



Users Guide

Jesmonite Metal Fillers

*To be read in conjunction with
Jesmonite AC100, AC300
Composite Users Guides*

All the information contained in this guide sheet is given in good faith. However, it remains at all times the responsibility of the customer to ensure that the materials are suitable for the particular purpose intended.

1. Packaging

A range of four metal powders can be supplied:

- a. Bronze powder
- b. Brass powder
- c. Copper powder
- d. Silver Bronze powder

2. Applications

Jesmonite Metal Fillers are added to Jesmonite AC100 and AC300 Composites to provide in-mould metal finishes. They can be added to the Gel Coat or to both the Gel Coat and substrate compounds for laminating and casting.

3. Mix ratio (by weight)

	Bronze/Brass/Silver Bronze/Copper
Jesmonite Liquids	300g
Jesmonite Powders	600g
Metal Filler	700 – 1000g

4. Mix method

Weigh out the Metal Filler in a separate container. First mix together the Jesmonite Powders and Liquids, and then add the Metal Filler and continue mixing until thoroughly mixed and lump free. Add a drop of Jesmonite Black liquid pigment to make a richer, dark bronze. If using Antique Black Powder Pigment to achieve a Dark Bronze, mix this with the powders before adding to the liquids and then add the Metal Filler.

5. Jesmonite Thixotrope

This should not be required with metal filled composite for gel coating and casting. Thixotrope can however be added to achieve paste consistency. Please note that the metal filler will also act to thicken the mix.

6. Jesmonite Retarder

This can be added to weighed liquids to extend pot life. Please refer to the appendix in the Jesmonite Composite User Guides.

7. Finishing metal filled products:

Bronze, Brass, Silver Bronze and Copper finishes do require the removal of the acrylic film on the surface to expose the metal.

This operation is carried out on an air dried and hard surface by abrading with fine grade wire wool to bring up a bright metal finish followed by wax polish or sealer, as for stainless steel. NB. Products naturally harden with time, and this will only enhance the metal finish so a good tip is to leave burnishing for as long as possible.

Patinated metal finishes are produced by using a cold patinating fluid after the bright metal finish stage.

8. Sealer

Jesmonite Sealer has a number of uses:

1. As a coating for external products, apply two coats of sealer by brush or spray to the product to give a clear stain finish. This produces maximum external protection.
2. For internal use, to prevent finger marking and provide a near matt finish, apply one coat of sealer, diluted with water by 75%.
3. By adding pigments and water to the diluted sealer, it is possible to create colour washes for patination.

9. Users Guides

For full instructions on product use this guide must be read in conjunction with AC100 or AC300 users guides.

10. Shelf life

When stored under dry frost-free conditions, the materials will have a shelf life of six months from the date of manufacture displayed on the container.

Bronze, Brass, Silver Bronze and Copper powders will oxidise and darken over a shelf life of six months. This is not critical, as polishing the metal surface restores the metal to it's original colour.