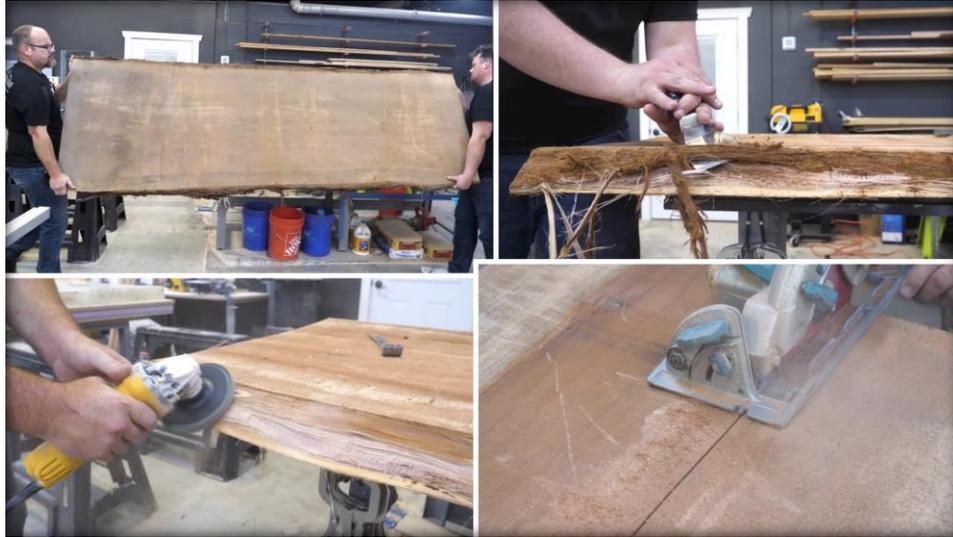
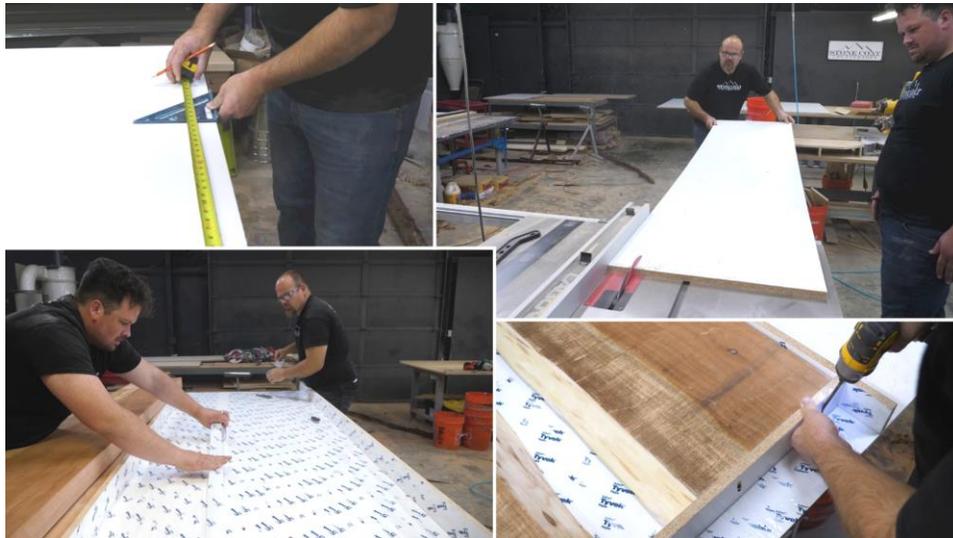


## 12 Steps to Epoxy River Table Success



### **Step #1: Prep your wood slab.**

Cut your wood slab to desired size. Remove any loose bark with a pry bar and hammer. Use a sanding disc on a grinder to clean up any stubborn bark. Cut your slab in half with a circular saw.



### **Step #2: Build your Casting Epoxy Form.**

We used Melamine wood boards for our form for this project. Determine the thickness of your wood slabs and cut the form boards 1/2" proud of your wood slab. Apply Tyvek tape to the form & form boards, overlap the tape by a 1/4". Screw down and secure your form together. Use Tyvek tape to seal where your form board meets the form bottom to keep from leaking



### **Step #3: Level the bottom & seal the wood riverbank.**

Using the Slab Jig, level the bottom of your slabs. Remove 1/8"-1/4" per pass. Return wood slabs to your form. Mix Quick Coat and apply to the live edge of the wood slab. Quick Coat is a 1:1 ratio by volume. Mix for 2 minutes with a drill and paddle mixer. Apply mixed Quick Coat with a brush or gloved hand



### **Step #4: Pour the Casting Epoxy River**

Casting Epoxy or Thick Pour Super Cast Epoxy both are measured at a 2:1 ratio by volume. Add desired metallic powder or epoxy dye. Mix for 5-8 minutes by hand using a mixing stick. Pour the river taking time to torch the epoxy to remove the air incorporated into the epoxy while mixing every 1/4"



**Step #5: Remove your river table from form & install support bars.**

Use a pry or flat bar to remove table from form when the epoxy river is cured. Router the bottom the table to install 1/4" x 1/4" tube steel to keep your project from cupping in the future. Use Quick Coat to install your support bars. Quick Coat - 1:1 ratio by volume, mix 2 min. Remove excess Quick Coat with a bondo spreader or squeegee.



**Step #6: Level the top with the Slab Jig, roundover the edge & sand.**

Quickly bring the table top to level using the Slab Jig. Remove 1/8"-1/4" per pass until level. Use a 1/8" roundover bit to round the top and bottom edges. Sand the surface and edges with 60-220 grit sandpaper.



**Step #7: Seal your table with Stone Coat Countertop Epoxy**

Apply 3 seal coats of Stone Coat Countertop Epoxy. Seal Coat is measured and mixed at 1 oz of mixed epoxy per square foot of table top. Stone Coat Countertop Epoxy is mixed at a 1:1 ratio by volume, mix for 2 minutes with a drill & paddle mixer. Spread the mixed epoxy with a shower squeegee. Use a torch to quickly remove air incorporated into the epoxy while mixing. Before applying the next seal coat, lightly sand the table with 220 grit sandpaper. Each seal coat will have less air escaping from the wood.



**Step #8: Fill stubborn pits.**

Use a furniture repair burn in fill-stick to fill and seal any stubborn pits. Heat the end of the fill stick, apply fill-stick material to pit. Use a flat edge razor blade to remove excess fill-stick material.



### **Step #9: Flood coat your Epoxy River Table.**

Use Stone Coat Countertop Epoxy to apply a finish flood coat. Flood coats are measured and mixed at 3 ounces of mixed epoxy per square foot of tabletop. Stone Coat Countertop Epoxy is a 1:1 ratio by volume epoxy, mix for 2 minutes with a drill and paddle mixer. Pour mixed epoxy onto the center of the table, use a 1/8" x 1/8" square notch trowel to evenly spread the epoxy. Using the heel of a brush, chop the top to remove trowel lines and ensure one last mix. Quickly remove the air from the epoxy with a propane torch.



### **Step #10: Remove dried drips.**

Use a grinder and sanding disc or a sander to remove the dried epoxy drips from the bottom of the project.



### **Step #11: Install.**

Ensure your table overhangs the cabinets evenly. Tape off the cabs with delicate release tape. Use 100% silicone to secure your table to the cabinet.



### **Step #12: Enjoy your Epoxy River Table.**

Your table will last many years to come. To clean use any cleaner designed for laminate or solid surface countertops. Keep from using a cleaner with any scrubbing additives. Use our Liquid Smooth product for a pleasant finishing touch. The epoxy

will be cured to its full scratch and U.V resistance after a 30-day cure. Begin using your new table after a 72-hour cure.