



# TOTALBOAT® TotalBoat Epoxy River Table Kit - Instructions

This kit contains just about everything you need to make a river table. A river table is created when a 'river' of epoxy runs between two pieces of wood, or around a single piece of wood (as shown in these instructions). Your epoxy river can be clear or tinted, and you can cast things in place in the epoxy, such as rocks and features, to add interest.

### Kit Contents:

- TotalBoat ThickSet Epoxy
- Mica Pigments - (10/pk, assorted colors, 5 grams/pk)
- 5 - One-quart plastic mixing cups
- 5 - Half-quart plastic mixing cups
- 5 - Pairs of latex gloves (Size: Large)
- 5 - Large wooden stir sticks (Size: 10")
- 5 - Tongue depressors
- Packing Tape - 1 roll
- 4 - Foam brushes (Width: 2")
- 1 - Heat gun with power cord
- 1 - Hot glue gun with power cord
- 1 - 24/pk glue sticks (Size: 4" length, 1/2" diameter)
- Sandpaper - 36 sheets/pk (3 ea. of 120-3000 grit; Size: 9" x 3.6")
- TotalBoat TotalShine Finishing Compound (Size: 16 fl. oz.)
- TotalBoat Premium Boat Wax (Size: 11 oz.)

### Additional Things You'll Need:

- Wood for project
  - Wood for building a mold
  - Drill & screwdriver for building the mold
  - Screws for fastening the mold
  - Variable Speed Buffer / polisher
  - Sanding block (if desired)
  - Acetone or denatured alcohol for use as a solvent wipe
- \*\*NOTE:** Use acetone for white oak or oily hardwoods such as mahogany because it helps remove oil from the surface 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 filled 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 MAKE AN EPOXY RIVER TABLE

### STEP 1 - SAND YOUR PIECE(S) OF WOOD



Sand the wood with 120-grit sandpaper so the epoxy will bond with the wood.

Vacuum to remove sanding dust, then wipe the surface with a clean rag wetted with **\*\*acetone or denatured alcohol\*\*** to remove any remaining dust or surface contaminants.

### STEP 2 - SEAL & SAND



Apply a thin coat of mixed epoxy to seal the wood. This important step prevents air in the wood from off-gassing and creating air bubbles once you've poured epoxy over it. Seal the wood with two thin coats of mixed epoxy, and allow to dry.

Next, sand the surface with 120-grit sandpaper to scuff the surface so the poured layer of epoxy will adhere well.

### STEP 3 - BUILD THE MOLD



Build a mold to fit around your piece of wood. Use packing tape to line every inch of the mold so the cured epoxy won't stick to the mold. Next, use the hot glue gun to seal all the interior seams of the mold so no epoxy leaks out. Using a tongue depressor, push the hot glue into the seams for a perfect seal. Level the mold, as desired.

**Tip:** Secure the wood to the bottom of the mold either with your first pour of epoxy, which will seep underneath the wood, or with hot glue. If you do not secure the wood to the bottom of the mold, it will float to the top of your first pour (which is sometimes the desired effect).

*(HOW TO MAKE AN EPOXY RIVER TABLE, continued on back)*

### STEP 4 - MEASURE & MIX EPOXY & HARDENER



Dispense 1 part resin to 1 part hardener (by volume) into a clean mixing cup. Mix both components together thoroughly. Mix enough epoxy to pour one layer at a time, at maximum recommended depth of 1/2 inch.

#### Tips for mixing and adding pigments (if desired):

- When mixing the epoxy, stir it slowly for 2-3 minutes. Stirring aggressively will create excessive air bubbles, which can remain suspended in the epoxy.
- After stirring, add epoxy pigments, if desired, and stir to mix thoroughly. Remember that a little pigment goes a long way, so start with less pigment—you can always add more.

### STEP 5 - POUR MIXED EPOXY INTO THE MOLD

**IMPORTANT:** Pour the epoxy no more than 1/2 inch at a time (per layer).



**Tip:** If you're doing multiple pours, wait 2-6 hours before doing 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). Continue to pour in shallow layers until you reach the desired thickness.

**Remove surface bubbles:** To pop surface bubbles easily, wave the heat gun (on low setting) back and forth across the surface. Keep heat six inches above the surface so you don't discolor or scorch the epoxy. Keep in mind that you're not trying to pop all the bubbles in one pass, but are helping the bubbles rise to the surface.

### STEP 6 - DEMOLD & SAND



**Wait about two days for the epoxy to cure completely.**

When the epoxy has hardened completely, remove your river table from the mold.

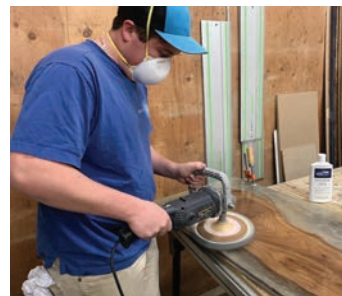
Sand the piece in steps, starting with 120 grit to remove lines left from the tape and any bubbles.

After sanding with 120 grit until the surface is smooth, move to the next grit and sand until smooth. Repeat

until you sand all the way to 3000 grit.

**Tip:** Dry sand using grits from 120-320. Wet sand using grits 400-3000. To wet sand, wet the surface with a water-soaked rag, then sand, as needed.

### STEP 7 - BUFF & POLISH



Apply TotalBoat TotalShine Finishing Compound to the top, and with your buffer, polish the surface. **Tip:** Start with your buffer on the lowest setting to spread the product around. Then keep increasing the speed (while applying less pressure) until you are maxed out. Buff until shiny.

**Warning:** Do not press down hard on the buffer.

Apply TotalBoat Premium Boat Wax with a microfiber towel. Put a generous amount of wax on a rag and work the wax into the project. Use a new, dry towel to remove all wax, and polish to a brilliant shine.



Add legs to your project to make it a table!



**Pigment colors used for this River Table:**

- Pure White
- Liberty Copper
- Battleship Gray
- Cobalt Blue