

### CAUTION!



- ▶ Do not expose the product to direct sunlight.
- ▶ Keep container closed to prevent contamination.
- ▶ May cause eye and skin irritation. Use this product only in a well-ventilated area with protective gloves and eye protection.
- ▶ Do not eat, drink or smoke while using this product.
- ▶ When mixed in very large masses, this product can generate excessive heat. Handle with caution.
- ▶ Dispose of containers and contents in accordance with all Federal, State and Local regulations.

### SHELF LIFE

Unopened: 6 - 12 months\*

Opened: 3 - 6 months\*

*\*depending on how the product is stored.*



For more product information, please visit:

[www.SuperEpoxySystems.com](http://www.SuperEpoxySystems.com)

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Product/Document #: 152991  
031423



**SUPERCLEAR**  
Super Epoxy Resin Systems

# FORGE BOND

## KNIFE EPOXY

## 1:1 EPOXY

## RESIN & CURING AGENT INSTRUCTIONS

## READ ALL INSTRUCTIONS CAREFULLY BEFORE USING THIS PRODUCT

FORGEBOND KNIFE EPOXY is a premium epoxy resin system that uses high grade ingredients for an impact & fracture resistant, easy to use, multi-purposed, knife epoxy. This product is perfect for full & hidden tang applications.

## SUGGESTED MATERIALS NEEDED

- ▶ Stir sticks
- ▶ Mix and measure buckets
- ▶ Putty knife or plastic spreader
- ▶ Drop cloth or plastic sheeting for easy clean up
- ▶ Disposable Gloves
- ▶ Safety protection

## INFORMATION TO KEEP IN MIND

Inaccurate measuring or improper mixing are the most common causes of poor results. This product **MUST** be used in a 1:1 ratio by volume and thoroughly mixed. For best results, work quickly in temperatures between 70-84°F, but 70-74°F are best.

## DIRECTIONS

### STEP 1:

The ideal working temperature is generally between 70°F and 84°F, but best results can be obtained at 70-74°F in a clean, dry, dust-free environment. Avoid working in high humidity.

### STEP 2:

To prepare your surfaces for bonding, apply acid etch or lightly scuff the surface of your tang with 80 grit sandpaper, or 220 grit on knife scales. Once your surfaces are coarse, clean thoroughly with Isopropyl Alcohol 90% or higher.

### STEP 3:

Prepare 1 part Base Resin to 1 part Curing Agent by liquid volume or 100 parts Base Resin to 87 parts Curing Agent by weight. Pour the Curing Agent first and then the Base Resin into a clean, smooth sided container large enough to hold all the liquid and allow room for mixing. We do not recommend mixing more than 4 ounces in a single container, as this product is mass dependent.

### STEP 4:

THE MATERIAL MUST BE MIXED THOROUGHLY FOR A MINIMUM OF 3 TO 5 MINUTES BY HAND. Be sure to scrape the container sides, bottom, and corners as you mix. Do not use a drill mixer. Working time is about 30-45 minutes.

### STEP 5:

Apply mixed epoxy evenly onto both the surfaces with a putty knife, plastic spreader, or gloved hand. Press both surfaces together and clamp with even pressure. Wipe excess immediately after clamping.

### STEP 6:

Material will be cured after 24 hours, but will gain maximum hardness within up to 7 days after the cure, depending on temperature.

**DISCLAIMER:** While this product can be used in a variety of applications, not all users or environments are the same. As such, specific directions for all individual users might not be addressed here. If there are any questions this document does not answer, pertaining to the individual customer's application, it is the customer's sole responsibility to contact us directly with any technical questions and procedures prior to the application of this product. See back of pamphlet for various means to obtain further information and or contact us directly; we offer FAQ's on our website and technical service via E-mail or phone Monday through Friday, 9am-4pm EST.