GRS SM401
Shoe Mould Investment

SM401 Investment is a gypsum bonded investment formulated for the casting of Aluminium shoe mould plates using silicone rubber patterns.

SM401 is specifically designed for the manufacture of aluminium shoe mould plates for the production of shoe soles. This method of manufacture is used to produce soles for many of the leading names in the training shoe industry.

A typical master shoe mould is constructed from wood, metal, or plastic. Silicone is then poured over the master mould and left to cure. Once set, the Silicone mould is stripped from the master, SM401 is poured into it and allowed to set.

The plaster mould is removed from the Silicone mould and dried out in the furnace. The plaster mould is then set into a frame and molten aluminium is poured over it, the metal is left to cool and the plaster is removed from the Aluminium casting.

- Highest purity raw materials used
- Particle sizing optimised to suit the requirements of the product
- Mixes easily to a fluid consistency to avoid air entrapment in the mould
- Designed to be used without a casting flask
- Excellent surface finish with high definition and close dimensional accuracy
- No mould breakdown reducing post cast finishing cast/operation
- Ease of removal from casting

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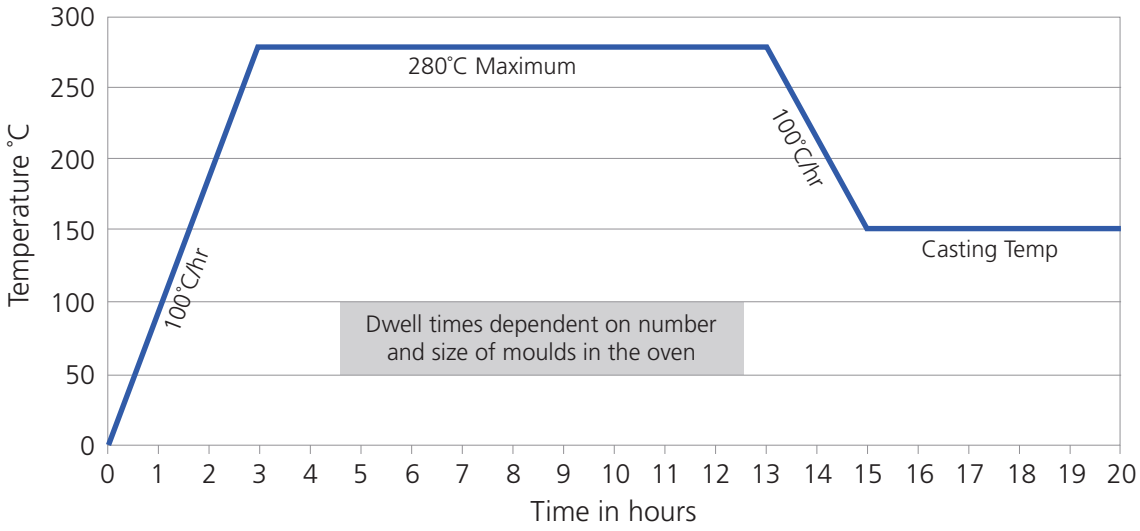
Typical SM401 Mixing Instructions

Mixing under vacuum	Time (mins)
Weigh out water and powder	0
Add powder to water	0
Mix under vacuum	4
Pour over patterns	1
Vacuum	1
Total time taken	6
Remove patterns after 30 minutes	

Mix without vacuum	Time (mins)
Weigh out water and powder	0
Add powder to water	0
Mix	2
Vacuum slurry	1
Pour over patterns	1
Vacuum moulds	2
Total time taken	6
Remove patterns after 30 minutes	

SM401 Recommended Drying Cycle



Technical Information - SM401

Powder : Water Ratio	**100 : 40**
Work Time @ 22°C	**10-12 minutes***
Initial Set Time	**15 minutes***
Setting Expansion @ 2 Hours	**<0.30%**

* Can be set to meet individual customer requirements.

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