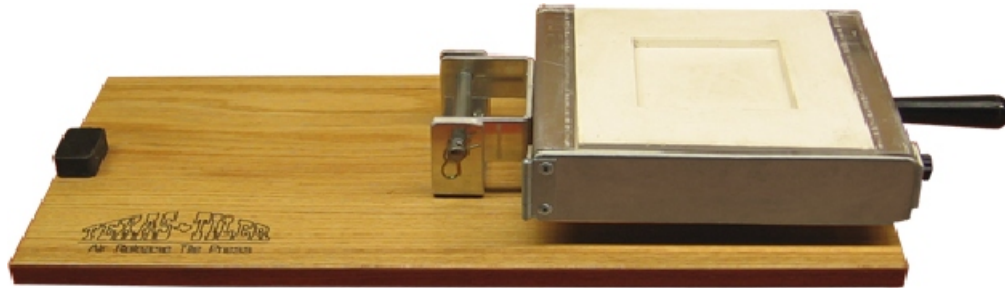


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Air Release Tile & Clay Press



Patent Pending

**How to make long lasting
urethane rubber models
for Texas Tiler die making.**



Making urethane rubber models from your handmade clay art. Also works with art designs made with other materials such as plasticine, wood, modeling clay, plastics, and resins.



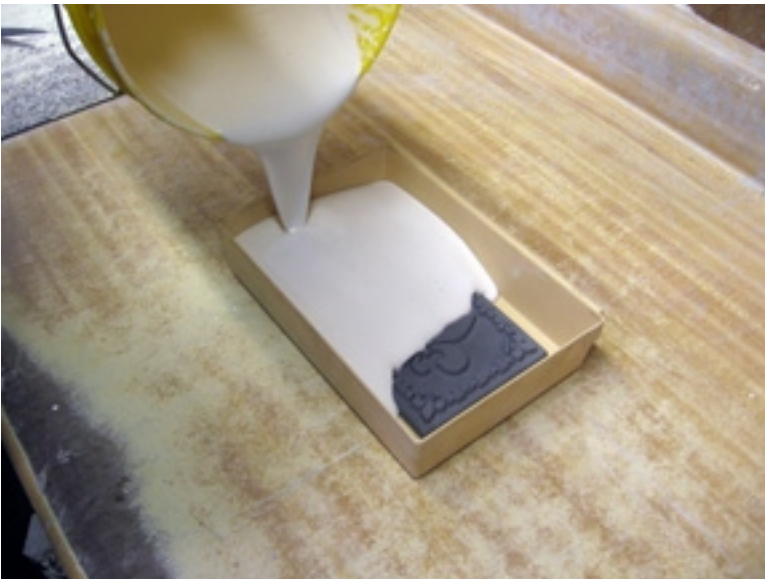
After making your art tile, carefully place it in a plastic tray that will hold plaster without leaking. Make sure the bottom of your art piece is in full contact with the bottom of the tray so that plaster will not flow under the clay.



Now mix a small batch of pottery plaster. Just enough to cover your clay piece by about an inch.



Before pouring the plaster, fill a hand spray bottle with water and 10 drops of liquid soap. Now spray a few squirts of water directly on top of the clay. The purpose of spraying the water on the clay is to prevent bubbles from adhering to the clay. When the plaster comes in contact with the water, the water floats upwards and carries any bubbles in the plaster with it.



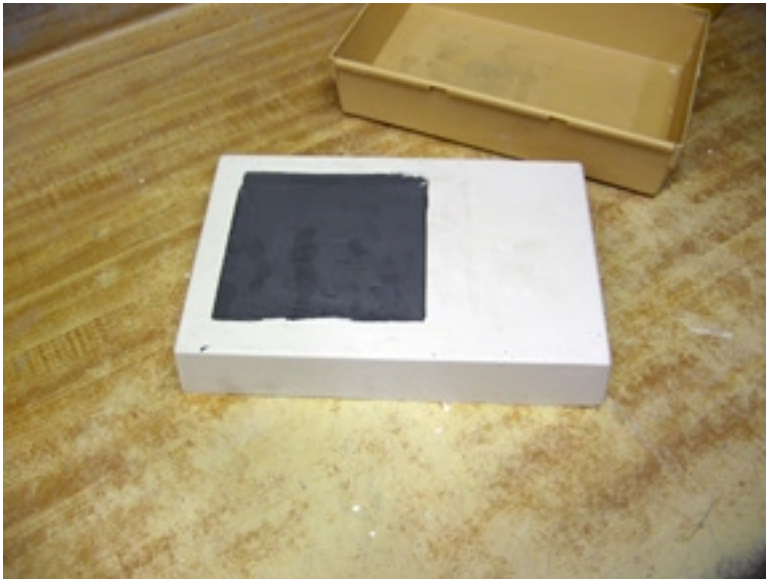
Next, slowly pour the plaster over the clay. Pour gently starting in a corner of the tray and allowing the plaster to flow over the clay. Do not splash the plaster or pour quickly as that will cause air bubbles. Nice and slow is the key.



It is not necessary to overpour or to overdo it with the plaster.

When the clay is covered about an inch, that's enough.

Now clean the bucket outside. Do not pour any of the plaster into plumbing. Hose clean outdoors.



When the plaster sets up, it is hard and generates a lot of heat. When it becomes hot, it's time to demold. Take the plaster out of the plastic tray.



Next we need to remove the clay from the plaster mold. Avoid using any tools to do this as you could cause damage to the mold. Blowing air into the edges of the clay will almost always do the trick.

You will not be able to salvage your clay piece, so don't try. Simply throw the clay away or recycle it.



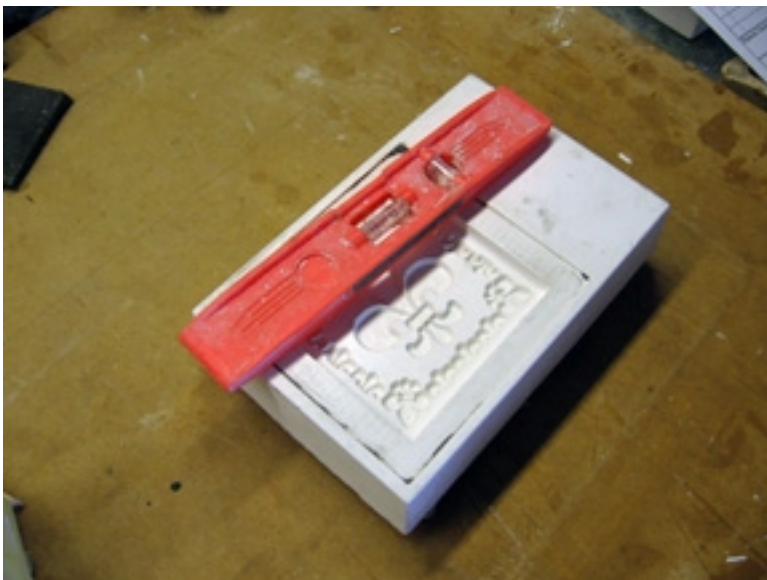
After removing the clay, take a wet soft sponge and gently clean the clay residue from the mold. The mold must be as clean as possible.



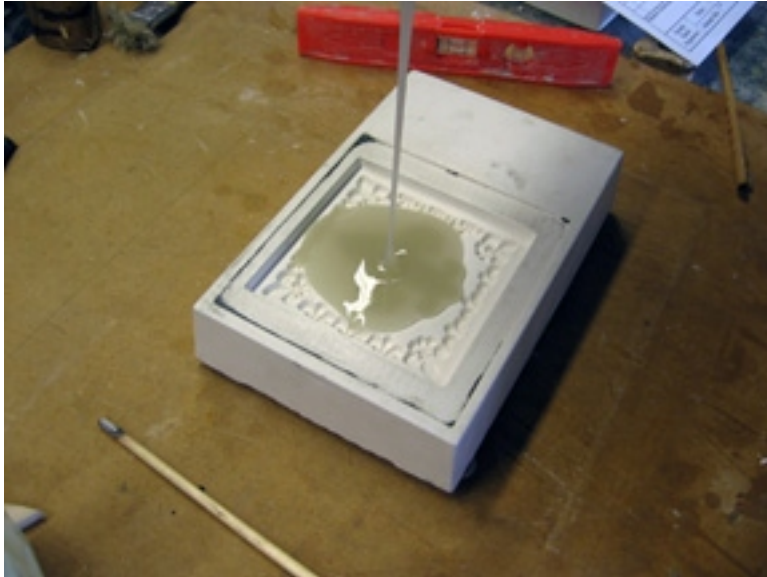
Next brush on a thin coating of petroleum jelly over the mold. The jelly acts as a good release for the urethane rubber. Be sure that you do not leave any jelly residue. Excesses should be removed. The mold should be nice and smooth.



Now we need to mix the urethane rubber. This is a two part mix consisting of 2 parts A to 1 part B by weight. Do this by using a small dixie cup on a scale. Then stir mix the rubber for about 30 seconds. Be sure to scrape the sides of the cup while stirring. You now have about a 20 minute pot life.



Next we must level the mold so that the rubber ends up the same thickness throughout. It is important to avoid a thick and thin situation. That's why it's necessary to level the mold before pouring the rubber.



After leveling the mold, pour the rubber mix over the mold cavity. Do not pour with a heavy stream. Pour with a thin stream as that will help to eliminate bubbles created by the stirring. Sometimes you can eliminate bubbles by brushing a thin coat of rubber over the mold first, and then pour the remainder.



Pour the rubber until the cavity is completely full and the mix is level with the top of the mold

It's always best to pour the rubber at room temperature. Avoid extremely cold temperature pourings.



Your rubber model is now completed. Leave the rubber in the mold for at least 12 hours.

Then demold. Your mold may not be used to make a die for the Texas Tiler press. Please refer to the tutorial on making dies.

After each use, it is important to clean the rubber model with water and store in a flat position covered. Do this and the rubber will last for years.