



Thank you for purchasing Royal Palm Resin. Royal Palm Resin is an epoxy casting resin which comes in 2 types. One is a thin epoxy which flows very well (closer to the consistency of water) and a normal which is more viscous (will flow like thick syrup or honey). It works great for casting, jewelry making, laminating, encapsulating and the like. It cures clear (part B may have a yellow hue to it prior to cast but once cast will not). For best results with this or any resin a pressure pot is suggested. However, following good technique you may get good results without a pressure pot particularly with the thin.

Shelf Life: 1 year (usually longer)

Working time: Approx 1 hr (temperature will affect this)

Demold time: 24hr (the thin version will usually require another 24hr or more to become fully hard)

For best results cast at or above 80 degrees F. For blank making or encapsulation a pressure pot is strongly advised at 40-50PSI. For both resins any type of casting will benefit from following the below process and should yield the best results.

1. Mix the resin in a HDPE painters mixing cup with ratio markings. These can be found at most hardware, paint stores, or autobody supply shops. For thin the ratio is 2:1 by volume NOT WEIGHT (2 parts of part A to one part of part B). For the normal the ratio is 1:1 (again by volume). White caps are A and black are B. (if the weather is cold you may want to warm the part A in a double boiler bath or some hot water keep the water temp below 120F)
2. Use a paint mixer at low RPM to mix the resin until all striations are gone (helps to use a light overhead and behind you to see these lines). The mixer I am speaking of are the types which look like a propeller with a circle around the outer edge and are attached to a drill. When attaching the mixer make sure that the drills direction advances the blades lower edge leading the direction of turning. Mixing in this way should result in very few bubbles. If you find you have excessive bubbles it may be related to one of the following issues 1) RPM of drill is too high 2) Lifting the mixer up and down in the column and allowing more air to be dragged in 3) Tilting the cup back and forth to much and again allowing air to be pulled in by the mixer 4) Using a wide cup with a small amount of resin so that the mixer cannot be submerged properly 5) The drill is moving the blade in the wrong direction

3. Once mixed use a heat gun on low heat and gently warm the resin. This will make the resin more fluid and increase the pressure of the bubbles to want to escape from the resin. Be very careful not to “cook” or “smoke” the resin. Keep the gun moving back and forth quickly and don’t keep it blowing on a single spot and don’t overheat in general. This can cause the resin to cure to quickly, thicken, and likely be brittle or unable to be poured.
4. When pouring the resin pour it “high and thin”. That is to say hold the cup one foot or more above the mold and pour a very thin stream in the edge/corner of the mold. This helps by allowing air bubbles to escape as you are pouring.
5. Once in the mold another gentle pass with the heat gun helps as well.
6. Another tip for helping remove bubbles is using an orbital disk sander with no paper set next to molds to help vibrate out any potential bubbles.
7. Place in a pressure pot if you will be using one.

If you have questions please don’t hesitate to contact me. Please feel free to like and share your work on the Royal Palm Resin facebook page <https://www.facebook.com/RoyalPalmResin/> we enjoy seeing your work and the great things you make with our resin. Also make sure to bookmark our website at <http://RoyalPalmResin.com>.

Thanks again and happy casting,

Jason Burr