



Working tips for **Super Sap 100 Epoxy / 1000 Hardener System** And **SURF Sap 101 Epoxy / 1200 Hardener System**

What is SUPER SAP Epoxy?

It's a low viscosity, ambient cure bio-based liquid epoxy system that's 55% derived from natural, renewable resources such as industrial waste pine and vegetable oils.

What is SURF SAP Epoxy?

Surf Sap Epoxy resin is similar to Super Sap in that it's feedstock partially derived (33%) from the waste streams of other products like bio-fuels production and other waste vegetable oil processing. However, we've maximized low-color clarity and retention for color sensitive applications, like surfboard manufacturing.

Our epoxy resins were engineered to maximize 3 things:

- 1) Mechanical performance; strength, toughness, and flexibility
- 2) Sustainability
- 3) Workability (for wet-layup and ambient cure conditions)

Safety

Although **SUPER SAP** has a lower percentage of typically sensitizing ingredients, normal safety precautions should still be taken. As with all resins, we suggest adhering to all OSHA and NIOSH regulations for working with epoxy resins, which may include using VOC rated respirators, proper ventilation, eye protection, gloves, and other protective clothing. Refer to MSDS for more information and emergency contacts.

Surfboard Wet-Layup Laminating Tips

***NOTE – Computer ink-jet printed color logos on rice paper may bleed during lamination. We suggest using only black ink if using computer ink-jet printing, or highly suggest using professionally silkscreened or laser printed logos on rice paper.**

- Use a scale to weigh out proper ratio of 2:1 by weight
- For tack free and sandable surfaces, you may use 1 cc or 1 ml of surfacing agent (Xylene/Wax solution a.k.a. Additive F from Resin Research) per oz of hardener (@ 72 °F, < 70% humidity). At warmer temperatures less surfacing agent may be used, and at higher humidity, more surfacing agent may be used.

- Mix well with a large mixing stick (4-5 minutes) or with a power mixer (2 minutes) at slow-medium speed. Be sure to scrape the sides of the mixing container to achieve an even mixture and proper cure. Avoid creating foamy bubbles when mixing.
- A medium to hard squeegee (blue rubber or yellow plastic) can be used to move the resin around the fiberglass surface. Overworking the resin should be avoided as it can introduce small bubbles and foam into the resin.
- Spread the resin evenly on the flat areas first, then coat the laps, allowing the resin to fully soak into the cloth. Do not overwork the resin as this may introduce foamy bubbles into the resin.
- To coat laps, a resin bead should be laid out on the rail by quadrants. A hard yellow squeegee can be used to push the resin down and into the laps.
- After the laps are wet out, a medium to hard squeegee can be used to pull excess resin off the flats. Once the flats are evened out, the laps can be tucked, and excess resin pulled off with a soft yellow squeegee.
- Since the resin is amber colored by nature, a small addition of white tint can help hide any inconsistencies in the lamination or blank

Thin Film Coating Tips

- For tack free and sandable surfaces, use 1 cc or 1 ml of surfacing agent (Xylene/Wax solution a.k.a. Additive F from Resin Research) per oz of hardener
- Mix by stick (4-5 minutes) or with drill mixer (2 minutes) at slow speed to minimize bubbles
- cross strokes (45 degree to the stringer) can be used to even out resin, followed by finishing strokes tip to tail.