

**ETOPOX**

# 3D WOOD

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CRYSTAL CLEAR EPOXY RESIN  
FOR WOOD AND WOOD MATERIALS

- Pour, coat, and seal
- Crystal clear, semi-transparent or colorful objects
- Highest possible UV-stability
- Layer thicknesses of up to 5 cm in one pour

# ETOPOX WOOD

## Epoxy pouring resin system

Practical tips for processing

October 2021-V1

### 1. EQUIPMENT

Weighing scales



Stirring device / stirring rod



Clean container for stirring and filling



Paint brush or paint roller



Hot air dryer or Bunsen burner



Adhesive tape, for masking the frame.  
Ideally, we recommend using PP material.  
Be sure to test it yourself



Suitable mold and fixing material



(Example images)

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### 2. GENERAL CONDITIONS What must be considered when using ETOPOX 3D Wood?

#### Read and observe the technical leaflets and safety data sheets

- Dust-free environment.
- Constant room temperature, ideally between 20-25°C during the processing and hardening period. Layers of more than 5 cm are also possible with the appropriate cooling in the room.
- The relative humidity may not exceed 60%. If the humidity is too high, the hardening time may increase and white spots may form in the top layer, as well as shiny and matte patches.
- The poured ETOPOX 3D Wood may not come into contact with water or other liquids for 7 days.
- ETOPOX 3D Wood can be further processed when it has fully hardened after 7 days (sanding, planing, milling, polishing etc.).
- Only leave mixed material residue to dry outdoors in metal containers, do not put flammable materials in the bucket, do not touch containers when hardening as there is a danger of burning.

### 3. IMPREGNATION

Seal/impregnate heavily vacuumed substrates (for example, wood) to prevent high material loss and small bubble formation in the end product. Use **614.1. ETOPOX Wood Sealer**.

1. Dispense the contents of the resin (A) with the contents of the hardener (B) in a mixing ratio of 100:45 (Observe technical leaflet).
2. Ideally, you should use an electric stirring device with a low or adjustable number of revolutions for the correct mixture and mix the material well for 3 min. This ensures that the resin (A) and hardener (B) have completely homogenized together. After thorough mixing, transfer the mixture to a clean container and mix again.
3. Apply the ETOPOX Wood Sealer to the desired surface using a roller or brush. Apply the material onto the surface to be coated **directly** after mixing as the product can heat up drastically / boil depending on the system and amount of material in the mixing container.

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### 3. IMPREGNATION (continued)

4. Leave the ETOPOX Wood Sealer to harden. The hardening time varies depending on the temperature, layer thickness, and epoxy resin system. Please pay careful attention to the further details in the **technical leaflet** for this.

### 4. POURING

1. Ensure that the pouring mold is in the perpendicular and completely sealed so that nothing can run out before pouring the **680.8 ETOPOX 3D Wood**.
2. Carry out the impregnation with the main coating of 2 ETOPOX 3D Wood evenly as described in point 2. For this, mix the resin (A) with the hardener (B) in a mixing ratio of 5:2. You can find further details about the filling height, processing time, and drying out in the **technical leaflet**.
3. Conspicuous small bubbles on the surface can be removed using a flame (Bunsen burner) or hot air dryer for 1-2 days.  
**Caution: Danger of burning! Observe the fire protection guidelines 12-15 of the VKF, available at: <https://www.bsvonline.ch/de/verbindungen/>**
4. Leave the ETOPOX 3D Wood pouring resin system to dry in accordance with the details in the technical leaflet. The material can be sanded after 7 days. Further hardening over >7 days is recommended, depending on the condition and the level of sanding to be achieved.
5. Further information about the processing and product can be found in the **technical leaflet**.

### 5. COLORING

1. Our **450.4 MULTIMIX** color mixing concentrates can be used to color or shade the crystal clear ETOPOX 3D Wood.
2. Only 1-2% (depending on the color shade and pouring height) is required to for complete coloration of ETOPOX 3D Wood.
3. For this, simply add drops of the respective concentrate - ideally with a larger pipette or other container - slowly into the transparent ETOPOX 3D wood and stir.
4. You can combine cool effects with the color mixing concentrates by adding small amounts of MULTIMIX pearlescence powder.

These practical tips and processing instructions are guidelines based on the generally known state of the art. It is therefore important to note the date of issue and, if necessary, to ask for new technical leaflets. The information and guidelines refer to normal and customary circumstances; whether they are appropriate for a specific individual case can only be determined by your own examination.

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