

Two Methods for Making Multi-piece Polyester & Fiberglass Jackets for Latex Molds

Before proceeding with either of these methods, determine the number and edges of the sections that will be necessary for the safe removal of the jacket.

It may be necessary to fabricate resin blocks to eliminate undercuts.

1. Identify those areas within the mold that will require blocks. This is done in together with the design of the subdivisions for the jacket as a whole. Some undercuts may require more than one block.

2. Using Butcher's Wax as a separator brush the wax into the undercut area. The use of a spray release such as Syn-Air Syn-lube 531 over the wax will enhance the release of the block.

3. Make a thick paste-like mixture of resin and talc. Fill the undercut with this mixture smoothing out the external side of the block with a spatula. Dipping the spatula in acetone will make this easier.

4. Insert a 1 1/2" wood screw that has been generously coated in Butcher's Wax into the center of the block up to the unthreaded screw shaft. The resin should be thick enough to hold the screw in place. The screw will act as a pin between the jacket and the block.

5. Remove the block before it has fully set, because of the extreme heat created by resin in bulk.

6. Remove the screw. Sand and file the block to a smooth finish. Any discrepancies in the surface could act as locks against the mother jacket. The block is much easier to deal with in this manner before the resin is fully set.

7. Replace the finished block into the mold and reinsert the screw. Rewax the entire block and the screw and spray with spray release. It is important to fill in any gaps around the screw or the block with more wax or with clay.

8. When creating the jacket avoid the screw head. When the jacket is completed remove the screw, lift off the jacket and remove the block.

Method #1 for Polyester Jackets

1. Create a clay wall approx. 2-3" high to segregate the first section. This wall when finished will act as a backing for the next subdivision, which abuts it. Place clay locks on the wall for registration.
2. Apply a generous amount of Butcher's Wax to the first section to be fabricated, excluding the clay wall.
3. Make a mix of polyester resin, thickened slightly with talc. Brush onto the first section. Allow this to nearly set up and then apply another layer of slightly thickened resin.
4. Immediately apply 1/2 ply fiberglass torn or cut into appropriately sized pieces over entire area.
5. Using a mix of slightly thickened resin, drizzle resin onto fiberglass. Tamp down resin with a brush continually wetted with resin, being careful not to pool the polyester.
6. Without waiting for the last layer to set up apply a final coat of resin-talc mixture, being careful to create a smooth a surface as possible.
7. After resin has set, remove the clay wall. Gently lift jacket and remove completely. If the mold is fairly flat or simple using a screwdriver to lift the jacket will suffice. However, if there is too much resistance the creation of a puncture hole in the middle of the jacket, into which compressed air (such as Dust-Off) is blown will facilitate the release of the jacket from the mold.
8. File down any rough edges and replace the jacket on the mold. If necessary apply more Butcher's Wax before the jacket is slid back on.
9. Proceed with the next section, using the already completed wall as a divider. Brush a generous application of Butcher's Wax on the latex, and also on the new wall.
10. Repeat the process as above, loosening each section as it is completed. With all pieces in place, drill holes through section walls so that pieces can be bolted together to provide a solid jacket.