





Materials

- 825 g A1 liquid 
- 1650 g A1 powder 
- 750 g sand
- 1.2 m² A1 triaxial fibre
- silicone mould
(50x60 cm = 0,3 m²)
- support mould
- Thix A

Tools

- scale
- cups
- brush
- drilling machine with mixer or stirring rod
- water



1 Calibrate the scale and weigh 250 g A1 liquid (1 part), 500 g A1 (2 parts) powder and 500 g yellow sand.



2 Place the silicone mould in the support mould.



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



4 Add sand to the A1, stir well with the mixer until you have a smooth surface.



5 Also add 5 g Thix A to the mixture of A1 and sand. (250 g + 500 g = 750 g + 0,5% = 5 g)



6 Stir it well with the mixer.



7 Clean the mixer directly after use in water.



8 Apply the A1 on the mould and spread with a brush.



9 By using Thix A the A1 becomes a gelcoat which can be applied on vertical parts.



10 The surface must reach a thickness of 3 mm. Let the panel dry for ± 20 min.



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



12 For the 2nd layer of A1 we weigh 125 g A1 liquid, 250 g A1 powder and 250 g yellow sand, and mix them like in step 3 and step 4.



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



Apply a little amount of A1 on the surface and divide it equally **15**. 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.



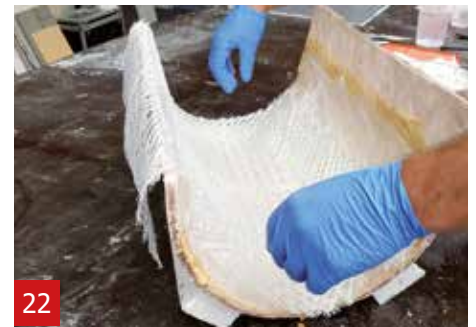
In the meantime weigh 450 g A1 liquid and 900 g A1 powder. Also cut 4 pieces of triaxial fibre (same size as the mould you will be using).



Add the A1 powder slowly to the A1 liquid and stir with the mixer until you have a smooth mixture **18**. Clean the mixer directly after use in water **19**.



Apply a thin layer of A1 on the surface **20** and divide it equally with a brush **21**.



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 divide the A1 over the surface.



Apply another layer of triaxial fibre. Repeat step **22**, **23** and **24** 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 out of the support mould.



The **final result** is an exact copy of the mould.



Lined area for notes



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