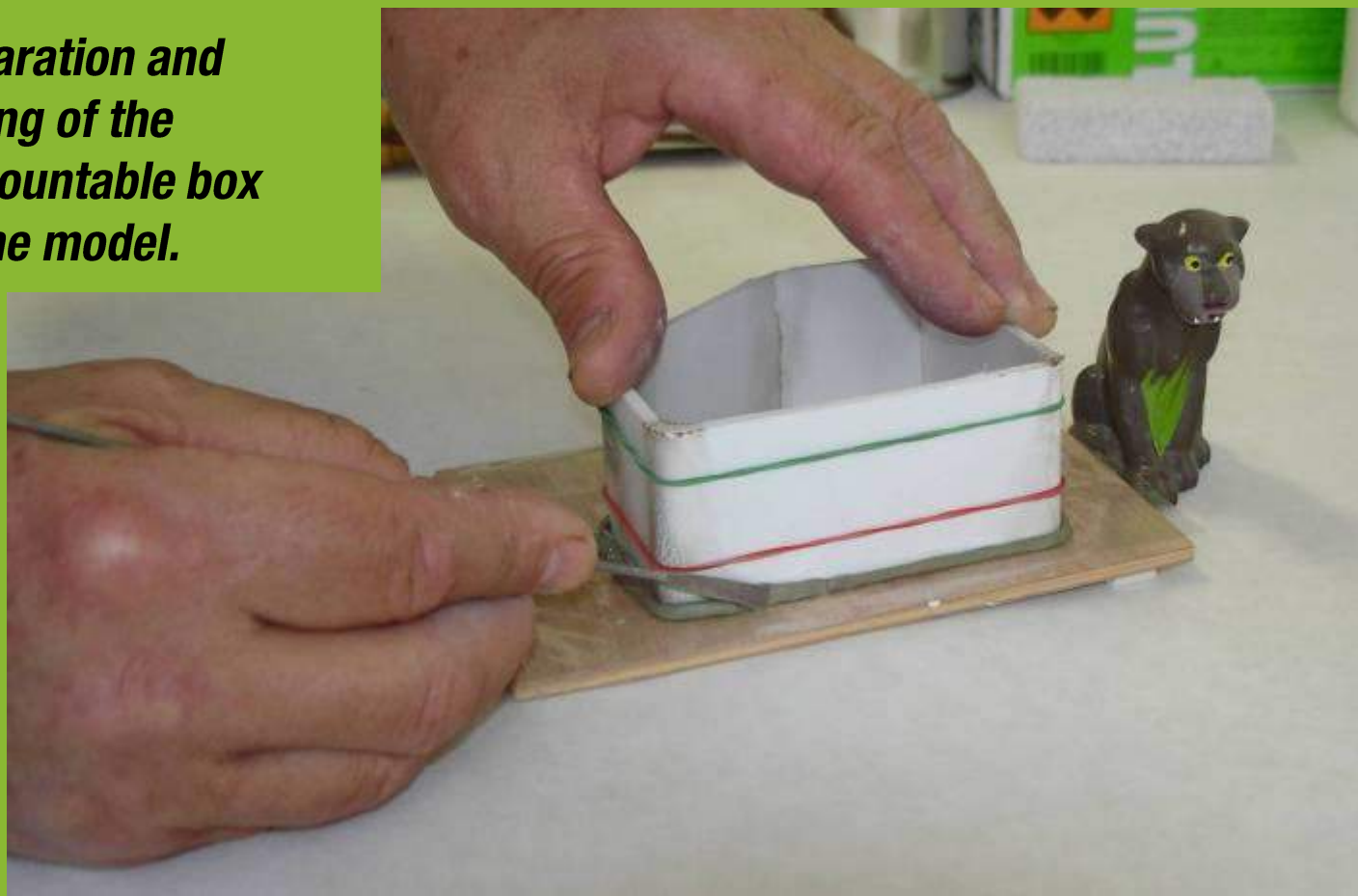


LUKOPREN N SUPER

Production of two-part mould

*Preparation and
sealing of the
dismountable box
for the model.*



LUKOPREN N SUPER

Production of two-part mould



*Separation coating
inside the box using
Lukopren Separator
(easier demoulding).*

LUKOPREN N SUPER

Production of two-part mould

*The necessary amount of the homogenized **Lukopren N** is weighed into an appropriate, ideally plastic container .*



LUKOPREN N SUPER

Production of two-part mould

*The prescribed amount of the **Lukopren katalyzator N** is added to the weighed rubber paste **Lukopren N** (thorough mixing of both components)*



LUKOPREN N SUPER

Production of two-part mould

*Forming the mould bottom (maximum thickness of 0.5 cm). Before pouring another rubber paste **Lukopren N** the bottom is allowed to vulcanize to a non-sticky state.*



LUKOPREN N SUPER

Production of two-part mould

*Separation coating
of the model using
Lukopren Separator
- easier demoulding.
(Let it dry).*



LUKOPREN N SUPER

Production of two-part mould

*Production of the first
mould part, **Lukopren N**
is weighed into the
auxiliary mixing
container.*



LUKOPREN N SUPER

Production of two-part mould

*Dosing of pigment
paste for colouring
rubber
(for visible resolution
of the described parts
mould - not
necessary)*



LUKOPREN N SUPER

Production of two-part mould



*Thorough mixing of **Lukopren Katalyzátor N** with coloured **Lukopren N**.*

*To remove air bubbles
- can be shortly
evacuated after
mixing up the
catalyst.*

LUKOPREN N SUPER

Production of two-part mould



*Production of the first mould part, **Lukopren N** is slowly pouring – easier to leave of bubbles*

LUKOPREN N SUPER

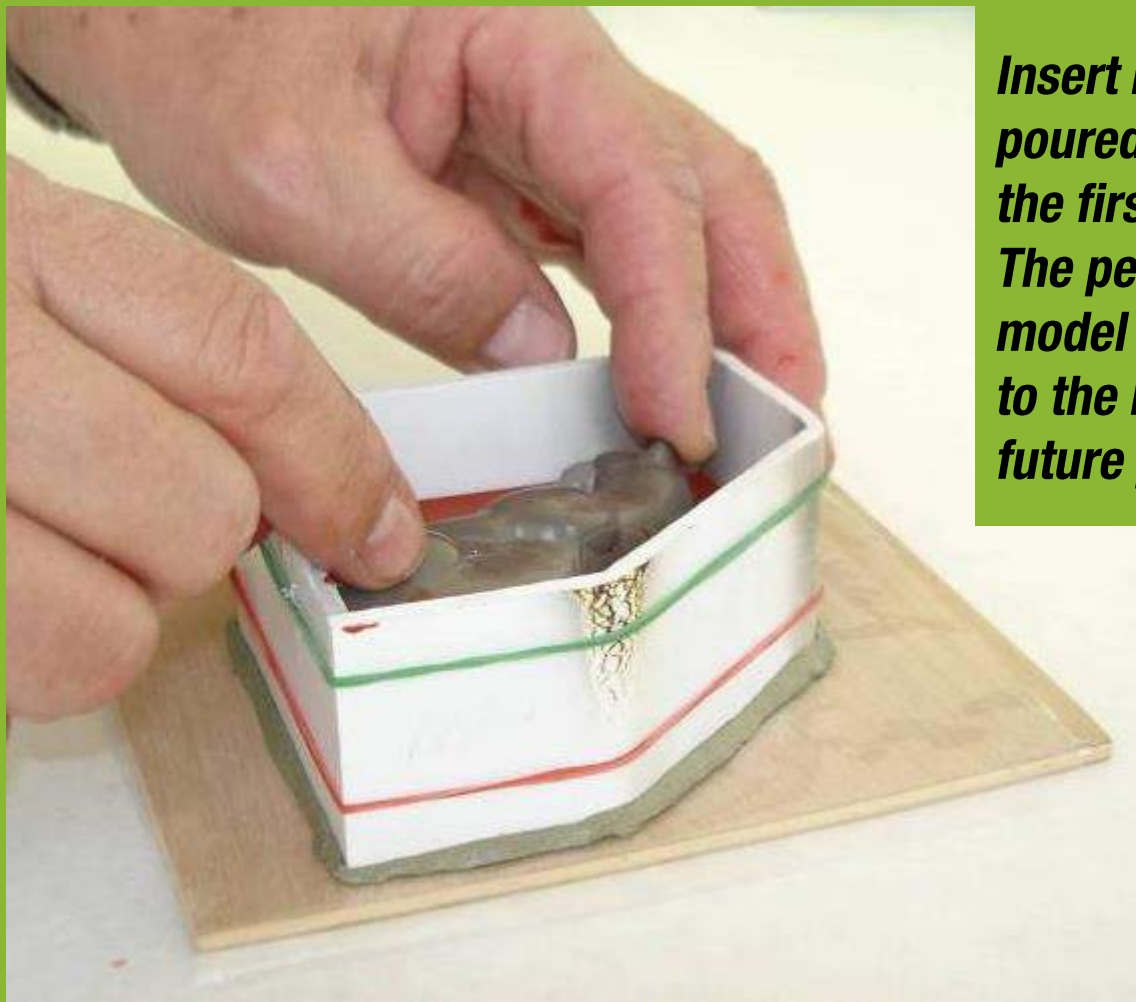
Production of two-part mould



Just poured part of the first mould part before inserting the model. Removing air bubbles by piercing.

LUKOPREN N SUPER

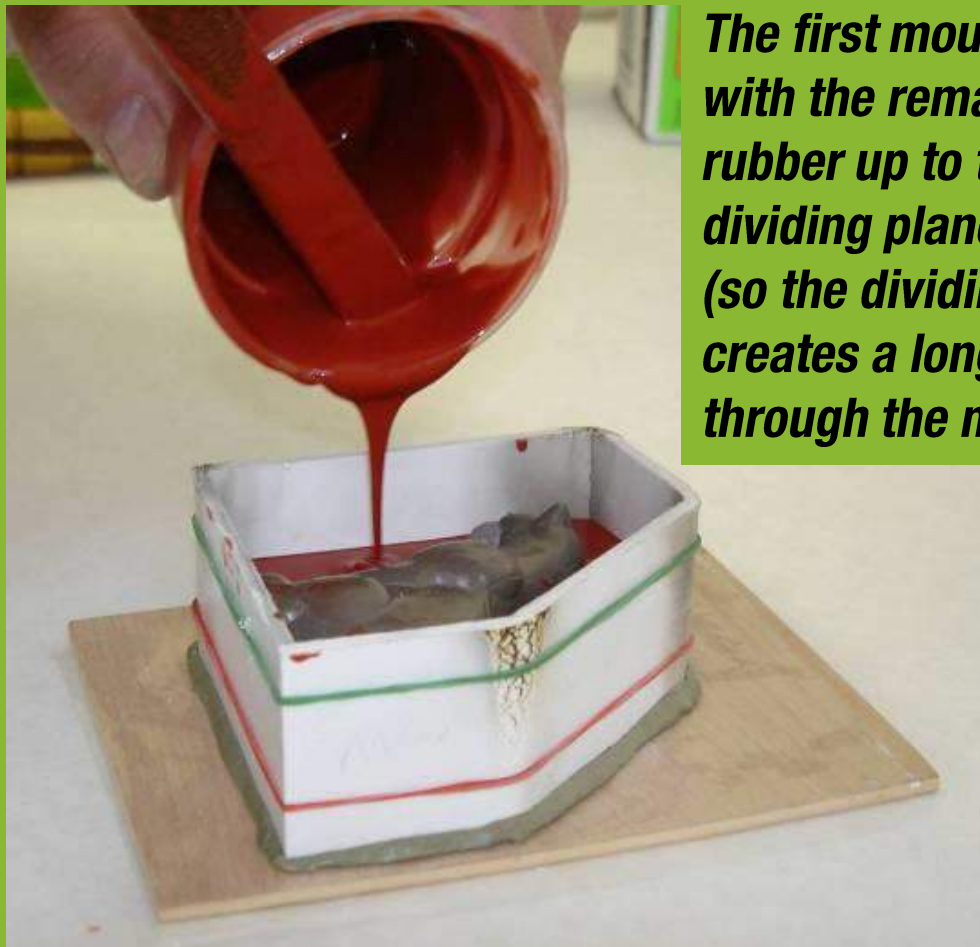
Production of two-part mould



Insert model into the poured layer of the first mould part. The pedestal of the model is attached to the box wall - the future pouring hole.

LUKOPREN N SUPER

Production of two-part mould



The first mould part is filled with the remainder of the rubber up to the intended dividing plane (so the dividing plane creates a longitudinal cut through the model.

LUKOPREN N SUPER

Production of two-part mould

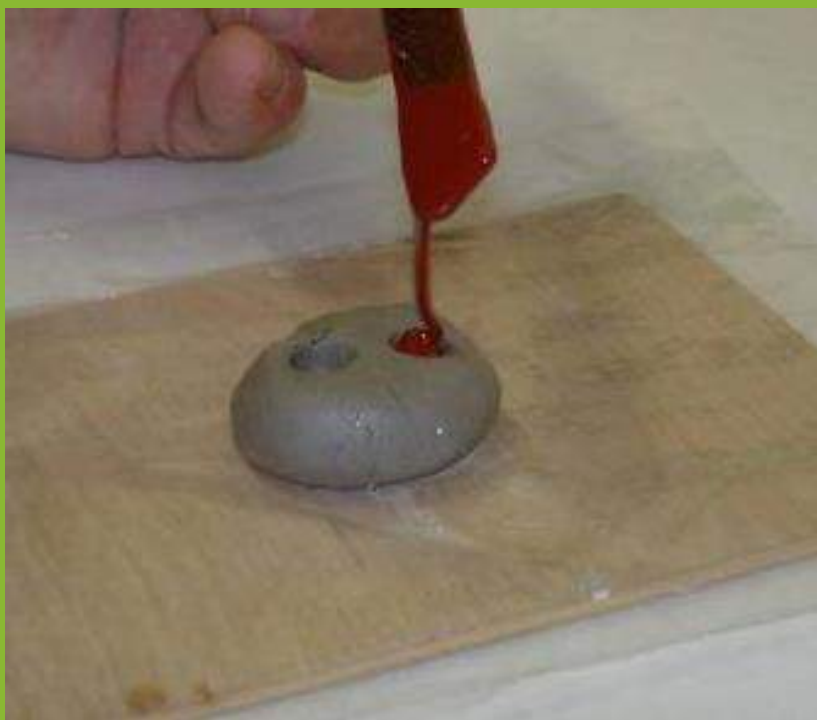


One of the methods of create mould locks. In the auxiliary modeling mass, a suitable shape of the locks is created.

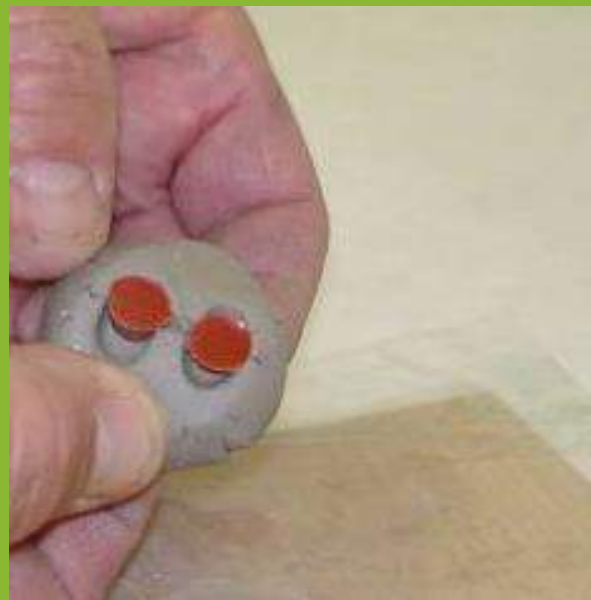


LUKOPREN N SUPER

Production of two-part mould



Lukopren N is poured in modelling clay. Ready locks are released after the curing.



LUKOPREN N SUPER

Production of two-part mould



*Sticking the locks to
the vulcanized
dividing plane of the
mould.*

LUKOPREN N SUPER

Production of two-part mould

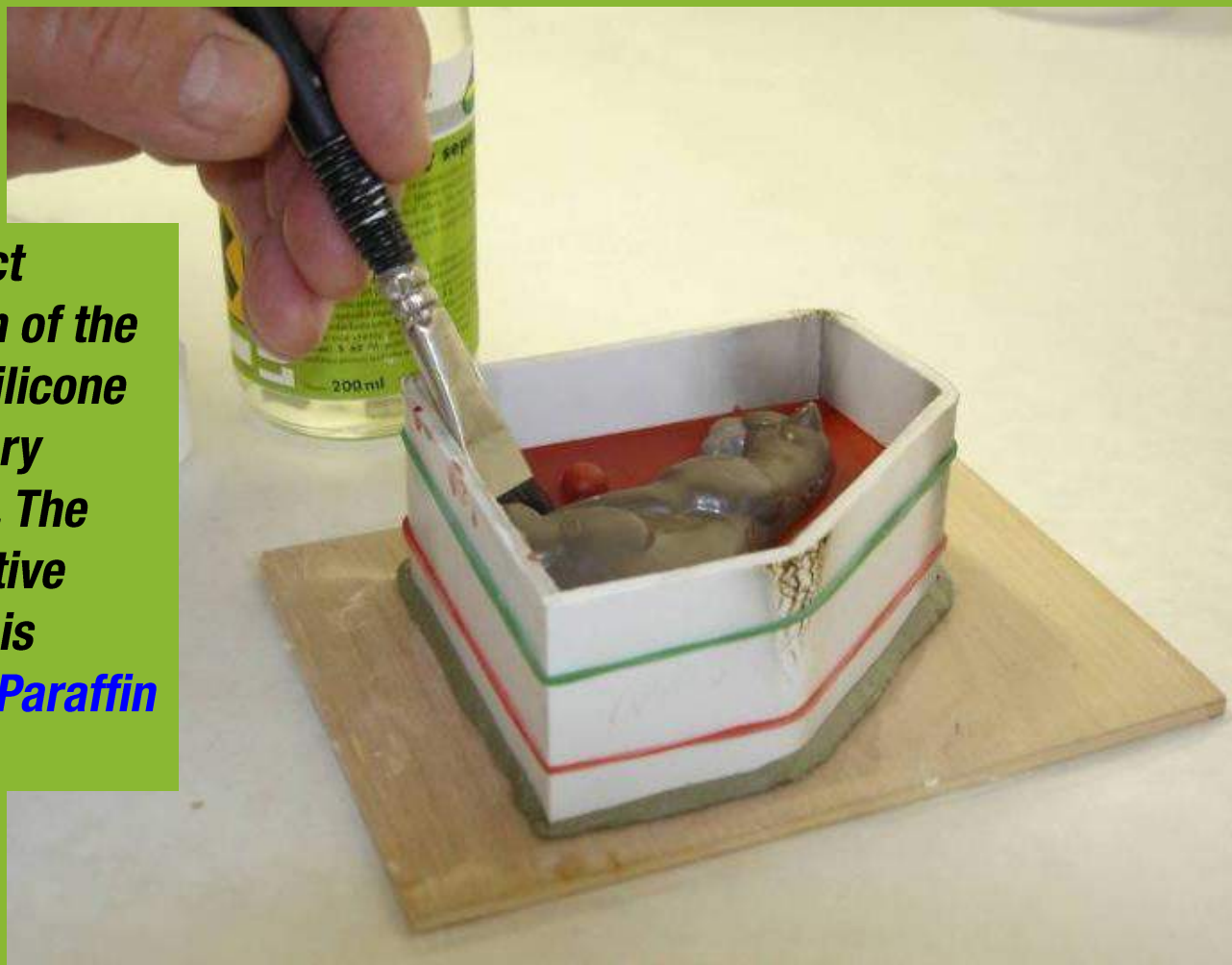
*Locks from cured rubber are bonded to the dividing plane of the first part using **Lukopren S 6410**.*



LUKOPREN N SUPER

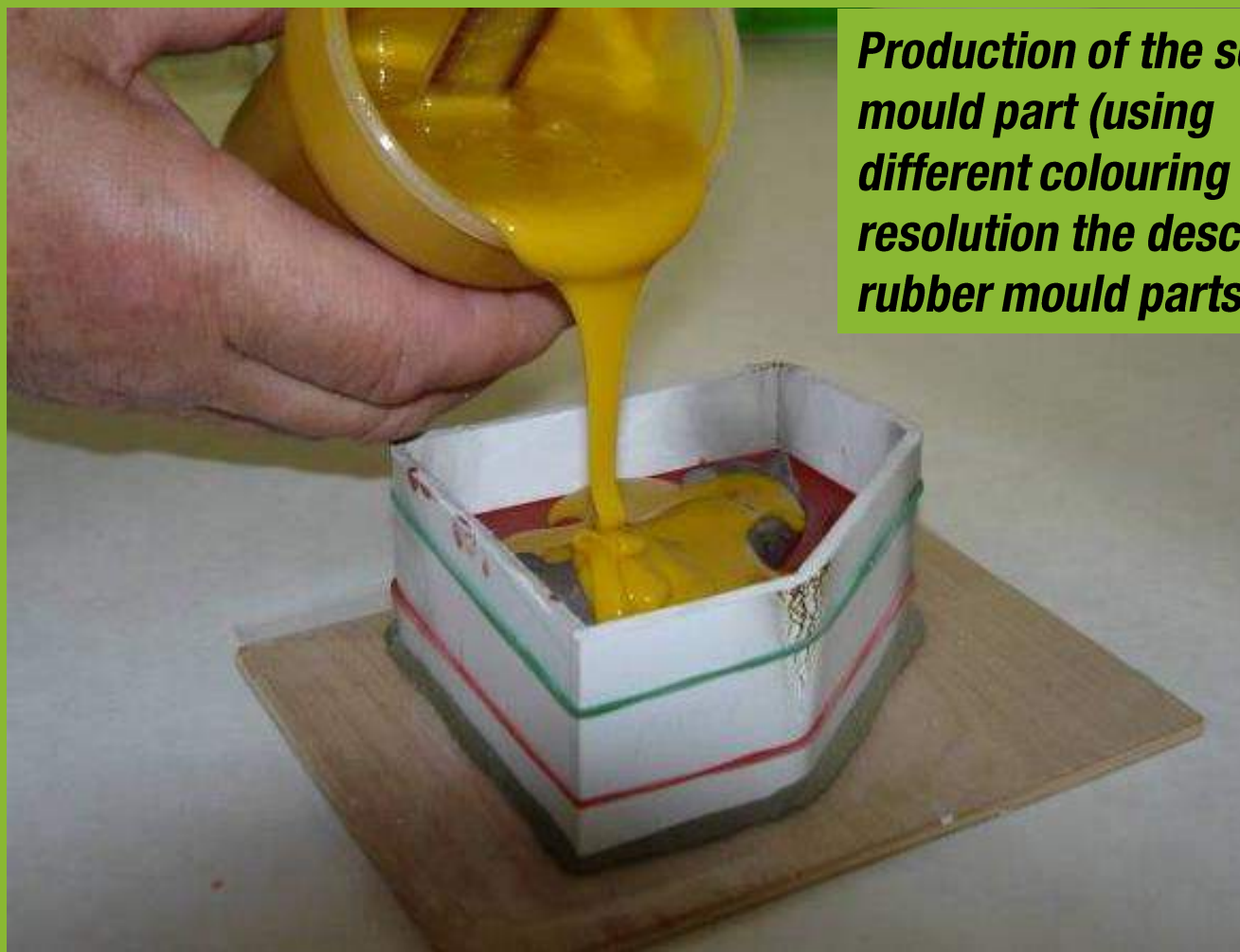
Production of two-part mould

*The perfect separation of the silicone-silicone bond is very important. The only effective separator is **Lukopren Paraffin separator***



LUKOPREN N SUPER

Production of two-part mould



*Production of the second
mould part (using
different colouring to
resolution the described
rubber mould parts).*

LUKOPREN N SUPER

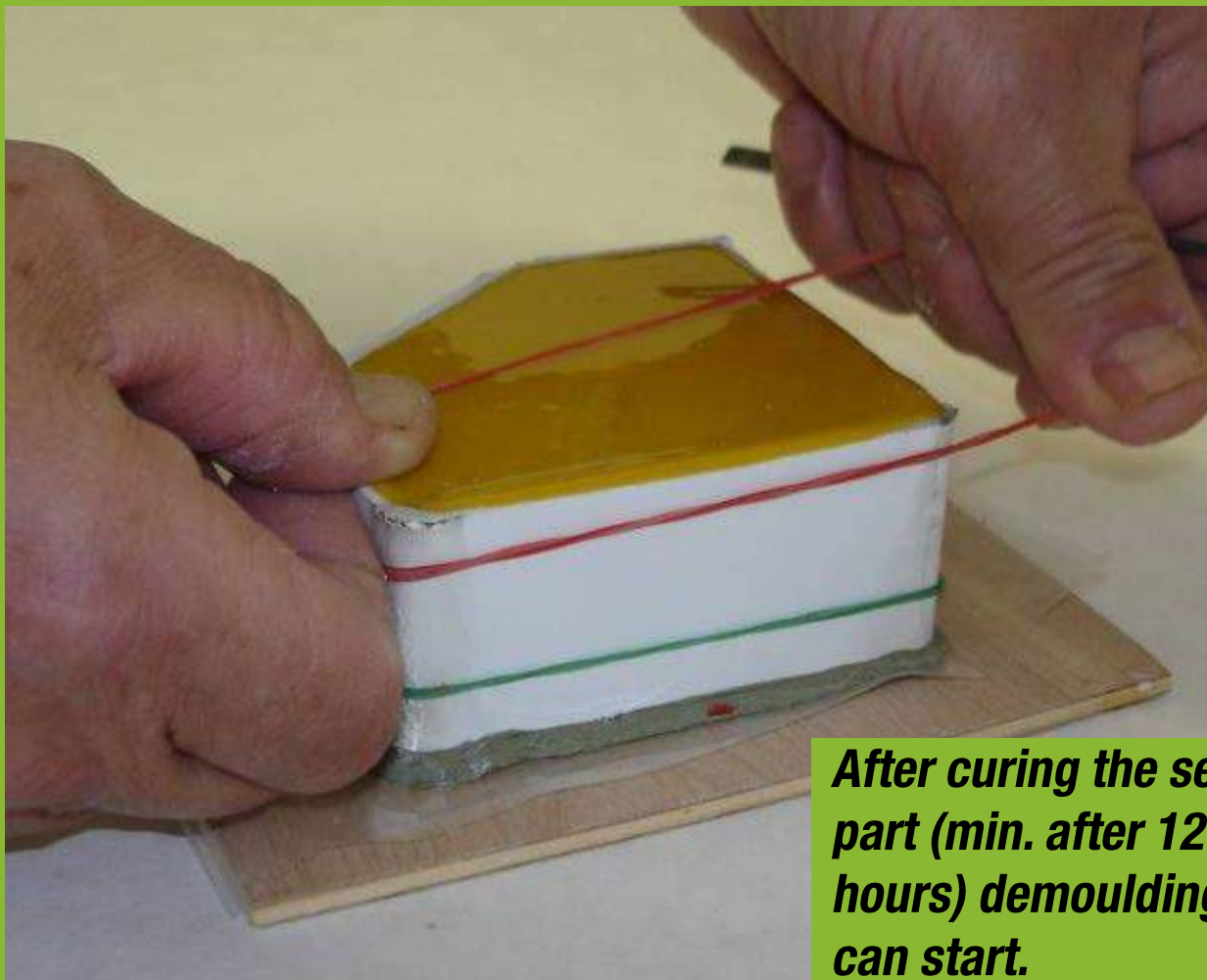
Production of two-part mould



*Production of the second
mould part – filling the
box up so that the mould
has the correct wall
thickness.*

LUKOPREN N SUPER

Production of two-part mould



After curing the second part (min. after 12 – 24 hours) demoulding can start.

LUKOPREN N SUPER

Production of two-part mould



*Disassembly of
the auxiliary box
(needs to be
carried out very
carefully) and
sealing.*

LUKOPREN N SUPER

Production of two-part mould

Before dismantling the box, first by creasing the vulcanizate, you cancel its adhesion to the walls of the box



LUKOPREN N SUPER

Production of two-part mould

*Demoulding – opening
the mould in the
dividing plane*



LUKOPREN N SUPER

Production of two-part mould

*First and second
parts of the mould
with model*



LUKOPREN N SUPER

Production of two-part mould

*Finishing of the mould
- for rounding the
edges is used a
whetstone of pumice.
The various overflows
of rubber on the
pouring hole is
carefully cut off.*



LUKOPREN N SUPER

Production of two-part mould

*Two-part mould from
Lukopren N Super*

