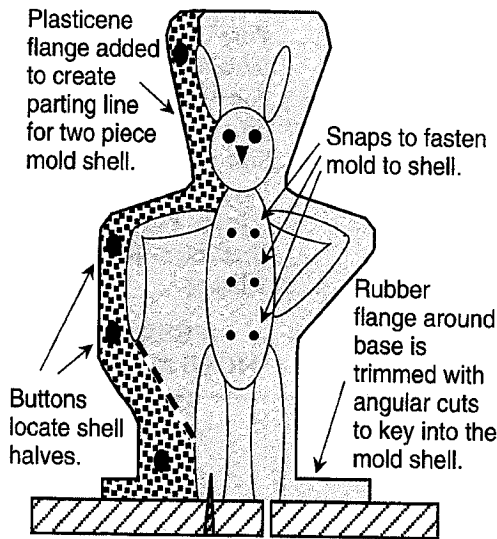
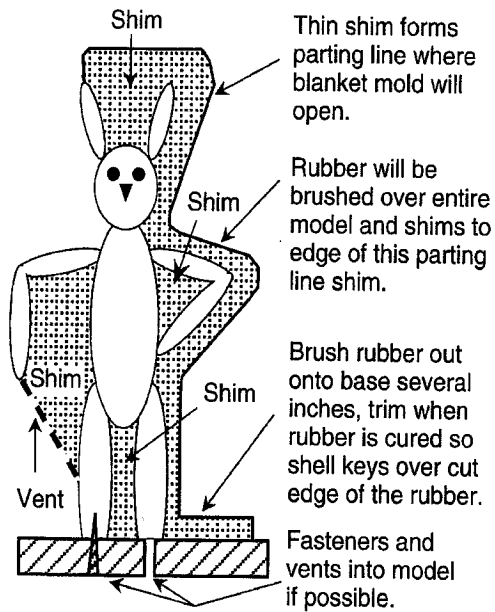


# BLANKET MOLDS

## 6. Brushed-on molds, shell is made after mold is cured.



### First, Make The Mold

To make a brush-on blanket or "skin" mold, the model is mounted and prepared with sealer, necessary shims, coated with release and rubber is brushed on as recommended for that product.

Some one piece brushed-on molds are simply peeled off a low relief or pyramid shaped model like a sock. To reduce the chance of tearing and prolong mold life, a brush-on mold of tall objects should have at least one parting line up one side so it may be opened and removed like a coat. A more complex mold may be made in two or more pieces.

A thin shim of aluminum or plastic must be fitted into all openings where mold halves must separate. Vents made with drinking straws or any rod-like material must be fastened on the model with plasticene, glue or hot melt glue. Remember, neater fastening means less cleanup of the casting.

Large blanket molds require rubber "snaps" or keys or other methods of holding large areas of the mold to the shell. Buttons of rubber, cast in advance in plastic pill holders, can be bonded onto the last coat of the mold rubber so that the shell is formed around them holding the mold in position in the shell.

### Second, Building The Shell

A rigid mold shell is built of plaster and hemp, resin thickened with Poly Fiber or resin and fiberglass. The shell may be one, two or more pieces in order to allow removal from the rubber blanket mold. There can be no undercuts of any significance which will lock the shell onto the rubber when there is a casting or model inside the mold.

The parting line for the rigid shell is defined with a plasticene flange applied over the mold. The plasticene may have a groove or locating depressions on the side that will contact the shell material to create good locking and positioning of the shell halves. The mold shell is built one section at a time against the release coated rubber mold and plasticene flange. When one section of the shell is complete, the plasticene is removed, release is applied, and the next shell section is built against the first. The two halves of the shell will compress the rubber flanges along the mold opening together, for a good seal to retain the casting material without leaking.

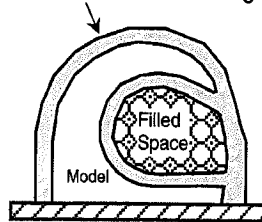
### Flexible Mother Mold

Sometimes a flexible mother mold is preferable to a rigid shell. Soft low cost Poly Urethanes like Poly 74-30 can be poured over a release coated blanket mold enclosed in a box or simple rigid shell to avoid having to make a multi-piece shell. A flexible mother mold can be pulled off simple undercuts. It may use a little more rubber, but it can save lots of labor.

### Filling Undercuts

When brushing on a mold, all undercuts must be eliminated by filling them with mold rubber or some filler material. If the filler material must be compressible, a hollow rubber bladder can be formed by bridging the hollow area with plastic wrap pressed into the previous coat of rubber and coated with another layer of rubber. If more support is needed, the space can be filled with small pieces of soft foam or pillow filling and coated with rubber.

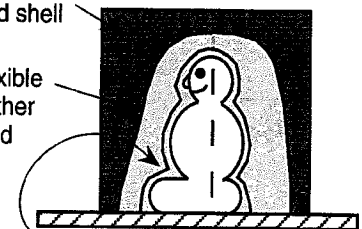
Brushed on mold with undercut space filled before building shell.



Rigid shell over flexible mother mold

One piece rigid shell

Flexible mother mold



Undercuts in brushed on mold.