



THE COMPLEAT SCULPTOR

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EasyCast Instructions

WHAT IS EASYCAST?

EasyCast is a reactive clear casting epoxy. It's solvent free and low odor. It can easily be colored, tinted or combined with fillers to create faux granite or metallic castings. These characteristics make it ideal for casting and embedding up to 6 ounces (maximum) per pour. Due to heat build up and discoloration, do not attempt to cast more than 6 ounces at one time. For larger casts, use Castin'Craft Polyester Casting Resin.

TOOLS NEEDED

- Plastic measure / mixing cups (do not use wax coated cups as the wax may break off and contaminate your mix).
- Wood stir sticks
- Disposable craft brushes
- Wax paper or plastic sheet to protect work surface.

MOLDS

Polypropylene or polyethylene resin molds are designed for use with Polyester Casting Resin or Clear Casting Epoxy due to their self releasing characteristics. Rubber molds made from latex, urethane or silicone can be used if treated with Castin'Craft Mold Release / Conditioner. **WARNING:** Due to the strong bonding properties of EasyCast, only use plastic molds designed for resin casting. Other molds such as candy, soap or candle molds are generally not useable even with a good mold release. If you're not sure, test a spot on the mold, such as the back side.

MOLD PREPARATION

1. Determining mold capacity: Occasionally plastic molds state the size of the mold cavity. However rubber (latex, urethane and silicone) molds generally do not. To determine the amount of material required, fill mold first with water, then carefully pour this water into a measuring cup. **CAUTION:** Some rubber molds may absorb water. This water can cause a cloudy or milky appearance in your finished piece. Make sure your molds are thoroughly dry before using.

2. Prepare all molds with Castin'Craft Mold Release/Conditioner per package instructions. Rubber molds require two applications. If two applications are not applied, you may not be able to remove your cast pieces once cured.

WORK AREA AND SURFACE:

- For best results, your work area and surface should be between 70° F / 21° C and 85° F / 29° C.
- Work surface should be dry, level and free of dirt or dust.
- Protect work area with a plastic drop sheet, wax or newspaper.

INSTRUCTIONS

EasyCast was designed for a maximum single cast of 6 ounces or less. Due to heat build up and discoloration, do not attempt to cast more than 6 ounces at one time. For larger casts, use Castin'Craft Polyester Casting Resin.

1. IMPORTANT: EasyCast performs best at 75° F / 24° C. EasyCast bottles should feel slightly warm to the touch, if they feel cool, they must be warmed by placing them in warm tap water (not hot) for 5 to 10 minutes prior to using. If bottles become overheated, allow them to cool before using. Never mix hot resin and hardener together! Mixing EasyCast when cold will result in cloudy casts with microscopic bubbles.

2. MEASURE: Carefully measure equal amounts of resin and hardener into a straight sided, flat bottom, wax free measuring container. **WARNING:** Do not vary the 1 to 1 ratio for any reason! Failure to measure equal amounts of resin and hardener will result in soft or sticky castings. Do not simply pour the contents of both bottles and expect to get properly measured amounts, always measure.

3. DOUBLE MIXING (REQUIRED): For EasyCast to chemically blend, it must be mixed together in two stages. With the resin and hardener measured, use a stir stick and mix together for two full minutes. During mixing, use the stir stick to scrape the sides and

bottom of your mixing container. Occasionally scrape the mixture from your stir stick back into the solution. After two full minutes of mixing, pour the contents from the first container into a second container. Using a new stir stick, mix the contents of this second container another minute, again scraping sides of container and stir stick. Pour immediately from this second container.

4. BUBBLES: EasyCast has been formulated to self degas within a few minutes of pouring under most casting conditions. However adding fillers such as granite or metallic powders can result in a cloudy, bubble filled mixture. These bubbles will slowly rise to the surface of your cast. If needed use a hair dryer and pass heated air quickly over the EasyCast surface to remove bubbles. Be careful, excess heat can melt or warp plastic molds.

5. CURE: For best results, cast pieces should cure at temperatures between 70° F / 21° C and 85° F / 29° C. Curing time will vary depending on room temperature and thickness of cast. Thin castings will take longer than thick castings. Normal cure for castings ½" thick is 24 hours for soft cure, 72 hours for hard cure.

6. DE-MOLDING: Rigid type plastic molds can usually be twisted slightly to break the cast pieces free. Pushing in from the back side of the mold will also help. Note: Do not attempt to de-mold pieces that have not cured for a minimum of 24 hours. You may damage your casting by doing so.

7. TRIM & SAND EDGES: Edges can be trimmed with a knife or sanded if needed. Use 150 grit or finer sandpaper to remove excess material. A file, sander or Dremel tool can be used for shaping and carving completely cured castings.

8. CLEAN UP: While liquid, the material can be cleaned from tools with alcohol or solvent. Use warm water and liquid soap to clean from skin. NEVER USE SOLVENTS OR ALCOHOL TO CLEAN EASYCAST FROM YOUR SKIN.

TECHNIQUES

- **FAUX MARBLE:** Faux marble is easily created with the addition of 3 or more contrasting colors of Castin'Craft Opaque Pigments.

Experimenting with the following process will enable you to perfect color combinations and marbling techniques. Some color combinations to consider are:

Green Marble, use green, white & touch of black.

White Marble, use white with a touch of black.

Brown Marble, use brown, white and a touch of black.

Pink Marble, use pink (red blended with white), white and a touch of gray (white blended with black).

1. Mix EasyCast per package instructions.
 2. Divide mixed EasyCast into three containers.
 3. Add a single color to each container and blend. NOTE: Add just enough pigment to color mix and no more!
 4. Pour all three colored mixes into one container. Stir lightly once or twice to swirl colors together, then immediately pour into mold.
- TIP: Avoid over mixing which can muddy colors.

- **TRANSLUCENT GLASS EFFECT: Use Castin'Craft Transparent Dyes.**

1. Mix EasyCast per package instructions.
2. Add transparent dye to mixed EasyCast, approximately one drop of dye per ounce of EasyCast. Less or more can be used for varying shades. Dye colors can be blended to create additional colors.
3. Blend, then immediately pour into mold.

- **FAUX METAL CAST: Use metal powders**

1. Mix EasyCast per package instructions.
2. Add metallic powder to mixed EasyCast, approximately ¼ teaspoon per 8 ounces. Less or more can be used for varying effects.
3. Mix well to ensure all powder is blended, then immediately pour into mold.

- **FAUX GRANITE: Stone Filler mixed with EasyCast produce dramatic granite like results.**

Custom colors or marbling can be created by combining Stone Fillers. Stone Fillers appear white but change color immediately when EasyCast is added. TIP: Adding more Stone Filler will give you a stronger more dense granite effect. Be careful, adding too much granite powder can result in a stiff mixture which is hard to pour.

1. Mix EasyCast per package instructions.
2. Measure Stone Filler into plastic measuring cup.
3. Add an equal amount of mixed EasyCast to the Stone Filler.
4. Stir mixture slowly to avoid airborne dust from powder, then pour into mold.
5. Releasing air bubbles from surface of cast: If needed use a hair dryer and pass heated air quickly over the surface. Be careful, excess heat can melt or warp plastic molds.

- **CASTING EMBEDMENTS:**

Photos, prints, fabric, etc., must be presealed with two coats of white craft glue (Weldbond) to prevent pieces from turning transparent. Delicate items such as dried flowers should be sealed with two coats of a fast drying acrylic spray (EnviroTex Spray Sealer or Krylon). Wood pieces can be sealed with EasyCast or white craft glue, however this must be done and cured before embedding to prevent air from escaping from the wood piece, which will in turn create bubbles in your casting. Solid non porous objects such as seashells, coins, stone, plastic, etc., do not require a seal coat. If you're not sure, test a sample piece first.

POLISHING & BUFFING

Occasionally some EasyCast pieces may require cut polishing to remove imperfections, sanding marks or to change the surface to a semi-gloss or matte finish. NOTE: EasyCast when polished will not develop a high gloss or wet look as per the original surface. For a high gloss surface, consider recoating the cast piece with EasyCast or Envirotex Lite.

1. Hand Polishing: Use Tin Oxide or Micromesh for a matte finish. Follow the package instructions for applying with water.
2. Buffing: Cast pieces can be buffed on a buffing wheel using Plastic Polishing Compound.

WARRANTY:

The recommendations given here serve only as a guide. Because of variables of temperature, humidity, types of molds, colorants and embedments, we cannot guarantee results. Our liability is limited to the replacement price of the product

DANGER:

CONTACT WITH HARDENER MAY CAUSE PERMANENT EYE DAMAGE. MAY BE HARMFUL BY SKIN CONTACT OR BREATHING VAPORS OR MISTS. CONTACT WITH RESIN MAY PRODUCE ALLERGIC REACTION BY INGESTION, INHALATION OR SKIN CONTACT. CONTACT MAY CAUSE EYE/SKIN IRRITATION.

PRECAUTIONS: AVOID INHALATION, INGESTION, EYE AND SKIN CONTACT. WEAR PROTECTIVE GLOVES AND GOGGLES. DO NOT WEAR CONTACT LENSES. DO NOT TAKE INTERNALLY. USE ONLY IN ADEQUATE VENTILATED AREAS. USE WINDOW EXHAUST FAN OR OTHER SUITABLE EQUIPMENT TO REMOVE VAPORS AWAY FROM THE WORK AREA. WASH WITH SOAP AND WATER AFTER USE. KEEP CONTAINER TIGHTLY CLOSED WHEN NOT IN USE.

KEEP OUT OF THE REACH OF CHILDREN

SIGNS AND SYMPTOMS OF OVER EXPOSURE:

SKIN CONTACT: Irritation, dryness, flaking. After sensitization, hives or rashes.

EYE CONTACT: Irritation, redness, or eye watering.

INHALATION: Irritation. After sensitization allergy type symptoms, with possible breathing difficulties. May cause Central Nervous System (CNS) depression. Evident by headache, dizziness, or nausea.

INGESTION: Irritation. Large quantities may cause nausea, and vomiting. May cause Central Nervous System (CNS) depression. Evident by headache, dizziness, or nausea.

EMERGENCY AND FIRST AID PROCEDURES: EYE CONTACT: Remove any contact lenses and flush eyes for 15 minutes with water. Hold eyelids open to ensure complete flushing. CONTACT A PHYSICIAN IMMEDIATELY.

SKIN CONTACT: Remove contaminated clothing/shoes and wipe excess from skin. Flush skin with water. Follow by washing with soap and water. If irritation occurs, GET MEDICAL ATTENTION. Do not reuse clothing until cleaned. Contaminated leather articles, including shoes, cannot be decontaminated and should be destroyed to prevent reuse.

INHALATION: Leave the area to obtain fresh air. If breathing has stopped, give artificial respiration then oxygen if needed. If difficulty breathing or other symptoms continue, CALL A PHYSICIAN.

INGESTION: DO NOT INDUCE VOMITING. CALL A PHYSICIAN IMMEDIATELY or the Poison Control Center. If patient is conscious, give 12-16 oz of water for dilution effect only. Do not give anything by mouth to an unconscious or convulsing person.

Conforms to ASTM D 4236 and the Federal Hazardous Substances Act.

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