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## INSTRUCTIONS FOR REDUCIT® PATTERN COMPOUND

No. 179-031

*Reducit® is a unique positive casting material which will shrink uniformly, resulting in scale replicas from most molds. In a single stage of reduction, a Reducit® cast will shrink to approximately half of its original volume, or 2/3 of its original size in linear dimensions. Further reductions can be achieved by taking a mold from the reduced cast and repeat the casting and drying process.*

**NOTE:** REDUCIT® HAS A WORKING TIME OF ONLY 10 MINUTES ONCE IT HAS BEEN MIXED WITH WATER.

### Mixing Instructions

1. Mixing proportions are 2 parts of water to 1 part of Reducit® powder by volume. Pour the water into your mixing bowl first and then add the powder to the water.
2. A smooth and creamy consistency in the mix is essential. Stir the mixture clockwise and counterclockwise for at least 2 minutes. Be sure to scrape the sides of the bowl as the blending progresses. The appearance of the mixture may be deceptively smooth, until you look more closely and discover that there are still many lumps of unblended material. If any of these lumps are allowed to remain unblended in the mixture, they will result in tiny raised points on the surface of the cast as it dries. The lumps will not be visible at first, when the cast is removed from the mold; they will only emerge later during the drying process, indicating that the Reducit® was not thoroughly mixed.

**NOTE:** ALWAYS POUR REDUCIT® INTO A NONPOROUS MOLD SUCH AS RUBBER (URETHANE, SILICONE, OR LATEX). IF YOU MUST USE A POROUS MOLD SUCH AS ONE OF DRIED PLASTER OR WOOD, IT MUST BE SEALED BEFORE CASTING SO THAT THE REDUCIT® WILL NOT STICK TO THE SURFACE OF THE MOLD.

### Pouring Reducit®

1. The consistency of the Reducit® will be somewhat thick, but still fluid enough to be poured or brushed into your molds. You will want to work quickly, pouring all of the Reducit® into the mold as you move it against the surface of the mold with your fingers or brush, to ensure that you make good contact with your mold and avoid trapping air bubbles in the fine details. If you are filling a two piece mold that includes lots of small details such as fingers and toes, you may coat each half of the mold separately, then join them and fill to the top; or, first close your mold and reach into it with a brush to coat the surface. You have about ten minutes of working time from the moment you dump your Reducit® into the water, until it is no longer workable. For large or small pieces, wait at least one hour before unmolding.
2. After at least one hour, you may remove the cast from your mold. Your Reducit® cast should be air dried. Do not use heat to cure the pattern. Doing so will result in very uneven shrinkage. You may use a dehydrator if you have one, but air drying works best. Proper air drying may take 2 to 4 days.
3. Thin medallion-type forms will generally warp as they dry. One of the things you can do to avoid the warpage is to build a wall around the edge of the mold, a couple of inches high, so that when you pour the Reducit® into the mold, You will have added two inches of thickness to your cast. This will prevent warpage, but the casting will naturally take longer to dry out and reduce. Another method is to pour beyond the edge of the mold in order to create a “lip” of excess material (about 1/2” thick). After removing the casting from the mold, this “lip” may be weighted down to restrain the casting from warping while it dries.