



“YOU SUPPLY THE TALENT... WE’LL SUPPLY THE REST!” THE COMPLEAT SCULPTOR

LI-QUA-CHÉ Porable Papier Mache - Non-Fire Casting Compound

LI-QUA-CHÉ is a recycled paper fiber, polymer based compound that is not fire hardened. It air dries at ambient room temperature to a hard, durable, break resistant product. Low water content and a special manufacturing process allow for an increased number of castings with your **plaster/ceramic molds**. LI-QUA-CHÉ’s viscosity provides for easy pourability and a satin, smooth exterior surface. The paper fiber’s reinforcing action can be seen on the interior surface of each casting.

Low Shrinkage

The unique formulation of LI-QUA-CHÉ reduces the amount of shrinkage that occurs in the air-curing process.

Break Resistant Quality

Bonded with microscopic recycled paper fibers, the clay particles go to the surface of the piece, while the fibers remain on the interior. This new process provides a reinforcing action that adds strength and break resistance to the finished piece. Using LI-QUA-CHÉ to produce your castings will reduce breakage losses!

Uses Plaster/Ceramic Molds

The ease of use with one part molds is a major benefit of LI-QUA-CHÉ. One-part molds are quick and easy to use, and so is LI-QUA-CHÉ. For ease in filling a mold, LI-QUA-CHÉ may be used in a squeeze bottle. In only a matter of minutes you may remove your raw casting from the mold. The time savings continue with LI-QUA-CHÉ’s fast drying formulation which allows you to paint or otherwise finish your casting in just a few short hours. Conventional plaster/ceramic, two-piece molds are also used with LI-QUA-CHÉ. If you have worked with ceramics before, then you already know the basic techniques of LI-QUA-CHÉ casting. Plus, you’ll find these additional advantages as well.

- Faster mold set-up time!
- Easier-to-handle raw casting!
- Fast dry, no firing kiln required!
- Break resistant finished product!

Mixing and Diluting

LI-QUA-CHÉ should be poured approximately at the consistency of cream. When you open the jar the material may have a film over the top, or very slight, soft settling on the bottom. You should roll the jar to mix the material as this will create fewer air bubbles and faster bubble dissipation. Roll until the material is smooth and homogenous. LI-QUA-CHÉ is intentionally shipped in this very thick, creamy state. This allows you to dilute the product to the consistency that works best for your specific application, while also achieving a lower price. As a general rule-of-thumb, mixing up to 5 tablespoons of water per 8 ounces of LI-QUA-CHÉ will work well for most applications.

Pouring Plaster Molds

If your molds have not been used for a while, mist the inside of the mold lightly on the first pour. LI-QUA-CHÉ is user friendly to molds, causing less erosion and allowing you to pour your molds damper than other casting compounds. To help alleviate air bubbles, pour LI-QUA-CHÉ slowly and evenly. On large molds it is helpful to tip the mold slightly to let the material flow into the side of the mold, or use a pouring wand. Use extra care with larger, more complicated molds. On small jewelry type molds, LI-QUA-CHÉ may be spooned in, not poured and should be thinned a little with water.

Once the mold is full, wait until the walls reach the desired thickness. The length of time it takes to reach this thickness will depend upon the condition of the mold. Humidity and surrounding temperature will also contribute to the time factor. Under ideal pouring conditions, smaller molds can be poured off in 5 to 15 minutes, medium size molds in 15 to 30 minutes, and larger size molds may take up to 30 to 60 minutes.

When the walls have reached the desired thickness, pour off the remaining compound. This decanted material can be re-used. After the excess has been poured off, place the mold upside down on a suitable rack for an additional 5 to 10 minutes for drainage. For large or heavy castings it is best for the mold to be turned upright after draining. This prevents collapse of the casting’s walls. Small castings may be removed from the mold within 10 to 20 minutes, medium size in 20 to 40 minutes and larger, more complex molds, from 40 to

90 minutes. On larger castings we recommend leaving the piece in the opened mold to partially set before total removal. This of course, will depend on the design and kind of support that may be required.

Curing & Handling

When LI-QUA-CHÉ is removed from the mold, it is rigid but slightly fragile. Handle the raw casting carefully. It is at this time that you can do add-ons by applying LI-QUA-CHÉ to the add on and gluing in place. This is also the best time to do any cut outs. However, you do have a few hours in which to clean and finish the casting.

Cleaning is easiest when the raw casting comes out of the mold and gets progressively more difficult over the next 6 to 8 hours. When the casting is totally hardened, it may still be cleaned by softening the seams with water. Use the same tools to clean LI-QUA-CHÉ that you would use with ceramic casting compounds. When the casting first comes out of the mold a simple scraper and sponge will do the trick. As the casting gets harder you will find that it will sand and drill like soft wood. It is important to note that when LI-QUA-CHÉ is totally cured you can use water to soften the seams and the surface will not erode. Hardened LI-QUA-CHÉ can not be reclaimed. The curing process, after the casting is removed from the mold, takes up to 24 hours at room temperature. At this time you can finish the casting even though the curing process goes on for another 24 to 36 hours. When the casting is totally cured it is water resistant, but not totally water proof. THIS PRODUCT IS NOT DISHWASHER SAFE.

How to Finish Pieces

LI-QUA-CHÉ can be finished with paints and stains that are typically available to the ceramic and craft industries. THE ONLY FINISHES THAT YOU SHOULD **NOT** USE ARE THOSE THAT NEED TO BE FIRED! LI-QUA-CHÉ will not take the high temperatures of a kiln and should never be fired under any circumstances. There are many non-firing glazes on the market in brush and spray containers. Acrylic paints, stains, chinks, oils, watercolor markers, crayons, colored pencils etc. can be used to finish your LI-QUA-CHÉ casting.

LI-QUA-CHÉ for Dolls

LI-QUA-CHÉ is a great choice for those artists who wish to reproduce their own dolls, or reproduce other commercial doll molds. The doll needs no kiln firing and when dry is break resistant. Raw castings are easy to clean, dry and paint, as well as, being strong, durable and non-toxic. Dried castings are also easy to sand, carve and refine. They therefore, may be poured in a waste mold and the casting can become the refined model used for making a final model mold. Shrinkage is only 5-7%, similar to a ceramic fired piece.

LI-QUA-CHÉ BENEFITS

- Non-Toxic
- Non-Fired, Air-Cured
- Uses Recycled Paper
- Freeze/Thaw Stable
- EZ Trim & Repair
- Great Detail Replication
- Low Wear on Molds
- Low Shrinkage
- Ready-to-Use
- Composition Alternative
- Made in the U.S.A.

Doll Finishing

Doll makers who use LI-QUA-CHÉ suggest finishing the doll with a thinned down flesh colored stain. These stains can be obtained at local ceramic supply stores. Since LI-QUA-CHÉ castings are non-fired, for a look that is similar to fired coatings, use translucent stains instead of China paints. If you wish, you may polish this material as you would polish porcelain.

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