

# Technique Focus Slip Casting



**1** Ensure the object to be cast does not have any undercuts as this method of mould making will create a single pull mould. Place the object to be moulded on a non-porous surface. Seal all the gaps of the mould making frame with spent clay. Ballast the frame walls with extra blocks of clay. Mix the plaster (835g plaster to 1 pint of water) and pour over the object to be cast. Leave the plaster to set.



**2** Once the plaster is dry, remove frame and object from the mould. Moulds should be left until bone dry. For slip casting, build clay edge up around the rim of the mould. Mix casting slip thoroughly then tip into the plaster mould to just above the mould top. This allows for the excess to be trimmed away neatly.



**3** The length of time the slip is left in the mould depends on how thick the wall of the cast needs to be. A visual indication can be seen by looking at the change in colour of the slip around the edges of the mould or by moving the mould slightly to reveal the rim.



**4** Once you have the required thickness, pour out the excess slip into a reserve bucket. Leave the slip cast shape in the mould until it has begun to shrink and release itself from the plaster walls. Trimming around the top rim can be done with a clay cutter at the leather-hard stage. The piece can then be removed from the mould and coated with decorating slip or glazes.

## A White Earthenware Casting Slip

A low-firing slip formulated without talc for safety. Low shrinkage and high porosity combined with quick casting times make this an ideal slip. Firing range 1080°C-1180°C. 5 litre tub.

PM004



A

## B Mould Making Frames

These frames are made up of four pieces of wax-coated wood that are fitted with brackets at one end so that they can be interlocked to form a walled area of variable proportions in which to pour casting plaster over your chosen form. Seal all gaps thoroughly with plenty of spent clay. Size given is the size of the boards, there are four boards per frame.

PM011A 575 x 120 x 15mm Boards  
PM011B 575 x 300 x 15mm Boards



B

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