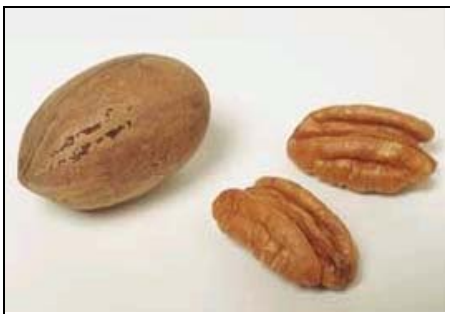


Casting Imitation Wood



Adding pecan flour fillers and wood flour to different resins will achieve a wonderful imitation wood that can be painted and or stained for an authentic wood look. Pecan resin is a plastic resin in which very finely ground up pecan shells ("pecan flour") have been used as a filler. The pecan flour is the same consistency as ordinary baking flour. Cured pecan resin has a dark woody look, similar to walnut wood.

Finished castings can be stained and clear-coated to achieve a realistic appearance. Casting wood pieces in

poly urethane resin is easy and inexpensive, too.

To make a wood grain casting, a rubber mold is made of a natural piece of wood. The liquid rubber (MoldRite25 or Por-a-Mold) will duplicate the finest wood. Before molding you must seal the wood to close the wood pores.

After you complete the mold you can prepare the casting material. This consists of KastEZ resin, a brown poly urethane compatible dye for added color and pecan shell flour for the wood body. Add a little of the dye at a time to Part A of the casting resin. Once the desired color effect is achieved, mix Part A and B together then add the pecan flour and continue mixing.

Pour casting mix into the mold. In about 15 minutes the finished casting may be removed from your mold.

Materials Needed:

- A. MoldEZ Resin
- B. Brown Poly urethane Dye
- C. Pecan Shell Flour

Our MoldEZ Resin works well because it is inexpensive, has extremely low viscosity (pours like water), and sets up quickly. Adding a dark pigment (brown or dark brown) to the resin/pecan shell flour mixture will give the final casting added definition and dimension. If casting into a urethane mold, a mold release agent is required. Synlube 530 is recommended because it can easily be washed off the cast piece. Other items that are needed consist of the rubber mold, measuring and mixing containers, mixing sticks and an accurate gram scale for weighing components. Amounts of resin, pecan shell flour and pigment required will vary depending on the desired effect. Most customers will experiment by varying the amounts of resin, pecan shell flour and pigment used in combination to attain a desired effect. For this example, we will use the following:

Part A of Resin: 10 Parts

Pecan Shell Flour: 10 Parts

Part B of Resin: 10 Parts

Liquid Dye (Brown): 0.5 Parts

1. **Release.** To prevent resin mixture from sticking to rubber mold, thoroughly apply mold release agent (Synlube 530) over entire mold surface. Brush into all surface detail let dry and follow with a second coat. Let dry.

2. **Mix.** To allow ample mixing time, mix pecan shell flour and brown pigment thoroughly with Part B of KastEZ Resin prior to adding Part A. Dispense 10 parts of resin - Part B into clean mixing container. Add 10 parts of pecan shell flour and ½ part of brown pigment to Part B and mix thoroughly. Mixture will be very thick.

IMPORTANT: If using pecan shell flour in the urethane resin, it is necessary to bake the pecan shell flour (150° F for 30 minutes) to eliminate any residual moisture. Let flour cool to room temperature before using. Failure to dry your additives will cause an adverse reaction that will cause your polyurethane to foam up. Test you material first to avoid an unsatisfactory project.



3. **Combine.** Add 10 parts resin - Part A to the Part B, pecan flour and pigment mixture. Mix thoroughly.

4. **Pour.** Pour the mixture into the mold. For best results, pour the mixture in a single spot at the lowest point of the mold. Let the resin seek its level inside the mold. A uniform flow will help minimize entrapped air.

5. **Cure.** The entire casting should be thoroughly cured before demolding. The resin and pecan flour mixture will take longer to harden than pure resin. Cure time depends on size of casting, mold configuration, amount of fillers used, etc. Generally, 30 to 40 minutes is sufficient. Applying mild heat will accelerate cure time. Let cool to room temperature.

6. **Demold** - remove casting from mold.

7. **Finish.** Lightly abrade casting with fine steel wool ('0000') to promote better surface adhesion of stain and shellac. Apply desired wood stain on to the surface of your finished casting. Let this coat dry thoroughly and apply a second coat. After drying, apply two coats of clear gloss shellac spray to prevent scratches or nicks on the surface of the casting. ■