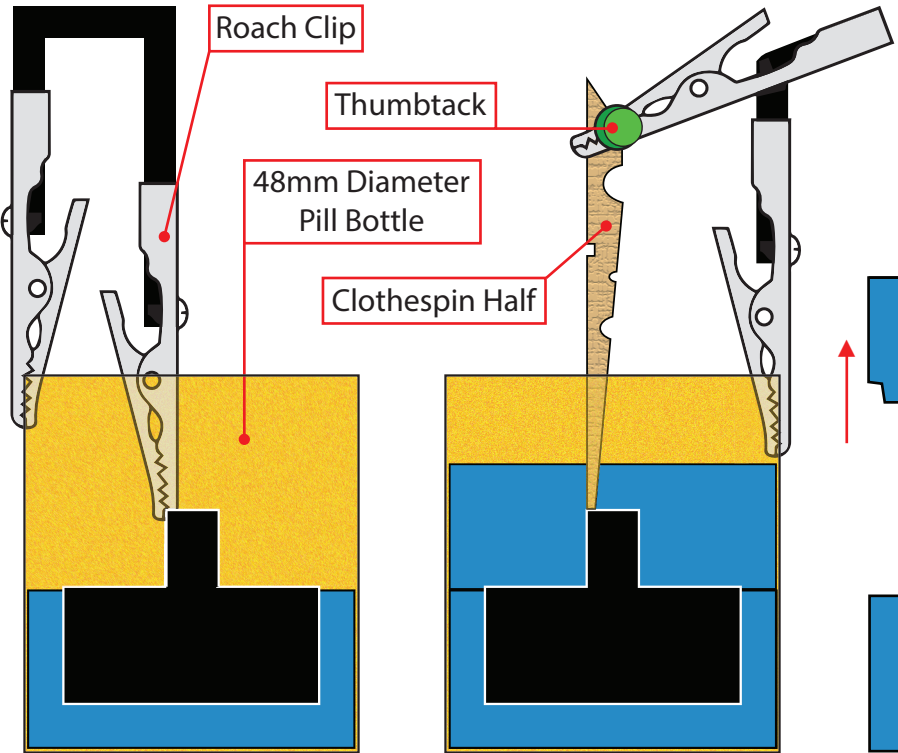


Roll Your Own W-30 Jog Wheels

Creating 2-Part Molds

Alumilite Plat 55 Silicone Rubber

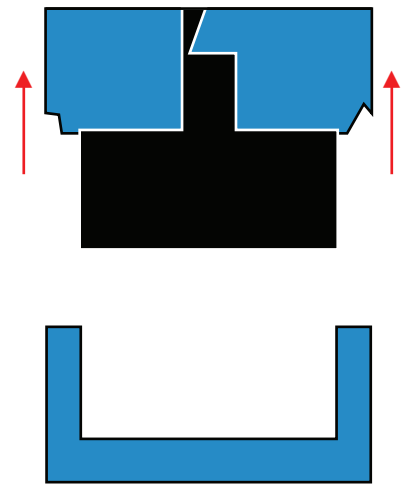


Inside a wide pill bottle, suspend a jog wheel in the air leaving a 7mm gap on the bottom and on the sides. Ensure that it is level with the bottom. Now put on some latex gloves for pouring the mold mixture!! You've been warned ;^)

Pour the mixture up to the top of the wheel. Don't let any mixture flow inside of the wheel wells

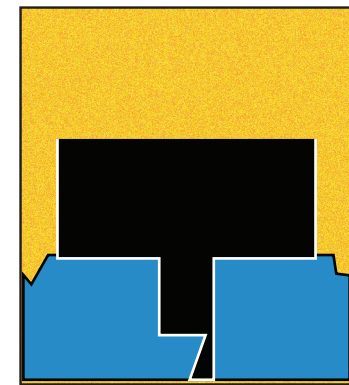
Don't worry about any trapped air bubbles. This mold won't be used in later steps. Don't throw it away! It still has a future and can be used to make some more Top Molds"

After the mold hardens, coat all of the exposed mold surfaces with Vaseline which helps to help prevent sticking. Suspended the thin end of half a clothespin on top of the flat section of the D-shaft and make sure it touches the top. This is done to create an empty section when resin is poured. Pour mold mixture all the way up to 7mm above the top of the D-shaft. Use a toothpick to poke way down into the open D-Shaft area to release any trapped air bubbles

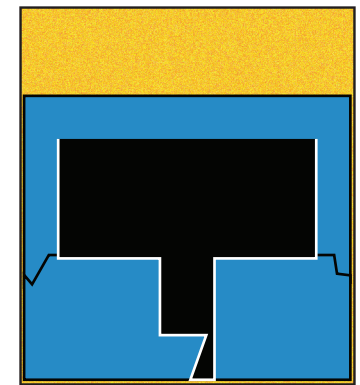


After **24 hours**, remove both molds from the pill bottle then pull the bottom mold away from the wheel and make sure to keep the wheel securely inside the top mold. Set the bottom mold aside because it's not needed anymore... however, it is still good for creating "Bubble Wheels" and/or "Top" molds

Use an Exacto knife and cut away three small unique shapes from the topside of the remaining mold. These unique shapes are used as reference alignment joints for the resin pouring phase

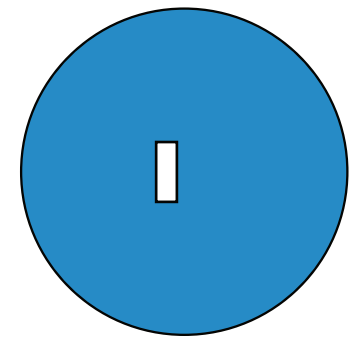


Turn the mold upside down and place it inside the pill bottle. Just like before, coat all exposed surfaces with Vaseline so the next poured layer will not stick to the silicone

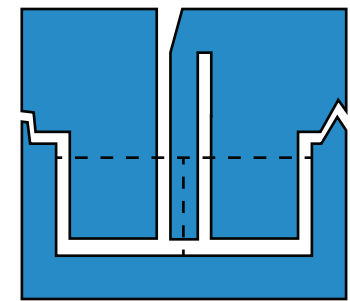


Pour another mold for the top half. This is actually the third mold you create and is how all the trapped air bubbles are eliminated

Final Mold Top View



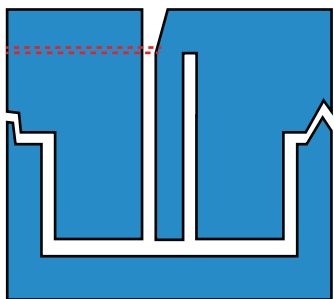
Final Mold X-Ray Side View
- - - - - = Wheel Well Walls



Roll Your Own W-30 Jog Wheels

Pouring Resin

White Amazing Casting Resin

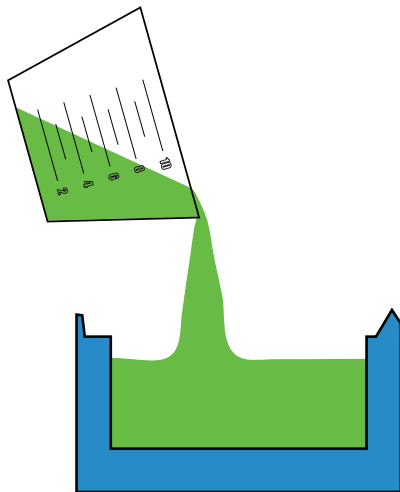


Use an Exacto knife to cut an 8mm slit from the outer shell to the inside of the pour tab. This gap is added to make part removal easier in a later step

Now that the molds are done, the easy part begins!

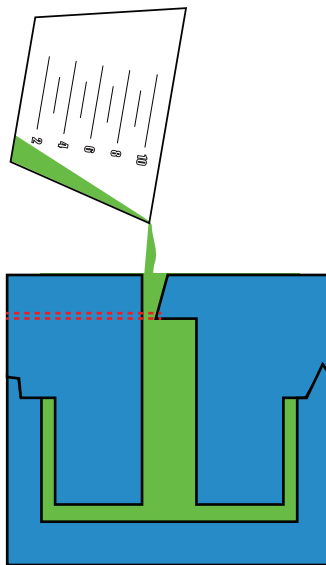
Sprinkle a liberal amount of talcum powder inside every area of the top and bottom molds and blow away any excess powder leaving only a very fine dusting on all surfaces. Heat both molds in the oven at 140 degrees for five minutes

----- = Exacto Knife Slit



Put on some latex gloves for pouring the resin!!!! You've been warned ;^)

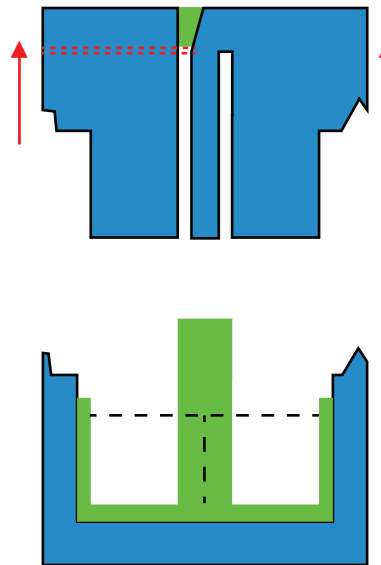
For the following steps, speed is critical! Right after you mix the resin, you **must** proceed as quickly as you possibly can (*Note: If using dye, only one normal sized drop is needed per wheel*). Remove molds from oven. Pour resin into the bottom mold only. Fill it 7/8 of the way to the top then press the top mold onto the bottom mold. Slightly tilt the joined molds North South East West to let any air bubbles rise and escape through the top opening



Keep moving fast! You only have a total of about 45 seconds work time after you mixed the resin!

Place the mold on a flat surface. Use a toothpick to poke way, way, way down through the top opening to release any trapped air bubbles inside the D-Shaft. Pour the rest of the resin in through the top opening and repeat poking with the toothpick

Place a can of refried beans on top to weigh it down. From my experience, only refried beans will work! ;^)



After 30 minutes, carefully insert an Exacto knife into the slit. Push it all the way through to create a hairline gap. This gap makes the part removal easier. After **24 hours**, carefully remove only the top mold (the one with the opening on top). While the resin is still slightly pliable, use a sharp pair of wire cutters and clip off the leftover "pour tab" area from the top. Leave the bottom mold attached to the wheel until the resin completely cures. Check your resin chart for the total cure time (White Amazing = 72 hours)

----- = Wheel Well Walls

If you find that the wheels do not grip the D-Shaft and are too loose, wrap some layers of aluminum foil over the entire wheel except at the top of the D-Shaft. **VERY BRIEFLY** use a hair dryer to heat-up only that area. Use some needle-nose pliers and **VERY GENTLY** close the opening a tad bit smaller. Quickly run it under the water faucet. So far, I've not shattered any wheels this way! Good luck with the pouring. Send me an eMail if you have any questions or comments

Notes

► Because of the unusual shape of this wheel, removing it from the mold before 24 hours have expired will deform the D-Shaft areas. Don't get antsy!

► Alumilite products have different characteristics. Instructions shown in this document apply only to "Alumilite Plat 55 Silicone Mold Making Rubber" and "Alumilite White Amazing Casting Resin"