

MOLDCRAFT



"Hammerers"
Wax pattern ready
for casting in bronze
by Lloyd Lillie
Boston

I Molding Materials

9E MOULAGE A flexible molding material popular for making life masks and other molds of delicate objects. Cut up and melt in the top of a double boiler. Prepare a flask around surface being duplicated. Generally no separator is required. Allow MOULAGE to cool to about 110°F. Brush in first coat; brush and pour back-up. Allow moulage to cool. A plaster mother mold may be required on large molds. Can be reused many times.

1 lb carton \$2.20 shipping weight 1 lb 3 ozs

8N WHITE MOLDING LATEX A liquid suspension of rubber particles. Mold is formed by painting several coats of MOLDING LATEX on plaster object to be replicated. Plaster should be sealed by two thin and well-dried coats of PATTERN SEALER. Paint on MOLDING LATEX and allow coat to dry (a fan will speed drying). Eight to sixteen coats are required to make a mold from 1/16" to 1/8" thick. RUBBER MESH can be incorporated after four to six coats to speed building up mold. Apply WAX SEPARATOR (Blue) to latex mold after final coat is dry. Mother piece mold of plaster should be cast before latex mold is removed.

1 qt \$4.00 shipping weight 3 lbs 5 ozs

2M BLACK MOLDING LATEX Similar to WHITE MOLDING LATEX, but containing carbon black. Lays up better on vertical surfaces and makes a tougher mold. Six month shelf life.

1 qt \$4.40 shipping weight 3 lbs 5 ozs

2R GELATINE The traditional material for making flexible molds. Soak one part (by volume) of gelatine in an equal volume of water for at least one hour and preferably overnight. Heat the soaked mixture to 140°F in the top of a double boiler. Add 1/2 part GELATINE STABILIZER for a mold with improved strength and stability. Pour mixture into cavity between mother mold (or flask) and plaster object being replicated. Allow mold to cool before removing mold from plaster. Gelatine molds may be cut up, soaked in water, remelted and cast. Add GELATINE STABILIZER only on the first use.

4 lb carton \$4.40 shipping weight 4 lbs 3 ozs

3B GELATINE STABILIZER A liquid used to improve the strength and stability of GELATINE molds.

1 pt \$1.75 shipping weight 2 lbs

1 qt \$3.00 shipping weight 3 lbs 5 ozs

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COMPARISON OF FLEXIBLE MOLDING MATERIALS

MOLDING MATERIAL	RELATIVE COST	SHRINKAGE on STORING	RESISTANCE to TEARING	PATTERN MATERIALS
2N MOLDING GUM	Medium	High (1)	Low	Plaster
9E MOULAGE	Medium	High (1)	Medium	Wax (2) & Plaster
2R GELATINE	Low	High (1)	High	Wax (2) & Plaster
2M BLACK LATEX	Low	Medium (1)	High	Wax, Plaster Metals (3)
8N WHITE LATEX	Low	Medium (1)	High	Wax, Plaster Metals (3)
2S 9M SILICONE RUBBER	High	Low	Medium	Wax, Plaster Metals (4)

(1) Shrinkage is reduced by storing in a sealed plastic bag containing a teaspoon of water.

(2) Wax should be as cool as possible to avoid damage to mold.

(3) Melting below 300°F.

(4) Melting below 500°F.

Molding Materials (cont.)

2N MOLDING GUM A convenient material for making one or two casts of delicate objects or flesh. Add water to gum until a paste is formed. Pour paste carefully against surface to be duplicated. Sets to a flexible solid in about four minutes. Make plaster casts immediately after mold sets. Will shrink considerably in one day unless stored in a sealed plastic bag with a teaspoon of water. Cannot be reused.

1 lb carton \$3.60 shipping weight 1 lb 3 ozs

IX METAL CASTING PLASTER A plaster for use in the lost wax process. Set up pattern and runners upside down. Apply two coats of WAX WETTING AGENT. Place a rigid flask around pattern. Use 1/3 PLASTER HARDENER to 2/3 water. Add METAL CASTING PLASTER until slurry has a creamy consistency. Include two handfuls of CHOPPED FIBERGLASS and stir in completely. Pour slurry into flask carefully to avoid trapping bubbles. If more than one batch is poured, set in metal hooks to connect parts formed from each batch. Makes a hard, dense mold in about one hour.

Dry mold and remove wax in an oven at 250 - 300°F. Heat molds to 1250°F for 4 to 12 hours to remove last traces of wax and carbon. Molds can be cooled back to 250°F without cracking. Mold must be dry when metal is poured into it.

Those without experience in lost wax casting should not attempt casting without consulting a competent foundryman.

18 lb carton \$2.60 shipping weight 19 lbs 14 ozs

2S Fast-setting

9M Slow-setting SILICONE RUBBER After the syrupy silicone resin and the liquid catalyst are mixed together in the proper proportions, the mixture sets to a rubbery solid. Directions for mixing included in each package. 2S Fast-setting SILICONE RUBBER is workable for 10 minutes and sets fully in about one hour. 9M Slow-setting SILICONE RUBBER is workable for about 3 hours and sets overnight (molds thicker than one inch may take longer). Can be brushed on to produce a thin sheath mold requiring a plaster mother mold, or can be cast into a block mold. 2S Fast-setting SILICONE RUBBER is recommended for sheath molding, while 9M SILICONE RUBBER is preferable for block molds. RUBBER MESH may be incorporated to speed build up of sheath molds.

Silicone rubber molds are dimensionally stable, resistant to chemical attack, and withstand temperatures up to 500°F.

When stored at 70°F, shelf life of uncatalyzed resin is at least four months. Useful life can be extended by storing in a refrigerator.

2S Fast-setting 1 lb \$6.00 shipping weight 2 lbs
9M Slow-setting 1 lb \$6.00 shipping weight 2 lbs

II Pattern Materials

6Z RED PATTERN WAX A wax formula compounded for lost-wax patterns. Adapted to making patterns by hand, rather than by injection molding. Can be slush cast or brushed into molds. Can be modelled after warming. Hard, but responds well to tooling.

1 lb. cake \$1.55 shipping weight 1 lb 2 ozs

7K BLACK MODELLING WAX An inexpensive petroleum wax for general purpose use. Excellent for modelling.

10 1/2 lb slab \$2.75 shipping weight 11 lbs

4R BEESWAX A strained beeswax suitable for modelling, casting or blending. Can be used to make flesh-colored casts.

1 lb cake \$1.30 shipping weight 1 lb 2 ozs

5V PATTERN METAL 158-190 An alloy of bismuth, lead, tin and cadmium which melts between 158 and 190°F. Can be melted in a glass beaker in boiling water. Produces smooth metal casts with good detail. Suitable for patterns, molds and as a solder for parts made of PATTERN METAL 281. Popular for metallizing wooden patterns to increase their resistance to abrasion. Can be used repeatedly simply by remelting.

Proof-casts made with this alloy are smaller than the mold cavity immediately after solidifying and cooling to room temperature. After remaining at 70°F for about 45 minutes, casts will have grown to same size as mold cavity.

2 lb ingot \$4.45 shipping weight 2 lbs 4 ozs

7N PATTERN METAL 281 An alloy of bismuth and tin which, like a pure metal, melts at one temperature. Since the melting temperature, 281°F, is above the temperature of boiling water, it cannot be melted in boiling water, but rather must be melted in an oven. The alloy is suitable for making both patterns and molds. Can be used repeatedly.

Widely used for proof casting molds since it is almost exactly the same size as the cavity after solidifying and cooling to room temperature. Cast will be approximately 2.8% larger than cavity being proof tested which may make removal of proof cast from rigid molds difficult. This expansion makes it handy for anchoring parts for machining or holding embossing dies.

2 lb ingot \$5.75 shipping weight 2 lbs 4 ozs

III Separators

2D METAL SEPARATOR (Black) A release agent providing exceptional release of low-melting metal patterns. Especially effective on metal permanent molds. Wash metal mold thoroughly to remove any greasy film. Warm mold before applying separator. After applying separator, dry mold thoroughly before pouring metal.

one pint \$1.45

2Q Light

7S Heavy PLASTIC SEPARATORS (White) General-purpose silicone separators. Suitable for releasing patterns cast in plastics. Two grades available: **7S Heavy** for sticky resins and complicated molds and **2Q Light** for non-tacky resins and simple molds.

one pint 2Q Light \$1.65

one pint 7S Heavy \$2.40

4H WAX SEPARATOR (Blue) A water-soluble separator for releasing wax patterns. Can be washed off wax patterns with cold water.

one pint \$1.15

6Q PLASTER SEPARATOR (Green) An efficient parting liquid for releasing plaster cast against plaster. Especially compounded for plaster piece molding.

one pint \$1.35

Shipping weight for one pint of any separator: 2 lbs

Our policy is to provide high-quality molding materials in convenient amounts and at low prices. Each item in this catalog is chosen expressly for its suitability in making replicas, models and patterns. The procedures suggested in this catalog are guides only; no guarantee is made of results in any case. Therefore the user should perform his own tests to determine the suitability of these items for his particular use.

SEPARATOR SELECTOR

MOLD MATERIAL	PATTERN MATERIAL			
	Plaster	Wax	Low Melting Metals (1)	Casting Plastics
Molding Gum	4H blue	(2)	(2)	(2)
Gelatine	4H blue	4H blue	(2)	(2)
Moulage	4H blue	4H blue	(2)	(2)
Black Latex	4H blue	4H blue	2D black (4)	(2)
White Latex	4H blue	4H blue	2D black (4)	(2)
Silicone Rubber	7S white (3)	7S white (3)	7S white (3, 4)	7S white or 2Q white
Plastic	6Q green	4H blue	2D black (4)	7S white or 2Q white
Metal	6Q green	4H blue	2D black (4)	7S white or 2Q white
Plaster	6Q green	4H blue (5)	2D black (4, 5)	7S white (5)

(1) melting below 300°F

(2) combination not recommended

(3) pattern may release satisfactorily with no separator

(4) dry mold thoroughly before pouring metal

(5) apply at least one coat of Pattern Sealer before applying separator

IV Molding Accessories

6W PLASTER HARDENER May be used in place of water in mixing plaster, or with water in any proportions. Significantly increases the strength of hardened plaster when used in place of water. Strengthens in proportion to the amount of hardener when used with water. Compatible with most plasters. Always check performance with a small sample before making final cast.

1 qt \$2.50 shipping weight 3 lbs 14 ozs
1 gal \$8.00 shipping weight 12 lbs

4M FIBERGLASS TAPE This packaging tape, one of the strongest available today, has glass fibers running along the length and a strong adhesive facing. Has many uses on a molding bench, such as binding split molds and securing patterns and molds for shipment.

60 yd roll \$3.25 shipping weight 9 ozs

5R STRETCH CORD A strong elastic cord which can be stretched to more than twice its initial length. Ideal for binding the irregularly shaped pieces of a plaster piece mold or a plaster mother mold together while pattern is being poured. A metal fastener for adjusting size of cord loop is included with each length of cord.

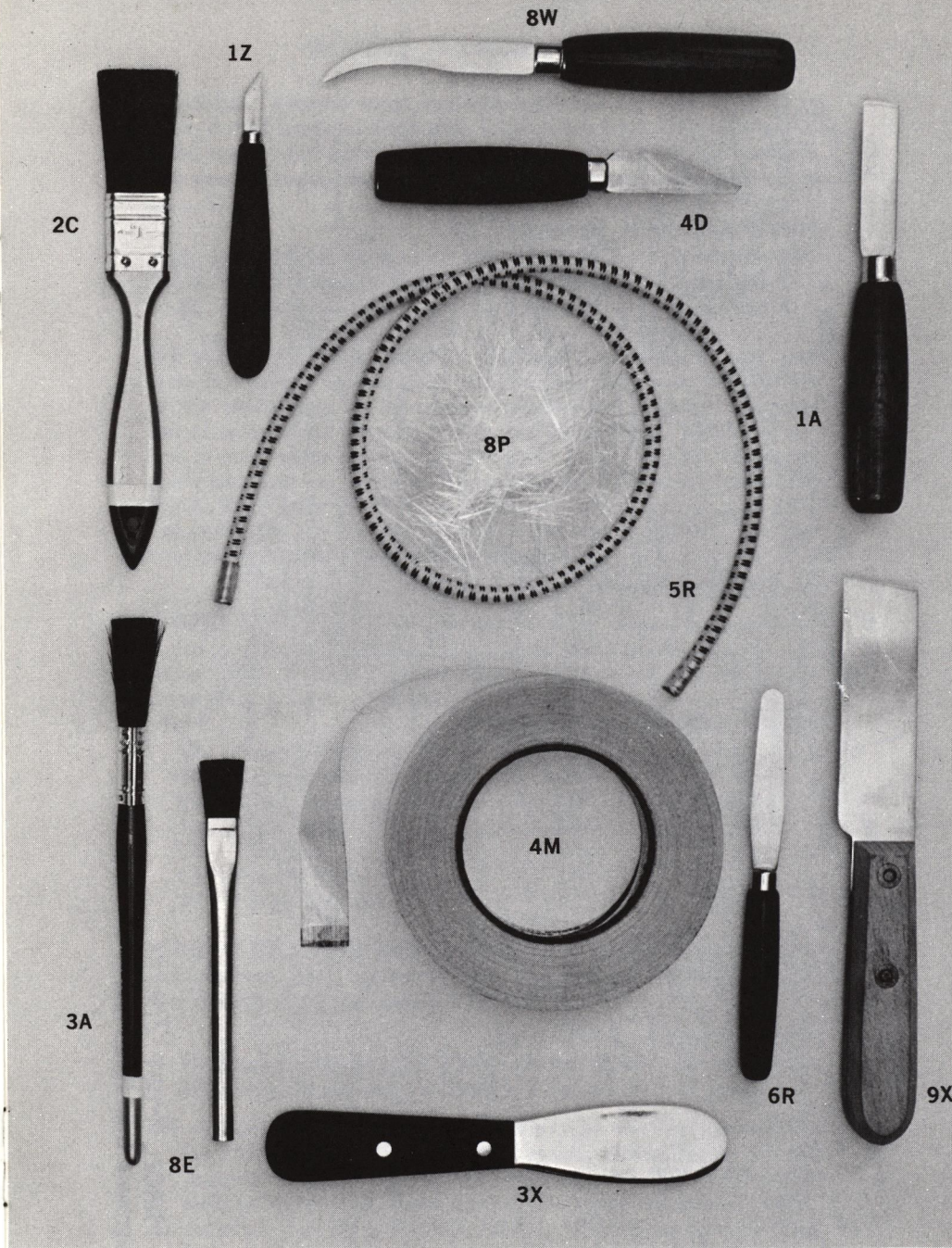
\$.25 per ft shipping weight 1/2 oz per ft

8P CHOPPED FIBERGLASS One-inch lengths of stranded glass fiber. Intended principally for use as reinforcement in rigid molds, such as those of plastic resins or metal casting plaster. Chemically treated to bond firmly to the mold material.

1 lb carton \$1.50 shipping weight 1 lb 3 ozs
10 lb carton \$9.50 shipping weight 11 lbs 14 ozs

3M PATTERN SEALER A premium plastic finish for sealing all porous patterns. Excellent for wood, plaster and papier-mache. Apply one to three thin coats and allow each to dry 4 to 8 hours in a warm place. Forms a hard, but flexible, surface coating. Extends the life of wooden patterns considerably.

1 pint \$2.20 shipping weight 1 lb 13 ozs
1 quart \$3.60 shipping weight 3 lbs 2 ozs



ORDERING

See ORDER FORM for detailed ordering procedure. Send a post card requesting ORDER FORM(S) if more are needed. All orders must be pre-paid, including parcel post charges.

Molding Accessories (cont.)

BRUSHES Because many molding materials are very difficult to clean out of brushes, disposable brushes are best. The brushes offered here are of good enough quality for most work, but inexpensive enough to be discarded after one or several uses. (See photo on p. 8)

	Price	Shipping Weight
8E Large Acid Swab	20 for \$1.00	12 ozs for 20
3A Round Molding Brush	3 for \$1.00	6 ozs for 3
2C Nylon Brush (1")	4 for \$1.00	8 ozs for 4

2H WAX WETTING AGENT Solution is applied to wax patterns in lost-wax casting prior to investing. Improves the wetting of the pattern by the investment plaster and reduces the number of air-bubbles trapped on the pattern surface. Wash pattern well in cold water and liquid detergent. Apply two or three even coats (until the wax pattern whitens slightly). On the first coat, rub WAX WETTING AGENT on any areas which do not coat well. Let each coat dry completely before the next is applied. Let final coat dry completely before investing pattern.

one pint \$1.60 shipping weight 2 lbs

KNIVES AND SPATULAS A selection of knives and spatulas, made by Yankee Craftsmen, are offered. (See photo on p. 8). The knives have and hold excellent edges. All tools are of durable construction.

	Price of One	Shipping Weight
1Z Stencil Knife	\$1.00	1 oz
4D Pattern Maker's Knife	1.05	1 oz
8W Mold Trimming Knife	.90	2 ozs
1A Shoe Knife	.85	2 ozs
9X Chopper	1.80	4 ozs
6R Palette Knife	.50	1 oz
3X Large Spatula	1.25	2 ozs

PLASTIC STORAGE BAGS These bags, made of extra heavy polyethelene sheet, are suitable for dust-free (and moisture-excluding) storage of plaster, gelatine or other types of molds.

	Price	Shipping Weight
7R Small Plastic Bag (20"x24")	5 for \$1.00	15 ozs for 5
5G Large Plastic Bag (24"x36")	3 for \$1.00	12 ozs for 3

4N RUBBER MESH An open mesh rubber matting for reinforcing LATEX or SILICONE RUBBER molds. Build a facing of mold material to about 1/16 to 1/8" thickness. Wash RUBBER MESH well in detergent, rinse and dry. Apply additional mold material, then lay in RUBBER MESH. When layer beneath mesh has set or dried, continue to build over mesh until it is completely incorporated.

\$.90 per sq ft shipping weight 6 oz per sq ft

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PATTERN MAKERS and HOBBYISTS**

MOLDCRAFT

SUMMER SALE

UTILITY SUPPLIES

2M BLACK MOLDING LATEX: Easy lay-up on vertical surfaces.
Makes a very tough mold.

	Cat. Price	Sale Price	Shipping Wt.
1 qt.	\$4.40	\$3.00	3 lbs 5 ozs

2N MOLDING GUM: Convenient material for making one or two casts of delicate objects or flesh.

	Cat. Price	Sale Price	Shipping Wt.
1 lb. carton	\$3.60	\$2.60	1 lb. 3 ozs

9E MOULAGE: Flexible molding material popular for making life masks and molds of delicate objects.

	Cat. Price	Sale Price	Shipping Wt.
1 lb. carton	\$2.20	\$1.45	1 lb. 3 ozs
2 lb. carton	\$4.00	\$2.50	2 lbs 6 ozs

6Q PLASTER SEPARATOR: Efficient parting liquid for releasing plaster against plaster.

	Cat. Price	Sale Price	Shipping Wt.
1 pt.	\$1.35	\$.85	2 lbs

4H WAX SEPARATOR: Water-soluble separator for releasing wax patterns.
Can be washed off wax patterns with cold water.

	Cat. Price	Sale Price	Shipping Wt.
1 pt.	\$1.15	\$.65	2 lbs

BRUSHES: Disposable brushes adequate for most work.

	Cat. Price	Sale Price	Shipping Wt.
8E Large Acid Swabs	20 for \$1.00	20 for \$.55	12 ozs
3A Round Moulding Brush	3 for \$1.00	3 for \$.80	6 ozs

7K BLACK MODELLING WAX: Excellent for modelling or general use.

	Cat. Price	Sale Price	Shipping Wt.
10½ lb. slab	\$2.75	\$2.45	11 lbs

RUBBER BUCKETS: Thick, strong rubber (not plastic). Perfect for plaster work.

	Sale Price	Shipping Wt.
8 qt. (8½" high)	\$1.99	2 lbs 10 ozs
12 qt (10½" high)	\$3.50	5 lbs 10 ozs

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- **Low Prices**
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4W GLOVES: Disposable vinyl plastic gloves.

	<u>Sale Price</u>	<u>Shipping Wt.</u>
4 pairs for	\$.95	4 ozs

2V FLUOROSPRAY (16 or 32 oz. cans): The perfect utility separator.

Teflon-type

	<u>Cat. Price</u>	<u>Sale Price</u>	<u>Shipping Wt.</u>
16 oz. aerosol can	\$2.00	\$1.80	1 lb 8 ozs
32 oz. aerosol can	\$3.00	\$2.70	2 lbs 10 ozs

7P SPRAY SILICONE #2 (20 or 32 oz. cans): An easily applied Silicone parting.

	<u>Cat. Price</u>	<u>Sale Price</u>	<u>Shipping Wt.</u>
20 oz. aerosol can	\$2.25	\$2.00	1 lb 12 ozs
32 oz. aerosol can	\$3.00	\$2.70	2 lbs 10 ozs

2S FAST SETTING SILICONE RUBBER. The modern flexible mold material.
9M SLOW SETTING

	<u>Cat. Price</u>	<u>Sale Price</u>	<u>Shipping Wt.</u>
2S Fast Setting 1 lb.	\$6.00	\$5.20	2 lbs
9M Slow Setting 1 lb.	\$6.00	\$5.20	2 lbs

PLASTIC STORAGE BAGS: Extra heavy plastic for dust-proof and moisture-free storage of molds.

	<u>Cat. Price</u>	<u>Sale Price</u>	<u>Shipping Wt.</u>
7R Small Plastic Bag (20" x 24")	5 for \$1.00	5 for \$.85	15 ozs
5G Large Plastic Bag (24" x 36")	3 for \$1.00	3 for \$.85	12 ozs

2R GELATINE: Traditional material for making flexible molds.

	<u>Cat. Price</u>	<u>Sale Price</u>	<u>Shipping Wt.</u>
4 lb. carton	\$4.40	\$2.80	4 lbs 3 ozs

3B GELATINE STABILIZER: Liquid used to improve strength and stability of GELATINE MOLDS.

	<u>Cat. Price</u>	<u>Sale Price</u>	<u>Shipping Wt.</u>
1 pt.	\$1.75	\$1.15	2 lbs
1 qt. <i>gr</i>	\$1.75 3.00	\$1.95	3 lbs. 5 ozs

Prices do not include postage

Volume discounts do not apply to sale prices

Sale prices in effect until October 1, 1965

MOLDCRAFT catalog sent on request