



**6ES3006 Poured Epoxy**  
***Clear Epoxy Resin for Castings***  
***and Inclusions***

*Today, the use of composite materials in interior designs enriches the aesthetic features of both modern and rustic furniture.*

*New trends combine slightly shaded or colorless epoxy resins with exotic woods. It is now possible to have something modern, original and special.*

*Sirca constantly looks toward modern technologies and has developed a special clear epoxy resin that can be tinted to match any desired look.*

*This epoxy resin is easy to use, shows optimal surface hardness and scratch resistance with exceptional light fastness and anti-shrinking properties.*

**Technical Features/Application Process**

6ES3006 can be used to achieve high/deep pour thicknesses which is typical of today's artistic wooden table production.

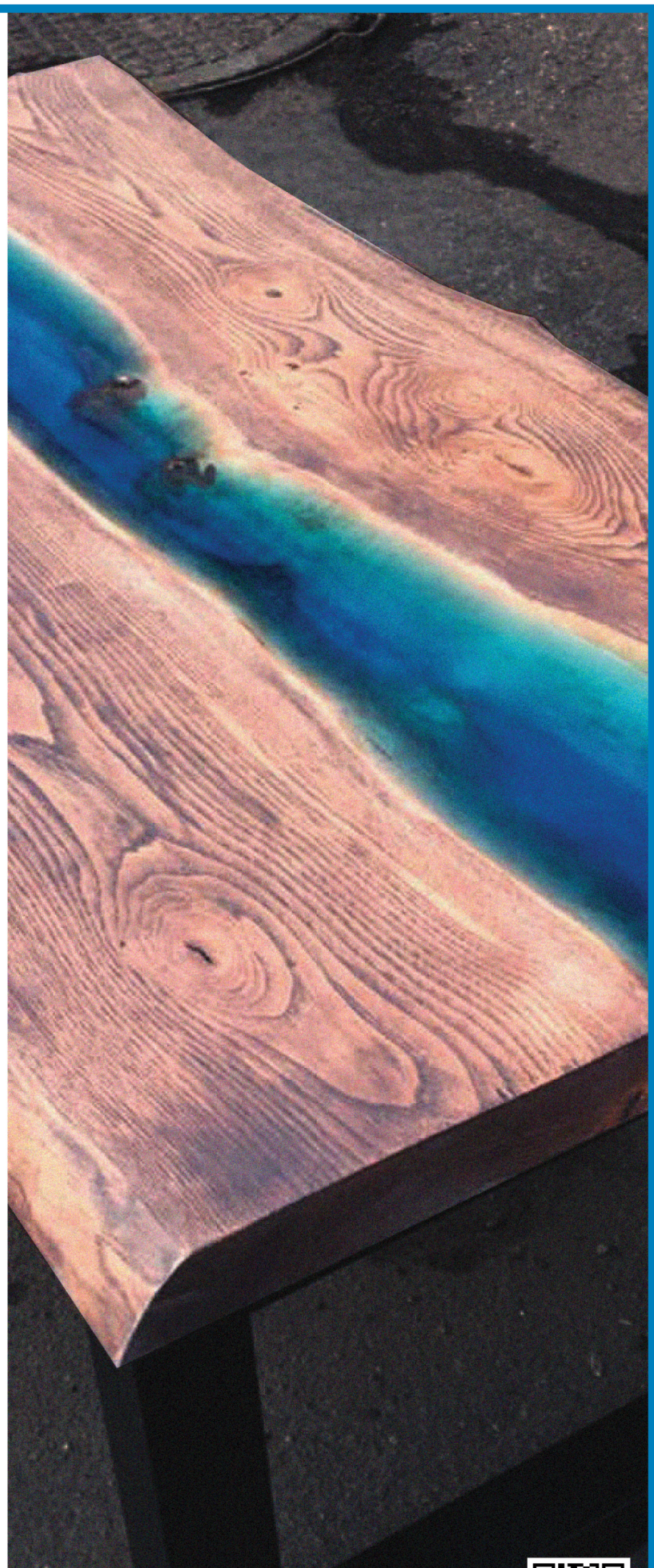
6ES3006 has to be mixed with a hardener at a 100 to 30 percent ratio. No additional reduction is required. The mixing ratio is by weight and is based on part A.

The mixing ratio is very important. Adding too much or not enough hardener will affect not only the clarity of the final product but also its final hardness. It is also important to completely mix the two products together. If the resin and hardener are not mixed properly, sticky spots will develop causing the project not to dry completely.

6ES3006 shows optimal resistance towards temperature shocks, optimal resistance to cold liquids and dry and wet heat.

**Dry Times**

Standard dry times for 6ES3006 at 77° is 24 to 48 hours depending on the total depth of the pour. Very high temperatures can cause cracks, color changes and air bubble retention. This product is completely cured in four days. At this time, your project can be buffed.



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### FAQ's and Technical Tips

#### Does the resin turn yellow?

Epoxy resins are generally color stable and have excellent transparency for long periods of time. For this reason, they are suitable for castings in furniture and other wooden objects.

#### For Optimal Results:

1. Apply the epoxy when the humidity is relatively low and with temperatures above 59°.
2. Do not apply the resin in cold or humid conditions.
3. Do not apply the resin on wet materials like undried wood or uncured concrete.
4. To achieve a full gloss finish it is suggested to sand the resin starting with 400 grit sandpaper and continuing until you have reached 1500 grit sandpaper before buffing the surface of the project.
5. It is recommended to apply a mold release product to the interior of the mold to ease the release of the project once it is fully cured.

#### Poured Epoxy projects are subject to retaining air bubbles so it is recommended to:

- a. *Mix the resin with the hardener slowly and for a longer period of time.*
- b. *Let the mixture stand for a least 10 to 15 minutes before pouring.*
- c. *Pour the mixture slowly and close to the surface / edge of the mold.*
- d. *Bubbles that surface after the pour is complete can be removed by applying heat from a heat gun or by lightly squirting a mist of acetone on the bubbles.*
- e. *6ES3006 can be tinted using 6FBU or 6CTE colorants.*

***Please contact your Technical Representative for additional information.***

12/2021

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