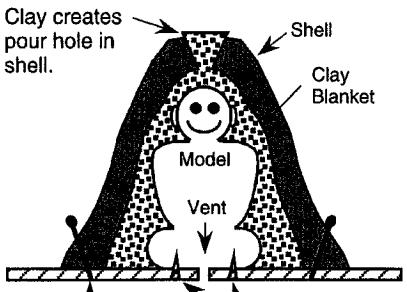
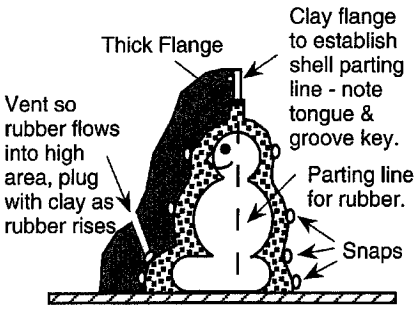
BLANKET MOLDS

5. For a poured blanket mold, the shell is built first.



Clay blanket 1/4 to 1/2" thick over model protected with plastic wrap, will be replaced with rubber poured inside shell. Clay eliminates all undercuts that could lock the shell onto the rubber.



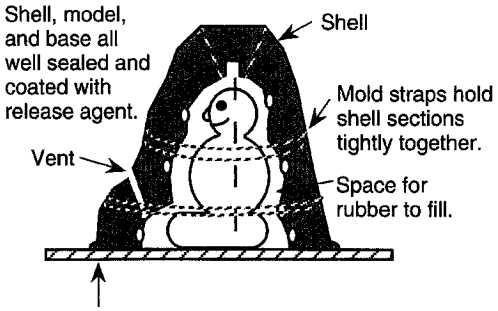
Thick flange in rubber along parting line allows keying into the shell and is thick enough rubber for proper cutting and/or mating with other half of mold.

"Snaps" will hold rubber mold into the shell, only needed on large molds where rubber mold may flop away from shell.

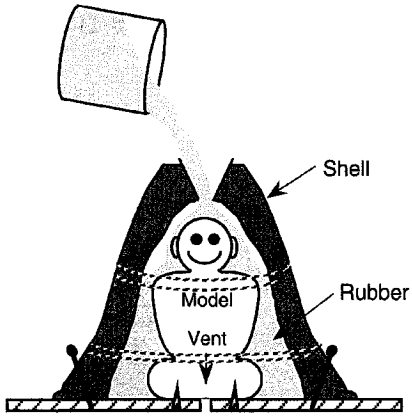
The mold shell is built first over a clay or plasticene blanket. Clay is removed and then rubber poured into the shell replaces the clay blanket exactly, thus mold keys and parting or cut lines can be perfectly established in clay prior to pouring the rubber. Rubber may be poured in one piece and cut with a mold key knife after curing, or can be poured in two halves by removing only half the clay blanket.

The shell in two or more sections is made of resin thickened with Poly Fiber, resin and fiberglass, or plaster and hemp, against a clay flange. When the first section of shell is hard, clay flange is removed, a release like petroleum jelly is applied to edge of the first section and second section is built against the first section for perfect keyed fit of the shell sections.

Rubber is then poured into the shell, over the model.



Plasticene, hot melt glue, or plaster seals the shell to the base and the shell sections together. Mold straps can also hold the shell to the base.



To estimate the amount of rubber needed to fill a shell, the clay used to make the blanket can be weighed. Poly Plastilene is about 17 cubic inches per pound. Poly 74-30 rubber is just over 27 cubic inches per pound so;

lbs of plastilene x 17 = lbs of rubber needed

If rubber is to be poured in two halves, only one half of the clay blanket is removed from the shell. Rubber is poured into one half. When cured, the clay is removed from the other half, release applied, and the second half of the mold is poured.