



Recipes

*Aluminumcement, Bone China,
Porcelain, Casting clay and
Plaster*



Art Supplies



Aluminumcement

Binder for e.g. casting stone
Cures faster than regular cement
Often used for casting reliefs and images

25 kg	Aluminumcement AC025
10 l	Water
1 5 kg	Sand or gravel of your choice (or a mixture thereof)

The material is fast drying and heat resistant up to 1100 °C
Wall thickness must be 5–8 cm

Bone China

50 kg	Kleipoeder Bone China ivory white KPIO8
20 l	Water
100 gr	Wateglas / sodium silicate CHI60
33 gr	Dolapix DHIO7

Liter weight is 1800 gr

Porcelain

100 kg	Porcelain clay powder KPII7
45 l	Water
25 gr	Giessfix 162/10 DHII0
10 gr	Formsil D DHIII

Liter weight is 1751 gr

Fill the tank with 45 l of water
Mixer in the lowest position
Pour out 25 kg of porcelain clay powder into the tank

Set the mixer to one position higher and add another 25 kg of porcelain clay powder **KP117**

Dissolve 10 g of Formsil D in 0.5 l of warm water
Dissolve 25 g of Giessfix 162/10 in 0.5 l of warm water

Pour the Formsil D and Giessfix into the tank
Pour out another 50 kg of porcelain clay powder **KP117** into the tank
Keep the porcelain running for 2 to 3 hours
Weigh 5 buckets at 8.7 L per bucket

Casting Clay

100 kg	Steengoed- of aardewerkkleipoeder KPIO1 / KPIO2 / KPIO3 / KPIO5 / KPIO6
35 l	Water
200 g	Gecalcineerde soda CHI27
160 – 220 cc	Wateglas CHI60

First add the water, then the calcinated soda and finally a minimum of water glass/ Sodium Silicate **CH160**; continue adding water glass/ Sodium Silicate **CH160** until the desired casting mass/density is achieved.

Plaster

Introduction

Plaster is an easily processable material: e.g. for pouring into a rubber mold. Softer plaster types can also be treated with tools such as graters, gouges and planers.

Plaster is a natural product and as a result there may sometimes be slight variations in quality.
It is of great importance to store the plaster in a dry, cool and dark place!!!

When working with plaster, it is important to maintain a good ratio of plaster and water.

If you're not yet familiar with the processing of plaster, we recommend you accurately measure plaster and water. If you are more experienced: a reasonable plaster / water ratio can be obtained by gently sprinkling the plaster into the water until an 'island' is created in the middle.

Procedure

Sprinkling time 1 - 1.5 minutes (apply calmly and evenly)
Allow to stand for 15 seconds after spreading.

Stirring time	1 - 1.5 minutes.
Venting	Stirring slowly will cause the air bubbles to rise
Processing time	within 10 minutes the plaster will set

Curing the plaster

Within an hour the plaster will have sufficiently set.
Heat is released during curing. After hardening, let the mold dry for a considerable time, this can be done in a warm and/ or draughty room, but not directly above a heat source.

Strength of the plaster

Porosity and strength of plaster are almost inversely proportional: soft plasters have a high density; hard species have low density. See Table.

Plaster	Gips/water Kg/liter	Porosity Newton/mm ²	Hardness	Application
Vigo 60	1.61 / 1	46.0	46	Ceramic molds
Hartform	2.50 / 1	29.0	115	Sculptures
Elfenbein	3.00 / 1	20.0	250	Statues / ornaments

Effects

Salt: A small amount of salt speeds up the (curing) process.

Hydrated lime: Slows down the process.
Temperature: a slightly higher water temperature will speed up the process, but never go above 50 ° C.

Stirring intensity: longer and more intensive stirring speeds up the process, the plaster will become harder and less porous.

Leftovers: throw away old remnants, always make the required amount.
Plaster has a shelf life of 1.5 - 2.0 years, provided it is kept dry and dark. In a transparent bag it is advisable to process it within a year.