

Weighing



All components must be weighed :

- 1 part Acrystal Aqua liquids
- 7 parts Acrystal Aqua powders

1. First weigh the Acrystal Aqua powders in the mixing bucket.
2. Acrystal Aqua liquids must be weighed in a separate container.
3. If required, add paste pigments.
4. If required, add the Aqua thixotrope (max. 1% of the total weight)

You will obtain the best result, if you calculate the 7 parts of powders on the global liquid weight (Acrystal Aqua liquids + pigments + thixotrope).



Mixing



Use a high shear mixing blade at a mixing speed that must be over 700 rpm to break up small lumps. The following sequence of mixing is critical.

1. Blend powders for 15 to 30 seconds.
2. Add Acrystal Aqua liquid.
3. At the beginning, the mixing is very thick, but it will suddenly become fluid.
4. Continue mixing 1 to 2 minutes until a lump free creamy consistency of compound is obtained.
5. The Acrystal Aqua batch mix is then ready for use.



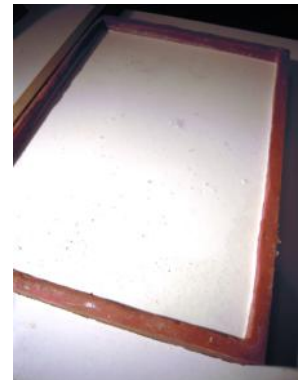
Use

Pot life :

- 30 to 45 minutes at 20°C
- 5 minutes at 30°C

Cast or laminate Acrystal Aqua continuously.

ATTENTION : When strengthening with glass fibre, always use AR fabrics (alkali-resistant).



Setting

ATTENTION : Once cast, It is essential to maintain Acrystal Aqua in a humid atmosphere for at least 72 hours.

Demoulding

Acrystal Aqua can be demoulded after 18 – 24 hours.

Curing

During the first 3 days it is imperative to:

- maintain the casting in a humid atmosphere or even keep it submerged in water at 20°C.
- never store in a dry, hot ventilated area .

A cure that is too fast can cause microscopic surface cracking.

Acrystal Aqua will continue hardening over several weeks

More than 50% of final resistance is obtained at the end of the 1st day. More than 85% at the end of 1 week.

The best results are obtained by maintaining the parts wet or immersed during all this time.

Finishing

Three finishes are available after curing of the product :

1. Matt

After hardening, the surface of the casting is covered in a light, white film which can just be washed off.



2. Shiny

After full curing:

1. polish the surface with a fine wire wool (use type 000 to avoid scratching the surface).
2. apply furniture polish (optional).
3. buff with a polishing mop.



3. Sandstone

1. Soften the surface of the casting by soaking in diluted hydrochloric acid.
2. brush more or less under water to obtain the desired surface abrasion.



ATTENTION : if abrasion is too severe, you can expose glass fibres.