

# AC100 STARTER KIT

## INTRODUCTION

Welcome to your first introduction to Jesmonite®. This kit is for users to experiment with and to get a feel for the material and see what it can do. Inside you will find AC100 liquids, Jesmonite Base, a silicone mould, stirring sticks, gloves and some pigments so you can play around with colours. There is enough material provided to produce either 4 squares or 6 hexagons, dependant on which mould you have in your kit.

AC100 is known as our “flagship” material, it was created in 1984 and led the way to all the other Jesmonite® products that are now available. All Jesmonite® materials are sold as a two-part system, liquids and base that are mixed together.

## PREPARATION

You will need scales for weighing, mixing containers such as cups or beakers should be clean and dry and of a suitable size. For mixing larger volumes of material it is essential to use a Jesmonite High Shear Mixing Blade, however for this size mix the enclosed wooden stirring sticks will do the job. Your working area needs to be warm and dry, and out of direct sunlight.

## MIX RATIOS

The standard mix ratio for AC100 is as follows;

AC100 Liquids	1 part by weight
Jesmonite Base	2.5 parts by weight

NB. Adjustments can be made to the ratio for addition of additives such as stone and metal fillers, sands, and lightweight fillers etc.

## HOW MUCH WILL I NEED?

SQUARE MOULD = 200g of mixed AC100 (56g liquids and 144g Jesmonite base)

HEXAGON MOULD = 126g of mixed AC100 (36g liquids and 90g Jesmonite base)

## MIXING

If you want to cast a solid colour, mix the pigment into the pre-weighed AC100 liquids, blend thoroughly and slowly add the Jesmonite base to the liquids whilst mixing until the mix is smooth, flowing and free from lumps.

Alternatively, you can add the pigment to the mixed Jesmonite, experiment by swirling it through to create different effects. You will not need much pigment; the standard addition rate is 2% by weight of total mixed Jesmonite (or 20g/kg) so for these sized casts you will only need a few grams. If you add too much pigment, it will stop the Jesmonite from setting or make the cast object weak and breakable.

## CASTING

For simple casts like the enclosed, pour a small amount of the mix into the mould and coat the surface evenly. To avoid any air bubbles on the surface, use a small clean, dry brush to coat the surface evenly and get into the edges of your mould. You can tap the mould too to get rid of surface air bubbles. Then fill up the mould with the remaining mixed Jesmonite, gentle tapping of the mould will help any air bubbles rise to the top surface. Then leave your cast for about 30-40 mins to set. Once you have taken it out of the mould, it will gain its full strength after 24 hours. Jesmonite needs all the moisture to evaporate to gain its strength, if you leave it in the mould it will sweat, may mark, and not dry thoroughly.

## SURFACE FINISH

Jesmonite AC100 contains a high quality pure acrylic resin that can be polished with a clean cotton cloth. Excellent results can be achieved with a wide range of waxes and polishing machinery, and Jesmonite AC100 is also compatible with a wide range of water-based sealers and varnishes.

## **STORAGE**

As a basic rule liquid containers should be kept well sealed to prevent water evaporation and skin forming. They should be stored at a constant temperature between 5 – 25°C and used within six months. Freezing must be avoided. Base should be kept dry and stored at 5 – 25°C.

## **CLEANING UP**

Because Jesmonite is water based, its easy to clean up when you have finished. Scrape any excess unused Jesmonite into the bin then wash your hands, mixing pots, brushes, and the mould in warm soapy water. It's that easy! You can use White Spirit to remove any pigment residue from your mould if necessary.

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The above information and recommendations are based upon our experience and are offered merely for advice. They are offered in good faith but without guarantee, as conditions and methods of use are beyond our control. It remains the responsibility of the end user to determine the suitability of the materials for the particular purpose intended.

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