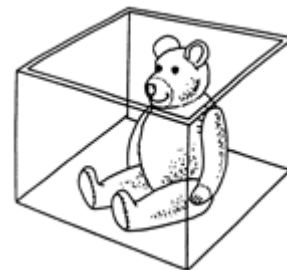


TOMPS Mould Making & Casting Guide 2006

Single Piece RTV Silicone Moulds

Fix the former down to a base board and build a case around it. Ensure the case is fully sealed at the joints using clay, plasticine or plaster as Silicone will readily run out through very small apertures. Note this former has no undercuts to consider.



Mix your silicone as per the ratios marked on the cans. In case of a kit for the job add one part to the other and homogenize well. ACC Silicones have a catalyst marker to show when mix is complete. Use a folding action rather than a whisking action avoiding air entrapment. If you have a vacuum or degassing chamber, use it now to remove any air from the mix.



Now start to fill the case from the lowest point allowing the silicone to flow up and over the former. If you couldn't degass the mixture then make the stream as thin and as slow as possible as this will aid air release. Fill the box to the top or at least 15 mm above the top of the former.



Allow the mould to fully cure to the demould time as a minimum. Extend your cure times if the ambient temperature and or relative humidity is low especially with condensation cures. The demould should be done slowly and carefully so as not to split the rubber. A small slit can be made if needed to aid release, minimise this slit as best as you can.



The mould is now ready for use (once the 95% cure time is reached and never before!). Use a release agent if needed and you can begin casting your new model.

