STUMBELBLOC - instructions for making and de-moulding the block

1. **Block making should only be done in some form of shade – not direct sunlight. Direct sunlight and extremes variations of temperature may cause the blocks to crack before they are properly cured.**

2. Paint/coat the whole of the inner surface of the two halves of the mould using used cooking oil or similar. (Note: on first TWO uses, a heavier oil e.g. gearbox oil: SAE 80W90 oil is recommended to compensate for oils released from the plastic). The oil can be painted on or sprayed using compressed air and a conventional paint sprayer OR a simple hand pump spray bottle. The latter method is quicker, easier and provides more even coverage. **This step is vitally important to ensure easy de-moulding. Note that it is vitally important that ALL internal surfaces and edges of BOTH moulds are coated. Improper coating will result in difficulty in de-moulding. Also ensure that the edges of the moulds are oiled.**

3. Stand the mould up with the open side at the top.

4. Using the bolts and wing nuts provided, join the two halves of the mould together. **Ensure that a washer (provided) is used BOTH sides to spread the load.** Slide the aluminium rails down each side of the joined mould.

5. Stand the mould - open side up - on a firm surface. **Note: If possible, use a vibrating table. This provides easier filling and avoids the need for tapping the mould (see step 7). A simple vibrating table can be constructed using a metal plate attached to a small table using motor engine mountings (or similar). An electric motor is attached to the underside of the table. Any suitable motor will suffice – e.g. an old washing machine motor or similar is ideal. The vibrating action is achieved by attaching bolts to the spindle of the motor – see photo.**


7. Whilst filling, tap both sides of the mould, top and bottom firmly with a rubber mallet to ensure that the cement mix properly fills all the cavities of the mould. **Note: this step is unnecessary if a vibrating table is used.**

8. When the mould has been filled to the top give a final shake and tap. After a few moments the cement mix will settle in the mould top up with cement as necessary and smooth off the open end with a trowel. After a few minutes the cement mix will settle. This will leave a gap of 1-3mm between the mix and the top of the mould. **This is part of the design of the brick and does NOT need to be “topped up”.**

9. Once the mould has been filled place on a level firm surface and leave to dry. **Do not move the filled mould for at least 24 hours after filling. Movement will cause the plastic mould to flex and the filling may crack.**

10. Leave to cure for a minimum of 24 hours (in ambient temperatures above 16 degrees) or a, preferably, a minimum of 48 hours (in ambient temperatures below 16 degrees C. and above 3 degrees C before de-moulding. **Note: Block making should not be attempted if ambient temperature is below 5 degrees.**

11. To remove the brick from the mould, stand on a firm surface. Use the edge of the small washer (provided) to run all around the middle seam of the mould to loosen any cement.

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mix. Then use the **large** washer placed in the middle of the seam at the top by twisting it to further loosen the mould. Pull half the mould away from the block. Then, using the handle end of a mallet or similar tool and knock the remaining half of the mould, first through the through the bottom cavity and then through the top cavity to loosen the second half. Having loosened the second half remove it from the block.

12. After removing the brick from the mould – leave to stand for at least 14 days to ensure proper setting. At this stage, mould can be left in the open air/sun if necessary.