



# How to make a mould

 **CRESTAMOULD®**  
Matched Tooling Systems



**SCOTT BADER**  
Making a **positive** difference

# How to make a mould with Crestamould

## Step 1: Test

Before initial start of mould, we advise a pot life test on all materials to ensure adequate/sufficient working times.

## Step 2: Preparation

Make sure the plug has been sealed & appropriate release agents have been used and that the mould is dust free.

## Step 3: Temperature

Mould, room and products should all ideally be between 18°C-20°C.

## Step 4: Materials

All materials should be stirred prior to use.

## Step 5: Gelcoat brush procedure:

Add 2% catalyst (MEKP) to the gelcoat. Brush 2 layers in total giving 400-500 microns per layer. Making sure that the first layer has cured before applying the second layer of tooling Gelcoat.

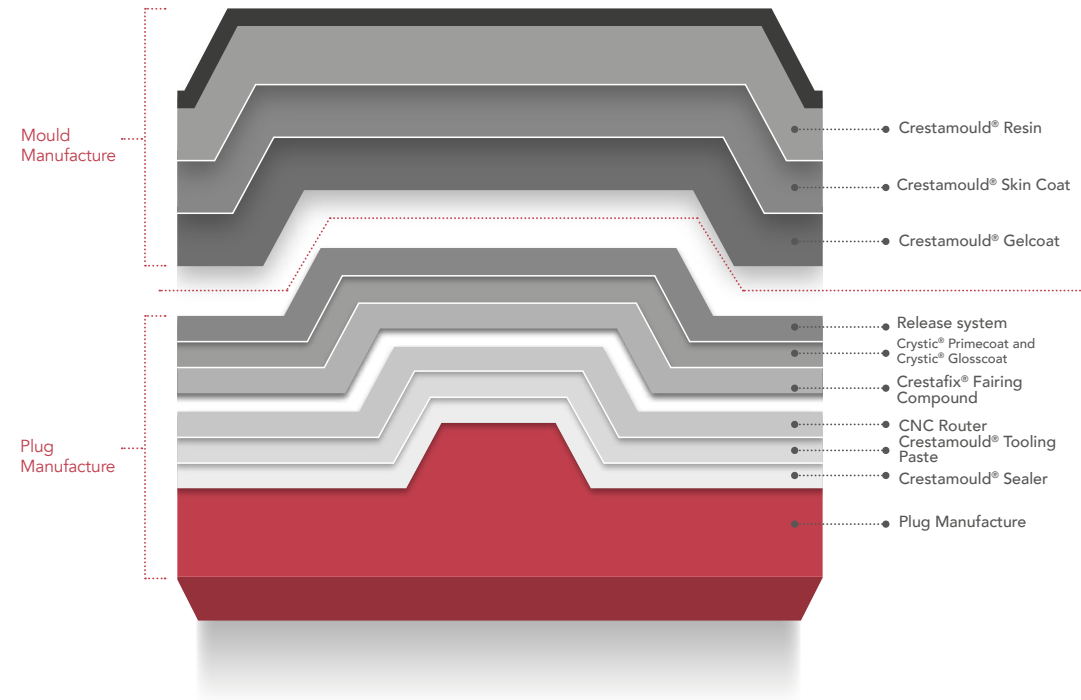
## Step 6: Spray procedure

Add 2% catalyst (MEKP) to the gelcoat, apply a mist coat initially over the area leave for 30 seconds, then follow with a number of passes to build up a thickness between 600 800 microns. Once the tooling Gelcoat has cured tack free (check recesses) you can move on to the skincoat using VE679PA or VE690PA.

**PLEASE NOTE:** A reminder that steps 6-8 (the skincoat) should be carried out in the shortest time possible (maximum 24hrs), with the first layers of RTR also being applied within 24hrs after the skincoat application has cured.

## Step 7: Skincoat

Before starting the skincoat make sure the gelcoat is dust free. Apply the skincoat using 2% Catalyst (MEKP), apply as a minimum 1 layer of 300g or 450g CSM, making sure that all of the CSM is completely wet out with the skincoat resin. Again leave until the resin has cured and returned to ambient temperature (this is depended on ambient working temperatures).



### Step 8: RTR 4010PA preparation

Mould should be dust & contaminate free, you may also want to give the surface a light abrade with sand paper to remove any high spots (acetone wipe if possible ensuring that mould is dust free).

### Step 9: RTR 4010PA

Minimum of 3 layers of 450g CSM are used per level, 600g may also be used. Material must be weighed to ensure the correct ratio of glass to resin and catalyst is used. Recommended glass to resin ratio is 3:1, at this stage add 1% catalyst (MEKP) to the RTR 4010PA. Care must be taken that the catalyst is mixed in correctly, otherwise uncured areas may be seen.

### Step 10: First application

Wet out the cured skincoat layer of the mould completely prior to glass application. Once the first layer of 450g/600g is laid, add more RTR 4010PA until a good coverage has been made, consolidating glass and continue to do so, it is important that you consolidate between each layer with metal fin rollers to remove any air voids. Poorly consolidated area's may fail to cure completely thus leaving soft spots in the mould.



### Step: 11

Allow RTR 4010PA to reach it peak exotherm and return to ambient temperature. Once the mould has done this, the process can be repeated. This can be repeated a third time if necessary, once the mould has exothermed and again returned to ambient temperature.

### Step: 12

If strengthening of the mould is needed (metal or wood) please talk to your mould designer, these can be fixed/overlaid with GRP resin.

### Step 13: Post Cure

For longevity of the mould, it is better to post cure on the plug @ 24 hours ambient temperature & 16 hours @ 40°C.

**PLEASE NOTE:** Other post cures options are available, please contact our technical support team for further advice. If post curing is not an option, at the very least the mould should stay on the plug at least 7 days at ambient temperature preferably between 18°C-25°C.

### Step 14:

Once the mould has been postcured, mould cleaner, sealer and release agent must be applied using guidelines from their manufacturer.



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