Pour Your Own Production Molds For Injecting Soft Plastics

This process allows you to easily create your own soft plastic injection molds ready for production using Vac Master 50 from Makelure.com. Pouring your own injection molds gives you the abilty to create any lure design you choose for a fraction of the time and price when compared to having parts produced at a machine shop.

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Modeling Clay: Begin by using Scupley Clay to create your originals to mold.

Form Originals: Soften clay by kneeding, role into a ball to remove creases and begin forming your original(s).

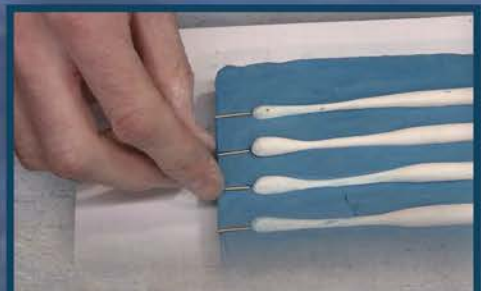
Bake: Bake at 275° F for 15 minutes per 1/4" thickness to harden.

Finishing: Once hardened, sand out imperfections and carve in additional details as desired. You can always add more Sculpey and re-bake if needed.

Claying up originals: Next, embed the originals half way down into a layer of synthetic modeling clay. This will establish the parting line. Push the clay up against the original and begin to establish a straight & clean parting line.

*** The cleaner the parting line, the tighter the seal between the two halves will be which reduces flash on the lures ***

Injection Ports: Next channel in your sprew and injection ports. Again, embed them into the clay half way. We used a section of hot melt glue stick for the main injection channel.



Gate The Tails: To allow the mold to fill completely you must vent the tail. Here we used small segments of .051 gauge stainless steel wire.

Mold Box: Build a mold box around the clay, seal with hotmelt glue, and spray originals and clay with Alumilite's UMR release agent.

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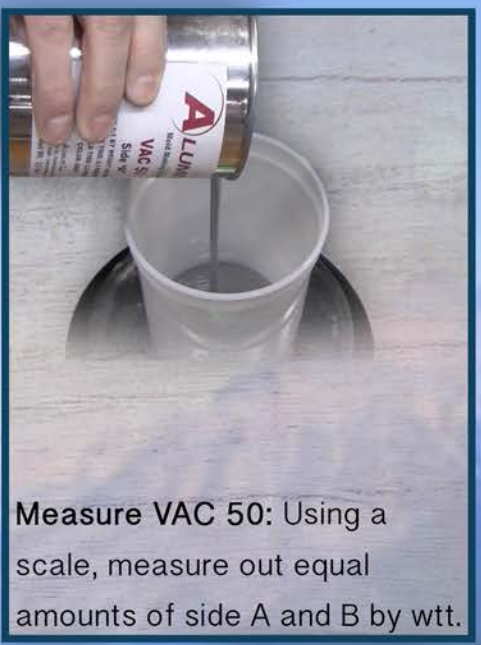
VAC 50 Casting Resin: Vac Master 50 is a high temperature aluminum filled casting material used to make cold cast aluminum molds for injecting soft plastic.

Mix each side of VAC 50: Using separate stir sticks, stir each side and re-suspend any aluminum powder that may have settled to the bottom.



Measure VAC 50: Using a scale, measure out equal amounts of side A and B by wtt.

Mix VAC 50: Combine into a mixing cup and stir thoroughly ensuring to scrape the sides and bottom.

Cast: Slowly pour the resin in to one corner of the mold which allows the resin flow around the master reducing the risk of air entrapment.

Curing & Second Half Prep: Allow VAC 50 to cure for 1.5-3hrs until hard. Turn mold box over, remove base and carefully remove synthetic clay. Do not disturb or remove the originals from the Vac 50.

Clean-Up: Remove all clay away from the originals. Any clay left behind and against the original may cause excessive flash and clean up on the lures.

Locators: Drill shallow ¼" locator holes around perimeter of mold. These will allow the two halves of the mold to align properly.

Release: Apply a liberal coat of UMR mold release all over the surface of the mold and originals. This release prevents the second half of the mold from fusing to the first half.

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Measure & Mix: Measure and mix your second batch of Vac 50.

Cast: If you have a highly detailed master, brush initial coat over originals and backfill with remaining resin.

Demold: Once cured scrape away any overlapping resin and identify parting line. Gently pry apart.

Completed Mold: Originals may break when separating sides.

Remove originals: Remove clay originals from mold halves while being careful not to scratch or damage the mold sufaces.

Sanding: Smooth the edges on the mold by sanding, grinding, or filing until flat and smooth.

Bore injection site: Find a drill bit slightly larger than your injector tip.

Counter-Sink Holes: Drill a counter sink hole at the injection port to accept injector tip approx 1/2" deep.

Mold Release: Prior to injecting your first parts, spray a light coat of UMR release.

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Inject: Firmly clamp mold closed, heat Alumisol and inject mold.

Demold Lures: Remove clamps and separate the mold.

Trim: Trim lures and you are ready to fish.

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