

CS-500 Washout Tooling Plaster

Safety Instructions.

- DUST MASK Must Be Worn To Avoid Inhaling This Product.
- Do Not Leave Mixed Plaster In Contact With Skin While Curing. The exothermic process generates heat and may burn skin.

Preparation.

- Clean WATER for mixing must be room temperature or cooler.
- Clean MIXING CONTAINER.
- Clean tooling MOLD.*

NOTE: Using buckets containing old plaster or hot/dirty water will rapidly increase rate of hardening and reduce working time. This may not allow enough time for air bubbles to escape.

Release Mold. Mold may be released with:

- Cooking spray (example: PAM® Non-Stick Cooking Spray).
- or
- Wipe on a thin layer of petroleum jelly (example: Vaseline).

Position. Stand mold vertical to avoid trapping air bubbles against any horizontal overhanging surface.

Mix Amounts. In a clean mixing container:

1. Measure clean water into container..... **5.0 Parts by Volume**
2. Add CS-500 Washout Tooling Plaster **8.0 Parts by Volume**

NOTE: Do **not** start mixing until total volume of plaster is added to the total volume of water, then immediately begin the Power Mix countdown.

Power Mix: No longer than 25-30 seconds.

Pour. Immediately pour into mold.

Technique: To avoid adding bubbles, pour quickly and smoothly.

To avoid entraining additional air in plaster, **tap** or **vibrate** mold while filling.

Cure. Allow to set for **45 minutes** before de-molding. Mold may then be stored indefinitely before oven drying.

Dry. ***MANDATORY BEFORE USE*** After de-molding, dry the mold in an oven per the schedule shown in Table 1.

Mold will attain maximum strength after drying. To aid in rapid washout, tool should be used within 24 hours of drying.

Washout. Soak tool with part in room temperature water bath. Tool will become heavier as water is absorbed into plaster, so avoid any movement that could damage thin composite laminates. While submerged in the water bath, a high pressure washer (1500 PSI maximum) may be used to facilitate more rapid removal of plaster.

Disposal. CS-500 is 100% recyclable. Contact local gypsum/plaster recycling companies in your area for proper disposal.

Table 1. Mold Drying Schedule

After each hour, increase the oven temperature by 50°F (28°C)

STEP	ELAPSED TIME	HOLDING TEMPERATURE
1.	1 Hour	150°F or 66°C
2.	1 Hour	200°F or 93°C
3.	1 Hour	250°F or 121°C
4.	1 Hour	300°F or 149°C
5.	1 Hour	350°F or 177°C
6.	1 Hour	400°F or 204°C
7.	1 Hour	480°F-500°F or 249°C-260°C
8.	1 Hour	500°F or 260°C
9.	Cool mold in oven 2 to 2½ hours. Remove mold from oven when temperature is below 150°F or 66°C.	

***Mold Size Consideration.** Mold cores up to 9-inch (23 cm) diameter may be poured by this method.

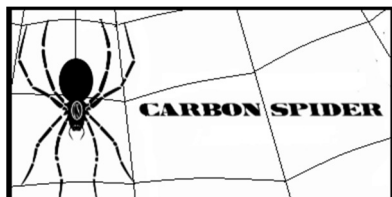
Molds more than 9-inch (23 cm) diameter require use of a perforated hollow mandrel positioned down the center to serve as a moisture escape path during curing and drying. To prevent cracking or breaking of mold during drying, all mandrels must be positioned away from mold surface a minimum of 1-inch (2.5 cm).

Net Weight: 50 Pounds

MSDS posted on www.CarbonSpider.NET

Date of Manufacture:

CS-500, 01 Sept 2017, Issue 03



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