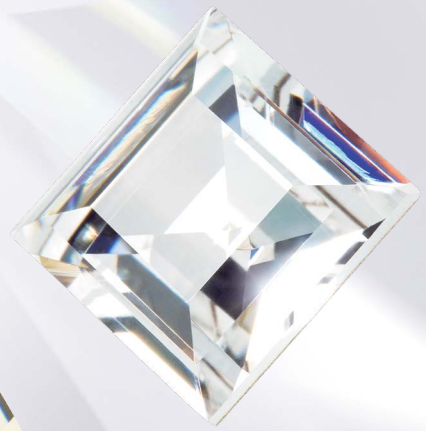




APPLICATION MANUAL

# Setting stones in epoxy clay

PRECIOSA

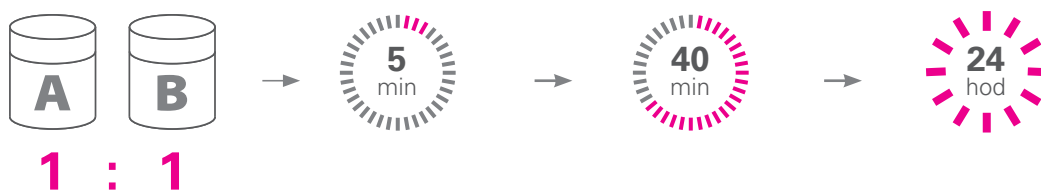


# Working instructions for two-component glue for fixing glass stones in costume jewellery products

## OVERVIEW OF PRECIOSA PRODUCTS SUITABLE FOR SETTING IN EPOXY CLAY

COMPONENTS		SETTING IN EPOXY CLAY
Fashion Jewellery Stones	Round Stones	✓
	Fancy Stones	✓

## PROCEDURE



### Preparation of the clay

Mix both clay components – A (resin) and B (hardener) – in the ratio recommended by the producer, typically 1:1.

### Mixing the clay

Mix both clay components for at least 5 minutes till they are thoroughly mixed together.

### Workability

The substance can be formed for 40 to 60 minutes, then it starts to harden.

### Curing

The epoxy clay needs to cure 24 hours to reach its full strength and durability. Do not handle the material during this period.



The above given data are valid for the majority of the delivered substances. It is, however, recommended to follow the producer's instructions.

## APPLICATION PROCEDURE



**1** Take the required quantity of the clay components A (resin) and B (hardener) from the cartridges in a ratio recommended by the producer, typically 1:1 by weight.



**2** Mix both clay components A and B thoroughly. A properly mixed substance is significant for a firm bond between the clay and the underlying material as well as for a proper fixing of the stone in the clay.



**3** Mix the clay for at least 5 minutes till you get a homogenous substance.



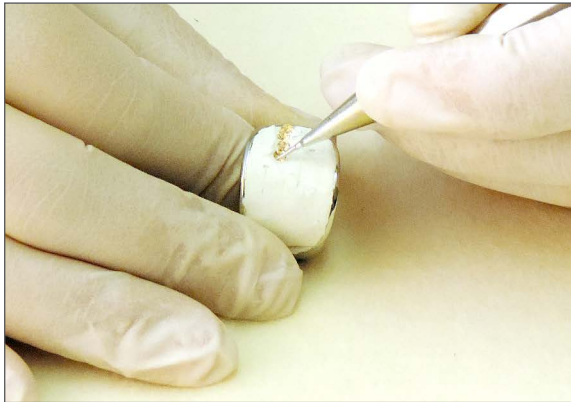
**4** Form the required shape from the substance.



**5** Fix the pre-formed substance on the base material (e.g. a costume jewellery part) and mould it into the final shape.



**6** Place the stones in the prepared substance and press them properly up to their girdle into it. Only then are the stones perfectly fixed in the costume jewellery part.



**7** The clay should not extend beyond the stone edges as it would negatively influence the brilliance of the stones (optical qualities).



**8** Produced substances are typically workable for ca. 40 to 60 minutes. Setting the stones and correcting their position should be carried out during this interval.



**9** The epoxy clay cures at ambient temperature. After curing, clean the product with a soft cloth or a stick with cotton wool. A small amount of alcohol can be used in case of need.

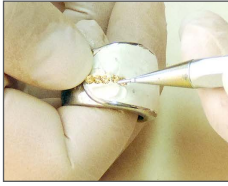


**10** The maximal strength of a finished product (stones fixed firmly) is reached after ca. 24 hours or when the clay is no more elastic.

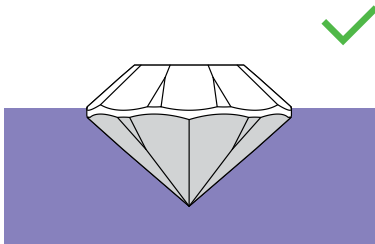


Use protective gloves when working with the clay. Make sure that the working surface is always clean, i.e. without dust, grease and other impurities.

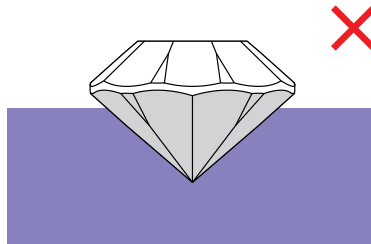




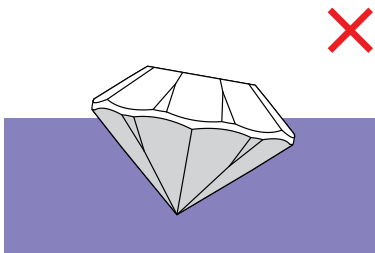
**A correct position of the stone in the clay**  
*Note to the step No. 6*



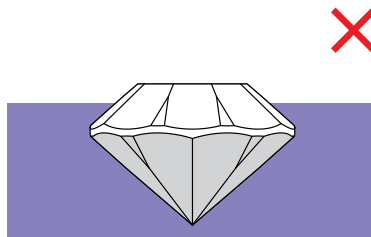
*A correct position of the stone in the clay*



*The stone is pressed too little*



*The stone is set askew*



*The stone is pressed too deep*

**Recommended epoxy clays**

PRODUCT	PRODUCER	WWW
Ferido X2-SP Glue	Cyberbond Apollo 2999 (Cyberbond)	<a href="http://www.ferido.com">www.ferido.com</a>
epoGEM	International Adhesive Manufacturer	<a href="http://www.inter-adhesive.com">www.inter-adhesive.com</a>
wGlue	Trinity Industry	<a href="http://www.wglue.en.ec21.com">www.wglue.en.ec21.com</a>

# Important advice and information

## ***POSSIBLE PROBLEMS, THEIR CAUSES AND RECOMMENDATIONS***

<b>PROBLEM</b>	<b>CAUSE</b>
Some stones fall out even after clay hardening.	<b>1, 2, 3, 5, 6, 8</b>
The substance is not fixed to the base material.	<b>1, 2, 3, 5</b>
Some stones lose their brilliance.	<b>4, 7</b>

<b>CAUSE</b>	<b>RECOMMENDATION</b>
<b>1</b> The correct ratio of A and B was not observed.	Pay attention to the proper ratio recommended by the clay producer.
<b>2</b> A and B components were not properly mixed.	Mix the substance longer till it is perfectly homogenous.
<b>3</b> The workable time of the substance was exceeded.	Mix a new substance.
<b>4</b> The stone surface was stained by clay.	Clean the product with a soft cloth or a stick with cotton wool after the clay was cured at the room temperature. Use a small amount of alcohol in case of need. Make sure that the working surface is always clean, i.e. without dust, grease or other impurities.
<b>5</b> The surface of the jewellery piece was not properly cleaned.	Make sure that the working surface is always clean, i.e. without dust, grease or other impurities.
<b>6</b> The stone is not set deep enough.	Set the stone up to its girdle.
<b>7</b> The stone is set too deep.	Set the stone only to its girdle.
<b>8</b> The substance has not cured for 24 hours.	Observe the recommendations of the clay producer regarding the curing conditions and glue lifetime.

# GENERAL RECOMMENDATIONS

## FASHION JEWELLERY STONES

## FLAT BACK STONES

Stones with coatings  
— use only gentle  
wash cycle (30 °C).



Turn inside out, choose a gentle wash cycle and use mild laundry detergent. To protect the crystals as much as possible, the use of a soft wash bag is recommended.



Turn inside out and use mild laundry detergent.



Do not wash!



Chlorine bleach may be used.



Do not use chlorine bleach!



Turn inside out and dry at reduced temperature.



Do not tumble dry!



Iron inside out using a silk/polyester viscose setting. Ironing the textile inside out and using a pressing cloth is recommended.



Iron inside out using a wool setting.



Do not iron! Do not iron directly over the crystals.



To protect the crystals as much as possible, the use of a soft wash bag is recommended.



The textile can be gently dry-cleaned using perchlorethylene. Turn inside out.



The textile can be gently dry-cleaned using hydrocarbon.



The textile will withstand gentle professional wet cleaning. Turn inside out.



The textile may not be dry-cleaned.





**BEADS AND  
PENDANTS**

**NACRE  
PEARLS**

**FASHION AND FASHION  
JEWELLERY COMPONENTS**

Beads

Pendants

Cup Chains

Plastic  
Bandings

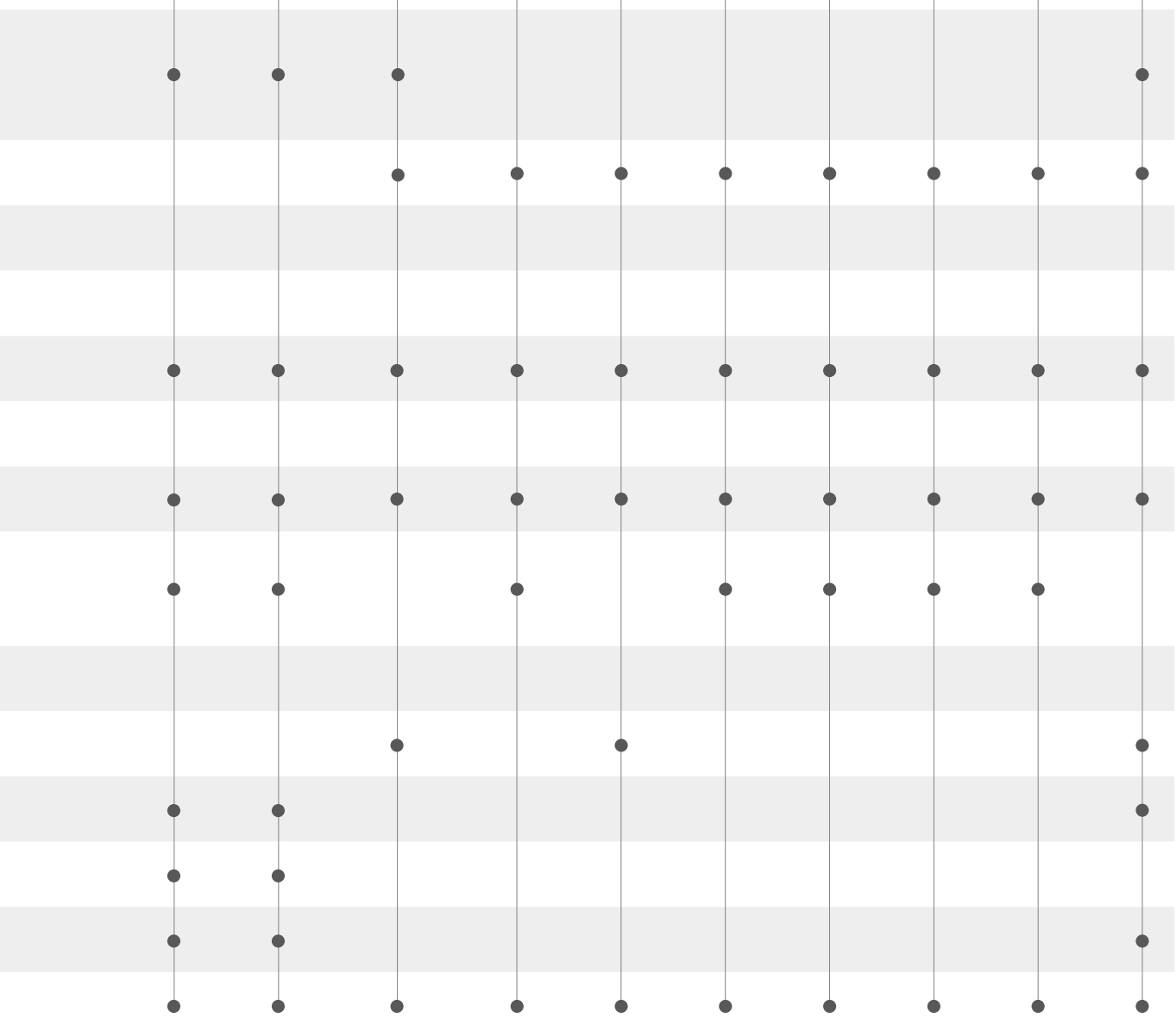
Metal  
Bandings

Rondelles  
and Balls

Fancy  
Rondelles

Stones in  
Settings

Crystal  
Threads



# Notes



## **Preciosa Components**

A Member of the Preciosa Group

Preciosa Group is a global leader in products *manufactured from crystal*. From the world famous Czech Beads and Crystal Components used in fashion industry, to tailor made Lighting projects for luxury hotels, royal palaces and yachts, the true craftsmanship of crystal production has been present in Bohemia since 16th century.

[PreciosaComponents.com](http://PreciosaComponents.com)