



### 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.

## LI-QUA-CHÉ

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.



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!**



### LOW SHRINKAGE

The unique formulation of LIQUA-CHÉ reduces the amount of shrinkage that occurs in the air-curing process. This can be seen in the picture to the left, which shows a fully dried LI-QUA-CHÉ casting in its original

## NON-FIRED CASTING COMPOUND

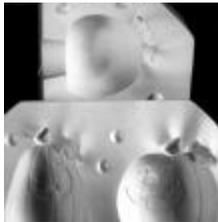
LI-QUA-CHÉ is a recycled paper fiber, polymer based compound that is not fire hardened. It air dries at ambient room temperature to a hard, durable, break resistant product. Low water content and a special manufacturing process allow for an increased number of castings with your plaster/ceramic molds.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

## USES PLASTIC /CERAMIC MOLDS

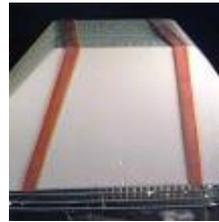


The ease of use with one part molds is a major benefit of LI-QUA-CHÉ. One-part molds are quick and easy to use, and so is LI-QUA-CHÉ. For ease in filling a mold, LI-QUACHÉ may be used in a squeeze bottle. In only a matter of minutes you may remove your raw casting from the mold. The time savings continue with LI-QUA-CHÉ's fast drying formulation which allows you to paint or otherwise finish your casting in just a few short hours.

## LI-QUA-CHÉ INSTRUCTIONS



1. LI-QUA-CHÉ is designed to be used with plaster/ceramic molds. Both one and two part molds may be used



5. Turn the mold upside down and let stand, to allow the LI-QUACHÉ to drain out of the mold. On large piece molds turn pour hole upright. Let stand for 15 - 45 minutes.



2. Dilute LI-QUA-CHÉ with water to an appropriate viscosity, and pour the mixture into your mold using some type of pouring picher



6. To remove your LI-QUACHÉ raw casting you may use traditional ceramic methods for breaking the mold.



3. Be sure to fill the mold to the top of the pour hole. As the water is absorbed into the mold, the level will fall. Let Stand for 15-30 minutes.



7. Once the mold is opened, you may easily remove the raw casting. LI-QUA-CHÉ is much more durable in this "fresh" state than other casting mediums.



4. After you have let the product set in the mold for a period of time, decant the remaining material. This material can be recombined with the original mix.



8. Now all you need are the finishing touches. LI-QUACHÉ can be trimmed in the wet or dry state and painted with any non-fired paint or stained.

## POURING PLASTIC MOLDS

If your molds have not been used for a while, mist the inside of the mold lightly on the first pour. LI-QUACHÉ 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-QUACHÉ 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 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-QUACHÉ is totally cured you can use water to soften the seams and the surface will not erode. Hardened LIQUA-CHÉ cannot 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, chalks, oils, watercolor markers, crayons, colored pencils etc. can be used to finish your LI-QUA-CHÉ casting.

# LI-QUA-CHÉ FOR DOLLS

**“KAYLA”** By: Lynda Casaubon

Doll Mold by: Doll Artworks



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.

Kayla's head, shoulder plate, arms and legs were cast using ACTIVA's LI-QUA-CHÉ. Doll Height = 26 in.

## DOLL FINISHING

**“Victorian Santa”**

By: Dusty Granity  
Distinctive Creations

All cast parts were made using ACTIVA's LI-QUA-CHÉ



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.



**“Raggedy Santa”** By: Judy Irwin  
Sculpted by: Randi Pewzner  
Doll Mold by: Collectible Doll Molds

## LI-QUA-CHÉ Has Many Applications



Doll Making



Fine Detail Replication



Traditional Ceramics



Classroom Projects



LI-QUA-CHÉ is available in 2 sizes  
1 Gallon Bottle (128oz) & 5 Gallon