Harzsystem R1 + H1
for a river table

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The resin and all necessary materials should be at a temperature of 16–25 °C. It's best to leave them overnight in the room where you'll be working on the project. Any damp or cold environment will affect the final result.
The room must be as free of dust and dirt as possible.

Quantity Calculation Example:
If the area is 100 cm x 20 cm and the pour height is 5 cm = 10 dm³ = 10 liters, this corresponds to approximately 12 kg of resin system.
Our recommended product number: 97138-G (10 kg Epox R1 + 3.8 kg Hardener H1)

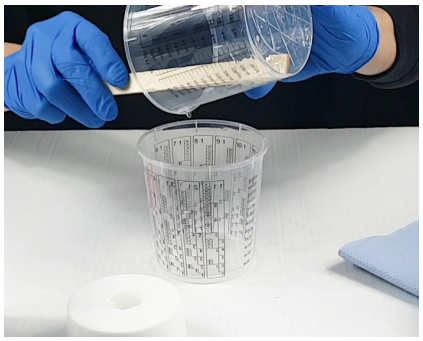
Mixing ratio:
100 parts Resin R1 / 38 parts Hardener H1

Preparing the Wood

- You must inspect the pieces of wood for cracks, knotholes, and gaps and fill them with resin to seal them. This prevents the wood from off-gassing when it is filled with epoxy resin. We recommend using our Epoxy Resin 4305 with Hardener 313 for this purpose.
- Make sure to clean the cavities beforehand.
- Use masking tape to seal the cracks and gaps and to prevent resin from leaking out. Masking tape works well.
- After some time, check to see if more resin needs to be added, and if so, refill the gaps again.
- Then let the resin cure completely according to the instructions.
- Afterward, use an abrasive to make the surface as smooth and even as you like
- You can do this with a sander or simple sandpaper. Sanding is also necessary so that the Epox R1+ Hardener H1 casting resin can bond with the Epoxy Resin 4305 + Hardener 313.

Preparation: Resin

1. Weigh the resin and hardener precisely and carefully—preferably using a kitchen scale (pay close attention to the mixing ratio)—and mix them together.
2. Be sure to mix slowly to prevent bubbles from forming.
3. Once you have thoroughly mixed the resin and hardener, pour the mixture into a second container and mix again to ensure that no unmixed resin remains—this is known as “double potting.”



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Processing

Now pour the epoxy resin onto the formwork.
A release agent can be applied to the formwork beforehand to facilitate demolding. (e.g., Formula-Five release wax, item number: 32035)

Do not pour more than 1.0–1.5 cm in a single pour.

If you want to pour a greater depth, you must do so in several steps.

The following rule always applies:
Allow the resin of the first layer to reach stage B (approx. 9–10 min) of curing.
The B stage means that the resin has hardened but is still tacky on the surface.
To determine whether this stage has been reached, touch the resin with a gloved finger; if it leaves a mark that does not stick to the glove, it has reached the B stage, and you can proceed to the next step of the pour.
If you allow the resin to cure past the B stage (i.e., if you miss the B stage), the resin will not chemically bond with the next layer. In that case, you'll need to sand it down with coarse sandpaper to create a bond with the new layer.

Notes - Tips

1. The addition of fillers—such as color pastes, powders, or pigments—should be tested beforehand.
2. In the final step, smooth the surface with sandpaper, starting with 80-grit, then moving to 120-grit, and finally 400-grit.
3. You'll achieve a particularly beautiful finish if you sand the table again afterward (e.g., with 1000-grit wet sandpaper) and coat it with a clear varnish (e.g., acrylic clear varnish).

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