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FORTON® MG - HINTS & TIPS

MIX DESIGNS

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Three important things to remember for processing Forton Modified Gypsum (FMG).

1. All **DRY BLEND PREMIXES** must be measured and mixed by **WEIGHT**.
2. The **DRY BLENDS & LIQUID POLYMER** are measured and mixed by **VOLUME**.
3. Forton Modified Gypsum must be **high shear mixed**, hand mixing is not appropriate.

Interior Grade

2 Parts FGR-95 (Powder) : 1 Part VF-812 (Liquid Polymer), *this is mixed by VOLUME*, ie level scoops.

When using metal face mixes the Metal Powder and FGR Powder must first be thoroughly combined at a ratio of 1 part FGR : 1.5 parts Metal Powder. *This must be measured by WEIGHT*, ie on scales.

Example – 100grams FGR : 150grams Bronze Powder, *this cannot be done by VOLUME*.

This dry blend of FGR+Metal can then be stored in a sealed airtight container until you are ready to use it. When mixing this dry blend with the VF812 Polymer, use at the normal *volume* ratio of 2 Parts Powder : 1 Part Liquid.

Exterior Grade

When processing Forton MG for outdoor applications, the FGR-95 must first be dry blended with Dry Melamine Resin & Ammonium Chloride at these *weight ratios*. Excess amounts of this dry blend can be stored in sealed airtight containers until you are ready to use it.

- FGR-95	100	Eg	1kg
- MF415 Dry Resin	10		100gms
- Am Chloride	0.5		5gms

This dry blend can then be mixed with VF812 Polymer at the normal *volume ratio* of 2 Parts Powder : 1 Part Liquid. When using metal face mixes the Metal Powder and Outdoor Dry Blend (FGR/Melamine/Ammonium) Powder must first be thoroughly combined at a ratio of 1 part Outdoor Blend : 1.5 parts Metal Powder. *This must be measured by WEIGHT*.



ALERTS

No black metal in contact with matrix. Use zinc coated or galvanised attachments & screws.

Allow for flexible connections on panels and architectural elements.

Do not mix with Aluminium Powder.

Column Joints – use FMG mix itself or an epoxy with exterior properties.

ACCELERATOR

Dissolve 450gm of Aluminium Sulfate in 3.785ltr of Water and label 'Forton Accelerator'.

Mix FGR-95 dry blend into VF-812 until creamy using a high shear mixer and high rpm drill.

Add 'Accelerator' and mix. Graduated cylinders or catalyst dispensers are easiest for measuring dose.

AGGREGATE FACE MIX

Blast 3rd day after demoulding using a small nozzle, 40psi @ nozzle, in a circular motion.

Depth of blast will be controlled by the aggregate size.

Blow off dust and seal with clear, breathable acrylic sealer or wax compound for interior. Typical concrete sealers may be used. VF812 can be used if diluted between 5:1 & 10:1, water:VF812.

PAINT GRADE – no face mix

Wipe the surface with acetone only.

Coating system must be breathable. Products like Colortec Max. VF812 itself can be used if diluted between 5:1 & 10:1, water:VF812.

Should have a smooth tight surface with no stains.

METAL FACE MIX – with patina

Remove casting from mould & allow to dry for 20-30 minutes. Apply cold patina and allow to dry. Burnish with Grade 0000 Steel Wool before or after patina.

Or-

Allow to dry overnight and Power Buff using water based compounds.

Use clear or coloured waxes or apply Permalac
DO NOT SAND METAL FINISHES

METAL FACE MIX – no patina

Remove casting from mould using latex gloves. Be careful not to handle surface with bare hands as skin oils can leave finger prints. Allow to dry overnight and polish with Grade 0000 Steel Wool.

Or-

Allow to dry for 3 days and Power Buff using water based compounds. Then polish and wax.
DO NOT SAND METAL POWDER FINISHES

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