

## One piece brush-on mould, brick slip

### Needed materials from the shop

- Silicone Condensation 20 A component
- Silicone Condensation 20 B component
- Silicone Thixo C (Thicker)

### Prepare for use

- Scales
- Silicone Condensation 20 A component
- Silicone Condensation 20 B component
- Siliconen Thixo C (Thicker)
- Measuring cup.
- Stirring stick/spatula
- Brush
- 2x Seringe

### Preparation

Before brushing on the mould 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

**Layer 1** (contact surface): This layer will determine the quality of the mould. Check if it is as you wish it to be, if not change it before applying the release agent.

1. Blend the two components with a stirring stick un till both components are fully mixed. It is important to cover every corner and not leave any unmixed parts. To be absolutely sure both components are mixed well a colouring a colouring agent can be added to the B-component. Now add 0.01% of the Thixo C to the silicone (one drop per 100 gram). For measuring and dispensing the B-component and the Thixo a syringe comes in handy. Use a clean syringe for both substances. Mix the silicone again after adding the Thixo C.



**Fig. 1** : This ornamental brick slip has been cleaned unwanted dents are filled up and the surface has been treated with a release agent (vaseline).

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- The Silicone is now ready for use. Apply a film layer of about 0.5mm silicone with a brush or spatula.  
Let it set for 1 ~ 2 hours before applying the second layer.

**TIP:** Do not prepare all the silicone at once. But the first and second layer separately. Because at the time the mould is ready for the second layer the prepared silicone will already be partly cured.

**TIP:** First apply a thin layer of silicone this will enable air pockets to come out. The surplus of silicone will simply drip onto the worktop where it will create the beginning of the rim of the mould.

**TIP:** Note the pot life of the silicone. It is about 1 hour.

**Layer 2** (support layer). The first layer has copied the structure of the surface perfectly. If there were any air pockets they have got plenty of time to get out. The second layer of silicone can now be applied. The first layer is still tacky so the second layer will bind with ease. Be careful not to damage the first layer while brushing on the second one. A wall thickness of 0.5 ~ 1 cm for the second and final layer will be enough to make a good mould.

### The second layer

- Pour the needed amount of Silicone Condensation 20 A-component in a measuring cup and add 2% Silicone Condensation B-Component. Then add 0,6 ~ 2% Thixo C. Mix all components well. Then let it rest for a few minutes to give the Thixo time to thicken the silicone. Then slowly stir the silicone one last time.
- The silicone is now ready to be applied. This time the silicone is thicker than the last. Apply it carefully and avoid brushing air pockets into the silicone. Push the brush in every hole so all air is pushed out.

**TIP:** The silicone is thick enough when you can put a piece of 1 ~ 2cm thick on the wall and it does not run or drip.

**TIP:** Apply the second layer carefully and avoid damaging the first layer.

- After about 8 ~ 10 hours the silicone will be cured well enough to be demoulded. However the final strength will be reached in about 7 days.



**Fig. 2 :** First apply a film layer of silicone on to the model. Enabling any air bubbles to get out through the film layer.



**Fig. 3 :** The film layer is applied. Now let it set for a short while.



**Fig. 4 :** The second layer is applied. This layer will give the mould strength.



**Fig. 5 :** The brick slip is completely covered in a layer of +/- 5 mm silicone.

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**Fig. 5 :** The original and the copy in Acrylic One.

### Additional information

- Let the silicone cure for about 8 hours before demoulding.
- Final strength will be reached in 3 to 7 days (depending on the added amount of B-component and the humidity).
- The percentage of B-component will determine how fast the silicone will cure. One can add 1,5 up to 3%.  
We like to use 2%. Adding more than 3% may have a negative influence on the strength.
- Always make sure everything is clean (from mixing cup to work bench etc.).
- Placticine or clay always needs to be treated with a sealer (like Vaseline) in order to prevent the silicone from binding with the porous surface of the placticine/clay.
- By adding a colouring agent to the B-component before mixing A and B one can see clearly if both components have mixed well enough to be applied.
- The silicone is ready when there is an even colour without stripes of discolouration's.

**Note:** If no Thixo is added to the silicone it can also be poured.