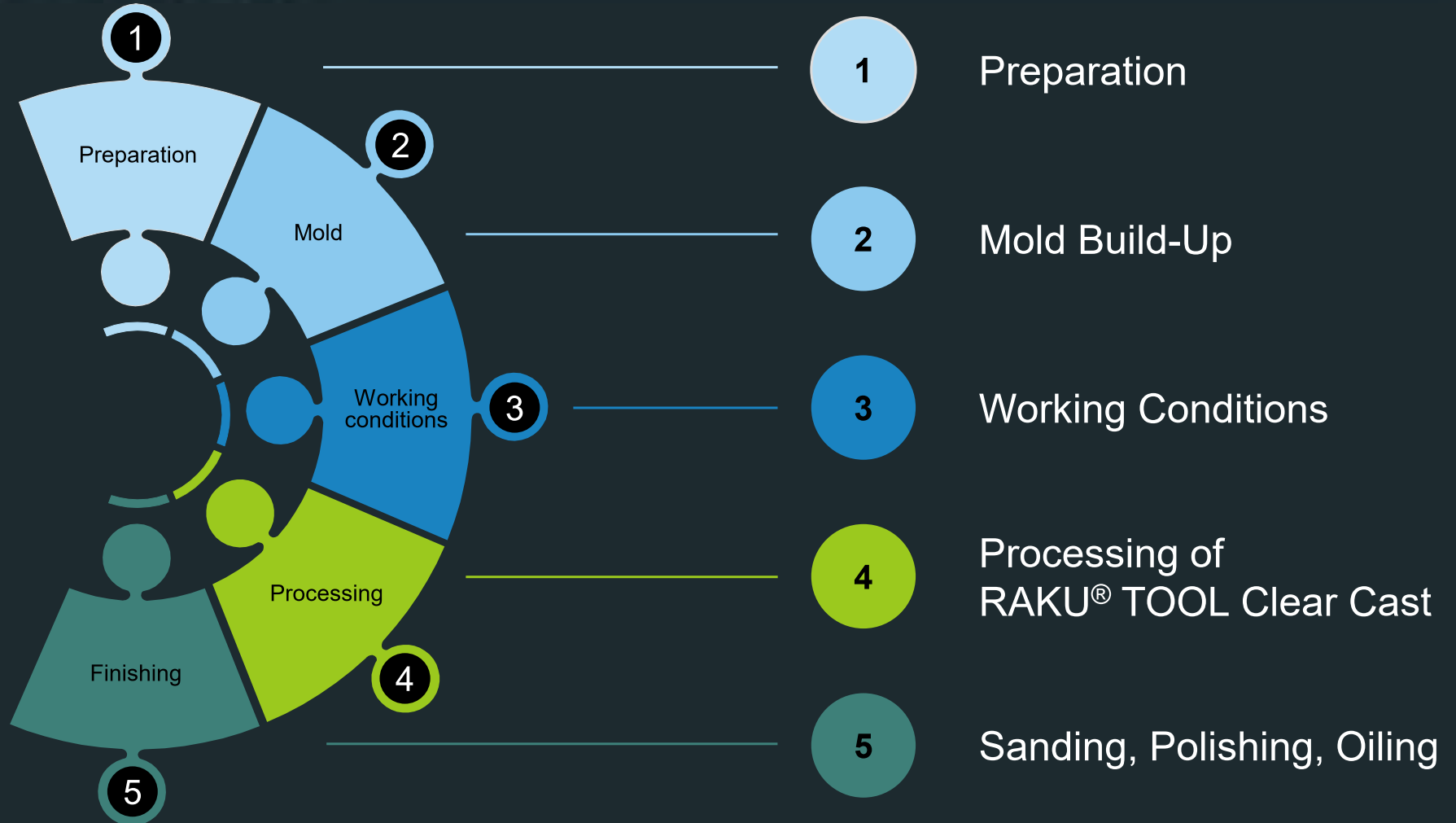


MAT / PAC, 02.08.2021

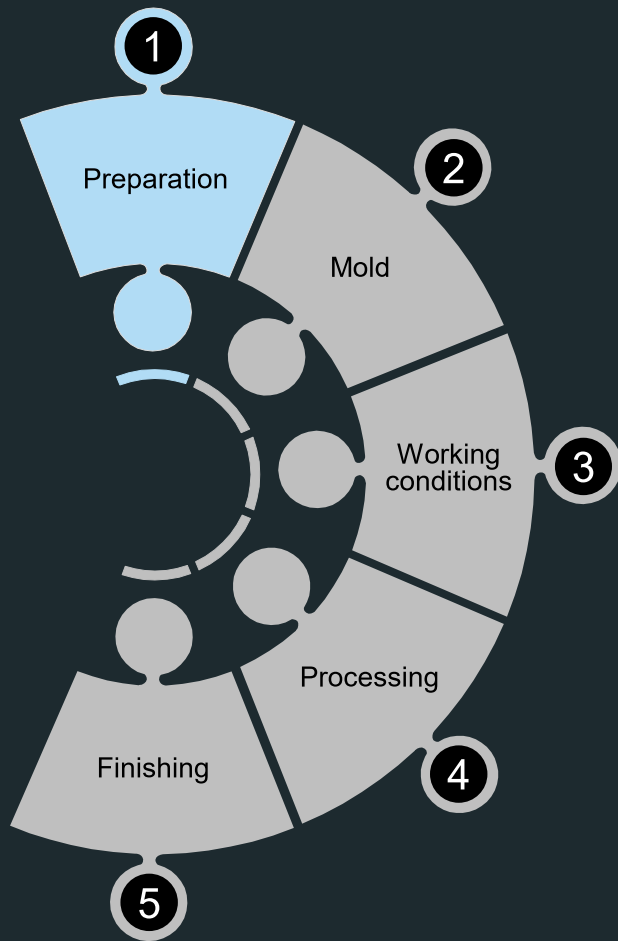
# Clear Cast User Guide River Table

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# Step-by-step guide



# Achieving a Clear & Bubble Free Casting by conscientious preparation

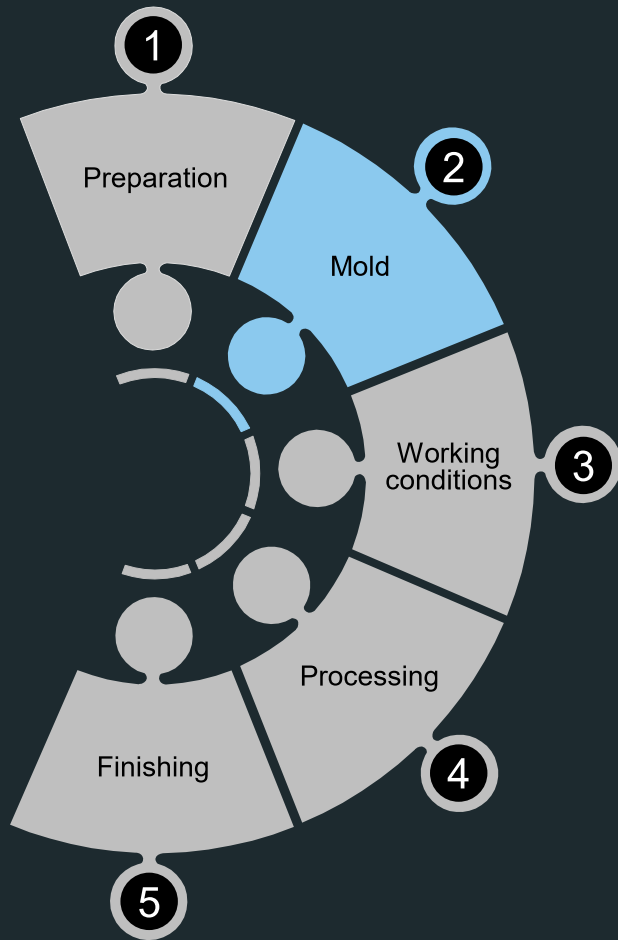


1

- The wood has to be dry. Ideally the moisture content should be <12%.
- Remove any remaining bark with a chisel.
- Sand the wood surfaces until smooth. The sides are best finished by hand using sandpaper or a wire brush.
- The wood needs very thorough cleaning from all dust (use a vacuum cleaner or microfiber cloth).
- Cracks and porous areas in the wood must be levelled, and all wood needs to be sealed with an epoxy sealer to prevent later outgassing of the wood. The sealed wooden contact surfaces to the Clear Cast must be roughened before casting.



# Mold Build-Up and Preparation

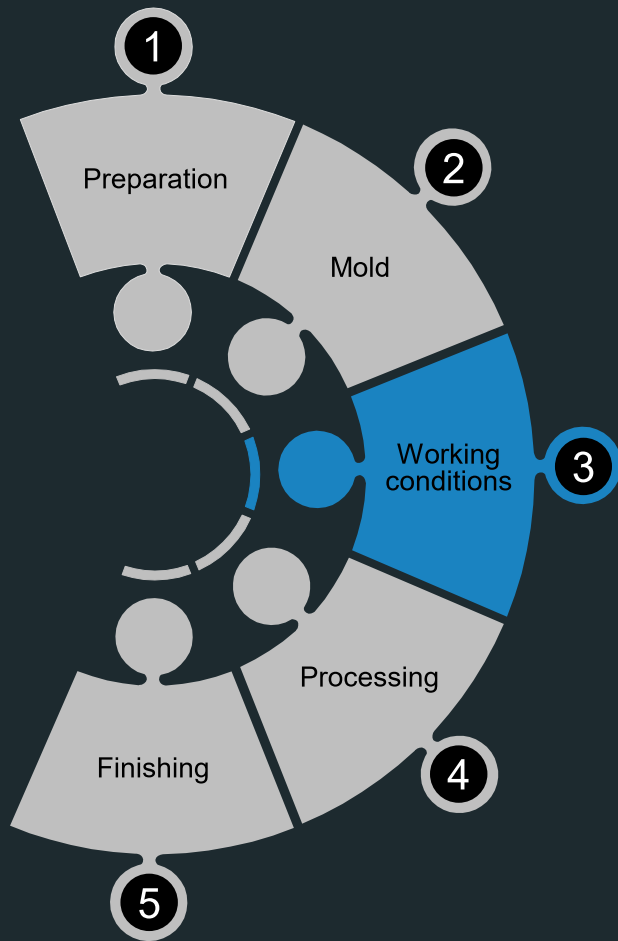


2

- Mold build-up in desired length and size of table.
- The side panels should extend past the actual table top by approx. 15 mm. Edges should be sealed carefully with silicone.
- Release agent: recommended are duct tape or release wax. Teflon spray or silicone spray are also suitable.
- Make sure that the mold is completely levelled. Place the wood into position and fix it with several parallel clamps.
- It is advisable, to use silicone along the inner edges of the wood, 1 to 2 cm in, to fill the mold.



# Working Conditions and Processing Temperature



- Extreme temperatures, hot or cold, as well as humidity can all have a negative effect on the appearance and performance of Epoxy Casting Resins.
- Room temperature (20°C) is the ideal processing temperature. This should also be considered for storage.
- Ensure the work area is dust-free, dry and well ventilated.
- Observe the maximum layer thickness which can be cast in a single layer.
- Calculate the amount of epoxy resin needed
- Observe the mixing ratio according to the data sheet

3

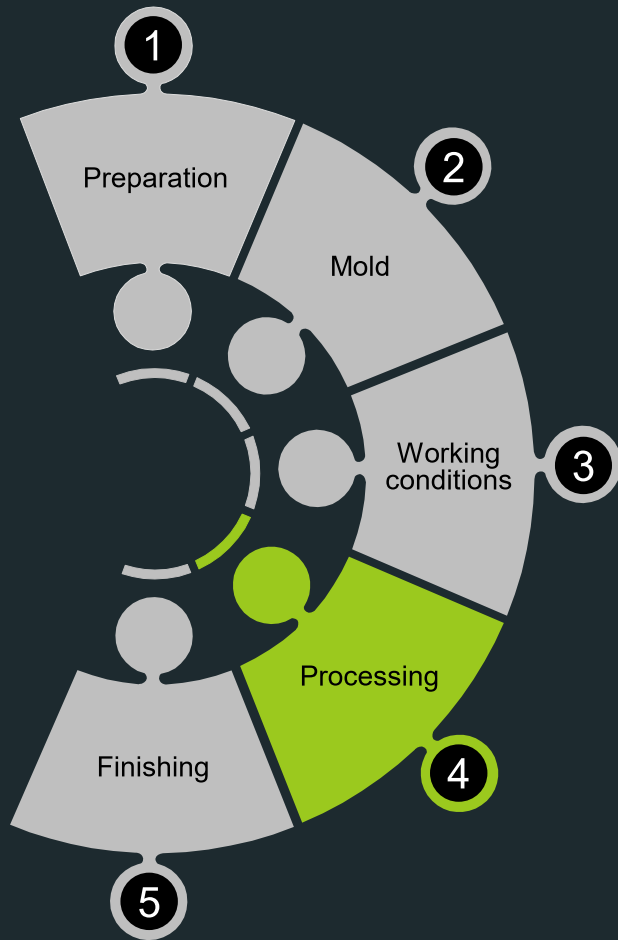
**RAKU TOOL**  
EC-2456 / EI-2956, EI-2957  
Epoxy Casting System

RAMPF  
Resins and Tools

Properties	
Viscosity	1000 - 1200 mPa·s
Storage temperature	5 - 30 °C
Shelf life	12 months
Working temperature	20 °C
Maximum layer thickness	2 mm
Minimum layer thickness	0.1 mm
Minimum curing time	10 min
Maximum curing time	24 h
Final curing temperature	60 °C
Final curing time	2 h
Final curing temperature	120 °C
Final curing time	1 h
Final curing temperature	150 °C
Final curing time	1 h



# Processing & Casting

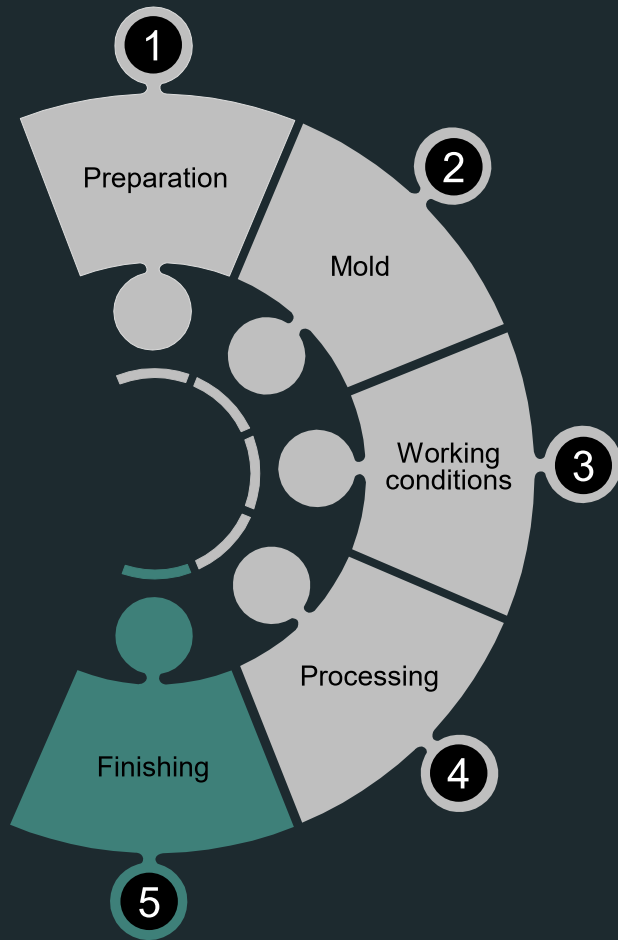


- Thoroughly mix resin and hardener using a drill mixer
- Important: protect yourself, wear safety glasses and nitrile gloves.
- Before using the resin mix allow the material to degas for about half an hour after mixing
- Fill the resin mix into the mold to slightly above the edge of the wood.
- Air bubbles in the resin mix can be easily removed with a hot air gun.
- Avoid hot spots of the material as high exothermic reaction can occur
- Please follow the recommended demold and cure schedule according to the TDS.

4



# Finishing



5

- Smooth edges can be processed with a router before sanding.
- Use an orbital sander for sanding.
- Start with 80/120 grit and work your way up to 2500 grit. Polishing with glaze will make the surface of the River Table glossy. This ensures that all traces of sanding are removed and a clear surface is achieved.
- In order to optimally protect the wood and for a natural appearance, oil is applied over the entire table top using a soft cloth.





# River Table

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