

**What do we need:**

- 825 g A1 liquid
- 1650 g A1 powder
- 750 g sand
- silicone mould 50 x 60 cm (0,3 m2)
- 1,2 m2 A1 triaxial fibre
- Thix A
- scale
- cups
- brush
- drilling machine mixer or stirring rod
- water



1 Put all the materials ready for use.



2 Calibrate the scale and weigh 250 g liquid, 500 g powder and 500 g yellow sand.



3 Place the silicone mould into the support mould.



4 Add the A1 powder slowly to the A1 liquid and stir with the mixer until you have a smooth surface.



5 Add sand to the A1 and stir well. Also add 5 g Thix A to the mixture of A1 and sand. $(250 \text{ g} + 500 \text{ g} = 750 \text{ g} + 0,5\% = 5 \text{ g})$



6 Clean the mixer directly after use in water.



7 Apply the A1 with a brush in the mould.



8 By using Thix A the A1 becomes thicker, like a gelcoat and the A1 won't drop down from the vertical parts.



9 The surface must reach a thickness of 3 mm. Let the panel dry for $\pm 20 \text{ min.}$



10 Clean the brush directly after applying the 1st layer.



11 For the 2nd layer of A1 we weigh 125 g liquid, 250 g powder and 250 g yellow sand, and mix them as in step 4 and step 5.



12 In the 2nd layer we **don't use Thix A** so we directly clean the mixer in water.



Apply this little amount of A1 on the surface and divide it equally **14**. This way you create a smooth finish layer.



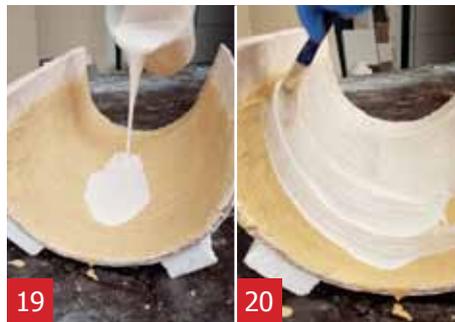
Clean the brush directly after applying the 2nd layer and again let the panel dry for ± 20 min.



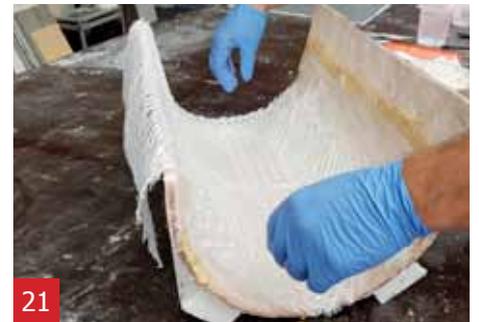
In the meantime weigh 450 g liquid and 900 g powder. Also cut 4 pieces of triaxial fibre same size as the mould you will be using.



Add the A1 powder slowly to the A1 liquid and stir with the mixer until you have a smooth mixture **17**. Clean the mixer directly after use in water **18**.



Apply a thin layer of A1 on the surface **19** and divide it equally with a brush **20**.



Apply a piece of triaxial fibre with the same size as the object on the surface.



Then smoothen it with a brush from the center.



Again apply a thin layer of A1 and smoothen the A1 over the surface.



Apply another layer of triaxial fibre. Repeat step **21** and **22** until you have 4 layers of triaxial fibre. When finished clean the brush with water.



Before demoulding let the mould dry for ± 1 hour.



Take the silicone mould carefully from the support mould.



The final resultat is an exact copy of the mould.

