

MOLD MAKING INSTRUCTIONS

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707 · 459 · 1483

10 Easy Steps



“The locking system is a godsend for my work”

Jamil Scherief
Seattle, Washington

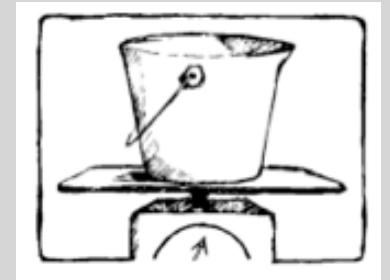


Simplify
the making of lids and plates



Brush or Spray

on a mold release



Weigh

plaster and water
according to the
formulas given



Mix



The large Quick-Release is used for casting with the molds

The small Quick-Release seats on the wheel head

Materials
to assemble

- Mold Soap
- Scale
- Mechanical Mixer
- Pottery Plaster #1
- Bucket
- Window Screen (optional)



The Quick-Release set

Plaster to Water Mixing Formulas

Mold	Plaster in lbs.	Water in lbs.
#1 Dinner Plate	7	5
#1 Salad Plate	3.5	2.5
#2 Lid & Bowl	12	8
#3 Dinner Plate	7	5
#3 Salad Plate	3.5	2.5
10 Flat	3	2
12/13 Flat	6	4
14/15 Flat	8	6
16 Flat	9.5	7
18 Flat	16	11
18 Platter	14	10
18 Bowl		
Slump	29	20
Hump	22	16

TIPS

USE A BARREL TO SUSPEND THE DOMED MOLDS AND THEN LEVEL AFTER POURING

USE FRESH PLASTER AND STORE IN AN AIRTIGHT BARREL

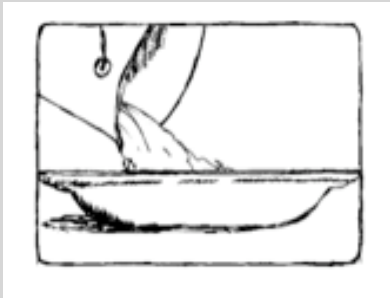
THE BOWLS AND THE SALAD PLATES NEED 3 COATS OF A GOOD MOLD RELEASE

DON'T FORGET TO FACTOR IN THE WEIGHT OF THE BUCKET

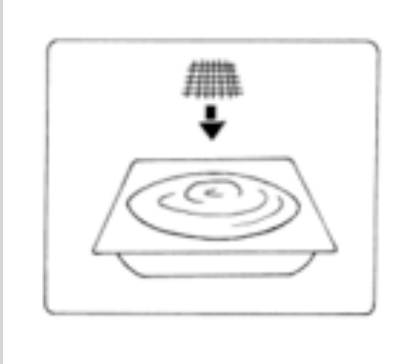
Mold Releases:
 Pure Lube
 Green Soap
 Johnson's Liquid Wax

Recommended Plaster:
 Pottery Plaster #1
 For more information about plaster:
 US Gypsum Co.
 1-800-621-9622

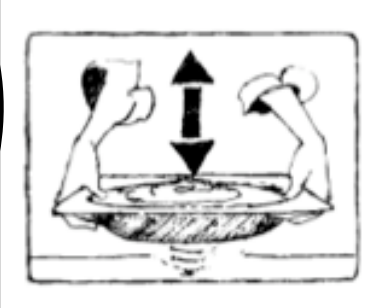
Reinforcing
 Adding a fiberglass mesh like "Scrim Cloth" or window screen will strengthen the flat bats
 Scrim Cloth Source
 Fibre Glast Developments
 800-838-8984
www.fibreglast.com



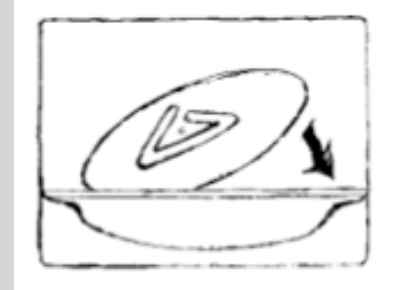
Pour Plaster Into Mold
 when consistency of pancake batter.



Seat Window Screen
 for added strength with the 10 and 12 Flats.



Tap Firmly
 to force out any air bubbles



Seat Quick-Release
 Press outside edge of Quick-Release down to firmly seat it

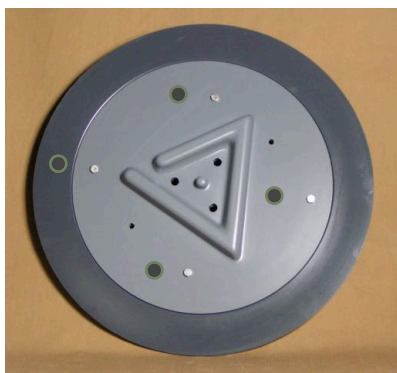
Casting with the 18" Molds

The Quick-Release and the Adaptor are bolted together before casting.

Bolt the two pieces together using four bolts (a good size is 1/4" x 1").

Tip: If you put the bolt head on the raised triangle side of the Q-R then the bolt head can be used to create a hollow impression in the back of the plaster bat when casting. This will then provide clearance of your wheel head bolts and your bats should then rest flat on the wheel head.

Bolt the Quick-Release to the Adaptor



TROUBLESHOOTING

Bat Not Releasing From Mold:

You can soften the plastic mold with a blow dryer, tub of hot water, or in the sun & then remove the bat. (Molds will become more pliable with repeated use).

Bat Wobble:

- Check that your bat is sitting flat and that you have enough wheel head bolt clearance. Carve out the plaster that is preventing it from sitting flat if necessary.
- Another possibility is that you've under-filled the mold of plaster so the Quick-Release won't work properly.

Creases on the face of your plate:

Use a clay paddy the same size as the bat and press clay down, first, before any back and forth movement of the clay

Forms not releasing in 24 hrs:

Give bat thorough drying before initial use.

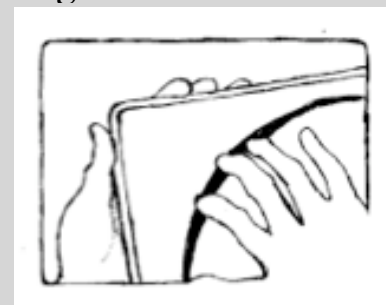
Warping:

- Place the foot of the plate out farther to support rim.
- Compress with a wooden rib.
- Dry plates rim down.
- Slow drying of plates by covering with plastic.
- Increase the angle of the rim with the sponging or carving method if necessary.



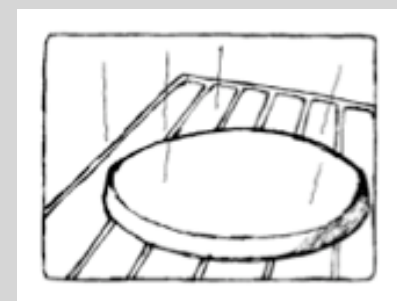
Weight

the center and the outer edge to assure a level cast



Remove Bat

After 30 min. to an hour. Pressing perimeter while turning



Dry Bat Thoroughly

Circulate the air around the bat using a fan until thoroughly dry.

A damp bat will NOT release the clay properly!



DRY PLATES
RIM DOWN ONCE
THEY RELEASE FROM
THE BAT

IT'S A SNAP WITH A DOMED BAT

Mounting the Quick-Release to your wheel head

1. Take out your wheel head bolts and then place the smaller half of the Quick-Release on your wheel head

2. Put your wheel head bolts through the holes in the Quick-Release to attach it to the wheel head and then tighten down the bolts.

Note: If you have wheel head bolt spacing other than 9 or 10 inches on center, or your hole placement doesn't fit exactly perfect, you can re-drill the holes to fit your wheel. You can drill the holes slightly oversize, too, & tighten down with a washer & bolt once you have your bat on dead center.

Creative Options:

Altering Your Molds to Make Them Yours

THE SPONGING METHOD

Sponging method: This is the method of choice if you want to alter the shape a lot, or if you wish to stamp, carve, comb or slip trail.

1. Cut a circular clay slab to fit in the bottom of the mold.
2. Attach the mold to the wheel using a thrown ring of clay to support it, or a Giffin Grip.
3. Sponge and rib the slab into the desired contour.
4. Add a pattern to the slab if you wish.
5. Let clay insert dry until almost leather hard.

6. Brush on a good mold soap & pour

Carving method:

Is useful for making minor changes to the contour of the

1. Carve the bat while the wheel is turning at high speed.
2. Carving is best done when the bat is still somewhat soft: before the thorough drying of step #10.

Some favorite alterations are

To get a nicely rounded lip on your plate it helps to carve a groove in the bat where you want the lip of the plate to be. Matched with a thickening on the back of the plate when throwing, a nicely rounded lip is achieved.

Carving this groove in the bat will also act as a guide to help you throw the same size plate every time.

This thickened and rounded lip will add more style to the plate, and **it helps the plate retain it's shape during firing**



Insert slab and then shape



Stamp, carve or impress



Plaster bat



Finished Dinner Plate



Apply clay paddy to bat. Press straight down with side of your fist to adhere.



Draw clay down and shape foot.



Test for even thickness. Then compress plate with a wooden rib.



Scrape and then sponge rim. No trimming should be necessary.



Pull up knob if forming a lid.

MOLD MAKING INSTRUCTIONS

the **SlumphUMP**



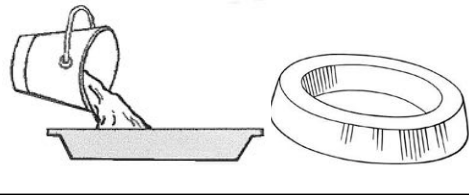
LARGE DECO PLATTER BY MELINDA KIPP

"They are easy to use and produce consistent, professional results."

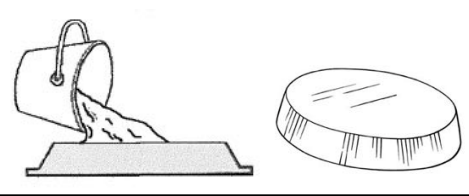
Materials to assemble

- Mold Soap
- Scale
- Mechanical Mixer
- Pottery Plaster #1
- Bucket

Slump



Hump



6 Easy Steps

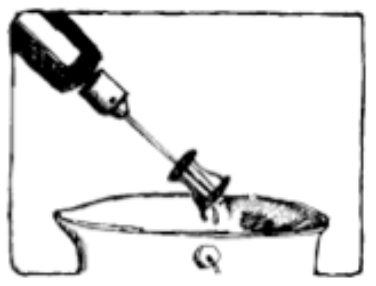


Brush or Spray
on a mold soap



Weigh

plaster and water according to the formulas given, factoring in the weight of the bucket



Mix

for 2 minutes

IF YOU CAN MAKE JELLO.....
YOU CAN MAKE A SLUMPHUMP

PLASTER TO WATER MIXING FORMULAS

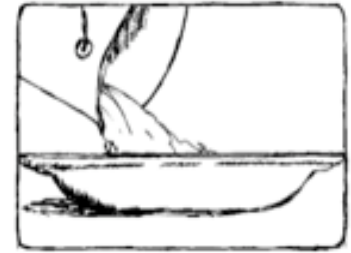
6 Easy Steps

Mold	Plaster in lbs.	Water in lbs.
Large Deco		
Slump	9	7
Hump	5	4
Medium Deco		
Slump	7	5
Hump	3	2
Large Oval		
Slump	11	8
Hump	6	4
Medium Oval		
Slump	12	8.5
Hump	7	5
Curved Oval		
Slump	17	12
Hump	11	8
Large Ellipse		
Slump	12	8.5
Hump	8	6
Medium Ellipse		
Slump	9	6
Hump	4	3
Curved Ellipse		
Slump	15	10
Hump	8	6
Large Oblong		
Slump	12	8.5
Hump	8	6
Large Rectangle		
Slump	12	8
Hump	6	4.5
Medium Rectangle		
Slump	12	9
Hump	10	7
Small Rectangle		
Slump	11	7.5
Hump	5.5	4
Large Square		
Slump	15.5	10.5
Hump	9.5	6.5
Medium Square		
Slump	14.5	10
Hump	10	7
Small Square		
Slump	10	7
Hump	5.5	4
Fish Platter		
Slump	15	11
Hump	13	9

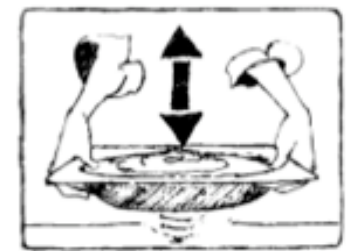
DON'T FORGET TO FACTOR IN THE WEIGHT OF THE BUCKET

USE FRESH PLASTER AND STORE IN AN AIRTIGHT BARREL

MOLD RELEASES:
PURE LUBE
GREEN SOAP
JOHNSONS LIQUID WAX

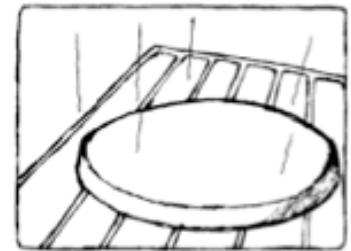


Pour Plaster Into Mold



Tap Mold

firmly to force air bubbles to surface



Remove and Dry

molds thoroughly. A pilot light in an oven works well.



Our Molds..... Your Imagination!

S lump mold work sequence



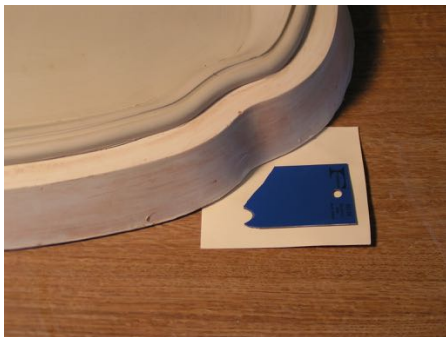
Smooth Slab



Ease Slab into Mold



Define the Angles



Finish the Rim - Bevel Tool



Variety of Texture Tools

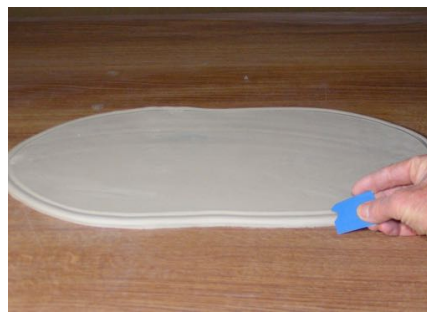


Textured and Slip Decorated

Hump mold work sequence



Cut slab around template



Bevel Rim with bevel tool



Add A Foot



Add Handles or Lugs

BEVEL TOOL
MAKE YOUR OWN RIM
FINISHING TOOL WITH
A FORMICA CHIP & A
ROUND FILE
OR VISIT OUR
"CUSTOMIZING" PAGE
AT
WWW.PSPOTTERY.COM

THE SLUMPHUMP IS REVERSIBLE!

More Creative Possibilities

Diminishing the Depth of Your Mold or How to Turn a Baking Dish Into A Platter

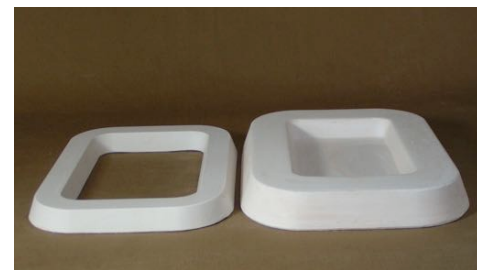
Here's One Way

1. Apply a mold soap to the mold
2. Mix and Pour plaster into the mold to the depth you desire the platter to be.
3. Insert scrim cloth into plaster to strengthen
4. Shake mold to level plaster surface

This will give you a “donut” shaped mold that will need a masonite or plastic bat to form the base. This donut can be hung from a hook to

Here's Another Way

1. Apply a mold soap to the mold
2. Pour plaster mix into the mold to the depth you desire the platter to be
3. Shake to level and let set up
4. Apply 3 coats of mold soap
5. Pour plaster mix on top of previous layer and let set up
6. Separate the two plaster forms



Changing the contour or the shape of your mold



Coil inserted in floor of mold to make the angle of the sidewall less steep for another platter option

Modified mold, on the left while the unmodified is on the right (with a steeper angle to sidewall)

You can add clay to the corners and then pour it to change the shape

Finished Platter