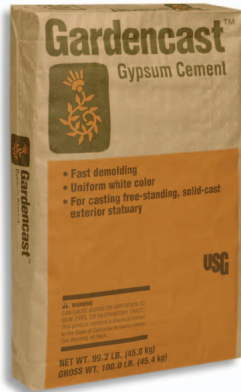


GARDENCAST™ Gypsum Cement



A High-Performance Time Saving Solution for Your Exterior Casting Needs.

- Rapid setting cementitious material when used with sand aggregate.
- Quick demolding capability increases productivity 300% over conventional cements.
- Excellent resilience and chip resistance.
- Ideal for free standing, exterior casting, and decorative exterior figurines.
- White in color.

Technical Properties		English	Metric
Use Consistency (parts of water by weight per 100 parts GARDENCAST and Sand)		12.5	12.5
1 Hr. Compressive Strength		2,500 psi	17.2 MN/m ²
Dry Compressive Strength		8,000 psi	55.2 MN/m ²
Maximum Setting Expansion		0.10%	0.10%
Density	Wet	131.0 lb/ft ³	2.10 g/cm ³
	Dry	110.0 lb/ft ³	1.76 g/cm ³
Set Time*		25-35 min.	25-35 min.

*Other set times may also be available. Call your sales representative for more information.

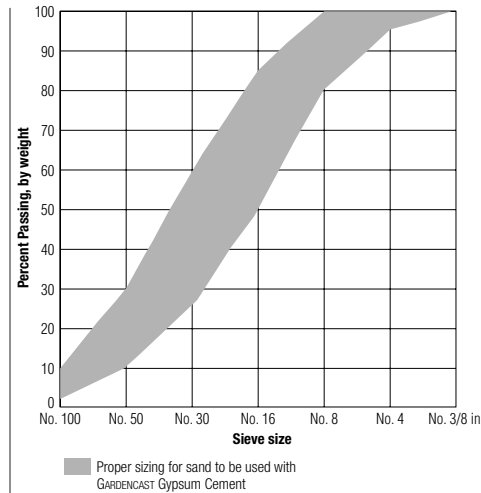
**General
Directions and
Guidelines**

Required Mix Design

- 50 lbs. GARDENCAST Gypsum Cement
- 50 lbs. sand (fine aggregate)
- 1-1/2 gallons (U. S.) water (12.5 pounds)

(Water measurement may have to be adjusted slightly for particle size and water content of sand. Refer to IG779 Technical Bulletin for details.)

Sand should be clean, dry, pre-washed, and properly-sized. It should be free from dolomitic and aluminum contamination and conform to ASTM C33 (see graph below). An example of a suitable commercially available sand is All Purpose Sand. GARDENCAST Gypsum Cement must be used with sand to maximize durability. For specific recommendations, consult your local United States Gypsum Company Technical Sales Representative or call (800) 487-4431.



**Mechanical Mortar
Mix Procedures**

- 1 With the mixer operating, add half of the sand to the water.
- 2 Carefully strew or sift the GARDENCAST Gypsum Cement into the mixer. Do not soak.
- 3 With the mixer operating, carefully add the remainder of the sand.
- 4 Mix thoroughly until lump free and slurry becomes pourable—3 to 4 minutes, but no more than 5 minutes.
- 5 Carefully pour the slurry into the mold to prevent entrapped air. Agitate the filled mold to assist in removing any noticeable air bubbles.
- 6 Set time is 25-35 minutes. Allow casts to remain in the mold for approximately one hour after set to ensure the adequate “green strength” necessary for demolding.
- 7 Demold and transfer the cast to a suitable drying area. Bench dry the castings to a constant weight before packaging for shipment. If the drying time must be accelerated, castings can be placed in a drying room capable of producing both increased air circulation and drying temperatures.

Maximum temperature in a drying room should not exceed 120 °F. Consult your United States Gypsum Company Technical Sales Representative for recommendations.



Mechanical Mixing—Variable Speed Propeller Type Mixer

- 1 Add the sand to the water.
- 2 Carefully strew or sift the GARDENCAST Gypsum Cement into the mixing container. Do not soak.
- 3 Use a high-speed, variable-drive propeller mixer to disperse the slurry. Mix for 3 to 4 minutes, but no more than 5 minutes.
- 4 Mix thoroughly until lump free and slurry becomes pourable—3 to 4 minutes, but no more than 5 minutes.
- 5 Carefully pour the slurry into the mold to prevent entrapped air. Agitate the filled mold to assist in removing any noticeable air bubbles.
- 6 Set time is 25-35 minutes. Allow casts to remain in the mold for approximately one hour after set to ensure the adequate “green strength” necessary for demolding.
- 7 Demold and transfer the cast to a suitable drying area. Bench dry the castings to a constant weight before packaging for shipment. If the drying time must be accelerated, castings can be placed in a drying room capable of producing both increased air circulation and drying temperatures.

Maximum temperature in a drying room should not exceed 120 °F. Consult your United States Gypsum Company Technical Sales Representative for recommendations.

Precautions

- 1 Water purity is important. Water should be as pure as possible. Typically, if water is drinkable, it is probably suitable for mixing the product. Water contaminated with organic impurities, soluble salts, and other chemicals may cause detrimental effects to GARDENCAST Gypsum Cement.
- 2 Proper mixing ensures dispersion of the GARDENCAST Gypsum Cement powder into the water. Accurately weighed water, powder, and sand is necessary to assist in fabrication of quality castings. Refer to required mix design for proper amount of mixing water.
- 3 Timing mix cycles is essential. Mechanical mixing methods must be used. Do not mix by hand.
- 4 Pour pieces in one continuous pour.
- 5 GARDENCAST Gypsum Cement is not a suitable product for the fabrication of bird baths, water fountains, or other applications where constant exposure to water occurs; nor is it suitable for casting planters or flower potting containers.
- 6 GARDENCAST Gypsum Cement is not suitable for structural or non-structural exterior architectural applications.
- 7 Do not use GARDENCAST Gypsum Cement for below grade applications.
- 8 Do not use sealers or coatings on GARDENCAST Gypsum Cement pieces.
- 9 Do not use aggregate that does not meet the size requirements of ASTM C33.
- 10 Color of the final piece will be dependent on the color of the aggregate used.

Warning

When mixed with water, this material hardens and becomes very hot—sometimes quickly. DO NOT attempt to make a cast enclosing any part of the body using this material. Failure to follow these instructions can cause severe burns that may require surgical removal of affected tissue or amputation of limb. Portland cement is strongly alkaline and contact with dust or when wetted can cause burns or irritation to the skin, eyes, nose,

throat, or respiratory system. Avoid dust inhalation and eye/skin contact. Wear eye and skin protection. If eye contact occurs, immediately flush thoroughly with water for 15 minutes and get medical attention. If dusty, wear a NIOSH/MSHA-approved respirator. Use proper ventilation to reduce dust exposure. Do not ingest. If ingested call physician. Product safety information: USA (800) 507-8899. **KEEP OUT OF REACH OF CHILDREN.**

Trademarks

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Notice

We shall not be liable for incidental or consequential damages, directly or indirectly sustained, nor for any loss caused by application of these goods not in accordance with current printed instruction or for other than the intended use. Our liability is expressly limited to replacement of defective goods. Any claim shall be deemed waived unless made in writing to us within thirty (30) days from date it was or reasonably should have been discovered.