

VULCAN

Rubber Mould Vulcanising Method

Step 10

Remove the mould from the mould can. The bottom of the can has a removable access plate which can be removed and using a rubber mallet or similar the mould can be gently knocked out. Separate the two mould halves and remove your patterns. If everything has gone well you will now have a strong vulcanised mould with perfect impressions of your patterns.

Step 11

The next stage is to trim up the exterior outer edges of the mould to neaten things up and to cut gates and vents. Gates allow metal into your impressions and vents will allow trapped air and gas to escape during casting.

The best way we have found is to cut gates in the bottom half of the mould and cut vents into the top half. You will need to use a sharp knife and new blade for each mould and caution is advised when cutting the rubber.

Gates should be cut cleanly and should be large and deep enough to allow for the metal to run freely into your impressions. The vents on the other hand are cut very finely approx 1mm and should run into the center of the mould and then back out to the edge this is so that metal will not just spray out of your mould, it has to go against the centrifugal force so will not easily exit the mould.

Step 12

Once the gates and vents are cut it is time to cast the mould. We have found that preheating the mould to approx 90 Degrees C gives better results than casting with a cold mould. Some casters do a few initial spins to heat up the mould. Remember to apply a dusting of french chalk to the mould halves before each cast.

Step 13

After the initial spin and inspection of the first casts you may need to adjust your gates and vents to achieve optimal results.

Note

Mould making is a highly skilled and empirical art and for the newcomer will require practice but perseverance will bring good results in the end and using these skills you will be able to make castings of all manner of products.