

Weighing



All components must be weighed :

- 1 part Acrystal Optima liquids
- 3 parts Basic Crystal powders

1. First weigh the Acrystal Optima liquid in the mixing bucket.
2. If required, add in the same bucket paste pigments and retarder.
3. Basic Crystal powder must be weighed in a suitable separate container.



Mixing



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

1. Blend liquid during 15 to 30 seconds using high shear blade and incorporate if needed Acrystal pigments and retarder.
2. While continuously mixing liquid, add slowly the powder.
3. Continue mixing 1 to 2 minutes creating a vortex in the mix until a lump free cream consistency of the compound is obtained.
4. Incorporate thixotrope if required.
5. The Acrystal Optima batch mix is then ready for use.



Use

Pot life at room temperature of 17 to 20°C :

- 8 to 10 minutes without retarder
- up to 90 minutes with retarder



Gel Coat



Casting

Setting

- First the mix becomes thick and the exposed surface matt.
- This step is followed by a temperature increase.
- The setting is finished when the item comes back to room temperature.

Demoulding

Demoulding is possible after 20 minutes to 2 hours depending on the size and the shape of castings and laminatings.

Curing

- 90 % of the hardness is achieved after 6 hours at 20°C.
- After 72 hours the item is completely cured.