

Technical Advice Sheet

Guide to avoid air bubbles when casting Flexil Moulds

*** Ensure Flexil is melted and held at the recommended pour temperatures ***

Bubbles are caused only by the expansion of air, due to heat from the Flexil HMC which is trapped under the model to be cast, or within the model, due to porosity.

Surfaces of the model which will come into contact with the Flexil must be sealed. To do this, a solution of 5-7% Unibond in water is recommended. Allow to dry between each of the 2-3 coats applied. A final seal of Vernacryl can also be applied. Do not treat the underside.

To ensure there is no air trapped under the model, it should be bedded onto a clay or Plastiline base.

Should the model be heated, the air within the model (porosity) will become pressurized and may break the Unibond sealer. To avoid this, it is suggested that some holes be bored into the base board under the model, and into the model if at all possible, to relieve the pressure, and allow the air to escape. The base board should also be propped up to allow free movement of the expanded air.

Two further points to bear in mind are:

- i) If the model is warmed before pouring Flexil some improvement will result.
- ii) Flexil should be poured onto the backing board at the lowest point, thereby rising and pushing air upwards.

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