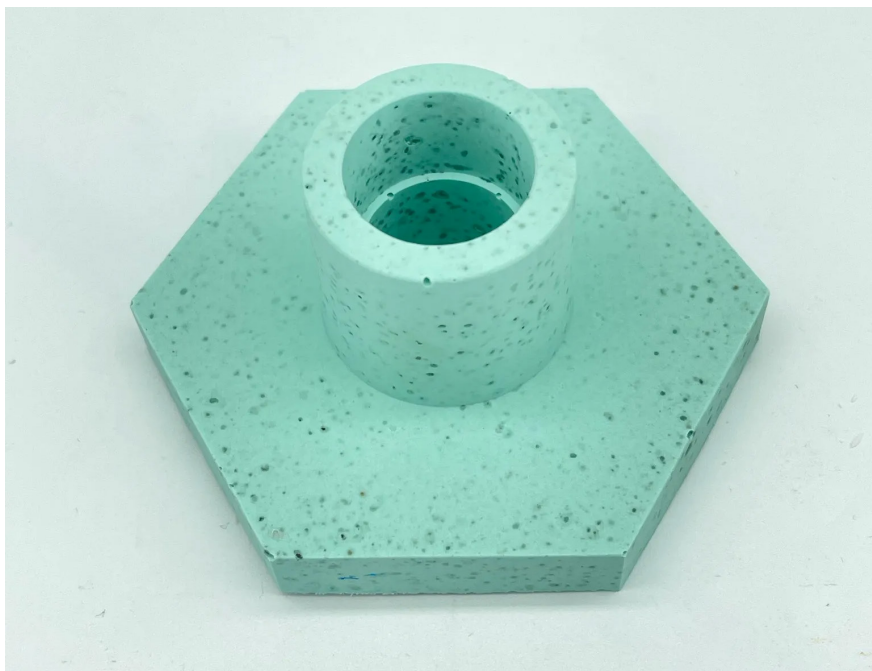


# Casting with Jesmonite



Zealand

# ➔ Jesmonite





## → Jesmonite AC100

Jesmonite AC100 is a two-component casting material; Liquid and powder.

- Modified gypsum composit material
- Waterbased
- Stronger than gypsum
- No toxic chemicals
- Fire retardant
- Not waterproof (can be impregnated)



## → Mixing

Mixing ratio: 1 part liquid - 2,5 part powder



Use a scale and be precise!

Liquid pigment can be added to the liquid. Later the color can be adjusted when the mixture is done.



Put powder **IN** the liquid.  
A little at a time.  
Whisk it well and thoroughly.  
No lumps.



The mixture will be very thick, but continue to whisk and it will become liquid again.  
It takes a maximum of 10-15 minutes before it starts to harden. TAP firmly on the mold to remove bubbles.  
Use a timer to minimize your stress.

## → Demold



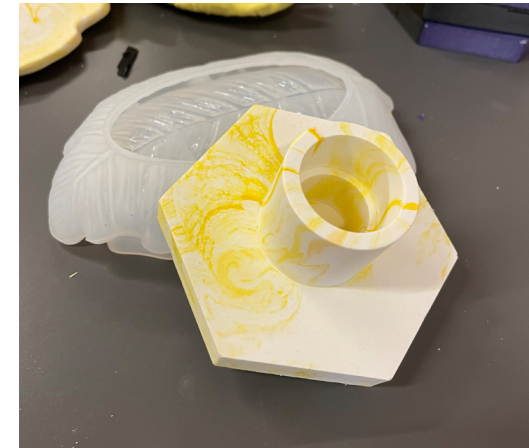
After approx. 20-25 minutes, carefully demold.

You can wait longer (if delicate parts), but you risk spots from the silicone on your object.



Turn the mold upsidedown.

Pull the mold away from the object.  
Be careful as the object is at a fragile state and easily break.



Let the object fully cure with air around it, for 24 hours.

Post processing:  
Can be sanded with water sandingpaper.  
Should be sealed with a waterproof sealer if the object will be exposed to liquid.

# → Weight

MOLD	LIQUID	POWDER
Candlestick hexagon	34 g	86 g
Square	69 g	171 g
Hexagon	45 g	113 g
Oval tray 165	94 g	236 g
Diamond jar	77 g	193 g
Diamond lid	91 g	229 g
(Diamond total)	169 g	422 g
Small jar	14 g	36 g
Vase	40 g	100 g



## Tips and tricks for casting

- Be sure to get all powder of your stick when mixing. You can minimize this by removing the stick before pouring more powder in the liquid.
- Pour from high above should help minimizing bubbles.
- Also swipe the edges of your cup while mixing.
- Wait a bit longer to demold if your mold has weak areas (like a thin stem).
- Put your mold on a piece of paper or cardboard before pouring in the jesmonite as it will help you to shake and knock out the bubbles if you have something harder to grab than the soft mold..

### Colour:

- Powder pigments in powder and if you use liquid pigments put it in the liquid. Adjust the colour when you have mixed it all together. Jesmonite recommend to maximum add 2% colour of the total weight of Jesmonite mix.
- One colour jesmonite: When you do a one colour item you can use your stick or a brush to make sure that the Jesmonite covers the bottom of your mold - and small details. Then you will get rid of bubbles that might be trapped.
- Make your own terrazzo by pouring a thin layer of jesmonite onto a flat surface covered with plastic. When it hardens you can break it into small pieces. You can also use leftovers from previous mixes.
- Mix the normal amount of Jesmonite and add the flakes of terrazzo. You might have a little leftover.
- Terrazzo items need to be sanded afterwards with wet sandpaper approx. grit 800-2000, to get the effect.

### Swirls/marble effect:

- Use a small amount of drops of colour. Gently make big circles with a toothpick. Be careful not to overdo it, the colours will mix when pouring.
- Another method is to mix your jesmonite and pour it in two cups. Put colour in one of them. Pour both cups at the same time in your mold, but move your hands around. (this method makes more solid colours but not as marble like).

### Extras:

- Use vinylcutter to cut a stencil and apply it to the finished Jesmonite item. Seal it afterwards.
- Use vinylcutter to cut thick vinyl (or use a silicone inlay) to get a depth in your casting.
- For more inspiration look at "[Claire's Crafty Corner](#)" on Youtube as she tests a lot of fun things.

**Du skal bruge:**

- bægre
- rørepinde
- underlag
- en god vægt
- Jesmonite pulver
- Jesmonite væske
- evt. pigment
- en form
- et ur

Blandingsforhold: 1 del væske : 2,5 del pulver

Arbejdstid: maksimum 12 min.

Demolding: 20-25 min efter den er kommet i form.

Gennemhærdet: efter 24 timer.

Forsejling: påføres hvis objektet skal udsættes for væske.

1. Vej materialerne præcist af.
2. Når de begge dele er målt af, blandes pulveret i væsken.
3. Rør rigtig godt i ca. 5 min. Husk kanterne.
4. Massen bliver tykkere - rør videre, den bliver tyndere igen.
5. Når alle klumper er væk, er massen klar.
6. Hæld det i din form og bank formen RIGTIG godt for, at undgå for mange luftbobler. Sæt ur til 20 min.
7. Når du demolder skal du være lidt forsigtig. Fjern formen fra dit objekt og ikke omvendt.
8. Lad objektet gennemhærde færdig på en måde, så den kan få luft på alle sider. F.eks. ved at stille den skråt op ad din form.

Lad dig ikke stresse over arbejdstiden. Det er vigtigt at du får rørt godt og det er der tid til.



## Udregning af støbeformens masse

For at regne ud hvor meget støbemasse der skal bruges til en form, kan man gøre følgende:

Nulstil vægten med formen på. Hæld vand i formen - helt til kanten.

Tag tallet og gang med 5%. Herefter deles tallet med 2 = vægten af jesmonite væske, der skal bruges.

Så tager du det nye væske-tal og ganger med 2,5 = vægten af pulver der skal bruges.

## Links

Jesmonite: <https://jesmonite.com/>

Dansk importør: DanLube (<https://danlube.dk/shop/39-jesmonite-ac100/>)

### Eksempel:

Vand i form vejer 200 g. + 5%=210 g.

Jesmonite væske: 210 g. / 2 = 105 g.

Jesmonite pulver: 105 g. \* 2,5= 262,5 g.

