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Armourcoat Ltd

Morewood Close Sevenoaks Kent TN13 2HU

T: +44(0)1732 460 668 F: +44(0)1732 450 930

UK Company 1997888. VAT Reg: 445788013

www.armourcoat.com

Product Data Sheet PDS006: Armourcoat Armourcast

1 Product Description

Armourcoat ArmourCast is a unique composition of crushed marble, gypsum, polymers and special additives used to create stunning three dimensional cast designs that look and feel like stone. The material and manufacture process are ideally suited to creating shapes and designs that are too complex for a trowel applied stone finish like Armourcoat Polished Plaster.

Armourcoat ArmourCast is available in five base colours that can be combined in varying proportions to create a wide array of natural stone colours without the addition of any pigment. The colours and crushed marble from which they are composed is as follows:

- White ArmourCast - Bianco Carrera Marble
- Yellow ArmourCast - Giallo Mori Marble
- Red ArmourCast - Rosso Verona Marble
- Green ArmourCast - Verde Alpi Marble
- Black ArmourCast - Nero Ebano Marble

Marble granules or vermiculite can also be added to impart more texture to the surface and coloured mica flakes to add further visual interest.

2 Properties

- Natural mineral material
- Contains no VOCs
- Wide range of stone finishes achievable
- Wide range of colours available
- Easily repaired with no colour bleed caused by pigment migration
- Quick demoulding of cast items enabling quick turnaround times
- Lightweight and when laminated with glass fibre reinforcement Armourcoat ArmourCast can be used to produce large and complex shapes without being excessively heavy
- Nominal weight 7 - 15kg m²
- High compressive strength 22 - 30 N/mm² (3000 - 4200 lb/in²)
- Completely non combustible and rated as Class O for flame and smoke tested to BS476 parts 6 & 7

3 Health & Safety

Armourcoat ArmourCast is a powdered product and a dust mask should always be worn when mixing or handling it. Wear protective clothing specifically gloves and eye protection and if contact occurs wash affected areas immediately with soap and water.

Do not allow the product to set hard on the skin as it will be very hard to remove.

4 Moulds

As with all cast products the accuracy and quality of the mould is a crucial factor in achieving good results. Moulds can be made of rubber, lacquered and waxed MDF or even GRP (glass reinforced polyester) and the type choose will be dependent upon:

- The complexity and detail demands of the object
- The size and shape of the object
- The number of repeat pieces that need to be cast from the mould

Other than silicone rubber moulds all other types of mould should have a release wax applied to the face of the mould prior to casting.

5 Blending and Mixing Armourcoat ArmourCast

Tip the required number of measures of each Armourcoat ArmourCast base colour to achieve the required formula into a large mixing vessel along with any mica flakes, vermiculite or marble granules required in the formulation and stir thoroughly with a mechanical mixer to achieve a homogenous mix. Keep dry and covered.

The Armourcoat ArmourCast formulation premix is then mixed with a gauging liquid comprising of Armourcoat R13 resin and clean water in a ratio of 1:4. The amount of gauging is dependant upon the consistency of mix required and the application method to be used.

Approximate liquid requirements are as follows:

- Spray application 2.1 litres per 10kg
- Dry pack method 1.7 litres per 10kg

For spray application place the required quantity of gauging liquid in a mixing vessel and slowly add the Armourcoat ArmourCast powder blend. Leave the material for a few minutes to allow the air to bubble out and then stir the material with a mechanical mixer until a consistent lump free mix is achieved. Do not over mix the material as this can cause air entrapment in the mix and lead to air bubbles in the face of the casting.

For dry pack application it is important not to try and mix too much material at a time and use a large mixing vessel so that the material can move around freely in the bottom of the mixing vessel without becoming too compacted.

For full mixing and application instructions see Armourcoat's ArmourCast Application Guide.

6 Fibreglass and Backing Gypsum

In order to create high strength, lightweight casting, 2 layers of a glass fibre matting of approximately 225g/m² is recommended. Chopped strand glass fibre can also be used. It is recommended that a 12mm (1/2 inch) clumped fibre is used at an addition level of ~ 4% by weight relative to the backing gypsum. These products are available from Saint Gobain Vetrotex. The gypsum used for the backing and reinforcement should ideally be a high strength, low expansion alpha gypsum. The gypsum should not require a plaster:water ratio in excess of 38:100 and should have a minimum dry compressive strength of at least 25N/mm² or (3,500 lb/in²)

7 Test Data

7.1 British Fire Test Results

BS 476: Part 6: 1989

Fire propagation index,1	0.1
Subindex,i1	0.0
Subindex,i2	0.1
Subindex,i3	0.0

BS476: Part7: 1997 Class 1 surface spread of flame

Armourcoat ArmourCast complies with requirements for CLASS 0 AS DEFINED IN PARAGRAPH a12(B) of Approved Document B, Fire Safety, to the Building Regulations 1991.

8 Coverage Rates

Armourcoat ArmourCast is supplied in 25kg units.

Coverage rates: ~ 4 - 8 kg/m².

9 Storage

Store in good dry conditions between 5° - 25°C. The shelf life of Armourcoat ArmourCast in unopened original packaging under correct storage conditions is 6 months from date of manufacture. Due to this short shelf life Armourcoat ArmourCast is only manufactured to order and is not a stock item. It is ordered by batch meaning a minimum of twenty 25kg units.