

# INSTRUCTIONS FOR USE



1. Place ring on a flat surface with the raised rim down.



2. Fill the ring with Delft Clay. Compact clay with a hammer.



3. Remove excess clay with a ruler. Turn the clay filled upside down.



4. Press the model halfway into the clay. Press the surrounding clay against the model.



5. Sprinkle the clay filled ring with talcum powder. Brush the talcumpowder over the surface.



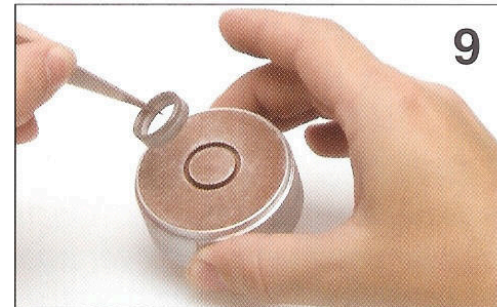
6. Place the second ring on the filled ring with the vertical marks on the two halves aligned.



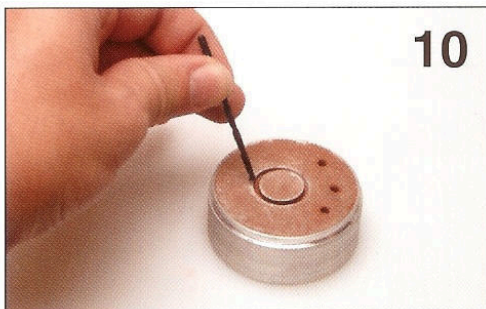
7. Fill the second ring with clay. Compact it with a hammer. Remove excess clay with a ruler.



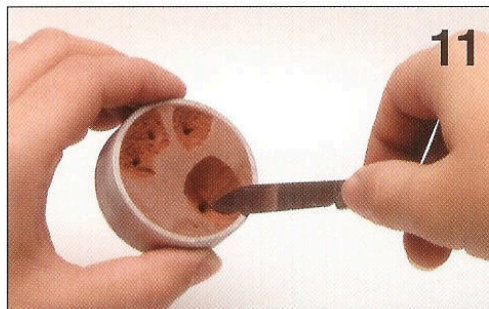
8. Remember to keep the position of the aligning marks together. Replace the rings later in the same position. Separate the rings.



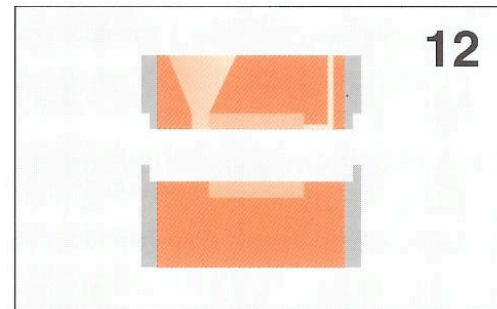
9. Remove model with a pair of tweezers very carefully. If subject is stuck, just move it slightly to make a space.



10. With a small stick pierce a hole for the pouring channel. Make air escape holes opposite the casting channel.



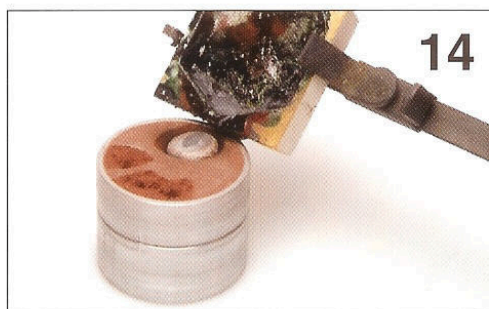
11. Carve the pouring channel into a funnel shape with a penknife and remove all the loose clay. Join the air escape holes to empty mould.



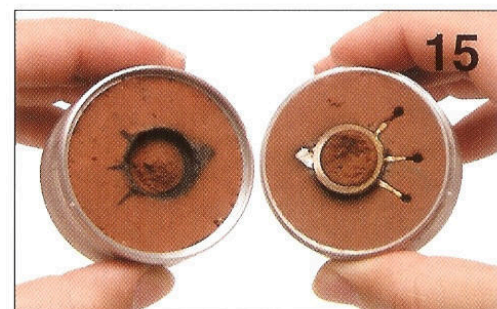
12. The funnel must be connected directly to the empty space. Don't make the funnel passage smaller than 5 mm. Smooth the inside of the casting channel.



13. Place the two parts of the mould together. Replace the vertical marks in the same position. The mould is ready for casting.



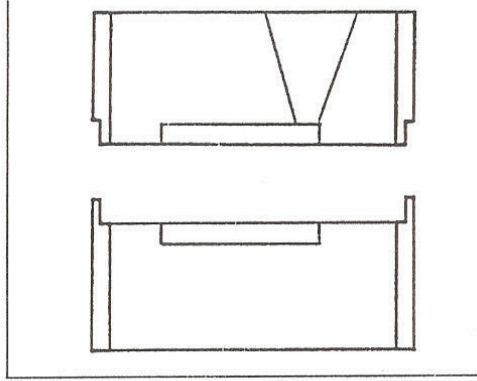
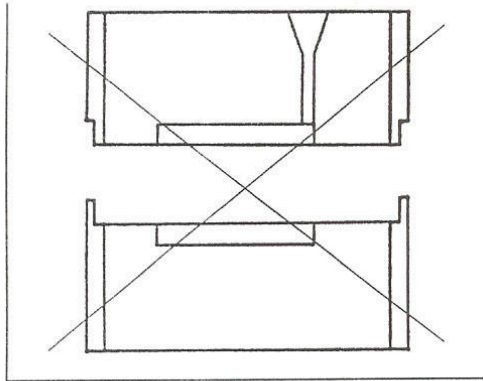
14. While pouring, rest the crucible on the mould. Keep the flame on the molten metal whilst pouring. After casting the mould can be cooled under a tape.



15. The burned clay in the mould must be removed and the remainder of the clay can be used again immediately.

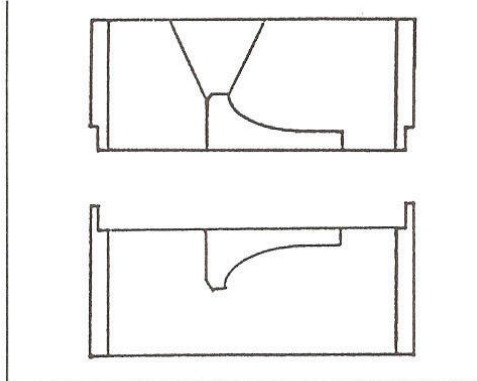
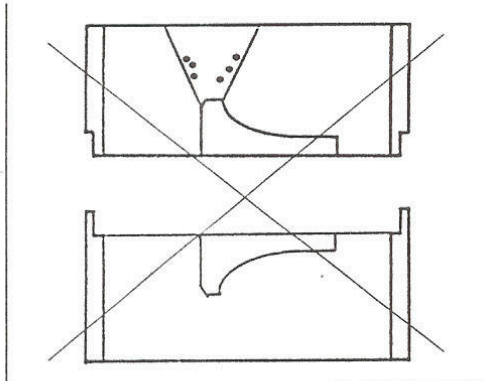
**WRONG**

**RIGHT**

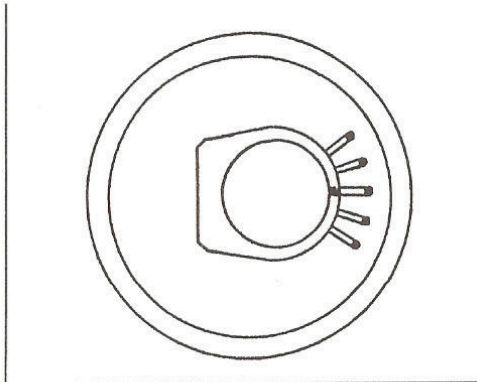
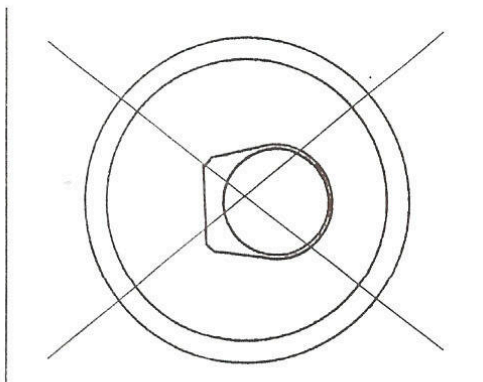


The runner should connect with the hollow space.

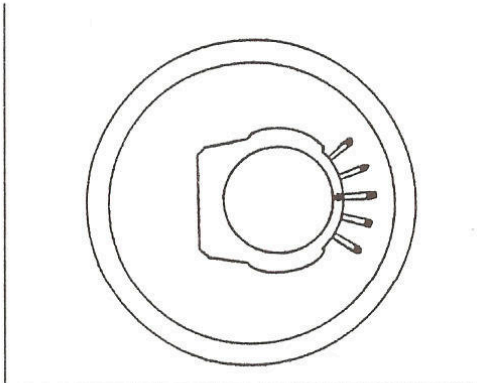
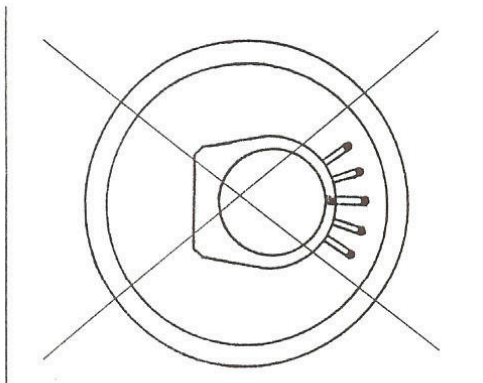
Ensure that the runner is sufficiently wide.



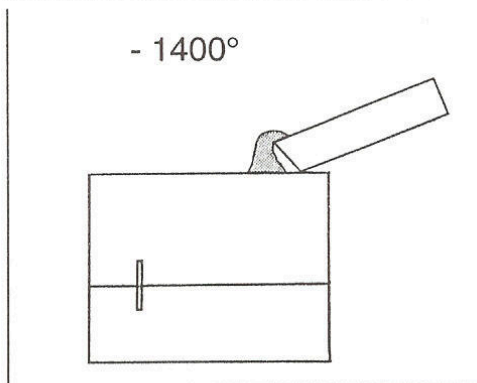
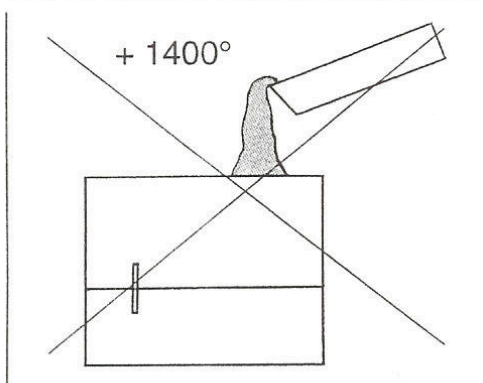
Remove all loose clay particles.



Move thin objects back and forth in the mould to create more space.



If the mould still has not filled up, create more space by cutting away some of the clay.



+ 1400°

- 1400°

Minimize the distance between the mould and the crucible.

Pour very quickly !

Use of metal with a temperature exceeding 1400° results in a rough cast.