Materials
- 825 g A1 liquid
- 1650 g A1 powder
- 750 g sand
- 1.2 m² A1 triaxial fibre
- silicone mould (50x60 cm = 0.3 m²)
- support mould
- Thix A

Tools
- scale
- cups
- brush
- drilling machine with mixer or stirring rod
- water
Column with sand structure

1. Calibrate the scale and weigh 250 g A1 liquid (1 part), 500 g A1 (2 parts) powder and 500 g yellow sand.

2. Place the silicone mould in the support mould.

3. Add the A1 powder slowly to the A1 liquid and stir with the mixer until you have a smooth surface.

4. Add sand to the A1, stir well with the mixer until you have a smooth surface.

5. Also add 5 g Thix A to the mixture of A1 and sand. (250 g + 500 g = 750 g + 0.5% = 5 g)

6. Stir it well with the mixer.

7. Clean the mixer directly after use in water.

8. Apply the A1 on the mould and spread with a brush.

9. By using Thix A the A1 becomes a gelcoat which can be applied on vertical parts.

10. The surface must reach a thickness of 3 mm. Let the panel dry for ± 20 min.

11. Clean the brush directly after applying the 1st layer.

12. For the 2nd layer of A1 we weigh 125 g A1 liquid, 250 g A1 powder and 250 g yellow sand, and mix them like in step 3 and step 4.

13. In the 2nd layer we don’t use Thix A so we directly clean the mixer in water.
Apply a little amount of A1 on the surface and divide it equally. This way you create a smooth finish layer.

Clean the brush directly after applying the 2nd layer and again let the panel dry for ± 20 min.

In the meantime weigh 450 g A1 liquid and 900 g A1 powder. Also cut 4 pieces of triaxial fibre (same size as the mould you will be using).

Add the A1 powder slowly to the A1 liquid and stir with the mixer until you have a smooth mixture. Clean the mixer directly after use in water.

Apply a thin layer of A1 on the surface and divide it equally with a brush.

Apply a piece of triaxial fibre with the same size as the object on the surface.

Then smoothen it with a brush from the center.

Again apply a thin layer of A1 and divide the A1 over the surface.

Apply another layer of triaxial fibre. Repeat step 22, 23, and 24 until you have 4 layers of triaxial fibre. When finished clean the brush with water.

Before demoulding let the mould dry for ± 1 hour.

Take the silicone mould carefully out of the support mould.

The final result is an exact copy of the mould.