

Castalot - Instructions For Use

A fast setting, refrirable mold material for glass slumping, fusing or kiln casting applications. Carvable (wet or dry).

Use an OSHA approved particle mask or respirator when handling this product or any other dry, powdered material.

Mixing Instructions

2 parts mold material to 1 part water by volume.

More water may be added to increase working time. Allow more time to set.

Don't exceed 60% water content.

Mix thoroughly for approximately 90 seconds, and pour immediately.

Working time 5-6 minutes.

pour over prepared model (clay, Plasticine, or rubber) as soon as material is thoroughly mixed.

It should have the consistency of a milk shake. Agitate vigorously to eliminate bubbles.

Remove from model as soon as material completely sets up (approximately 30-40 min).

For best results it is important to pre-fire the mold to 50° over the desired fusing, casting, or slumping temperature. This will fire out the impurities making a longer lasting mold. You may force fire the damp mold during the curing process.

Example: For a 6" X 9" X 1.5"D mold:

Initial phase: 30 min to 190° hold for 2 hours (this will force out the steam) then ramp @ 275° hr to desired temperature and allow to cool naturally. For larger molds, add more time to the initial heating phase and go slower to the top end of the cure.

This is an approximate schedule.

Yours may vary depending on mold and model type and kiln configuration.

Once the mold has been pre-filled, you may increase the ramp up time on consecutive firings, depending on mold size and glass configuration.

A thin coating of kiln wash is preferable for prolonged fusings and will also help extend the life of the mold.

This product is moisture sensitive. Reseal bag and store in a cool, dry atmosphere.

For Industrial Use Only.

