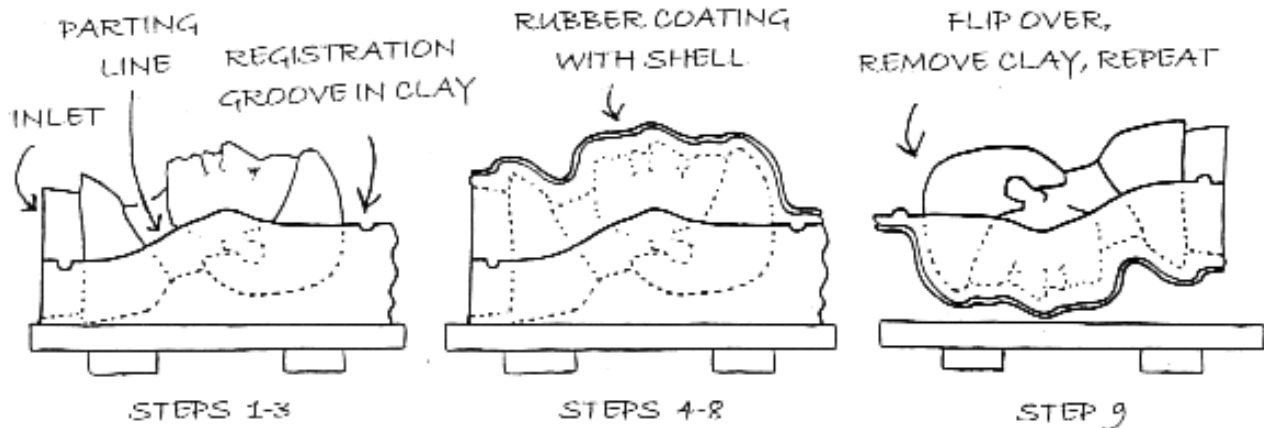


For quick and inexpensive rubber molds, use silicone sealer in 10 oz. rigid caulking tubes:

1. Always prepare your pattern: seal any cracks and attach to a board if necessary.
Determine and note parting lines, and number of mold sections necessary.
2. Build clay around prepared pattern, up to the parting line, including inlet for pour spout.
3. Make a registration groove, or any other keys, in the clay.
4. Apply appropriate parting agent: brush on petroleum jelly and/or use a spray release.
5. Put 1-2 tablespoons of Dawn blue dish-detergent into a bucket of slightly warm water.
6. Spread some Dawn onto your hands as a release agent. Keep repeating during process.
7. Squirt 3 pumps of '**GE Silicone I (not II) 100% Clear Silicone Rubber Sealant, for Windows and Doors.**' caulk into the water. Gather the strands and form a 'patty' in your palm.
Spread over your prepared pattern. Be careful to eliminate air bubbles and avoid water droplets. Repeat above steps as necessary, until at least ¼" thick for small pieces, up to ½" for larger pieces. Several layers of cheesecloth may be imbedded—after applying ¼" layer of silicone. Press pre-cut strips over silicone, then add layers of silicone to encase cheesecloth.
8. When silicone has cured and is firm to the touch, make a plaster-and-jute mother mold.
9. Turn over, remove clay, clean pattern and repeat steps 4-9 for each section.



Multiple-section Polyurethane 'Brush-on' rubber molds:

- Steps 1-4: *Same as above.* Obtain D&S *Brush-On 40* polyurethane rubber or equivalent.
- Step 5: Apply a coat of thin rubber with brush, until about 1/16 inch. Wait 20-30 minutes to firm up.
- Step 6: Apply coats of thick rubber (10 oz. ea.) with spatula, up to 1/4 inch. (Add **1** part 'Kick-It' per **100** parts of B to accelerate the curing time, and mix.) *Then* add **8** parts of **A** per **10** parts **B** by weight (or 10 to 10 by volume). Use 'Dry-It' to prolong shelf-life of Part A.
- Step 7: Allow to cure for 2-12 hours, depending on the amount of accelerator added to part B.
- Steps 8-9: *Same as above.* Note: Apply spray release to polyurethane rubber before adding shell.

RESOURCES: *GE Silicone I: Orchard Supply.* Supplies such as rubber, releases, accelerators, etc: *Douglass & Sturgess, 730 Bryant St., SF, CA, M-F 9-6. 1-888-ART-STUF or www.artstuf.com*