TORSO MOLD - BODY DOUBLE & SMOOTH CAST 325
1 - Having all mold making materials & supplies assembled prior to beginning the process will save time and avoid potential problems.

2 - Although Body Double will not stick to skin, it will encapsulate hair. Hyper Folic is added to Body Double to aid in the release of the rubber over hair. Release Cream is also applied to the model to ensure the Body Double releases from skin with ease.
3 - Accessory materials such as Silicone Thinner and Thi-Vex II thickener may be added into Body Double to modify the consistency of the silicone rubber.

4 - Body Double is measured properly, mixed thoroughly and applied directly onto the skin.
5 - The skin surface is covered with the first layer of Body Double. The recommended thickness for the mold is 3/8''. Some areas may be a little thicker.

6 - Body Double will adhere to itself, so multiple layers of silicone are applied on top of each other.
7 - Some surface areas represent undercuts. For these areas, batches of Body Double are mixed with Thi-Vex II silicone thickener which makes the rubber more buttery in consistency.

8 - As an option, thickened Body Double is put into a cake-icing bag and squeezed out to form a thick bead around the perimeter of the mold. This will help to register the plaster support shell.
9 - The registration bead will adhere permanently to the rubber surface.

10 - After the Body Double silicone rubber is applied and fully cured, a plaster bandage support shell is made directly onto the silicone surface while the rubber is still on the model.
11 - The plaster bandages are dipped into water; excess water is squeezed out and the bandages are then laid up onto the silicone surface.

12 - Multiple layers of plaster bandage are applied in a matter of minutes.
13 - To minimize strain on the model, the tilt-bed is orientated horizontally for the final touches of the support shell.

14 - If the support shell is not sturdy enough the mold could distort when casting.
15 - Wooden dowels are incorporated into the support shell to provide a secure base for the mold during the casting stage.

16 - Multiple connection points are required for the wooden dowels to be secured to the support shell.
17 - After the plaster bandages have fully cured, the tilt-bed is put in an upright position to begin the demolding process.

18 - With minimal effort, the support shell is carefully removed from the silicone rubber.
19 - The Body Double silicone rubber mold is then carefully removed from the model. The entire process has taken 1 hour and 40 minutes up to this point.

20 - After the demold, the silicone rubber mold is placed back into the support shell.
21 - Excess flashing of silicone rubber is trimmed away from the mold.

22 - The Body Double silicone rubber mold is now ready to be cast into.
23 - A wide variety of casting media may be used in a Body Double mold. We decided to create a piece using the Metal Cold-Casting Technique, which will yield a bronze-like finish on the surface.

24 - To prevent any casting media from bonding to the perimeter of the plaster support shell, a thin coat of sealer and release is applied to the plaster surface.
25 - Smooth Cast 325 urethane resin is measured out 1A:1B by volume.

26 - Several drops of So-Strong Black urethane tint is added into the Smooth Cast 325 Part B to aid in visual definition of the castings surface.
27 - The So-Strong urethane tint is then thoroughly mixed into Part B until the color is uniform.

28 - To achieve a bronze look, bronze powder will be mixed into Smooth Cast 325. The ratio used is 1A:1B:1 Bronze powder by volume.
29 - The Bronze powder is then poured into the pigmented Part B and thoroughly mixed until uniform. Be sure to scrape the sides & bottom of the container.

30 - When the mixture of Part A, Part B, black tint and bronze powder is thoroughly mixed, it is then cast into the mold and spread around using disposable brushes.
31 - The entire surface is coated. A second layer is then applied directly onto the first layer to build up the thickness of the casting.

32 - Foam It! 15 is mixed and poured into the Smooth Cast 325. This adds dimensional stability to the casting.
33 - Several drops of black So-Strong tint is also added into Foam-IT! 15 to make it cure black in color.

34 - After the casting has fully cured, it is then demolded from the Body Double silicone rubber mold.
35 - Post finishing work may include buffing and staining the surface of the casting. Smooth Cast urethane resins may be sanded, primed, drilled, tapped, hammered, stained and painted.

36 - The finished casting. Notice the high-resolution surface that was perfectly captured by the Body Double silicone rubber and then represented by the Smooth Cast resin.