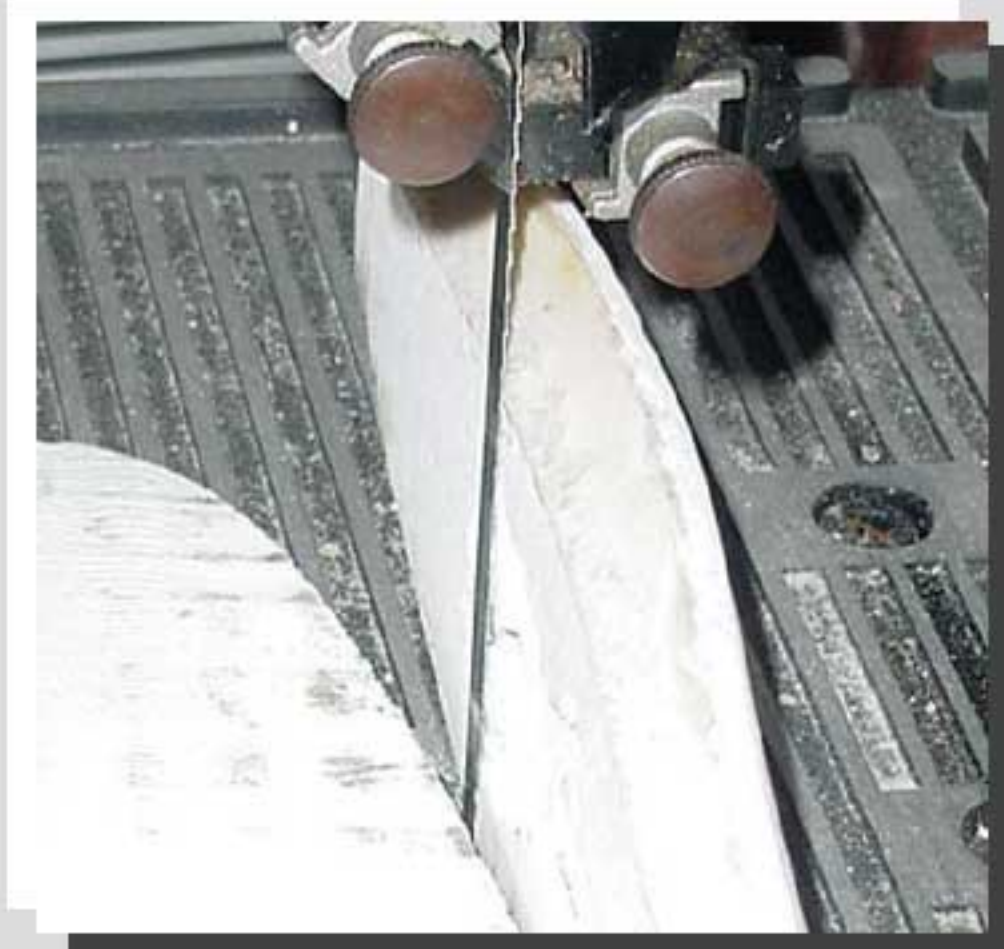


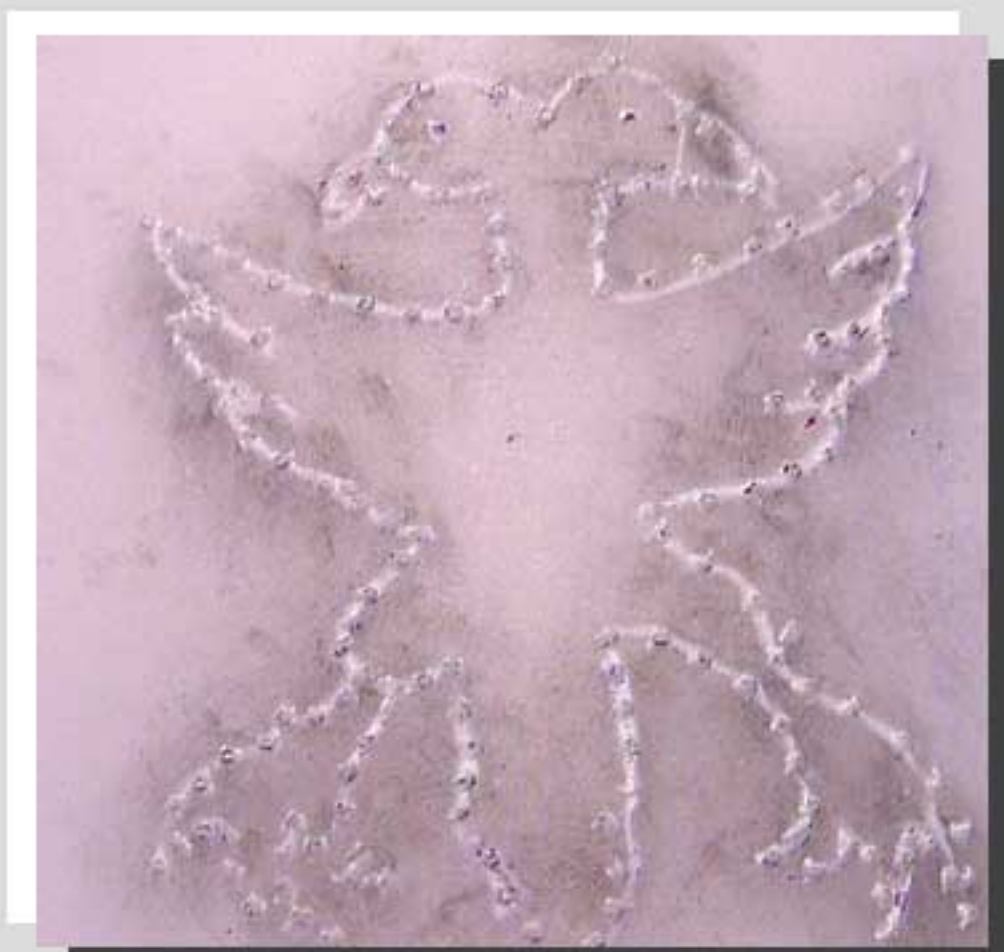
LOW TEMPERATURE CASTING

SUPPORT SHEET NO3

MAKING A CUTTLE FISH MOULD



1. They can be purchased from any pet shop. Using a band saw cut the cuttle fish lengthways to provide two equal halves. The halves need not be sanded as the cut forms a natural bedding which is secure from leakages during casting.



2. Prepare a tracing of your design and follow the pencil lines with a needle, making holes closely spaced which follow the whole of your trace, placing the trace on to a soft surface like polystyrene makes it easier to create clean holes. On completion, place the trace on to one side of the cuttle fish and dust with charcoal. This will transfer your pattern to the cuttle fish without damaging the surface.



3. Using a pointed tool, a lino cutter for example, carve out the shape into the cuttle fish.



4. Square off the top and bottom of the cuttle fish to allow it to fit within the mould holder.



5. Place the two halves of your cuttle fish together and with the Flamefast spring clamps place the mould into the mould holder. You may need to pack one side of the cuttle fish to ensure that the sprue is directly beneath the pour nozzle. The sprue is effectively a funnel to allow the liquid metal to run into the mould.



6. Because the cuttle fish is resilient you are able to use the mould on more than one occasion.



7. The finished eagle with a ring soft soldered to the double eagle head and a chain attached to the ring.