

What You Need To Know

About Molds

We select the mold material that best suits your piece unless otherwise requested. Generally, there is 1% to 6% total shrinkage from master to finished piece. Shrinkage occurs during molding, injection, casting, and finishing. Shrinkage has been calculated from in-house tests and manufacturer specifications and may be different depending on model geometry. (Example: Marquise dimensions change differently than squares and outside dimensions change differently than inside dimensions.)

It is your responsibility to plan for the dimensional change in your parts based on your needs. Consider your model's sprue location, mold material, finishing process and final part requirements. Please call or e-mail with any dimensional change (shrinkage) questions, concerns or for further assistance.

Sometimes, the pieces we receive, while esthetically beautiful, do not account for the natural laws of precious metal flow dynamics. These technical design issues often cause porosity, non-fills, and other casting defects. Based on our experience and testing capability we can compensate for these issues by changing sprues, adding risers, adjusting flask and metal temperatures or recommending a change in the model.

Mold Recommendations

If you want us to work from your mold or metal model, we may recommend modifications to ensure quality. Most commonly we need to replace, modify, move, or completely alter the feed sprue system of your metal model to get the best casting results. Alterations to molds or sprue changes on models are done for a fee. Sprue changes on models will also require making a new mold for a minimal fee. We will contact you in advance regarding any recommended changes.

IF YOU CHOOSE NOT TO HAVE MODIFICATIONS TO YOUR MOLDS OR MODELS, we reserve the right to reject a model mold, or waxes if we feel that the labor required to produce the order exceeds our costs, or that the results will produce poor quality pieces due to pre-existing uncorrected defects.

If you have spent a lot of time or money making a hand carved wax or rapid prototype, it is always in your best interest to make an RTV mold of your valuable design. The small \$30+ investment in a mold is far cheaper than re-carving or rebuilding your design again in the event of a less than satisfactory casting. Back up molds from waxes, are always made in RTV. The casting and mold department will make individual decisions on what type of mold is needed based on the model sent.

Copyrights and Trademarks: Hoover & Strong will not copy or infringe on a customer's copyright and is not liable for copyright infringements by others. It is the customer's responsibility to maintain ownership of the submitted design. Hoover & Strong will not cast designs that have trademarks other than those owned by the customer.



PLEASE NOTE:

Bracelets and/or complex-cut molds will require a quote.



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Types of Molds

Mold Type: VLT

Turquoise Silicon Medium Strength Mold



Molding and Injection Shrinkage: 3%

Pieces: Production (5+ per run)

Mold Use: Small to large production runs. This is our most popular silicon mold. This is a low temperature vulcanizing mold for metal models.

Silver Model Sprue - If needed, we will add a silver sprue to your metal master. This includes clean up of master and silver sprue. Price starts at \$20.

VLT Services - Price starts at \$30.

Large Size VLT - Price starts at \$60.

Mold Type: RTV

Clear Silicon Very Low Strength Mold



Molding and Injection Shrinkage: 1%

Pieces: 1-5

Mold Use: Cold mold process for molding waxes and items that can't be heated. This is not a mold for production runs.

Wax Model Sprue - If needed, we will add a wax sprue to your wax or resin master. Price starts at \$4.20.

RTV Services - Price starts at \$30.

SEND YOUR MODELS AND WAXES TO:

Hoover & Strong
10700 Trade Road
N. Chesterfield, VA 23236-3000
Attn: Casting

Before you send your waxes and masters, please inspect them for:

Surface bubbles, heavy file marks, flashing, incomplete prongs, bearings or bezels, dirt or metal filings on or in the wax, small gaps, cracks or parting lines in your wax. Also, check for the proper karat markings if needed in your models and masters.

Shipping Your Waxes, Masters and Molds:

For tracking purposes, FedEx or UPS are best. The U.S. Postal Service should only be used if you are insuring your items. Wax models should be very carefully packed into a smaller box to avoid any kind of shock. Use soft fibrous material that will not leave behind lint or allow much movement. Please ensure waxes are dry, with no solvent residue to avoid dust buildup. That smaller box should be taped to the inside of a larger box for protection.

REQUIRED FORMS

Prior to sending your casting order, you must complete and sign our CONTRACT CASTING FORM.

The Contract Casting Terms and Agreement Form also needs to be completed and signed the first time you cast with us, but you only have to submit this form once.

Scan this QR code to access all the casting related forms.



USE OUR ONLINE CUSTOM CASTING CALCULATOR!

Visit our website to get an estimated cost for your piece using our online calculator.

