Subject: 3d print >molds >cast
Posted by rangio on Wed, 14 Nov 2012 14:47:57 GMT
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that is! my revoltech Garou. it's a werewolf. I wrote it's not exactly what I have find in the box since I made positive molds for each piece, this in order to be able to cast a lot of werewolves. (though I made only one so far!!) parts were made here (but even there...)
it's a revoltech too. it features joints from that company named kaiyodo which brings to you those nice anime figures(I do collect revoltechs so I'm pretty familiar with them).

but I wanted MINE revoltech!!

I know now it was made before. but this is different. it's not directly 3d printed(way too easy)
I've made the molds instead! well, it took a while to do, hope you like!

you could also browse my flickr gallery, it's here:
http://www.flickr.com/photos/45657404@N08/8182417958/

File Attachments

1) 8182417958_6b3d06e988_b.jpg, downloaded 391 times

Subject: Re: 3d print >molds >cast
Posted by stannum on Thu, 15 Nov 2012 23:46:11 GMT
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So you print the mold instead of the part? What material for the print and what for the cast?

Subject: Re: 3d print >molds >cast
Posted by rangio on Fri, 16 Nov 2012 20:38:30 GMT
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I've used many materials for prints. i.e. white detail for teeth and wsf for the inner head(a single part sliding into the outer head which comprises eyes, mouth and the neck hole for the joint). really boring to do, the inner head is cast into a 6 parts mold. all the wolf is made in polyurethane resin.
I'm happy it worked since the inner head is cast into a mold hosting the already made teeth within. very intriguing technique!

claws are also white detail but I've had some issues cleaning the print. hmm.. I tried to get molds with the outer part as much detailed as I can. molds are made in silicone.

I've made this also to experiment different materials anyway, it's still an open project.
I'm glad you asked!

Subject: Re: 3d print >molds >cast
Posted by Youknowwho4eva on Fri, 16 Nov 2012 20:57:04 GMT
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I think the confusion is with your title. Your not saying that you used any casts or molds, your saying that 3D printing is greater than either of the other techniques?

Subject: Re: 3d print >molds >cast
Posted by rangio on Fri, 16 Nov 2012 22:35:10 GMT
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ouch! no! brackets just explain the workflow, ok?
make the 3dprint >then> make the molds out of them >then> cast the final part.

It's to get more copies.
a silicone mold can produce up to 40 copies.
but don't ask me what will I do with all those wolves!!

Subject: Re: 3d print >molds >cast
Posted by stannum on Fri, 16 Nov 2012 23:05:33 GMT
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> could also be read as a short version of -> or "arrow". That was not confusing, other pictures at flickr were.

OK, so you did silicone molds from the 3d print parts and then cast with those, using polyurethane, the "common" thing. Some people do single part molds and then cut them, 6 parts can be very work intensive, yes. Thanks for the info in any case.

The "part inside the mold" is called double shot in plastic injection industry. In hand casting, it's helps reducing bubbles or mixing materials, for example the first one I saw was casting horns and then placing them and casting the body of the full animal, pretty much what you did too. It's just an advanced version multiple step casting, used when the part is so big that it could cause heat problems or take too long to cure.

Subject: Re: 3d print >molds >cast
Posted by rangio on Sat, 17 Nov 2012 01:25:25 GMT
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it's the first time I do this double shot(now I know how to name this technique). I didn't want to paint the teeth, you know..
painting is not my forte.
btw could you post the link of the horned creature? I got curious and I'd like to see it.

Subject: Re: 3d print >molds >cast
Posted by stannum on Sat, 17 Nov 2012 03:48:01 GMT
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Sorry, no, it was time ago. Would a cannon do? They use a metal tube to get a hollow and strong barrel for a scale tank, and also show the "single part mold and then cut it" technique.

Could you explain why your 3D models and prints have big flat surfaces and keys? That is why it looked like you were using 3D prints as molds.

Subject: Re: 3d print >molds >cast
Posted by rangio on Sat, 17 Nov 2012 13:05:53 GMT
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I build a bounding box with lego, that's why parts have flat surfaces all around.
keys are.. do you mean those pins? I put them to make the molds match perfectly.

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1) 8059358643_82ffd5c78c_c.jpg, downloaded 239 times