# Skull Bottle Stopper Mold Casting and Assembly Instructions

## GENERAL:

The casting from this silicon mold may be used to attach to most of all PSI bottle stopper styles.

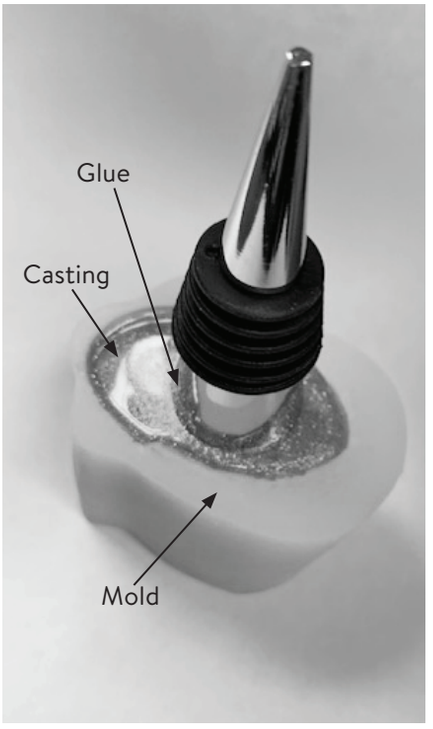
**Psi Compatible Bottle Stoppers**

#BS1 Classic Stopper (All finishes)
#BS3 Corkscrew Stopper (*)
#BS5 Silicon w/cork seal Stopper (*)
#BS8 Vintage Stopper
#BS9A Perfect seal adjustable Stopper (*)
#BS10S Stainless Mini Stopper
#BSN-4000 Whisky Bottle Stopper
#BSN-5000 Niles Standard Stopper
*(*) Requires drilling 23/64" or 3/8" hole*

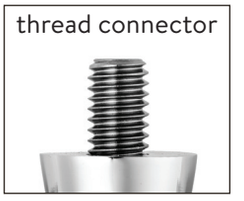
## 1) Cast the Stopper:

This mold requires about 60 total grams of resin. Some resins can be mixed in equal amounts by volume whereas others (Alumilite) require equal amounts by weight. Total volume in either case is about 60 grams.
Weigh or measure to equal portions then mix thoroughly.
Once the clear resins are mixed, they can be separated into 2 or more portions where colors for each portions can be mixed into the mold to taste.
Brush or spray a wax demolding agent into the mold cavity for best extraction of the casting.
Carefully pour the various color layers. Do not mix since it will change the colors.
If your resins tend to bubble, put the mold into a pressure pot to cure at about 50psi of pressure. Remove the molds after the designated curing time published for your resins.

## 2) Attaching Casting to Stopper with Glue

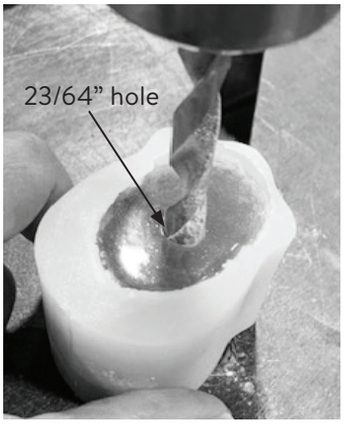



For this process, the threaded post component will not be used. Rough up the top of the stopper with an aggressive paper i.e. 90-110 grit until dull. Similarly, rough up the shiny bottom of the casting. Sand off any edge irregularities that may have resulted from the casting process. For best results, mix a 2 part epoxy. It's advised to place the casting back into the mold to hold all the parts vertical and steady. Visually center the stopper. Allow sufficient time for component to dry and cure.




## 3) Drill a 23/64" Hole

To connect the treaded connector directly into the stopper for best results, place the casting back into the mold to make sure you're drilling vertically. Drill the hole about 3/4" deep to accept the threaded connector.
The resin should be soft enough to directly thread into the casting. If it wont thread in (i.e. the casting is too hard) ... re-drill with a 3/8" hold. This may be a bit loose and we recommend gluing the connector into the larger hole.




## 4) Drill a 1/2" hold to accept a threaded connector

The advantage of this technique is the stopper can be easily installed and uninstalled from the casting in order to have the flexibility of changing stopper styles with castings. Drill a 1/2" hole 1" deep and glue in the #BSERT Connector.