

Hello, Mako here. Today I am going to explain how I made a Pewter Lost wax, or investment casting of the flag ship of Clan Odan-Urr the MC80 Star Cruiser, Solari.

I made this casting for the Great Jedi War 12 competition, The Maker, for The Dark Jedi Brotherhood. Member name Sylvia Arztin, pin 7640.

So, to start with you need some carvable wax, in this case, I used Paraffin wax that was melted from a block to form a tube. Paraffin wax is relatively inexpensive, though I had some extra from a different casting.

So what you want to do is to slowly work out a rough shape.

Then as you work your shape in you want to start refining that shape. This can be a bit tricky at first with the exacto knives but you get better with practice. (laugh) I have not had much practice.

So after I was happy with the carving I added a stand and base to it. This can be done by heating one end and pushing the melted wax against the piece you want it to stick to. Then melt some additional wax, dripping it onto the seam to seal it.

Now we add to the bottom the bit we will pour the pewter into.

For a carving reference I used Wookieepedia, link in description below.
(http://starwars.wikia.com/wiki/MC80_Liberty_type_Star_Cruiser/Canon)

Now we need to make the mold. I am using old tp rolls for the mold.

And test fitting to make sure it is large enough. Wax paper on top of a cookie tray is a must.

We will need a 50/50 mixture of plaster of paris and sand. We will add just enough water to get it roughly around the consistency of oatmeal.

Then we pour our mixture into the mold, make sure the pour spout you added is against the cookie tray.

After we let it sit for about 5 to 10 minutes we remove the mold.

Next we need to the cast over and find that pour spout with an exacto knife.

Make sure to cut a funnel into the pour spout.

I would suggest making sure you clean up after you are done.

After letting the cast sit to dry for at least 24 hours, we place it in the oven for at least 2 hours and 250 degrees fahrenheit. This is to melt the wax out of the cast, leaving a negative of your carving inside, and to finish drying out the cast. I should have left this one in for an extra hour.

So here is the extra lead free Pewter I had from other castings.

You will want a bowl of water, a hammer, something to melt the Pewter in, I use a cheap stainless steel bowl. And finally some propane, or in my case Mapp Gas. The mini cupcake tray is to pour the extra unused pewter into to form a small ingot.

Bring your cast straight from the oven. Very important that the cast is still hot when you pour the melted pewter into it.

Melting the pewter only takes a few minutes, slag will form on the top, but if your make sure to pour slowly it shouldn't be an issue.

After letting the pewter in the cast setup for a few minutes, go ahead and bust it open with your hammer.

Next put your casting into the water and scrub clean.

So now we need to remove the pour spout, a hacksaw and a vice will do just fine.

Then we hit it with the sandpaper to even it out on the bottom.

And there you have it, Clan Odan-Urr's flag ship, the MC80 Star Cruiser, Solari.

Thank you very much, and have a great day.