

Shell Brush On Mold (Mother mold)

Products used in this How To:

- * Molds
- * UMR Mold Release
- * Alumilite Shell Casting Resin
- * Alumilite 610 Foam
- * Excel Soft Handle Knife
- * Stir Sticks
- * Mixing Cups



Set the rubber mold back into the mother mold and make sure the locators are all pushed in place in the mother mold. Then be sure to spray in Alumilite's UMR in to the mold. Although it is not necessary, the UMR will aid in the release and help to preserve the life expectancy of the mold.



Mix equal amounts of Alumilite's Shell Casting Resin and add a small amount of orange dye. As soon as you the two liquids come in contact they will begin to gel. Mix thoroughly for 1 minute and then begin to spread/paint the Skin Coat into the mold. Only mix what you can apply within the 7 minute open time of Shell.



Continue until the entire mold cavity is evenly coated. Try to build a minimum of 1/16-1/8" thick layer throughout the mold.



An easy way to build up thickness with out using a ton of Shell is to brush in a layer of Alumilite's 610 Foam. The 610 Foam will add reinforcement as well as wall thickness to the piece. Here we have used approximately 8 oz of A + 8 oz of B of the 610 Foam with a small amount of Brown Dye. Using the brown dye in the foam will give the original orange outside layer a little bit of depth.



Pour a small amount of the thoroughly mixed 610 Foam along the top edge and allow it to flow down.



Using a cheap paint brush (will not be able to salvage), spread the mixed foam throughout the mold until it is all covered.



Continue to brush the foam up the walls until it begins to expand. Then allow the foam to expand and cure.



If you have thin areas of foam, mix up a smaller second batch and concentrate brushing the material on the top edge and in the thin areas. Then allow it to expand and cure.



Once the 610 Foam has expanded and cured, remove the rubber mold from the mother mold and prepare to remove your reproduction.



Peel the rubber mold off of the Skin Coat piece to demold.



You now have a perfect reproduction of your original.



The last thing you'll want to do is to simply trim the flash off of the edge with sharp knife and you are ready to make your next piece. Once it is painted and the stem is added, you will have a beautiful reproduction that will easily withstand outdoor conditions.

