	Work Instruction	
	Plaster Mold Production	
Revision: 00	Procedure No.: WI-8.2.4.46	Date Effective: 6/11/2012

### Plaster Mixture

Ratio of plaster powder (CRM-101-118) to hot water is approximately 3.25 pounds : 1liter. Small deviations are acceptable, so reference-only measuring equipment is acceptable. A typical batch is 13 pounds of plaster and 4 liters of water.


### Plaster Production Procedure

1. Place rubber mold on a flat and level table surface
2. Weigh plaster on scale
3. Pour plaster into mixing container
4. Pour hot water into container
5. Mix contents
6. Pour some plaster into rubber mold
7. Remove any bubbles from rubber mold surface
8. Pour remainder of plaster into rubber mold. Overfill the cavity
9. When plaster has hardened slightly, scrape excess plaster from top of rubber mold
10. When plaster has hardened well, remove plaster mold from rubber mold
11. Check for imperfections in plaster mold and fix as necessary
12. Allow mold to dry completely before use

### Revision History

Revision Level	Date of Revision	Sections	Description of Change	Initial
00	6/11/2012	All	Initial Release	TCH

### Authorization

Position	Held By	Signature
Product Manager	Thomas Hittie	
Senior Management Representative	Abraham Joseph	