

flow RESINS

Technical Data Sheet

Issue Date: 01/10/2021

Product Name:

RIVER FLOW

Product Description:

RIVER FLOW is a deep pour casting system. It is crystal-clear and designed specifically for deep casting in timber and other deep pour casting applications. RIVER FLOW is perfect for river tables and other wood art applications. It is also excellent for embedding and casting larger sized objects. It is suitable for pouring layers up to 50mm thick (at room temperatures of 25°C or below).

Product Highlights:

Low odour, low yellowing, low initial viscosity, good thermal stability at temperatures 20°C to 70°C, and good mechanical properties. The low exotherm helps to control timber gassing in large castings.

Physical Properties:

Part A

Viscosity at 25°C	mPa.s 1000 - 1300
Specific Gravity at 25°C (g/cm ³)	1.1 - 1.15
Colour	Clear liquid

Part B

Viscosity at 25°C	mPa.s 250 - 350
Specific Gravity at 25°C (g/cm ³)	0.95 – 1.00
Colour	Clear liquid

Handling Properties:

Mix Ratio - Part A : Part B (by volume)	100 : 50
Pot Life (200g Sample) @ 25°C	8 – 10 hours
Peak Exotherm (200g Sample) @ 25°C	40°C
Demould Time @ 25°C	48 hours
Full Cure	7 days
Hardness	90D +/-

Instructions:

Ensure timber is dry and free from oils, solvents, dust, silicones etc. When using RIVER FLOW as a river table resin it is best to pre-prime the raw inside edge of the timber with several coats of a faster setting epoxy like EASY FLOW. This seals the raw edge negating air bubbles from forming on the surface.

Mix enough Part A and Part B by volume exactly to ratio for the initial pour.

Pour a **maximum** of 50mm thickness at any one time. Allow to exotherm (heat) for 18 to 48 hours prior to a second pour (may need to wait longer in cooler temperatures). If pouring more than 50mm thick, or at temperatures exceeding 25 °C the epoxy can generate excessive heat resulting in shrinking and cracking.

Allow to cure for 48 hours prior to machining. Belt or orbital sand to achieve a smooth, level surface. Use ART FLOW as high gloss, self-levelling coating or timber oil after sanding.

Extra care MUST be taken to ensure thorough mixing of Part A and Part B. Ensure casting is performed in a well-ventilated area as some vapours will be released at these curing temperatures. PPE is recommended. Please refer to the safety data sheet for more information.

www.flowresins.com.au

Flow Resins Pty Ltd ABN 46 652 889 613

flow RESINS

Technical Data Sheet

Issue Date: 01/10/2021

Handling Precautions:

This Part A and Part B combination has been formulated with the objective of being as safe as possible however in common with most epoxy resins and hardeners, consistent skin contact with the uncured materials should always be avoided. Materials may become very hot during curing.

Do not touch in under the specified demoulding time as burns to the skin may occur. Our testing is based on a 200g sample size. Ensure all casting is performed in a well-ventilated area as some vapours will be released at these curing temperatures. Please refer to the safety data sheet for more information.

Storage:

Store the components in a dry place at 18 to 25°C, in tightly sealed original containers.

Disclaimer:

The data presented in this leaflet are in accordance with the present state of our knowledge and does not absolve the user from carefully checking all supplies immediately on receipt. We reserve the right to alter product constants within the scope of technical progress or new developments. The recommendations made in this leaflet should be checked by preliminary trials because of conditions during processing over which we have no control, especially where other companies' raw materials are also being used. Recommendations for use do not constitute a warranty, either expressed or implied, of the fitness or suitability of the product for a particular purpose.

