

SILICONES

and more

Mould in one part, badge

Needed materials from the shop

- Silicone Condensation 20 A component
- Silicone Condensation 20 B component
- Plasticine

Prepare for use

- Scales
- Silicone Condensation 20 A component
- Silicone Condensation 20 B component
- Formwork/slats
- Measuring cup.
- Double sided tape
- Stirring stick/spatula

Preparation

Before the mould is casted make sure that the model is clean. Brush of any dirt or dust and polish out unwanted bumps. Because your mould will copy everything including the smallest details. De glanzende delen in uw Glossy parts on the model will also be glossy on the mould. Matte parts will also be matte on the mould. Treat the surface of the model with a release agent if necessary. Put every thing ready for use so you can work fast.

Let's start

1. Place the model on a flat spirit level surface that does not bind well (**Fig. 1**). Place a formwork around the model to prevent silicone from flowing away. The formwork can be made out of wooden slats or in this case plasticine (see fig. 2). Please note that silicone is very liquid, any crack or hole is enough to run through. So always double check before casting and apply some extra plasticine were needed. Always make the formwork higher than the model. This height will determine the thickness of the bottom side of the mould.

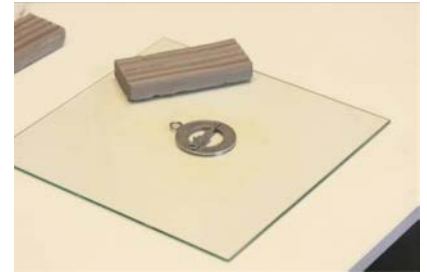


Fig. 1. The model is placed on a flat surface (glass plate).



Fig. 2: Make a border of plasticine around the model as a barrier for the silicone.



Fig. 3: The B component has a small dosage. A syringe to measure and dispense is swift and accurate. In this case you can read 1 ml as 1 mg.

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2. Now place a border of plasticine (see fig. 2) or a formwork around the model so the silicone will stay in place.
The formwork can be made out of wooden slats for example. Always check for small holes or cracks and close them with plasticine. Make the border or framework higher than the model for this height will determine the wall thickness of the base of the mould.
 3. Calculate the required amount of A-component and pour it in a mixing cup and add 2% B-Component (fig. 3).
 4. Blend the two components with a stirring stick until both components are fully mixed. It is important to cover every corner and not leave any unmixed parts.
- Tip: *To be absolutely sure both components are mixed well a colouring or a colouring agent can be added to the B-component.*
5. The silicone is now ready to be casted. Take the pot life of the silicone into account during processing. After about one hour the silicone will become too thick to be casted. Casting the silicone in a thin trickle will give air that is trapped inside the silicone time to escape (fig. 4). Using a vacuum pump is not imperative but it will improve the quality of the rubber.
 6. Wait about 8 hours before starting on the second part. Gently touch the silicone and check if it has cured well enough. Although the mould is ready for use in about 8 hours the final strength will be reached only after 7 days.
Note: aggressive materials may shorten the life span of the mould.

This mould is suited for casting; soap, plaster, poly-urethane, epoxy, cement and Acrylic One.



Fig. 4: Casting the silicone in a thin trickle will give air that is trapped inside the silicone time to escape.



Fig. 5: The mother model, mould and a copy out of red casting wax.