

# ACRYLCAST

## MINERAL CASTING SYSTEM

# INSTRUCTIONS

### Introduction

**AcrylCast** is a non toxic, water based - mineral/acrylic - casting and molding system. It is easy to use and pleasant to work with.

**AcrylCast** consists of a mineral powder component and an acrylic liquid component that are mixed together to a yoghurt like consistency that can be cast solid or laid up by hand with glass fiber reinforcement to form strong and lightweight pieces. These pieces can be painted, sanded, machined, polished and are extremely strong and durable.

Applications include the production of architectural elements, reproducing sculpture, molds and back-up molds, creating theme effects etc .

Metal powder (bronze, iron, brass) can be added to give the look of metal. Marble and stone powders can be added to achieve various results.

mixing ratio by weight:  
**40 parts of liquid to 100 parts of powder**

### Measuring & Mixing

- Shake or stir the liquid component well. Dispense the required amount into the mixing cup.
- Add the appropriate amount of powder into the mixing container by gradually sifting it through the fingers.
- Let the mixture soak for a minute
- Mix thoroughly by hand or machine until dry powder is evenly dispersed into the liquid (min. 60 seconds) to a lump free, creamy consistency.
- Pot life will be about 6 to 12 minutes depending on circumstances. Machine mixing will reduce pot life. **Note: Using a power mixer is easier and gives better results than hand mixing.**

*To minimize dust inhalation, we recommend that you wear a dust mask while weighing and mixing components. Use only clean, dry measuring and mixing vessels and stirring utensils.*

### Pouring into a mold:

- Brush a face coat of **AcrylCast** onto the surface of the mold. This helps to break surface tension and ultimately reduce air bubbles.
- After a face coat is applied, the remaining mixture is slowly poured into the mold. Be aware of your working time—allow for enough time to apply surface coat and pour remaining material.

### Hand Lay-Up Technique:

With the addition of fiberglass matting or chopped fibers, **AcrylCast** can be “laid-up” to make elements that are thin, lightweight and exceptionally strong. For exterior use and improved weather-resistance we recommend to add **AcrylCast OX** (Optional X) component (10% to the dry powder). Applying a sealer or painting the element is recommended for outdoor use.

- Brush in one or two detail coats without reinforcement. This coat can be filled with metal powders, marble powder etc.
- For additional coats, chopped strands can be added to the mixture from ca. 2% (easy to apply) to a maximum of ca. 6% (maximum strength)
- When using mat or roving, the mixture is brushed straight into the mat
- Adjust the weight and density of your reinforcement to the scale of your piece
- E-glass can be used. AR glass is recommended