

SOFT PLASTIC MOLD INSTRUCTIONS

**JANN'S
NETCRAFT**



Please Read These Directions First!!

We know you are excited to begin making your own soft plastic baits. Please read these instructions before starting.

Safety

The plastisol you will use to make soft plastic lures must be heated to about 325° F. Spilling or splashing hot plastisol can cause serious burns to you and your helpers.

1. Always wear safety goggles or a face mask to shield against plastisol splatters.
2. Wear gloves, leather shoes and long sleeve shirt and pants to protect against burns and plastisol splatters.
3. Never let water or moisture come in contact with hot plastisol. Moisture will turn to steam violently when it contacts the plastisol and cause splattering.
4. Use care to prevent burns when handling plastisol, injector and molds.
5. Work in a well-ventilated area.
6. Keep young children away from your work area.

ABOUT OUR SOFT PLASTIC MOLDS & INJECTOR

Netcraft soft plastic bait molds are two piece molds that produce three dimensional worms and fully formed specialized baits. The molds are virtually unbreakable and feature built-in alignment pins for easy assembly. C-clips are included with each mold to keep the mold closed during filling. The injector is used to force the hot plastisol into the mold. Its reservoir is large enough to make several baits from one filling.



About The Material You Will Be Using

The Soft Plastic (Plastisol)

Our liquid plastic is a scorch resistant hot-melt plastisol formulated to make soft flexible baits. It can be reheated, allowing you to reuse plastic scraps.

Hardener

Add our hardener to your liquid plastic for harder, tougher worms. Always mix into cold, liquid soft plastic.

Coloring - Our coloring is highly concentrated pigment and can color up to 1/2 gallon of plastisol. Available in easy-to-use dropper bottles.

Tools and Materials Needed:

Mold	Injector	C-clips
Aluminum Foil	Plastisol	Stir Sticks
Coloring	Microwave	Paper Clip
Goggles	Gloves	
Long sleeve shirt and pants	Non-Stick Cooking Spray	

Optional

Scent	Salt	Glitter	Hardener
-------	------	---------	----------

View our Worm Making Video

http://www.youtube.com/watch?v=TnZmPo1Q_MU



Getting Ready To Shoot Some Baits...

1) Ready the molds for pouring

Plastic baits will stick in the mold unless the mold is lubricated. To make your baits easy to remove, apply a liberal amount of vegetable oil cooking spray to the mold cavity before shooting.



2) Assemble the Molds

The mold's built-in alignment pins are positioned so the mold can only be completely closed in one position. Use all of the C-clips included with your mold to secure the halves of the mold. The number of clips required depends on the size of the mold. Make sure to clip the mold on both sides to prevent leakage.



3) Prepare your Plastic

Mixing

Soft plastic (plastisol) used for making plastic baits is a thick milky white liquid. It must be thoroughly mixed to blend the material that has settled to the bottom of the container. Improperly mixed plastisol will make poor worms and the entire container of plastisol will be wasted. *We recommend removing some of the plastic from the container to allow for proper mixing, you can then blend this plastic back in to the container.*



Heating

The liquid plastic must be heated. Your microwave is the best way to heat your plastic. We recommend that you heat the plastic in a microwave safe measuring cup. Fill your measuring cup with about 1/2 cup of mixed liquid plastic. Heat for 1 minute, then stir. Heat for 30 additional seconds and stir again. Repeat until plastic becomes clear and thick (like syrup). Microwaves vary in power, we have found 1-3 minutes is average for this amount of soft plastic.

Customize your Plastic

You can now add coloring, glitter, salt and scent to your heated plastic.

4) Lubricate the Plunger. Fill the reservoir

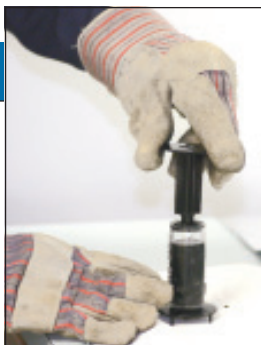


Spray the O-ring end of the plunger every time you fill the reservoir with heated soft plastic. Fill your injector about $\frac{3}{4}$ full of heated soft plastic.



5) Injecting your mold

With the filled injector body still sitting on your work bench, insert the plunger. With the plunger in place, turn the entire injector over so the nozzle points upright. Slowly press the reservoir down on the plunger until the hot plastisol starts running out of the nozzle. This will purge any air left in the injector. If some of cooled plastisol has blocked the nozzle, pick off the excess and poke the nozzle clear with a bent paperclip. It takes minimal pressure to fill a mold. Do NOT use excessive pressure to clear the nozzle. Severe burns may result.



Place the mold on the injector with the nozzle in the smaller injection gate of the mold. This will be in the tail end on the bait. Holding the mold firmly with both hands, apply slow downward pressure until the soft plastic fills the mold and the overflow reservoir at the top of the mold. Two cavity molds need a short cooling period before filling the second cavity. Set the mold aside for a few seconds and fill another mold while you wait for the first cavity to cool.

6) Allow mold to cool

Remove the mold from the injector and stand the mold upright. Allow the soft plastic to cool to a solid consistency. The amount of cooling time will vary based on the size of the bait and number of mold cavities.



7) Remove your bait from the mold



Remove the C-clips and separate the 2 halves of the mold. Your bait will still be warm and soft. Use care not to stretch the bait when removing from the mold. Lay bait out straight on a piece of aluminum foil to finish cooling. After completely cooled, carefully pinch off the sprue with your fingers. (Some baitmakers prefer to cut off the sprue with a razor blade)

Your baits are ready to fish!



Soft Plastic Molding Tips

- Keep your plastisol well mixed.
- Start your session by making lighter colored baits. Plastisol colors can be darkened, they can't be lightened.
- Save and recycle your scrap and used baits. Everything can be re-melted.
- Bait colors will sometimes bleed, so keep different colored scraps separate to recycle.
- Overheated plastisol will burn and become unusable.
- Use vegetable oil to lubricate molds, injectors, cups and pans.
- Plastisol will drip and overflow. This can be easily cleaned up and reused.
- Lines and clouding may show up in the molds and injector. This is a normal result of moisture and has no effect on the mold or injector.
- Soft plastic shrinks as it cools. Make sure the overflow and fill reservoirs are full to the top when you inject the mold. Underfilling will cause hollow bodies.
- To Make A Blood Line (coreshot) - This method requires two injectors. Shoot the body color and leave the mold about 1" short of filling. Immediately shoot the contrasting color to fill the mold. This will make a blood line in the center of your bait.



Questions ?? We are here to assist you!

Contact our Technical Customer Service Department
Techhelp@jannsnecraft.com
Phone 419-868-8288
Fax 419-868-8338