

### Weighting

All ingredients must be weighed :

- ▶ 1 part Acrystal Aqua liquid
- ▶ 7 parts Acrystal Aqua powders

1. first weight the Acrystal Aqua liquid.
2. (optional) add the thixotrop Aqua (maximum 1 % of the total weight of the mixture)
3. (optional) add the Acrystal pigments.
4. weight Acrystal Aqua powders in the mixing bucket.



Acrystal Aqua liquid



Thixotrop (optional)



Pigments (optional)



Acrystal Aqua powders  
Mixing bucket

### Mixing

▶ Use a high shear mixing blade to limit the incorporation of air, à une vitesse lente, in order to mix the product and break up any lumps.

1. mix the Acrystal Aqua powders for a few seconds.
2. add slowly the liquid (Acrystal Aqua + thixotrop+pigments).
3. at the beginning, the mixture is very thick, then it suddenly becomes more fluid after a while.
4. continue mixing until you obtain a homogeneous mixture.
5. let it bubble for a few moments. .



High shear mixing blade



Mixing of the powder part



Incorporation of the liquid part

**Acrystal Aqua batch mix is ready for use.**



Very thick mixture



Fluid after a while

### Use

Minimum using temperature 12°C

- ▶ Pot life at room temperature of 17 - 20°C : 30 to 45 minutes.
- ▶ Pot life at 30°C : 5 minutes.

#### Attention :

- ▶ Always pour or apply the product continuously.
- ▶ If using fiberglass, it must be of the AR (alkali-resistant) type.



Casting



Application on a polystyrene foam or other type support

### Setting

- ▶ It is imperative to keep the Acrystal Aqua object in a humid environment for a minimum of 72 hours in order to avoid micro-cracks over time.
- ▶ For this, it will suffice, for example, to cover the product with a plastic film.

### Demoulding

- ▶ Demoulding is possible after 12 to 18 hours.

### Curing

- ▶ During the first 3 days it is imperative to :
  - keep the Acrystal Aqua object in a humid environment (for example under plastic film) or even immersed in water at 20°C.
  - avoid storage in a dry, warm and ventilated place.
- ▶ Acrystal Aqua takes 3 weeks to fully cure. Best results are obtained by keeping the parts moist or submerged throughout this time.
- ▶ More than 50% of the final strength is achieved after 1 day.
- ▶ More than 85% after 1 week.
- ▶ Maximum strength is achieved after 28 days.

### Finishing

- ▶ Three surface finishes are possible after the product has hardened :
  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 :
    - polish the surface with a fine wire wool (use typ 000 to avoid scratching the surface).
    - apply furniture polish (optional).
    - buff with a polishing mop.
  3. Sandstone
    - soften the surface of the casting by soaking in diluted hydrochloric acid.
    - brush more or less under water to obtain the desired surface abrasion.

#### Attention :

- ▶ If abrasion is too severe, you can expose glass fibres.

