



SNAPSHOT:

Preferred Volume: 1 to 100 units

Prices Beginning at: \$140

Single Tool Production: 2-4 parts per day

AT A GLANCE:

A closed mold process, the mold receives a coat of custom color gel coat and glass laminate is inlaid. A flexible bag is held onto the surface by vacuum pressure. Using that pressure, resin is then pulled into the mold and allowed to cure. This process offers a finished part with one or two molded sides.

PERFECT FOR:

Internal Supports & Substrates, Spa Components, Vehicle Bodies

NOTABLE CUSTOMERS:

American Standard, Pennsylvania College of Technology

Vacuum Infused Resin

ATTRIBUTES



EXCELLENT
SURFACE
DETAIL



HIGH
STRENGTH



LONG LIFE
EXPECTANCY



PRECISION

Creative Strategy

SIZE & COMPLEXITY

- Maximum 10' x 10'
- Considerations: hardware, parting lines and substrates

MATERIALS

- Color matched gel coat with chopped fiber or hand rolled fiberglass mat
- Considerations: tensile, flexural, compression strength, corrosion resistance and service temperature

COLOR CHART: *view online at www.rsalberts.com*

DRAFT

Draft is the amount of taper for molded or cast parts perpendicular to the parting line. An angle is incorporated into a wall of a mold so that the opening of the cavity is wider than its base. Draft angles allow for easier ejection of the part from the mold.

- Smooth Texture: 0° draft acceptable in some cases
- Smooth Texture: 1° draft preferred minimum
- Light Texture: 2° draft preferred minimum
- Heavy Texture: 3° draft preferred minimum

WALL THICKNESS AND RADIUS

- Minimum .0625"
- Maximum .500"
- Preferred minimum corner radius .250"

SURFACE FINISH

With a closed mold process, the tool side and non-tool side can capture a smooth, polished finish. The gel coats cosmetic finish may reveal the fabric print without a barrier coat.

TOLERANCES

Allowable variation for any given size in order to achieve proper function when considering the design intent. As with all molded products, part material's shrink value should be considered when building your pattern and mold.

- Tool side $\pm .010$ "
- Non-tool side $\pm .020$ "



RALPH S. ALBERTS
COMPANY INCORPORATED

60 Choate Circle Montoursville, PA 17754

Phone: (570) 368-MOLD (6653)

Fax: (570) 368-6353

rsalberts.com