

- 1) Make sure all pieces are in elastomer table
- 2) Make sure solvable support fits easily in the mold
 - ↳ If not, sand the edges with a file
- 3) Apply a thin coat of mold release (Eco release 200 by Ham) if necessary. If you have not sprayed in last day.
 - ↳ If too much, remove by Simple Green or IPA.
 - * Never use acetone with any of the parts
- 4) Mixer: use the non-disposable cup (3 pieces). The lid, cup & safety.
 - ↳ weigh total amount (silicone rubber + cups) and set balance in mixer to that weight.
- 5) Zero scale after placing the cup on top of it. We pour roughly 80g from each part of Dragon Skin 20. During the pouring process precision matters. We want a constant flow rate of rubber from a short distance from the cup. If we pour too fast, bubbles will be trapped. 20 minutes start here.
- 6) Use the thinky mixer with 2000 rpm / 1:00 min settings for mix/defoam. Don't forget to adjust the scale.

7. Very very carefully empty the mixed silicone rubber into the bottom mold, small distance between cup and mold while pouring + slow pouring.
 8. Vacuum Degass the mold using the oven + vacuum pump. Oven must be at room temperature. Turn vent knob to off/close, vacuum knob must be on. Turn on the vacuum pump. Leave mold in vacuum for. ~ 10 mins.
 9. ~~Four~~ Carefully place the support on top of the bottom mold, Allow it to naturally submerge. If necessary, apply a small constant force to aid it. When the support is fully submerged in the silicone rubber, place/cover mold with the lid.
 10. Place a small weight on top of mold to keep it closed. Cure for ~ 4 hrs.
 11. Post cure in oven for ~ 8 hrs @ $^{50+}65^{\circ}\text{C}$
- * Clean silicone rubber only after it cures.