

# **MPK BRUSHABLE RESIN**

## **(3minute & 6 minute)**

MPK BRUSHABLE RESIN may be used in place of fiberglass for brushable molds if needed. However, it is not as strong or durable as fiberglass, but can still be very strong if multiple layers are applied.

When adding multiple layers of brushable resin, begin brushing it on as the previous layer is gummy and still curing. This will assure the layers molecularly bond and the layers will not shear apart during use.

The following instructions are based on tests done at 72° room temperature.

Below 70°, you may gain 30 seconds of working time. Between 75°-85°, you may lose 30 seconds to 90 seconds of working time. Above that, 85°-95°, you may possibly lose 90 to 180 seconds.

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## **SHAKE OR MIX B-SIDE WELL BEFORE USING**

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### **3 MINUTE BRUSHABLE RESIN:**

Mix for 0:30 seconds in a figure-8 motion, scraping the bottom and sides of your mixing cup.

At 0:30 seconds: it will thicken and become warm. Begin brushing it in your mold at this point.

At 2:00 minutes: it will become stringy.

At 2:30 minutes: it will be very thick but still movable if needed.

At 3:00 minutes: it will freeze in place and you will not be able to brush any more.

At 3:30 minutes: it will become gummy, (if needed, we recommend adding additional layers at this stage).

At 10:30 minutes: the material will have no tack, but will still be warm and pliable. Do not disturb it until it is hard and fully cured.

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### **6 MINUTE BRUSHABLE RESIN:**

Mix for 0:30 seconds in a figure-8 motion, scraping the bottom and sides of your mixing cup.

At 0:30 seconds: it will thicken and become warm. Begin brushing it in your mold at this point.

At 3:00 minutes: it will become stringy.

At 5:00 minutes: it will be very thick but still movable if needed.

At 6:00 minutes: it will freeze in place and you will not be able to brush any more.

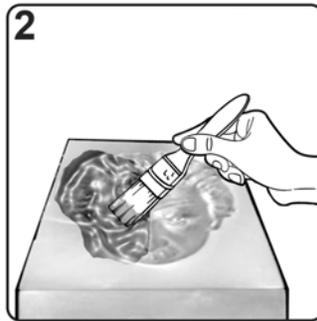
At 7:00 minutes: it will become gummy, (if needed, we recommend adding additional layers at this stage).

At 25:00 minutes: the material will have no tack, but will still be warm and pliable. Do not disturb it until it is hard and fully cured.

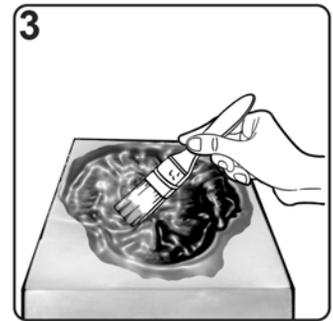
# INSTRUCTIONS FOR MPK BRUSHABLE RESIN (INNER MOLD)



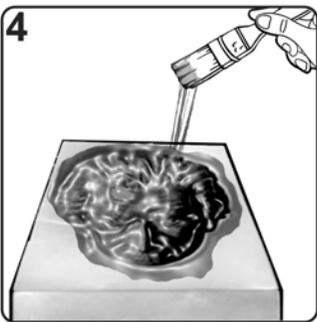
Weigh and pour your material (53/47 ratio by weight) and begin mixing. Mix in a figure-eight motion, scraping both the bottom and sides of the cup. The material will quickly start to thicken, become warm, and will be ready to begin brushing into your mold.



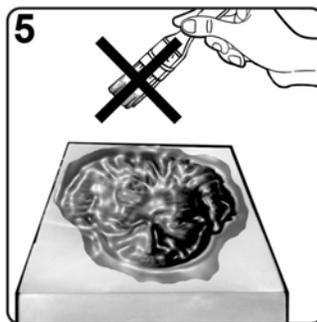
The material will collect in the lowest points of the mold. Brush in an upwards motion away from the low points to combat pooling and slouching.



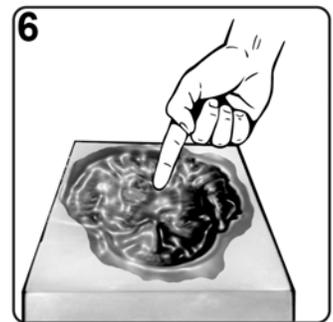
The material will continue to thicken over the next few minutes. Keep brushing the material up to the highest points of the mold.



After a few minutes of brushing, you will notice that the material will stop slouching and freeze in place, and will become stringy if you continue to brush it.

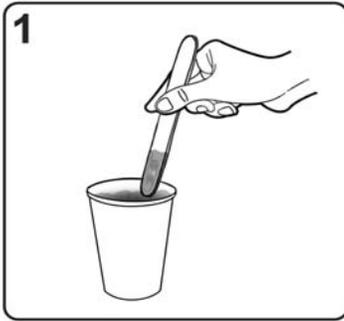


Stop brushing the material once it becomes stringy and freezes in place. If you continue brushing, the material could pull away from the silicone mold. At this stage, additional layers of resin may be brushed on if desired.

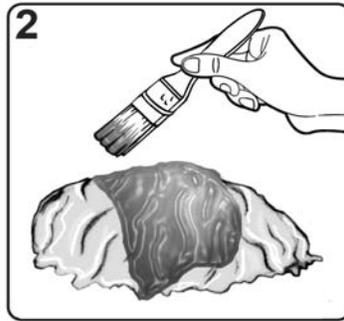


The material will go from gummy, to sticky, to tacky, and soon the tackiness will go away completely, but the material may still be slightly soft and pliable. Leave in mold until fully cured and hard.

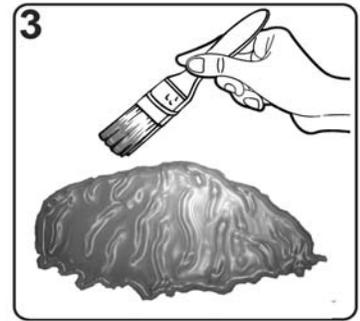
# INSTRUCTIONS FOR MPK BRUSHABLE RESIN (OUTER MOLD)



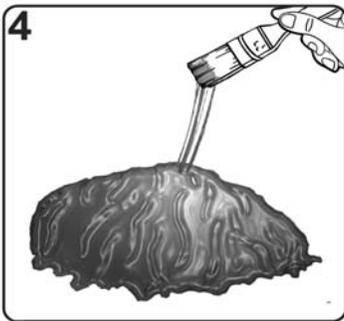
1 Weigh and pour your material (53/47 ratio by weight) and begin mixing. Mix in a figure-eight motion, scraping both the bottom and sides of the cup. The material will quickly start to thicken, become warm, and will be ready to begin brushing onto your brushable silicone mold.



2 The material will run off the sides to the lowest points of the mold. Brush in an upwards motion, towards the top, away from the low points to combat pooling and slouching.



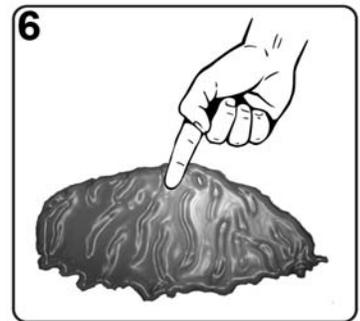
3 The material will continue to thicken over the next few minutes. Keep brushing the material up to the highest points of the mold.



4 After a few minutes of brushing, you will notice that the material will stop slouching and freeze in place, and will become stringy if you continue to brush it.



5 Stop brushing the material once it becomes stringy and freezes in place. If you continue brushing, the material could pull away from the silicone mold. At this stage, additional layers of resin may be brushed on if desired.



6 The material will go from gummy, to sticky, to tacky, and soon the tackiness will go away completely, but the material may still be slightly soft and pliable. Leave on mold until fully cured and hard.