

Replicating Rock With Polyurethane Molding Method

This process starts with a latex of silicone mold taken from a natural rock formation. If you are replicating a single boulder, you will need to construct a "cradle" to support the sides of your mold. For information on MAKING MOLDS, contact your Chemline Representative.



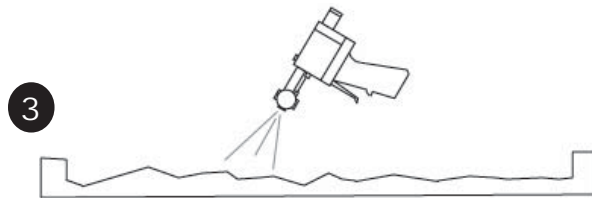
STEP ONE - Mold Release

Apply a mold release to the silicone of latex mold. Wait for the material to thoroughly dry. Approximately 5 minutes dry time.



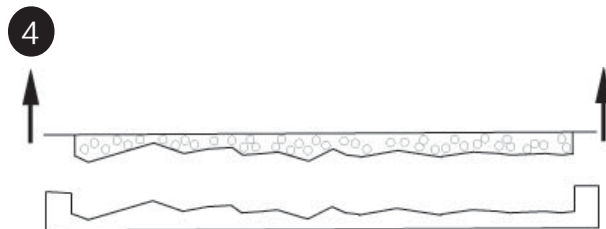
STEP TWO - In Mold Coating

Apply CHEMTHANE 1600 (in-mold coating) to the mold. Wait for the material to thoroughly dry. Approximately 5 minute dry time.



STEP THREE - Structural Resin

Apply CHEMTHANE 7465 into the mold. Take time to completely wet out the mold, taking in account any deep contours of undercuts. Wait 5-25 minutes for the structural resin to thoroughly cool down before removing the part from the mold.



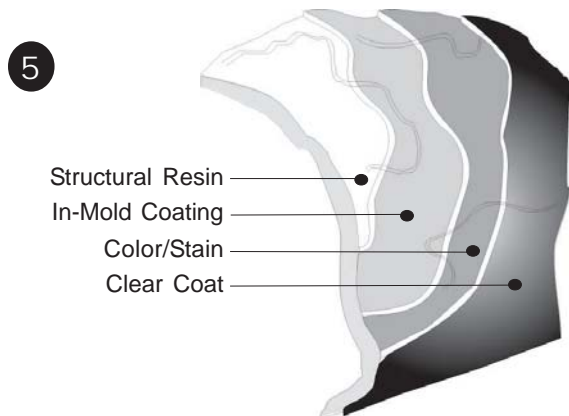
STEP FOUR - Demold

Remove the part from the mold after 5-20 minutes.

STEP FIVE - Coloring/Post Finish

OPTION 1: Pour approximately four (4) ounces (118ml) of CHEMTHANE 1650 in a small cup gun. Add a 1-2 teaspoons of powder pigment to cup and mix. You can now spray apply the pigment to the rock face.

OPTION 2: Mix approximately 1 ounce (30ml) of CHEMTHANE 1600 in a small paper cup with 1/4 teaspoon (5 ml) of powder pigment. Drip a small brush or the corner of a cloth into the mixture and wipe the rock face with in a horizontal motion. Wipe excess liquid off the face of the rock with a dry cloth.



STEP SIX (optional) - Clear Coat

Apply CHEMTHANE 3350, a clear aliphatic top coat to resist yellowing, fading and wear. Dry time: 30 minutes.

FINAL CONSTRUCTION (Optional)

If this is a climbing/decorative wall or large scenic element (playground fixture, stage prop, etc), apply a structural backing material such as high density polyurethane foam or chopped fiberglass. For large rock formation you should wait to apply the backing until the parts are pieced together on a frame work.