ARK EPOXY RESIN

2:1 RATIO WATERCLEAR LOW VISCOSITY SYSTEM

USE TO: Coat and waterproof wood, fiberglass, metal, plastic, and most porous surfaces.  
Casting resin with slow hardener. Color with ARK Pigments  
Laminate with Fiberglas, Carbon, Kevlar  
Glue, Fill, and Fair with the addition of fillers.

SURFACE PREP: Apply directly to clean dry wood. For fiberglass, metal, and plastic clean the surface with Acetone or Lacquer thinner, sand, and remove dust. Do not use Varsol or petroleum-based solvents to clean surfaces.

MIXING: Mix 2 parts Ark Epoxy Resin with 1 part Ark Hardener. Use graduated containers or pumps to measure, don’t guess, too much or too little hardener will affect a proper cure. Mix thoroughly, scraping the sides of the container, add fillers if desired, and spread with a solvent-resistant Brush, Roller, or Squeegee.

RECOATING: Recoat with ARK Epoxy as soon as the previous coat is tacky, 2 to 6 hours depending on Hardener and Temperature. After 8 hours or when the epoxy has cured hard sand with 80 grit paper before applying more epoxy or paint. Can be used over other epoxies as long as they have cured, and are sanded.

POT LIFE: Time before mixed Epoxy will start to thicken if left in the mixing container. Getting the mixed epoxy out of the mixing container and into a paint tray or spreading in a thin film on fiberglass or another surface as soon as possible will extend the working time.

WORKING (GEL) TIME: The time you have to work with the mixed Epoxy before it starts to harden. Pot Life, Gel, and sanding time will vary depending on the hardener, temperature, mixed volume, time in the mixing container, and laminate thickness. Pot life and cure time will roughly double for an 8C drop in temperature, and ½ for an 8C rise.

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| HARDENER | | **MIXING RATIO**  **BY VOLUME** | **MIXING RATIO**  **BY WEIGHT** | **POT LIFE @ 22C/71F** | WORKING  (GEL) TIME | SANDABLE | POT LIFE@  12C/54F | SANDABLE | FUL CURE |
| FAST | **100:50** | **100:43** | **8 -10 MIN** | 15 -20 MIN | 6 -8 HRS | 15 – 20 MIN | 10– 14 HR | 7 DAYS |
| MEDIUM | **100:50** | **100:43** | **10-15 MIN** | 20 – 40 MIN | 8 – 12 HRS | 20 – 30 MIN | 12 – 20 HR | 7 DAYS |
| SLOW | **100:50** | **100:43** | **15-20 MIN** | 30 -60 MIN | 15– 24 HRS | 35 – 40 MIN | 24 - 48 HR | 10 DAYS |

PAINTING, VARNISH: Apply Paint or Varnish after 7 days full cure. Sand starting with 80 grit paper, and finish with 220 or finer. Remove dust with a vacuum, wipe down with water or Acetone on a clean cotton cloth, and allow to dry thoroughly before applying the coating. Do not use varsol or petroleum-based solvents. Apply 5+ coats of UV Spar Varnish or 2 or 3 coats of Primer and Marine Enamel Paint. For maximum gloss and durability finish with Epifanes 2 part Polyurethane paint.

FILLERS: Mix resin and hardener first, stir in Colloidal Silica,(Thickener for gluing), ARKFAIR (For gluing and medium density filler), Cotton Fibre (high strength gap filler), 3m Bubbles (low strength sanding filler), or Wood Flower( for fillets and filling in wood construction).