'll need for your project:

Visit our calculator: www.industrialclear.com/calculator



Painter's pyramids or small plastic cups to elevate the piece off the table



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Adding Color

Elevate your project with **color!**

- Tinted epoxy accentuates natural features in wood like cracks and holes.
- Mica powder creates the **swirled effect** popular in river tables.
- Add more colorant for a solid effect or less for a translucent look.
- Try pouring a tinted layer on the bottom with embedded items in a clear top layer.
- For best results, tint Industrial Clear with a concentrated, non-water based colorant like pigment paste, mica powder or a colorant specifically designed for epoxy resin.
- Don't add more colorant than **6%** of the total combined volume of resin and hardener or the epoxy may not cure properly. Start with a small amount and add more as needed.
- **Test first** to make sure you like the outcome.



Resin Tint and Alcohol ink
www.industrialclear.com/color

SAFETY TIPS

- Adding colorant to Industrial Clear will compromise its food safety compliance. To be safe, apply a thin layer of clear Industrial Clear as a final topcoat.
- Adding colorants that aren't labeled "non-toxic" to Industrial Clear means the mixture can no longer be considered non-toxic, and safety precautions should be taken.
- Don't use a flame torch on epoxy tinted with colorants containing flammable solvents, like spray paint or alcohol inks.



Prep Work

Setting Up For Success

- Wood should be clean and dry before applying Industrial Clear.
- Oily or waxy residue on the wood surface should be sanded off to prevent the epoxy from repelling.
- Remove loose pieces of wood or bark to prevent them from curing into the epoxy.



- If you plan to fill knots or holes, flip the wood over so the bottom side is facing up. Use sheathing tape to mask them off, including the small ones. Alternatively, you can cut a piece of acetate to fit over the hole and securely tape it to the wood.
- Press the tape firmly to create a tight bond that will prevent any epoxy from seeping out.



Stop bottom epoxy leaks



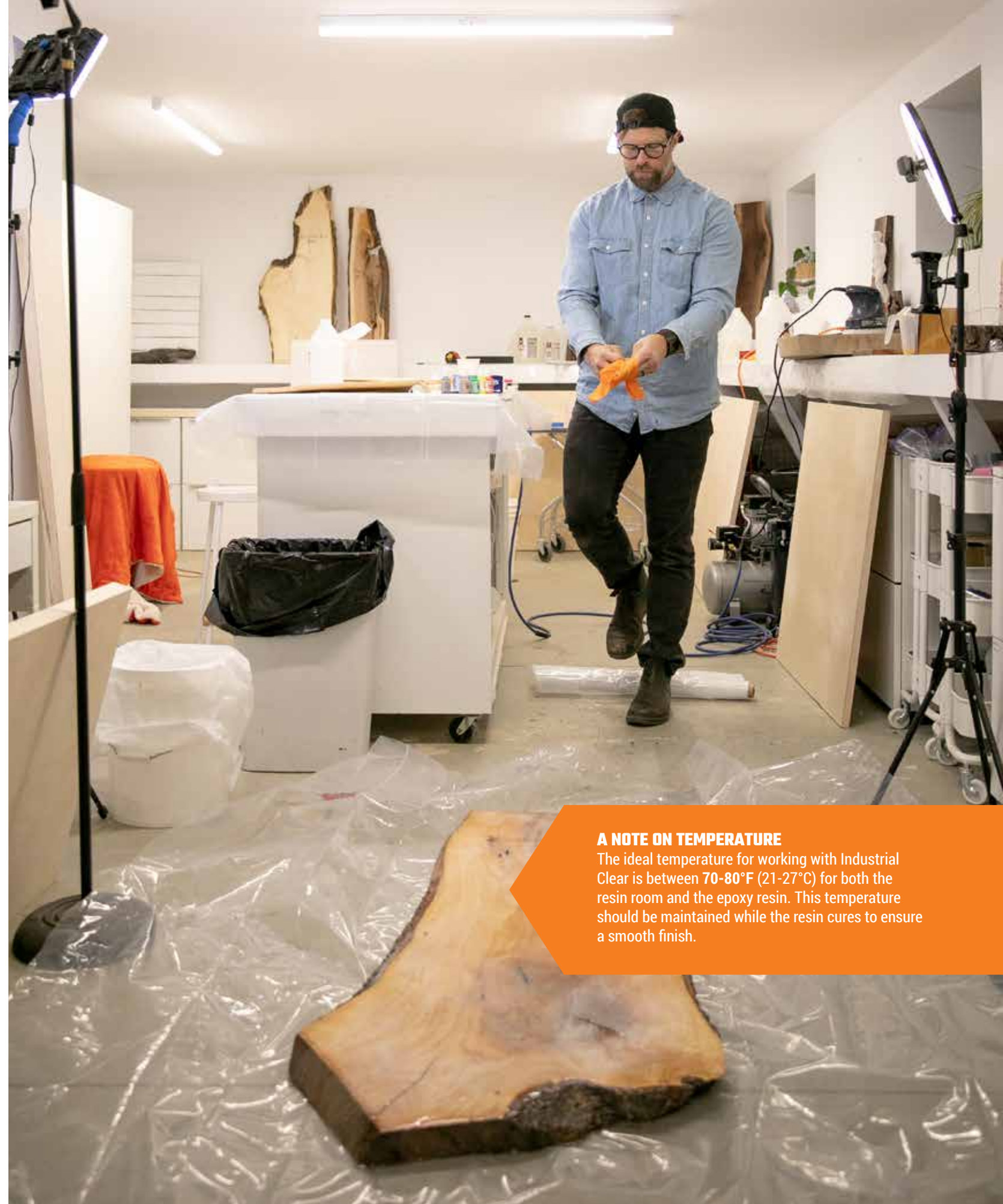
- Tape off the bottom perimeter with painter's tape. The tape will catch drips and can be removed once the epoxy is dry.
- Apply a line of silicone to the inner seams of DIY molds to prevent the epoxy from leaking out. Ensure the silicone is smooth and fully set before pouring epoxy into the mold.



- If you don't want epoxy on the sides of your piece, use painter's tape to tape them off.
- Line your work surface with a plastic drop sheet and have all of your tools laid out and ready to go, including your dust cover materials.
- Elevate the piece off of your work surface using plastic cups or painter's pyramids.
- Use a level and make adjustments with shims if necessary to ensure the wood is as even as possible.



Peel off bottom drips



A NOTE ON TEMPERATURE

The ideal temperature for working with Industrial Clear is between 70-80°F (21-27°C) for both the resin room and the epoxy resin. This temperature should be maintained while the resin cures to ensure a smooth finish.



ROCK-HARD EPOXY RESIN

Do I Need to Seal First?

Sealing wood prevents air bubbles and absorption, so you use less epoxy!

Porous materials like wood can release air bubbles into the epoxy. Very dry wood has a tendency to soak up epoxy, requiring multiple coats as a result. Applying a coat of sealant creates a barrier that prevents both of these issues.

- Apply 1-2 coats of wood sealant or Industrial Clear to dry wood using a brush, foam brush, or gloved hands. Pay close attention to sealing cracks, knots or voids in the wood. Allow to dry.



- If you've sealed with Industrial Clear, let it dry to the touch and then sand with 80 grit sandpaper to create a rough surface for the next layer to adhere to. Clean the surface of sanding debris and apply the flood coat of Industrial Clear. Alternatively, skip the sanding step by pouring the second coat of Industrial Clear at the 3-5 hour mark and the first coat is still sticky.



Test before sealing

It's important to note that **epoxy resin will change the color of wood**. In most cases, it greatly enhances the appearance; however, certain types of wood may become significantly darker.

We recommend conducting a small sample test first. Apply a small amount of resin to an inconspicuous spot and if the outcome is darker than you'd like, seal the wood with a clear drying wood sealant instead of resin to help preserve the original look.





2:1



Measure and Mix

Industrial Clear was intentionally formulated with a 2:1 mixing ratio to achieve a rock hard cure.

- Combine **2 parts resin to 1 part hardener, by volume**. You can pour and mix in the same container in any order, as long as you stick to the correct ratio.
- Follow the recommended mix ratios on the instructions. Do not weigh the components or add more hardener to speed up the cure, or you'll end up with a sticky mess.
- Mix thoroughly for **4 minutes** using a flat-edged mixing stick to scrape the sides and bottom of the container, **stirring slowly to minimize bubbles**.
- Remove loose pieces of wood or bark to prevent them from curing into the epoxy.

- After mixing, you can add pigments or keep it clear, and then you're ready to pour. You have approximately **45 minutes** to pour and spread Industrial Clear before it becomes too thick to work with.
- As long as you've measured accurately and mixed thoroughly, you shouldn't have issues with the epoxy curing.
- To determine the required amounts of resin and hardener for your project, please use our online calculator at www.industrialclear/calculator.

MIXING LARGE AMOUNTS

For large amounts, we recommend stirring by hand with a bucket and large stir stick. Avoid drill mixing attachments if possible: they create an abundance of bubbles and don't effectively scrape the sides of the mixing container.

stir slowly to minimize bubbles.



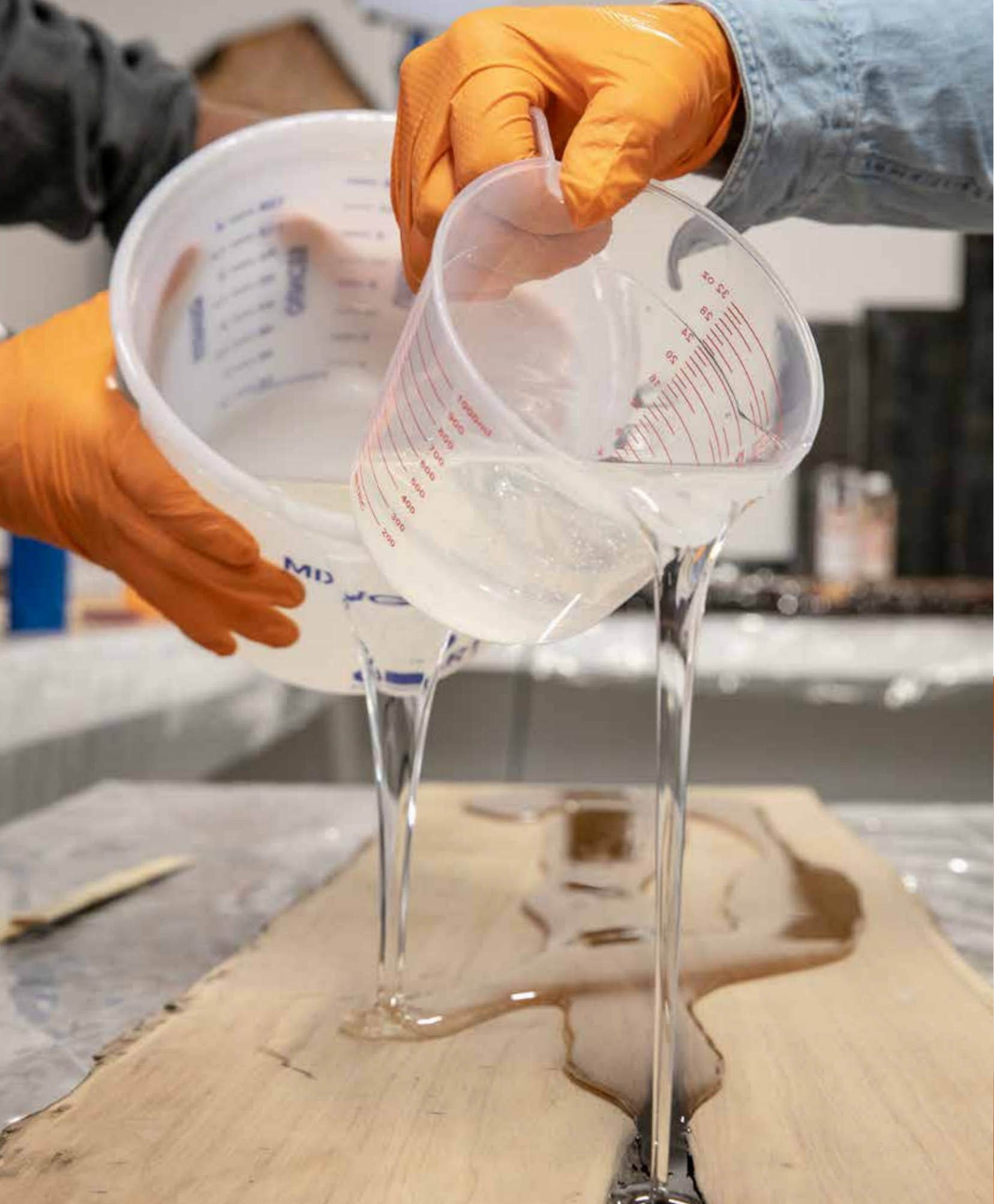
Visit our calculator
www.industrialclear.com/calculator

A NOTE ON POURING

Epoxy resin is sensitive to both mass and temperature, and if left to sit in the mixing container, it will cure much more quickly, potentially even flash curing. For this reason, we advise pouring within 45 minutes of mixing for best results.

It is best to use a large container with a wide opening rather than one that is tall and narrow to help avoid an exothermic reaction.





ROCK-HARD EPOXY RESIN

Pour



This is the fun part! Enjoy your pour.

- Pour Industrial Clear in the center of your piece. It will naturally begin to **self-level** to a thickness of approximately 1/8" or 3 mm.
- Industrial Clear epoxy resin can also be injected into a small cavity or a mold with a syringe. We do not recommend applying epoxy resin with a sprayer or an air gun.

POURING INTO MOLDS:
Industrial Clear can be poured in layers up to 1/2" or 12 mm at a time. Thicker layers can lead to trapped bubbles in the resin or an excessive heat buildup, which may cause a flash cure. To achieve a thicker coat, it's recommended to pour Industrial Clear in multiple layers.





Spread



Spreading Techniques

- After pouring, use a flat or jagged-edged spreading tool to gently guide the epoxy to the edges.
- You can either bring the epoxy right up to the edges without going over, or allow it to run over, using a brush or gloved hand to smooth out the sides.
- If you've taped the bottom of your piece off before pouring, remove the tape (and the drips) once the epoxy is dry to the touch, approximately 18-24 hours after pouring. Alternatively, wait until the resin is fully cured and use a Dremel or hand sander to remove any resin drips that may have accumulated on the bottom.







INDUSTRIAL
CLEAR

ROCK-HARD
EPOXY RESIN

Torching

Torching for a bubble-free finish

- After spreading the epoxy, remove surface bubbles by quickly running one or two passes with a flame torch over the entire piece.
- Be careful not to hold the flame too close or in one spot for too long.
- For best results, use a propane or butane torch. While a heat gun can create cells and other effects with tinted resin, it lacks the necessary heat to effectively pop bubbles.
- Keep the flame 4-6" from the surface for best results.



Flame spreader attachment

The best tool for the job!

www.industrialclear.com/torch



OVERTORCHING

When it comes to torching, **less is more**. Overtorching can result in imperfections like yellowing, ripples, or an alligator skin effect. Do not torch epoxy past the 45 minute working window.





Covering & Cure Times

Cover and Cure

• Once the bubbles have been torched, examine the surface for remaining bubbles or dust and remove them with a toothpick. **Cover your work with a dust cover to prevent anything from landing on the wet epoxy.** A large clean cardboard box or plastic tote works well. For oversized items, create a tent by propping something large and sturdy over top of the piece and covering it with a plastic sheet.

• Industrial Clear will be **solid and dry to the touch at the 24 hour mark and will reach a full, rock hard cure at 7 days.**



A NOTE ON TEMPERATURE

Epoxy resin cure times are affected by temperature. It will take longer for epoxy to cure in cool temperatures whereas warm temperatures promote a faster cure. The ideal working temperature for Industrial Clear is between 70-80F (21-27C) and should be maintained while the resin cures. Sometimes resin that seems "bendy" hasn't finished curing yet and just needs a little more time or to be moved to a warmer environment.



Cleaning Up

Easy clean up starts with your prep work

- Line your work surface and floor with **plastic drop sheets** to keep clean up simple.
- Keep a roll of **paper towel** and a spray bottle of isopropyl alcohol to wipe tools and clean up spills and drips.
- Wear **disposable gloves** to protect your hands from a sticky mess.
- Epoxy resin doesn't adhere to plastic so work with a reusable plastic spreader, stir stick and mixing container for easy clean up.
- **Wipe wet containers and reusable plastic tools with paper towel** to remove as much epoxy as possible. Wipe down once more with isopropyl alcohol or acetone to remove all traces of epoxy residue. Next, wash with hot soapy water and air dry.
- Or, simply lay wet tools on a plastic lined surface and peel off the cured epoxy the next day. You can let the remaining epoxy cure in the container, and once cured, peel it out.
- Be careful not to have cold AC blowing on the curing surface.



DO NOT POUR LEFTOVER EPOXY DOWN THE DRAIN!

Instead, let it harden in the cup and dispose of the cured resin in the trash the next day. Or, keep some small molds or other projects nearby while you're working; use your leftover resin to create a brand new piece. Being an industrial-grade adhesive, leftover epoxy can be used to mend broken items and for other small repair jobs around the house.



Finishing

The perfect finish

• After 7 days, Industrial Cure will become rock hard and fully cured, and your project will be ready to put into use. If you need to machine it, you can safely do so at this point by sanding, drilling, turning it on a lathe or running it through a saw.

SAFETY TIP

When machining cured epoxy, it's important to wear a dust mask and safety glasses to protect your lungs and eyes from epoxy dust and particles. If possible, sand outside or use a sander that connects to a shop vac for effective dust collection.

Sanding

• It's not uncommon for wood to need 2-3 coats of Industrial Clear. The initial coat seals the wood to prevent absorption. Think of it as hardening the outer layer of a sponge to prevent excess resin from being soaked up.

• Sanding down the initial layer, especially if there are large smooth spots, provides the next layer with some grit to adhere to.

• The next coat will fill any cracks, knots or divots. Try to make everything flush.

• After filling imperfections, sand the surface once again to ensure it is flush.

• Pour the final coat on top, ensuring that your project is perfectly level. Don't worry if the surface appears cloudy and scratched; once you've poured the resin, it will look perfectly clear once again!



How to get a matte finish

Industrial Clear cures to a high gloss finish, but you can create a matte finish using sandpaper, wax and some elbow grease.

• Start by sanding with coarse sandpaper, like 80 grit, to rough up the surface. This step is important for pieces with CNC resin inlays: it will clean up excess epoxy and ensure the epoxy and wood are perfectly level.

• Next, wipe down the surface with a wet cloth to raise the grain and allow the board to dry for approximately 10-15 minutes.

• Sand with 120 grit sandpaper, wiping down with a wet cloth afterward. Repeat this process with 220 grit and 400 grit sandpaper, wiping down and allowing to dry in between each sanding.



• Finally, use 600 and 1000 grit sandpaper to polish the board and make it buttery smooth. There's no need to wet the board between these higher grits.

• Once the board is smooth, apply a non-toxic, food safe oil. Allow the oil to absorb into the board and wipe off any excess. Then, apply a non-toxic, food safe wood conditioning wax, such as beeswax, and buff it smooth. Reapply this wax approximately every month to maintain the finish.







**ROCK-HARD
EPOXY RESIN**

Project Ideas

From charcuterie boards to river tables, Industrial Clear can be used to create a wide range of items with a modern or rustic look.

Industrial Clear can be used in several ways:

- When applied as a clear finish, it **enhances wood's natural beauty**, unique grain, color variations, and live edges.
- Epoxy can be tinted in a wide array of vivid colors and used as a filler.
- It can give new life to found and salvaged wood, stumps and driftwood transforming them into functional furniture items.
- Antique furniture pieces can be repurposed using Industrial Clear, giving them a fresh, modern look.
- Replace a standard desk top with a live edge wood slab, creating a beautiful, one-of-a-kind workspace.
- **Embed** items into a layer of Industrial Clear, such as personal mementos, mosaic pieces, or LED lights, adding a creative, personalized touch to a table, desk or bar top.







**ROCK-HARD
EPOXY RESIN**

What Else Can I Do with Industrial Clear?

Industrial Clear is a versatile, high adhesion material, formulated for the toughest of jobs. No matter what your project, we've got you covered!

• Its strength and durability make it an ideal choice for high traffic areas like **countertops, table tops, bar tops and concrete floors**. Industrial Clear is **waterproof** and can be used on boat hulls and other items frequently submerged in water or exposed to the elements.



• Industrial Clear is an **industrial-grade adhesive**, intentionally formulated to resist moisture, heat, chemicals, and weather. This makes it more durable, longer-lasting, and able to create a bond that can withstand greater force and stress compared to traditional glue.

• It can be used as a **substitute for glass**, offering the same glossy, clear appearance. However, unlike glass, which is prone to shattering, Industrial Clear provides enhanced impact resistance and inherent flexibility to withstand impact more effectively.

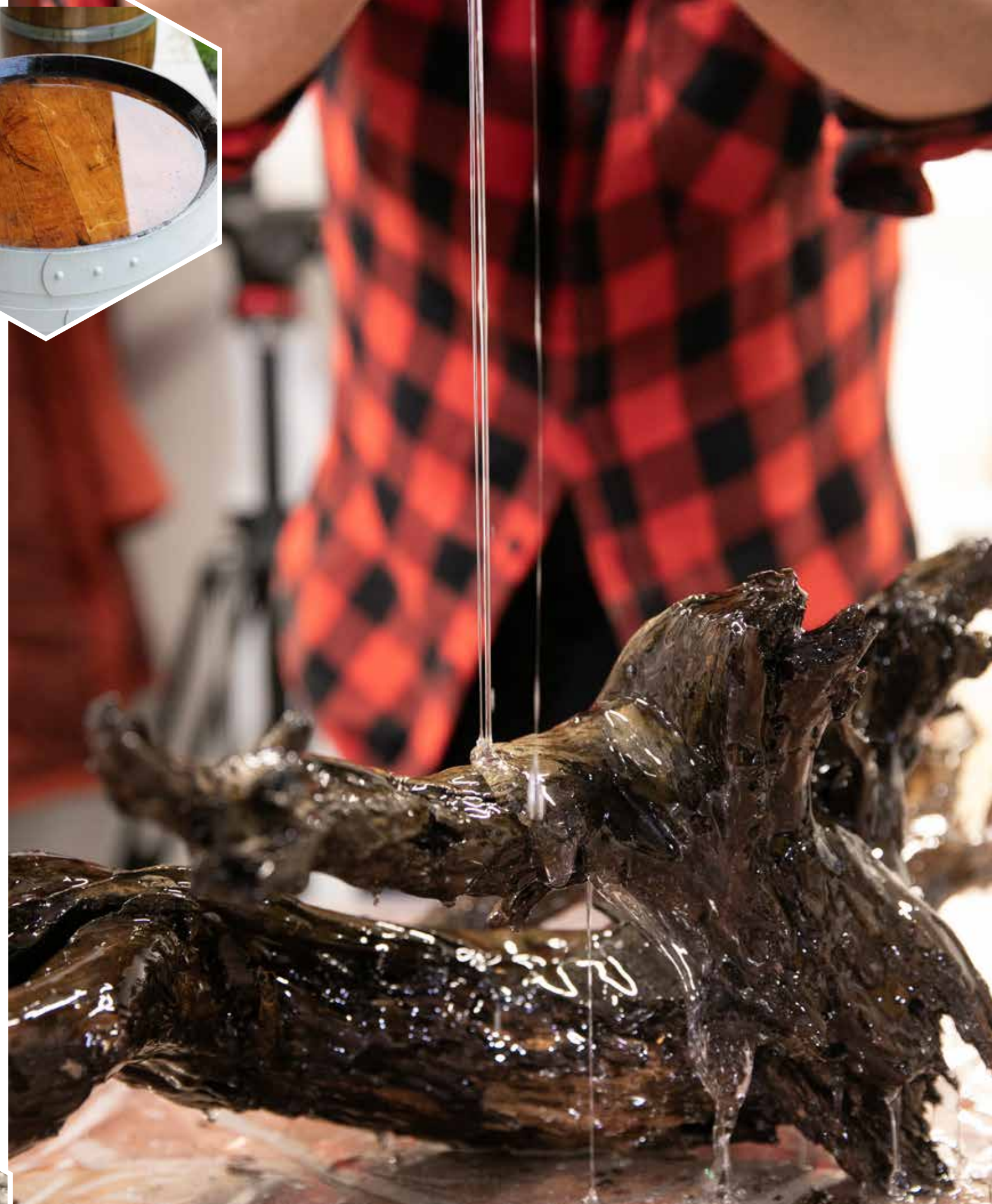
• Unlike steel, which is susceptible to erosion, Industrial Clear is **resistant to rust and corrosion** and impervious to moisture, chemicals and bacteria.

• Industrial Clear **protects metal surfaces** from rust, corrosion, moisture, and chemicals.



• Industrial Clear's outstanding mechanical properties make it **stronger than concrete**. Once cured, it becomes nearly unbreakable and able to withstand impact and abrasion. Its durability, as well as its resistance to chemical, moisture and bacteria, enables it to endure heavy wear and tear for decades, with minimal maintenance.

• Aggregate, natural flagstone, and outdoor pavers become highly saturated when coated with epoxy. Mix 4 parts aggregate to 1 part Industrial Clear and pour over a pebble path or natural flagstone for a brilliant, waterproof finish.





Troubleshooting

Sealing

Wood looks beautiful coated with epoxy, taking on a deep rich color and enhanced grain. However, an organic material like wood can contain trapped air that may release into the epoxy as bubbles. A coat of sealant, applied before the epoxy, is a simple but important step that can help prevent this.

- Various factors, including the type of wood, its dryness, moisture content, and the presence of natural imperfections like knots or cracks, can contribute to the formation of bubbles.
- A sealant coat creates a barrier, preventing trapped air from escaping, as well as tinted epoxy from bleeding into CNC cuts or wood cracks.
- A brush-on sealant is the best approach: it provides excellent coverage, creates an effective barrier and is easily worked into holes and cracks.
- Alternatively, you can apply a very thin coat of Industrial Clear. However, keep in mind that epoxy can alter the wood's color. We recommend conducting a test in an inconspicuous spot beforehand so you know what results to expect.



Bubbles

Bubbles can occur in epoxy resin for a number of reasons, including trapped air and temperature. To minimize excess bubbles when working with Industrial Clear, here are some precautions you can take:

- Stir slowly: To avoid creating excess bubbles in the epoxy batch, stir slowly by hand. A drill mixing attachment creates far too many bubbles, which requires extra torching to remove them.
- Use a flame torch. A quick pass with a flame torch is the most efficient way to remove surface bubbles. Repeat if bubbles continue to release, however it's important not to overtorch. Avoid holding the flame too close to the surface or in one spot for too long and don't torch epoxy that has passed the 45-minute working window or you may end up with surface imperfections such as ripples and waves.
- Work in warm temperatures: Working in temperatures colder than 70-80°F or 21-27°C can result in thick epoxy resin, full of microbubbles that will not torch out. If the resin is cold, bring it up to temperature by placing the capped bottles into a warm (not hot) water bath for around 15 minutes. Maintain a stable temperature for the first 24 hours of curing to prevent cold-induced microbubbles and other imperfections.
- Seal first: To prevent trapped air from releasing into the epoxy as bubbles, use a sealant designed for wood or apply a thin coat of Industrial Clear. Pay special attention to seal cracks, knots or voids in the wood. If you're embedding objects into the epoxy, seal them first with a spray or brush on sealant. Once placed in the epoxy, gently move the object around with a toothpick to allow trapped air underneath to release to the top.
- Don't pour too thick: It's important to note that Industrial Clear is meant to be poured in layers no thicker than ½" or 12mm. Pouring thicker than this can lead to a rapid heat build-up, potentially causing bubbling and even a flash cure. If you want a thicker coat, it's best to pour in multiple layers.



Sticky or soft spots

If the epoxy has not cured properly or has sticky spots, a few factors may be responsible:

- The resin and hardener were not accurately measured at a 2:1 ratio, by volume.
- The epoxy mixture was not mixed thoroughly enough, resulting in uneven curing.
- The sides and bottom of the mixing container were not properly scraped, leading to unmixed resin and hardener remaining on the container's surfaces.
- Scraping the epoxy out of the mixing container while pouring caused unmixed product stuck to the sides to contaminate the mixture, resulting in soft, sticky spots in the cured resin.
- The curing temperature was too cold (below 50°F or 10°C), preventing proper curing. Try moving your piece to a warmer environment to see if it hardens up.
- Too much colorant was added, throwing off the resin-to-hardener ratio required

HOW TO FIX STICKY EPOXY

- Remove any liquid or runny epoxy (sticky is ok.)
- Sand down the properly cured areas, carefully removing the sanding debris.
- Apply a fresh coat of accurately measured and well-mixed Industrial Clear.
- Allow the new coat to cure in a warm and dry environment, ideally between 70 and 80°F (21-27°C).

Surface Imperfections

Occasionally, imperfections may appear in the cured surface, including ripples, waves, dimples, dust, hair, bare spots, or a cloudy appearance. The good news is that many of these imperfections can be fixed by sanding down the cured surface and applying a fresh coat of epoxy. Spot fixing is not recommended because it's almost impossible to achieve a seamless finish by pouring a small patch of epoxy on top of the original coat. It's better to sand down the entire surface and pour a fresh coat for an even, flawless finish.

Here are the main reasons for the most common imperfections and how to prevent them from recurring:

- Ripples and waves can happen as a result of over torching. Only a few passes with the torch are necessary to remove surface bubbles. Remember not to bring the flame too close to the surface, avoid holding the torch in one spot for too long, and never torch resin that has exceeded the 45 minute working window.
 - The curing temperature was too cold (below 50°F or 10°C), preventing proper curing. Try moving your piece to a warmer environment to see if it hardens up.
 - Dimples: single dimples form when micro dust particles land on the wet epoxy. A clean dust cover will prevent this from happening. However, if you notice areas with several dimples with more of an "orange-peel" look, it may be the result of temperature fluctuations during the curing process. For a smooth, even finish, maintain a stable temperature in your resin room, ideally between 70 and 80°F (21-27°C) for the first 24 hours of curing.
 - A cloudy appearance: This occurs when moisture is introduced into the wet epoxy. This can be caused by wet tools or moisture in the wood or embedded objects. To prevent this, ensure everything that comes into contact with the epoxy is completely dry.
 - If the epoxy cures in a humid environment, it can develop amine blush, an oily or waxy film on the surface. It's recommended to work in conditions with humidity below 60% for the best results. To remove amine blush, wipe the surface with a cloth and warm, soapy water using a dish soap like Dawn. Use a damp cloth to rinse off any soap residue. If the film remains, use something slightly more abrasive like a Scotch Brite pad. After cleaning, allow the surface to dry completely. If the surface has been scratched, rough up the epoxy with coarse sandpaper. Remove sanding residue and pour a fresh coat of epoxy to restore the clarity.
- Bare spots can occur for a variety of reasons:**
- Not enough epoxy was applied. We recommend preparing a little more than you think you'll need to ensure you have full coverage.
 - Dry wood, knots, and cracks can soak up the epoxy, leaving bare spots. To prevent this, seal the wood first to create a barrier.
 - An uneven surface: Since epoxy self-levels, it will flow to the lowest point, which can result in bare spots. Use a level and shims to keep the surface as flat as possible.
 - Surface contaminants: oily, greasy or waxy residue on the surface prevents the epoxy from adhering, leaving bare spots. Make sure the surface is clean before applying the epoxy.

Losing Epoxy: Absorption, Leaks and Drips

It's a good idea to mix up a little more epoxy than you think you'll need in case of unforeseen problems like spills, absorption, or leaks.

- Very dry wood has the tendency to absorb resin, so it's a good idea to apply a sealant coat first. This will create a barrier to prevent the epoxy from absorbing into the wood.

- To avoid potential leaks, tape up knots, holes, and even small cracks on the bottom of the wood with sheathing tape before applying the epoxy.

- The best way to deal with cured drips on the bottom of your project is to prevent them from becoming an issue in the first place. Tape off the bottom of your piece with good quality painter's tape, and when the epoxy runs over the sides, the drips will collect on the tape. Once the epoxy is dry to the touch, usually after approximately 24 hours, you can simply remove the tape along with the drips. To prevent drips from forming, you can apply a coat of epoxy to the top of your project only, leaving the sides clean. This will help ensure a smooth, drip-free finish.



FAQ



Scan for online FAQ
www.industrialclear.com/faq

• What safety precautions should I take when working with Industrial Clear?

Always wear gloves when working with epoxy resin to avoid a mess and possible skin irritation. Since Industrial Clear is a non-toxic epoxy resin, contains no solvents and releases no fumes or VOCs, a respirator is not required when working in a well-ventilated space. If you are at risk of the resin splashing in your eyes, wear protective safety goggles. If resin gets in your eyes, flush repeatedly with water for 15 minutes, do not rub and seek prompt medical attention. If resin gets on your skin, wash with warm soapy water. You may experience some itchiness or redness where the resin has been in contact with your skin, but this should subside once the resin has been removed. If you experience swelling or skin rash, discontinue use immediately and seek medical attention.

• What is the shelf life of Industrial Clear?

The shelf life of Industrial Clear is 1 year in unopened containers and 6 months once opened. After this time, you may notice the hardener taking on an amber color from oxygen exposure. This oxidation does not affect the product's performance or cure. In fact, when used over wood or other dark substrates, you will not notice the discoloration at all.

• How do I store Industrial Clear?

Industrial Clear should be stored indoors, in a dry spot at room temperature. Ensure the bottles are tightly sealed. If the product does freeze, simply allow it to return to room temperature before use.

• What is Industrial Clear's coverage like?

Based on a thickness of 1/8" or 3 mm:

The 48 oz Industrial Clear kit covers approximately 12 sq feet or 1.11 sq m.

The 1.5 gallon Industrial Clear kit covers approximately 48 sq feet or 4.46 sq m.

The 3 gallon Industrial Clear kit covers 96 sq feet or approximately 8.9 sq m.

The 15 gallon Industrial Clear kit covers 480 sq feet or approximately 44.6 sq m.

• How do you clean Industrial Clear?

Since Industrial Clear is waterproof once cured, you can clean the cured piece with a soft cloth and a mild dish soap without fear of damaging the surface. To restore the gloss, treat it as you would glass, with a non-abrasive glass cleaner and soft cloth. Avoid using steel wool, scouring pads or abrasive cleaners as they will scratch or dull the resin surface.

• What is Industrial Clear's heat resistance?

Once cured, Industrial Clear can withstand temperatures of up to 350F (176C). Be aware that very hot objects, like a dish straight out of the oven, a hot pan or boiling water, may leave an impression on the cured resin surface. Allow the resin to completely cure for a full 7 days before putting your project into use.

• What surfaces will Industrial Clear adhere to?

Industrial Clear has great adhesion and will bond well to most materials including wood, metal, glass, ceramic and concrete. It creates a strong, waterproof seal that is easy to clean. For best results, ensure the substrate is clean and free of dust and grease. It does not adhere well to most surfaces that repel water including plastic, acrylic, silicone, and vinyl. Use this to your advantage by pouring into silicone molds and you will not require a mold release spray. Your surface should be pH neutral. Epoxy will not adhere well to an acidic surface.

We always recommend doing a test pour first on a sample piece so you know exactly what results to expect.

Can Industrial Clear be used for outdoor projects?

Yes, Industrial Clear can be used on both indoor and outdoor projects. It can withstand outdoor elements including summer heat and cold winter temperatures without cracking. Industrial Clear also contains UV resistant additives that absorb the sun's UV rays and slow down the damaging effects of the sun.

• What can I do with leftover epoxy?

Keep silicone molds to make small projects, such as coasters, on hand in case you have any remaining Industrial Clear that needs to be used up.

Industrial Clear is also a super strong industrial-grade adhesive, so if you have any leftover resin, use it to repair things around the house! Fix a boot sole, a broken mug, jewelry, a loose rake head, or a broken toy, strengthen loose furniture joints, reinforce a loose screw or bolt, pour into rotting wood to harden it, cover rust on metal, fix a cracked paving stone, use it to seal and waterproof an outdoor object, tint it and fix a chip on your countertop, attach a patch to your backpack, seal a crack in a boat hull and so on. Rub epoxy soaked gloves over the handles of hatchets or other tools with wooden handles. You won't find a stronger, harder curing glue than Industrial Clear epoxy resin.

• Can I shape and mold Industrial Clear?

Yes, Industrial Clear can be shaped and molded while it's curing. Allow the mixed resin to sit for approximately 6 hours until it's dry to the touch, but still pliable. At this point, you can bend, mold and shape it however you want. Industrial Clear will hold the shape as it cures to a rock hard solid over the next few days.

BONUS

RESINTINT™ COLOR MIXING GUIDE

1 primary, secondary + tertiary colors



2 neutrals



3 browns



4 blues



5 pastels



5 pearls



6 adjusting opacity

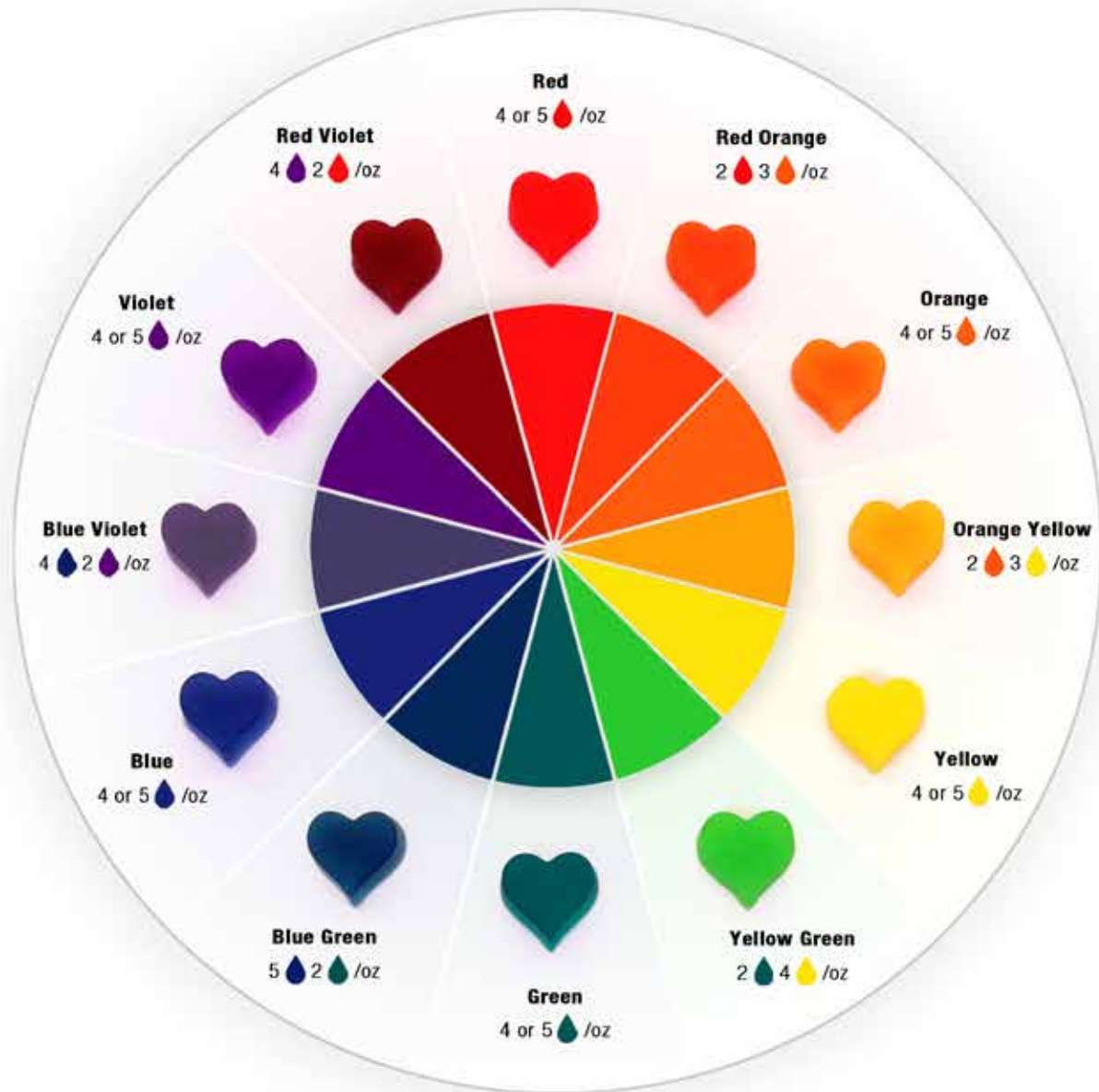


7 muting a color



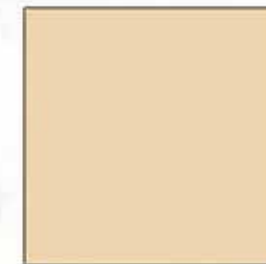
RESINTINT™ ORIGINALS COLOR MIXING

Using the colors from our **ResinTint Originals**, drop in the recommended amount of tint for each ounce of epoxy to achieve the 12 primary, secondary, and tertiary colors.



RESINTINT™ MAKING NEUTRAL COLORS

To make a basic sand color, use our **Neon ResinTint** plus **White**.



The basic formula:

3 neon green: 2 neon pink: 2 neon yellow: 5-7 white / oz



Peachy nude color: Add a drop of Neon Pink



Greyish neutral color: Add a drop of Neon Green



Bright sand color: Add a drop of Neon Yellow

You can play around with the ratios a bit to get the exact tone you're looking for.

Lighter or Darker Sand: Add or subtract drops of white

RESINTINT™ MAKING BROWNS

To make a deep brown color, use our **Original ResinTint**.





The basic formula:


2  red: 2  green: 2  yellow: white as needed  / oz

Adjust this basic formula to get the exact shade you need:




Mahogany Brown: Add a drop of red or violet  



Olive Brown: Add a drop of yellow 



Greyish brown: Add a drop of blue 

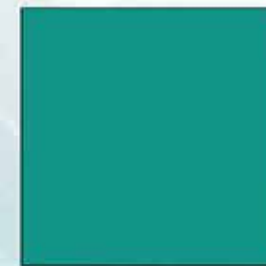
RESINTINT™ MAKING BLUES

To make specific blues, use our **Original ResinTint**.



Deep Ocean:

3  blue: 3  black: 2  white: 1  purple / oz



Caribbean:

3  blue: 3  green: 4  white / oz

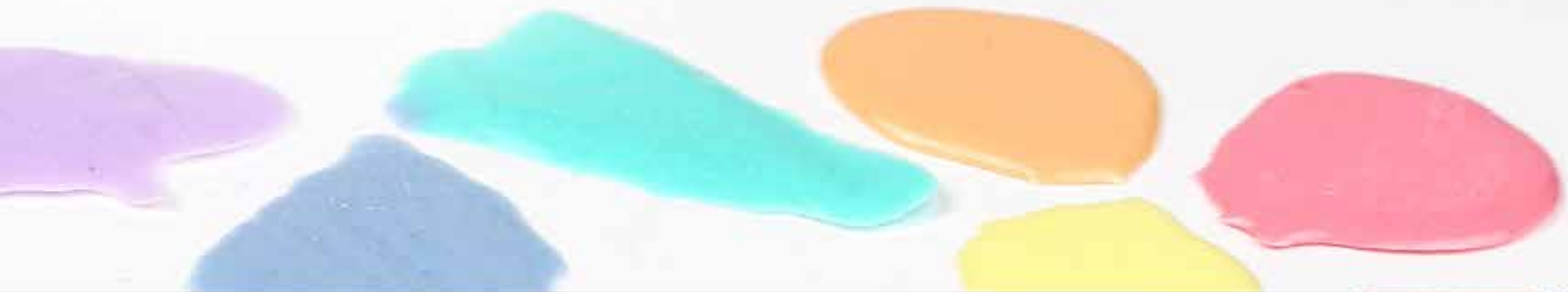


Sky:

4  blue: 12  white / oz

RESINTINT™ MAKING PASTELS

You can make any color a pastel by adding white.
Add equal parts of white ResinTint to drops of coloring.



MAKING PEARLS

Make any color pearlescent by adding Metallic White
from our Metallic ResinTint package.



RESINTINT™ ADJUSTING OPACITY

To create a **translucent** color effect, only add a few drops of ResinTint to your resin.



For a **deeper translucent** color, try using Alcohol Ink instead of ResinTint.

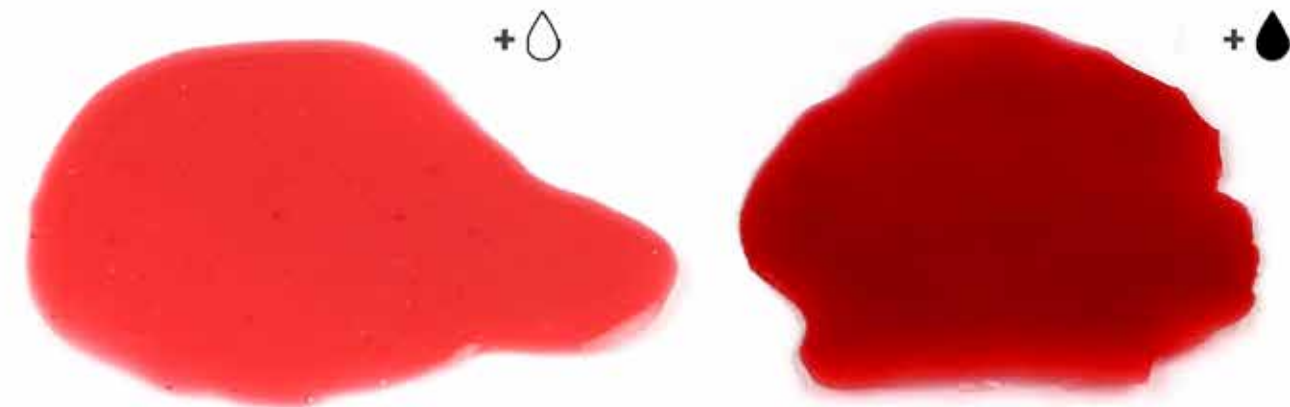


To create a completely **opaque** color, just add a few more drops of color than usual.



note: You can add tint up to 6% of the total volume of resin.

You can also create an opaque color by adding a small amount of white or black to your mixture. This can change the color a bit, so be careful not to add too much — A little goes a long way!



RESINTINT™

MUTED COLORS




To achieve muted colors like sage green, dusty rose, or periwinkle blue, try adding a small amount of color from the opposite side of the color wheel.

Examples:

Sage Green

2  Neon Green : 1  Neon Pink : 3  White

Lavender

1  Neon Pink : 3  Original Blue : 3  White

Butter Yellow

3  Original Yellow : 1  Neon Pink : 3  White

Periwinkle Blue

5  Original Blue : 1  Neon Pink : 3  White

Peach

4  Original Yellow : 2  Neon Pink : 3  White

Olive Green

2  Original Green : 1  Neon Pink :
3  Original Yellow : 2  White

Dusty Rose

2  Original Blue : 2  Neon Pink : 3  White

*"When you can't find what you want,
you do it yourself"*



All you need is a beautiful piece of wood.

Whether it's a bartop, tabletop, counters or
charcuterie board, this guide will lead you
towards completing a perfect project.

You got this!

BONUS



www.IndustrialClear.com