

Built-In Injector Series

SOFT PLASTIC MOLD INSTRUCTIONS



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 immediately when it contacts the plastisol and cause it to spew in all directions.
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

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. Wing nuts are included with each mold to keep the mold closed during filling. The plunger is used to push the hot plastisol into the mold.

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

Optional

Scent	Salt	Glitter	Hardener
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http://www.youtube.com/watch?v=TnZmPo1Q_MU

Make your own
Soft Plastic Baits Video



View our Worm Making Video

1) Ready the mold 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 and the plunger before shooting.



2) Assemble the Mold

The mold's built-in alignment pins are positioned so the mold can only be completely closed in one position. Use all of the wing nuts included with your mold to secure the halves of the mold. The number of nuts required depends on the size of the mold. Tighten the wingnuts evenly finger tight. Never use pliers to tighten nuts.



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) Fill the reservoir

Lay the mold on a flat work bench and slowly pour plastic filling the mold reservoir about $\frac{3}{4}$ full of hot soft plastic. Leave space in the reservoir for the plunger to fit.



5) Injecting your mold

With the filled mold still sitting flat on your work bench, insert the plunger into the reservoir until it contacts the hot plastic. Once the plunger is in place, turn the entire mold on end so the plunger is at the bottom and points upright with the cavity at the top. Slowly press the plunger into the mold reservoir until the hot plastisol fills the mold cavity and the overflow reservoir. It takes minimal pressure to fill a mold. Do NOT use excessive pressure to fill the mold. **Severe burns may result.**

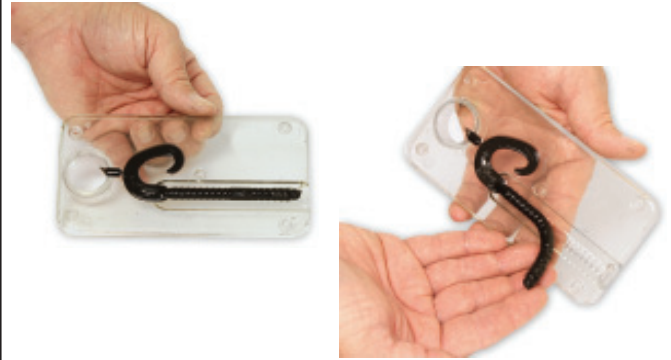


6) Allow mold to cool

Let the mold stand in the upright position and allow the soft plastic to cool. If the mold is laid flat immediately after shooting, hot plastic will run out of the overflow and result in a misformed and/or hollow bait.



7) Remove your bait from the mold



Remove the wing nuts and separate the 2 halves of the mold. Your bait may 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. This is a normal result of moisture and has no effect on the mold.
- 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.



Questions ?? We are here to assist you!

Contact our Technical Customer Service Department

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