



TOTALBOAT® TotalBoat Clear Epoxy Bar Top & Table Top Project - Instructions

Kit Contents:

- TotalBoat TableTop Epoxy Resin & Hardener
- Clear packing tape (Size: 2" wide)
- 5 - Quart size plastic mixing cups
- 5 - Large wooden stir sticks (Size: 10")
- 5 - Plastic resin spreaders (Size: 4" x 2-3/4")
- 5 - Pairs of latex gloves (Size: Large)
- 1 - Heat gun with power cord

Additional Things You'll Need:

- Wood surface table top
 - 120-grit sandpaper
 - Clean rag
 - Acetone or denatured alcohol to use as a solvent wipe
- **NOTE:** Use acetone for white oak or oily hardwoods because it helps remove surface oil and improves adhesion. For most other wood species, you can use denatured alcohol instead of acetone.**

Calculate How Much Epoxy You'll Need

Measure the area to be covered with epoxy to determine how much you'll need.

To calculate the area, multiply the **Length x Width X Depth to determine the volume needed in cubic inches.**

- 1 quart of mixed epoxy = 57.75 cubic inches
- 2 quarts of mixed epoxy = 115.5 cubic inches
- 3 quarts of mixed epoxy = 173.25 cubic inches
- 1 gallon of mixed epoxy = 231 cubic inches

HOW TO CREATE A CLEAR HIGH-GLOSS EPOXY TABLE TOP FINISH

STEP 1 - SET UP YOUR TABLE TOP



Position your table top so it's at a comfortable height. Depending on the height of your work area, you may need to remove the legs from your table or it will be difficult to work on the table top itself.

Make sure the top is level.

STEP 2 - CLEAN & SAND THE SURFACE



Clean the table top by wiping with a rag wetted with ****acetone or denatured alcohol****.

Sand the wood with 120-grit sandpaper so the epoxy (or embedded object) bonds properly. Vacuum to remove sanding dust, and wipe again with a clean rag wetted with ****acetone or denatured alcohol****.

STEP 3 - (OPTIONAL) ATTACH ITEM TO TABLE TOP



In this example, we're applying an adhesive-backed, plastic-coated nautical chart to the table top. If you are using photographs or other paper items, laminate them first, or use an alternative sealant to prevent damage. It's important to adhere the item securely to the table top before you flood the surface with mixed epoxy.

STEP 4 - MIX RESIN & HARDENER



Mix a small batch of TotalBoat TableTop Epoxy for a thin seal coat. Combine **1 part Resin and 1 part Hardener**, by volume.

Tip: Use the 2-cup mixing method: Stir slowly for about 2-3 minutes, scraping the sides and bottom of the cup to mix both components thoroughly. Next, pour the mixture into a clean mixing cup and stir again for 2-3 minutes. Mixed epoxy should be clear, not cloudy.

STEP 5 - APPLY A THIN SEAL COAT



Apply a thin coat of mixed epoxy to seal the surface. After pouring the epoxy, spread it with an epoxy spreader or use the heat gun (keep the heat 6" off the surface, and keep it moving). The seal coat creates an ideal surface for the flood coat to bond to. If you are applying the seal coat to bare wood (instead of a chart, as shown here), the seal coat prevents air in the wood from off-gassing & creating bubbles during the flood coating stage.

STEP 6 - SAND THE SEAL COAT



Allow the seal coat to cure for 24 hours.

Next, sand the surface lightly with 120-grit sandpaper. Make sure not to sand through the seal coat.

Solvent-wipe with acetone to remove sanding residue. Allow to dry completely before taping the edges to form a dam for flood coats.

(HOW TO CREATE A CLEAR, HIGH-GLOSS TABLE TOP FINISH, continued on back)

STEP 7 - TAPE THE EDGES TO FORM A DAM

Apply clear packing tape around the edges of the table, to form a dam. Be sure you have at least 1" of tape sticking up beyond the top edge of the table to contain the flood coat(s) of epoxy.

Tip: Add more tape at the corners to give extra support to the tape barrier.

STEP 8 - APPLY A FLOOD COAT OF MIXED EPOXY

Mix enough epoxy to pour only one layer at a time, at a maximum recommended depth of ¼ inch.

Dispense 1 part resin to 1 part hardener (by volume) into a clean mixing cup. Mix components thoroughly, using the 2-cup mixing method mentioned in Step 4.

POUR: IMPORTANT! Pour the epoxy no more than ¼ inch at a time (per layer).

Pour the mixed epoxy slowly onto the table top, distributing it across the top as you pour. Use the yellow scraper and the heat gun to move the epoxy around and help spread it evenly.

**STEP 9 - (OPTIONAL) APPLY MORE FLOOD COATS TO BUILD DEPTH**

If you're doing multiple flood coats to build depth, wait **3 hours minimum before another** pour. You want to pour the next layer when the epoxy is still in the gel state and the heat caused by the reaction has dissipated. If you wait for the surface to harden completely, you'll need to sand in between pours (using 120 grit, vacuum, & solvent wipe clean). Sanding between coats will not adversely affect the cosmetics of the final product—the hazy surface will become clear again when you pour the next flood coat.

Continue to pour in shallow ⅛-¼ inch layers, waiting **3 hours minimum between layers until** you reach the desired thickness.

Tip: For best results on the finished edge, it's important to maintain the edge between pours. Depending on the condition of the tape, you may need to change it between pours, once the epoxy has set up.

STEP 10 - REMOVE THE TAPE AND APPLY THE FINAL FLOOD COAT

Remove the tape. Sand any rough edges with 120 grit, and wipe with acetone.

Pour mixed epoxy slowly onto the table top, distributing it across the top as you pour. Use the yellow scraper and the heat gun to move the epoxy around, help spread it evenly, and pop any air bubbles.

Allow the mixed epoxy to flow over the sides. Use a plastic spreader to help smooth the vertical edges.

STEP 11 - SAND THE BOTTOM EDGE

Before sanding, wait about two days for the epoxy to cure completely.

When the epoxy ran over the sides in the previous step, it created drips on the bottom, which you'll want to remove by sanding with 120 grit, or chiseling. Solvent-wipe with acetone to remove residue. Reattach the table legs, if you removed them in Step 1.

**IMPORTANT!**

- Do not place items hotter than **124°F** on the cured surface.
- TotalBoat TableTop Epoxy is not intended for outdoor applications with prolonged exposure to sunlight. If the top is used outdoors, coat with varnish such as TotalBoat Halcyon Clear.