



Data Guide

## POLYESTER CASTING RESIN

### INSTRUCTIONS

1. Pour and drain the required amount of resin that is required into a mixing pot, add the filler powder into the mixing bowl, in small quantities at a time, mix thoroughly until all the powder is absorbed and dispersed in the resin, leave the mixture to stand, thus allowing air bubbles to rise and disperse from the mixture.
2. Having ensured no air bubbles remain in the mixture, slowly add the contents of the hardener container and stir carefully to avoid making air bubbles, stir until the hardener is thoroughly dispersed in the mixture.
3. The mixture is now ready to be poured into the moulds as follows:
  - a) Half fill the mould and allow the mixture to flow around the internal surface of the mould, by turning and tilting at the same time, flexing the mould with thumb and forefinger to aid the flow of resin mix into the mould detail, and to ensure any air trapped in the mould can exit.
  - b) It is very important to ensure your castings are free from pinholes caused by air being trapped in the mould; particular attention should be paid to the areas of fine detail and undercuts e.g. faces, heads, ears, hands and feet.
  - c) Prepare a support for your mould as it has to be able to sit flat. Cardboard is a good substance to use as a support. Once the mould is level, fill it to the desired level.
4. The supported mould is to be left undisturbed until the curing and setting cycle, (during which heat is generated), has elapsed. The period of time this takes is relative to room temperature e.g. cooler temperatures extend the curing time.
5. Once the casting is set, the mould should be carefully removed from the casting in the following manner:
  - a) Moisten the outside of the rubber mould with soapy water (washing liquid is ideal). h) Carefully peel back the mould on itself.
  - c) Do not exert undue force as you may tear the mould or damage the casting.

(1) Any tackiness of the casting will normally disappear after it has been exposed to the air for a while.

  - c) Alternatively wash the casting in warm soapy water, brushing gently with a soft brush.

### PRODUCT INFORMATION

Castings can be painted with most types of stains and paints, except oil based paints. An antique appearance can be given by lightly brushing on a wood stain and rubbing of the excess colour on the high points of the casting before the stain has dried, castings can also be wax polished if required.



Castings which turn out with small imperfections in their detail due to air bubbles, can be filled with a small amount of mixture being used as a filler.

Do not add the hardener to the resin mix until you are ready to commence casting. Then only add the hardener to the amount of resin you will be using within approximately 20 minutes, as after this time the resin will begin to harden and make working with it too difficult.

With large castings the mixture may become excessively hot while in the mould. Should this happen, suspend the mould in cold water and leave until the casting has set.

Shelf life is limited to six months from the date on the bottom of the Casting Resin can. Always store this product in a cool, dry place

#### **SUPPLIED**

In the following sizes: 1 ltr, 2 ltrs, 4 ltrs, 20 ltrs

Do not allow contents of the Hardener Container to come in contact with skin or naked flame.

**SAFETY PRECAUTIONS:** Do not use near fire or flames. Harmful or fatal if swallowed Use disposable gloves to avoid skin contamination. If resin comes into contact with skin, wash uncured resin off with soap and water. Wear safety glasses to avoid eye contamination. Mixed formulation contains Epoxy Resin and Amines. If swallowed do not induce vomiting. Give a glass of water. Contact a Doctor or the Poisons National Information Centre on 0800 764 766 (Urgent information only). Eye Contamination: Hold eyes open and flood with water for at least 15 minutes. See a Doctor immediately.

#### **WARRANTY**

Because the use of this product is beyond the control of the manufacturer, no liability or responsibility can be accepted for any loss or damage arising from its application or use. Liability for faulty material is limited to product replacement only.