

FORTON MG INSTRUCTIONS

Mixing:

The only equipment required is a good scale, a mixer blade and a high rpm electric or air drill. It is advisable to mix the materials in clean, plastic buckets properly sized for the volume of materials being mixed. Optional is a piece of insect screen to screen the face mix for lumps, chips and to remove entrapped air.

Note: It is recommended to wear a NIOSH approved dust mask while weighing and mixing.

1. In one plastic bucket put the weighed Forton VF-812 liquid polymer. Typically no additional water is required. If pigments are used, they can be added to the VF-812 at this time. Note: a small amount of pigment is very effective in the system; however, it is impossible to determine the ending color until after the piece has been demolded and dried. It is possible to over pigment the mix, in which case the material does not cure within the normal range of time and the material does not achieve its typical strength.
2. In the second dry plastic bucket, put the weighed gypsum, dry resin and hardener. If metal powders, sands aggregates or fillers (cab-o-sil) are used, they can be added to the same bucket. It is advisable to dry blend these materials either with your hand or a dry mixer blade with a dry high rpm drill to reduce clumping when mixed with the liquid.
3. The dry materials are then mixed into the bucket containing the liquid. Mix thoroughly with a high rpm drill using a shear type mixer. Typical mixing time is 1 to 2 minutes. When mixing metal powders, small amounts of clean water may be added during mixing if the slurry appears too thick or is setting too quickly. Prolonged mixing can accelerate the thickening rate of certain metal powders. If additional defoamer, accelerator or retarder is used, it can be added and mixed in at this time.
4. For face mixes and direct slurry casting, it is strongly recommended to pour the slurry through a screen into a clean plastic bucket. This removes air bubbles and clumps.