

MOULDING STUMBELBLOC

STEP 1: OILING THE MOULDS - ALL SURFACES EXPOSED TO CEMENT



- a: Use 80W90 gearbox oil for the 1st time only, this is essential
- b: Use cooking oil on its own or mix 10% diesel/90% oil (used cooking oil will also work)
- c: Do NOT use any other oils, these will damage your moulds.
- d: Use a brush, spraygun or dip method to coat moulds, dont miss a spot!
- e: Oil aluminium strips for easy release
- f: Pack moulds face down to drain any excess oil
- g: Oil only enough moulds necessary for casting in the next hour
- h: Assemble moulds red with yellow.



STEP 2: CAST MOULDS / FILL



OPTIMUM MIX:

2 x Level Wheelbarrows Building Sand,
2 x Level Wheelbarrows 13mm Stone,
1 x 50kg 42,5 MPa Cement.

A: Vibrate by hand if no vibrating table available

B: When by hand first fill the mould then tap with rubber mallet



C: Do not top up the mould with mixture after casting, settlement of the mix is essential: 1 - 3mm. Do not fill the mould to the top, leave a 3-5mm gap as show in C.



STEP 3: CURING

Production must be done under shelter.



Moulds need to be stored on a level surface for 2 nights. The moulds must not be moved during this time as microscopic cracks will form decreasing the strength of the block. Put oil on top of blocks 30 minutes after casting to stop evaporation and cover with plastic sail.

STEP 4: RELEASING MOULD



Do NOT veer from the 'Unzipping' method shown in these pictures, as you may damage your moulds and/or blocks.



Do not hit directly onto strips when removing.



First use a small washer to 'unzip' then use bigger washer provided and roll down both sides.

Tap gently with back of mallet at position shown. Repeat this action on bottom cavity.

See rapid demoulding video with air compressor.



STEP 5: STORING

Handle blocks with care after demoulding and store for 1 more day before palletizing

Cure blocks for 28 days before using in construction.



4 laborers can produce 1 100 blocks in 5 days. This is enough to build a 36m² cottage.

