Flexible Mould Making

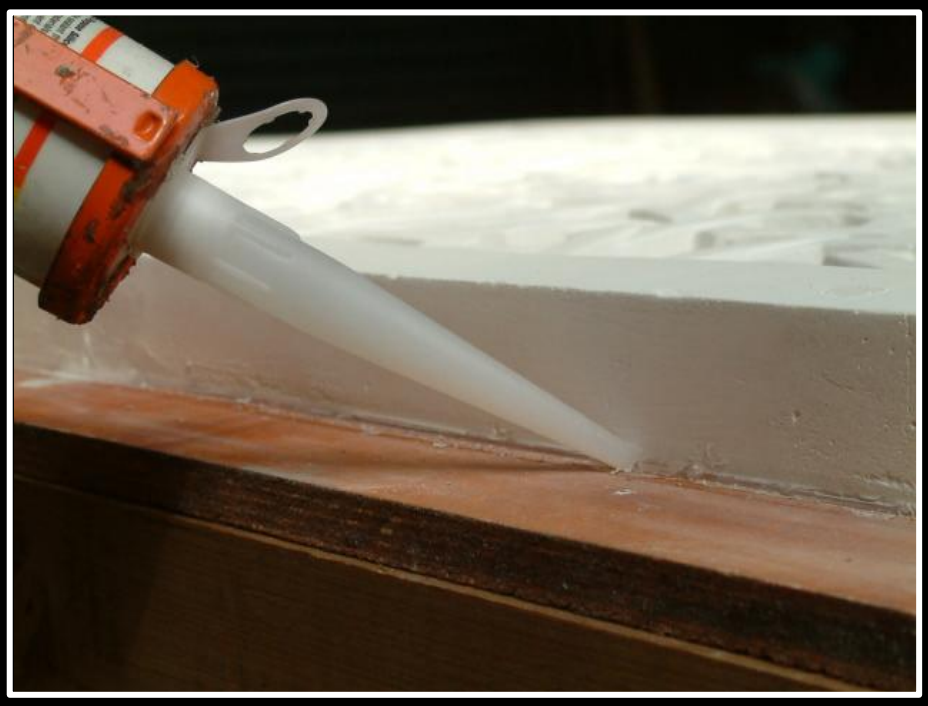
Presentation

Start with a master pattern

This is a replica of the item to be produced

Ensure the pattern is free from defects
Fill and sand where required

Fix the pattern to a baseboard ensuring there are no gaps



Fix sides to the baseboard. Again there must be no gaps.

Ensure the mould is level

Apply a wax based release agent and allow to dry

Calculate the amount of rubber required

- Calculate the volume of the mould

L x W x H

1.2 x 0.7 x 0.05 = 42 litres

Subtract the volume of the master mould

(assuming it contains 50% voids)

1.1 x 0.65 x 0.04 x 0.5 = 14.30 litres

- The volume of the Duramould is therefore

42 – 14 = 28 litres

This equates to 28 kgs

The specific gravity of Duramould is 1

With some rubbers the SG can be as high as 1.4. Using these, you would need 39 kgs

An additional 11 kgs

Remember this when comparing prices!

Duramould A & B are supplied in 25kg drums

Duramould has a simple mix ratio of 1:1

We require to mix

14 kgs of Duramould Part A

14 kgs of Duramould Part B

Due to the high quantity, it will be mixed in

Two batches

7 kgs Part A

7 kgs Part B


AVERY


kg
0
1kg
2
3
4
5
6
7
8
9
10
11
12
13
SET TARE
READ NET
ADD


VERY
GHAM - ENGLAND


2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21
SET TARE WEIGHT ON STEELYARD
READ NET WEIGHT ON DIAL
ADD FOR GROSS WEIGHT

Mix parts A and B thoroughly

Transfer to another container and remix

Pour the mixed Duramould onto the centre of the pattern

Let it flow to the edges

Use a hot air blower to remove any remaining air bubbles

Leave overnight

De-moulding
Firstly, remove the sides

Then peel the set Duramould from the pattern

Treat the mould with concrete release agent prior to use

When not in use, store the mould flat