



# Bio-Clear 810<sup>®</sup> TECHNICAL DATA

<b>FOR BEST RESULTS</b>	<p>TEST the epoxy on your surface. Mix up a small amount of the epoxy (2 to 1 mix ratio) and apply to a test surface to ensure compatibility and to test your mixing method. Some surfaces will release a lot of air bubbles. Incompatible inks may bleed. Unknown or unsuspected contaminants on the surface may discolor the epoxy. If the epoxy is not thoroughly mixed, tacky/sticky spots that never harden will result. Do not use the small amount of epoxy that collects at the bottom of the mixing container as it most certainly will not be correctly mixed epoxy. Sudden changes in temperature or humidity may affect the epoxy. Make sure your raised edges or sills are leakproof and level. Once poured, it is almost impossible to stop an epoxy leak in a corner. Bio-Clear 810 cannot be brushed on. It must be poured at sufficient depth to prevent surface tension related fisheyes. A fan blowing over the freshly poured epoxy may help to reduce exotherm (heat) related problems.</p> <p>The epoxy will feel dry and hard overnight, but it takes a week for it to fully cure and harden. Do not place objects on the epoxy before then as they will stick or leave a dent or impression in the still hardening epoxy.</p> <p>Potlife is approximately 40 minutes at 75°F for a 6 ounce amount, so mix only the amount of epoxy that can be easily applied within that time limit. Apply 1/4 to 1/2 inch thick on smaller pours and 1/4 inch on larger pours. The more mass of epoxy that is poured, the thinner the layer should be. Do not mix more than 3 gallons at a time, even on big jobs exotherm related stress cracks or distortions may form.</p>
<b>NOTES</b>	<p>Part A (Epoxy base) should be slightly yellow. If it is milky, it has crystallized. This is common with very pure, clear epoxy resins. Warming the resin to 90 - 110° overnight (oven, microwave, heat lamp, etc.) will dissolve the crystals. This does not affect the performance of the product.</p> <p>Unless top-coated with a UV absorber, this epoxy will yellow and eventually turn cloudy with exposure to sunlight. This epoxy will generate a considerable amount of heat when it hardens. Thin plastic containers will melt.</p> <p>Mix slowly to avoid introducing excess air bubbles. After pouring, most bubbles will come to the surface and burst. Most of the remaining bubbles may be removed once they come to the surface with the quick pass of a heat gun. This must be done before the epoxy has set up.</p> <p>As noted before, test the epoxy on your surface. What happens after the clear epoxy is poured upon the surface is the sole responsibility of the purchaser. Supplier liability is limited to 1 three gallon unit maximum for Bio-Clear 810. See warranty statement.</p> <p>Shelf life is a minimum of six months.</p>
<b>TEMPERATURE</b>	<p>Temperature will exert a considerable influence on the rate of curing of chemically cured coatings such as Bio-Clear 810 epoxy. In broad terms expect each 10°C, (18°F), rise or fall in temperature to half or double dry times and pot lives.</p> <p>The epoxy and the surface to be coated should be at a constant 68 degrees or warmer for 24 hours before and after the pour.</p>
<b>TRANSPORTATION</b>	<p>Epoxy base - Nonregulated by USDOT, IATA &amp; IMO. Curing agent - USDOT, IATA &amp; IMO "Regulated". Class 8, Packing group III, UN 2735, Corrosive</p>

**SAFETY:** This is a hazardous material if misused. Read and understand the Material Safety Data Sheet (MSDS) before use.

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