

ACCU-CAST

PRODUCT DESCRIPTION

Accu-Cast is an advanced irreversible hydrocolloid molding material. There are four different formulas of Accu-Cast. They are formulated to have very low shrinkage rates, high tear strength, fine grain, and a warm water mix, these materials far exceed the common expectations of molding materials in the Special Effects Makeup industry.

THREE FORMULAS

- **ACCU-CAST 390**
With a setting time of 3 minutes when using 32°C water, this material is ideal for smaller projects like fingers, hands and small props. Strongly recommended for children's hand casts.
- **ACCU-CAST LS-680**
With a setting time of 6 minutes when using 26°C water, this material is ideal for medium sized projects like hands, arms, faces and larger props. The special LS formula has an especially low shrinkage rate ideal for really critical jobs
- **ACCU-CAST 880**
With a setting time of 8 minutes when using 26°C water, this material is ideal for big jobs like heads, torsos, full bodies and really large props.
- **IMPERIAL BODY GEL**
With a setting time of 5 minutes when using 32°C water, this material is ideal for most projects. Will set hard and strong, with good tear strength. Ideal for medium-sized lifecasting projects like faces, heads and torsos.

PRODUCT FEATURES AND BENEFITS

- Low Shrinkage Rate- Resists "pull-away" from plaster bandages for over 60 minutes.
- High Tear Strength - Easier to remove mold from subject without tearing.
- Fine Grain - Good surface detail and hard smooth surface on stone cast.
- Calibrated Set - Different setting times allow you to match your impression material to the job.
- Thicker Mix - When mixed thicker, Accu-Cast will not drip like typical materials.

TYPICAL PROPERTIES

Before Mixing

- Form..... Fine Powder
- Colour..... 390:Yellow, LS680:Green, 880:Blue, IBG:Orange
- Odour/Flavour..... None
- Density (fluffed)..... Approx.20(+/-0.5) pounds/ft3

After Mixing:

- Mix Ratio(Water/Powder)..... Pourable:25g powder/100mlwater
Brush-Up:36g powder/100ml water
- Density..... 73 pounds/ft3
- Viscosity..... Pourable: Thin Brush-Up: Medium Thick
- Working Time(total)..... approximately 40 seconds less than setting time.

After Setting:

- Maximum Recommended Pour-Up Timeless than 1 hour
- Shrinkage (when covered with wet towelling):

10 minutes.....	<0.10%	40 minutes.....	0.46%
20 minutes.....	0.16%	50 minutes.....	0.62%
30 minutes.....	0.33%	60 minutes.....	0.75%

Not for product specification: These technical data are intended for reference only and are not for preparing sales or safety specifications. The above figures were prepared with due diligence, but Accu-Dent assumes no responsibility for errors in recording or reporting. For assistance and recommendations on sales or safety specifications for this product, contact Accu-Dent Research & Development Co. Inc.

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MIXING GUIDELINES FOR ACCU-CAST IMPRESSION MATERIALS

CHECK THE WATER TEMPERATURE:

390	90°F(32°C)	approx. 3 minutes
LS-680	80°F(26°C)	approx. 6 minutes
880	80°F(26°C)	approx. 8 minutes
Imperial Body Gel	90°F(32°C)	approx. 5 minutes

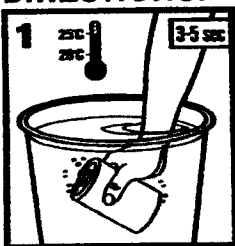
1. Estimate the amount of Accu-Cast powder you will need for the job at hand. Weigh it out.
Note: Pourable impressions of a single hand including 3 inches of wrist typically takes about 3 pounds. Brush-Up impressions of a full face, including neck, typically takes about 2 pounds for a 3/4 to 1 inch coating. For body impressions, a medium mix is appropriate. One part powder to 3 parts water (by weight) is considered ideal.
2. Calculate and measure the amount of water necessary.
Note: A good viscosity for Pourable impressions (in a mold) is about 16oz powder to 64oz water (25g powder:100ml water). A good viscosity for Brush-Up impressions (without a mold) is about 16oz powder to 44oz water (36g powder: 100ml water).
3. Measure the water volume and temperature. Different Accu-Casts have different setting times and recommended water temperatures. Accu-Cast 390 sets in approximately 3 minutes when using 32°C water, Accu-Cast LS680 sets in approximately 6 minutes using 26°C water, and 880 sets in approximately 8 minutes using 26°C water. Imperial Body Gel sets in approx 5 minutes using 32°C water. Note: In each case, cooler water will retard the set, and warmer water will accelerate the set.
4. Put the powder into a mixing bowl or bucket at least twice as large as the container holding the water. For mixing volumes of powder greater than 1 pound, we recommend mixing with a drill operated power mixer like a "Jiffy Mixer" or the like. **Avoid** the ones that look like small round cages with many vanes. These are difficult to clean and tend to whip a lot of air into the mix. Cordless drills work best, but if you are using a corded model, make sure not to drop the drill into the water or the mix. It will short out and ruin your equipment.
5. Pour approximately one third the water into the powder in the mixing bowl or bucket.
6. Stir vigorously with your hand or with a flat spoon or paddle shaped instrument.
7. Add more water and continue stirring. Stirring with your fingers spread wide apart can help incorporate the water quickly. Do not be hesitant during the mixing process - you cannot hurt the material. Make sure that all of the powder has been incorporated into the mix, especially around the bottom edges of the mixing bowl or bucket.
8. Even though Accu-Cast was designed to be mixed somewhat thicker than other alginate based molding materials, each operator has personal preferences on the ideal consistency. Stop adding water when the mix reaches what you consider the ideal viscosity. If this requires adding a little more water than in the instructions, do so, but do it quickly- you have a limited amount of time to mix and apply the material before it sets.

TIPS

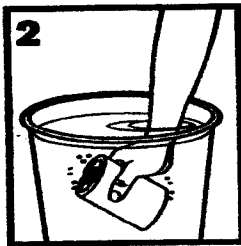
1. For head molds, apply petroleum jelly ("Vaseline") to eyebrows, moustaches, beards, and hairline. This will make it much easier to remove the mold from the subject.
2. For hand casts in a mold, have the subject thoroughly coat their hand with impression material from the mixing bowl prior to inserting it into the mold. Pour the Accu-Cast into the mold, and at the last second, have the subject take a large handful before plunging the hand into the mold. This will help eliminate voids that tend to happen in the palm of the hand.
3. If a particular job calls for it, the setting time of any Accu-Cast can be increased by mixing with colder water, and decreased by using warmer water. Be careful, because water under 10°C or over 43°C can be extremely uncomfortable on exposed skin.
4. It is highly recommended that the subject be tested for possible allergic reactions to Accu-Cast before proceeding with a large project. Although rare, allergic reactions can be extremely uncomfortable and frightening for the subject, especially when preparing a face mold. Mix a small amount of Accu-Cast, and apply to the subject's skin (inside of elbow or wrist is recommended). After the Accu-Cast has set, ask the subject about general or localised discomfort, itching, redness or swelling. In the unlikely event of more than a small reaction, antihistamines can be administered.
5. 5-gallon white plastic paint buckets work exceptionally well for mixing larger quantities of alginate. They are easily large enough, and the steep sides keep splatter to a minimum. Don't worry the alginate will not stick to your bucket. It will be very easy to remove after it sets.
6. If dust is a problem (indoors for instance) you can cut a round hole in the paint bucket lid large enough for your mixing head to fit through. This will minimise the escape of airborne dust.

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DIRECTIONS:



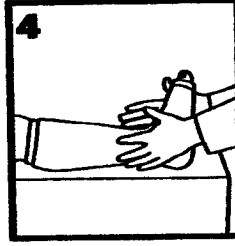
Dip bandage for 3-5 seconds diagonally across bucket containing water 20-25°C.



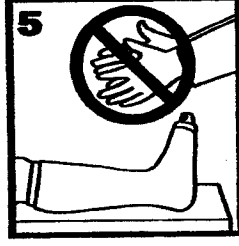
Wet only 1 bandage at a time.



Squeeze gently to remove excess water from the bandage.



Working time is 2-3 minutes.



Do not mould the cast after 5-6 minutes.



No weight bearing before 48 hours.

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