

Shoe Mould - SM 400

Shoe Mould Investment Powder



SM 400 Investment is a gypsum bonded investment formulated for the casting of aluminium shoe mould plates using silicone rubber patterns.

SM 400 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, SM 400 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
- Ease of removal from casting



Technical Information

Powder : Water Ratio	100 : 40
Work Time @ 22°C	10 - 12 minutes*
Initial Set Time	15 minutes*
Setting Expansion @ 2 hour	0.75%
Thermal Expansion @ 400°C	0.30%

* Can be set to meet individual customer requirements.

Mixing Instructions

Machine Vacuum Mixing	Min.
Weigh out water and powder	0
Add powder to water	0
Mix under vacuum	4
Pour over patterns	1
Vacuum flask	1
Total time taken	6

Hand Mix Then Vacuum	Min.
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

Drying Cycle

