

<p align="center"><b>Slush Molding</b> Individual Module: 16</p>	<p>TEL 204: Polymer Molding &amp; Forming Department of Technology</p>	<p>Student Name: (PRINT)</p>
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**Overview:**

Slush molding involves an open hollow mold. Molds are preheated, filled with plastisol and allowed to dwell until a desired product wall thickness is built up. Then the excess plastisol is poured off and the product and mold is cured in an oven.



**Module Grade:**

Fit, Finish & Trim (20)	Uniform Thickness (20)	Burns (20)	Completely Cured Product (20)	Lessons Learned (20)
Instructor Signature:			Date:	Grade:

### Molding Procedures:

1. Wear safety glasses.
2. Wear gloves and do not touch hot molds, hot plastic, hot molder surfaces.
3. Preheat the mold to 350 – 380 degrees Fahrenheit. A torch may be used outside of the resin room but the mold must then be placed in an oven to stabilize.
4. Pour plastisol into mold and let dwell until desired thickness is built up. Fishing lures require a very short dwell. Door stop requires long dwell to produce 1/4" thickness. Kicking tee: Place back in oven with a plywood cover to minimize skinning to build a 1/4" thickness.
5. Pour off excess back into the bath after the wall thickness is obtained.
6. Place back in an oven and cure at 380 degrees for 25 to 45 minutes. Watch for a color change and **keep it from burning**. The coating is cured when its surface changes from glossy to dull and back to a glossy finish.
7. Quench in a cooling bucket for a few minutes. NEVER use the sink to quench a plastisol mold.
8. Check the cure by slicing a small piece and pulling on it to check toughness. Re-cure if it breaks.
9. Trim the product with a sharp utility knife.

### Lessons Learned:

List the most important lessons learned from this polymer module.

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2. \_\_\_\_\_

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3. \_\_\_\_\_

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