



Casting compound for the manufacture of reliefs, figures and models

- Measurable without weighing
- Mixing with water in a simple manner
- Not harmful to skin or injurious to health.
- Not detrimental to environment

Characteristics

Appearance white powder

Mixing ratio

by volume, powder : water 3 l : 1 l

by weight, powder : water 3,5 kg : 1 l

= mixed volume 2,3 l

Working time app. 15 min

Setting time app. 20 min

Surface hardness above 200 N/mm²

Working instructions

Preparing the casting moulds:

Set up the relief moulds in a level position, hang up hollow caoutchouc molds in a suitable arrangement.

Mixing and filling the moulds:

Determine the required quantity in respect to the above named mixing volume. Measure the powder in a dry measuring vessel; prepare water in an amount of 1/3 of the volume of powder in the mixing vessel. Strew the powder into the water, allow to soak and mix thoroughly for 1 minute. In order to mix larger quantities it is advisable to use a mixing machine. Pour an adequate quantity of the mix into the mould just as to cover its surface. Distribute the mix with a soft brush in the relief form; knead the caoutchouc mould cautiously. By this means it is assured that possibly existing air bubbles can escape and smooth surfaces are yielded.

Thereafter the rest of the mix can be poured more rapidly.

Demoulding:

The set model can be removed from the mould approximately 40 minutes after casting.

Advantageously it is to be stored ventilated by air from all sides, e.g. on wooden lathes.

Colouring the surface:

Water based colours may be applied 2 - 8 hours after demoulding. If using enamel paints or impermeable coatings, final setting reaction and drying are to be completed in advance. At temperatures of 20-25 °C drying of the castings requires at least 2 days, it may be reduced to 24 hours if they are stored at temperatures of max. 40° C.

Useful hints

It is important to use only pure water and clean receptacles and stirrers.

Do not exceed the working time.

Packing

Paper bag with foil liner	50 kg
Paper bag with foil liner	25 kg
Foil bag	5 kg

Shelf life

At least 12 months in closed, vapour-proof packages.

The above recommendations are given to the best of our knowledge. We grant the quality of our products according to our specification. Any further liability cannot be accepted since the proper application of our products is outside of our control.

