

FROM CLAY TO BRONZE

90 foto's showing the making of the sculpture "The Swimmer"

From inspiration up to the finishing touch

- **From clay to wax**
- **From wax to bronze**

- **Modeling the sculpture in clay**
- **Making of a copy in wax**
- **The lost wax technique : casting the sculpture in bronze**
- **Finishing the bronze sculpture**

1 modeling the sculpture

Inspiration

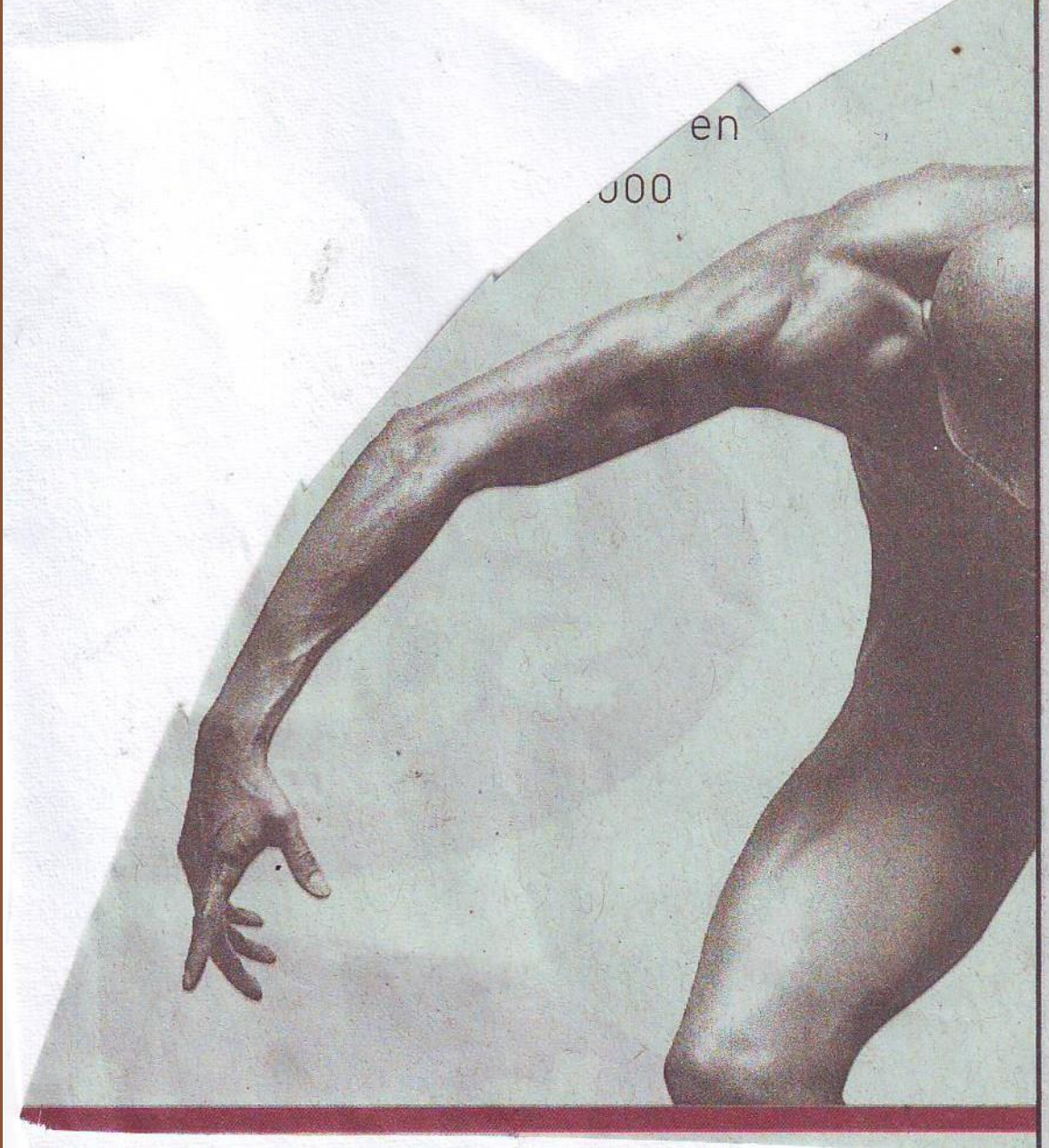
Preliminary study

Foto's

Drawing

Fixture for the sculpture

Modeling



Inspiration : foto in magazine :
publicity for ballet event

Michael Phelps in olympic games





Draft on paper





Fixture in iron



Starting modeling in clay

















The Swimmer in clay front view





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The Swimmer in clay detail



- **2 Making of a copy in wax**
- Rubber and plaster mold
- Making of a copy in wax
- Retouching the wax sculpture



First layer of rubber



Dividing plates are placed



Second rubber layer



Opening in rubber mold used to
pour in the wax



Making plaster mold on the rubber mold



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Preparing the connecting holes



Unfixing the plaster mold



The 3 pieces of the plaster mold



Unfasting the rubber mold



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The sculpture in clay visible again





All the parts of the mold and what rests
of the original clay sculpture



The parts of the rubber/plaster
mold



The original clay figure returns to
the clay container



Rubber mold fixed into plaster
mold



All parts put together



Brushing warm wax into the
rubber mold





All part brushed into with warm
wax



Connecting the mall parts with
iron wire





Pouring warm wax in



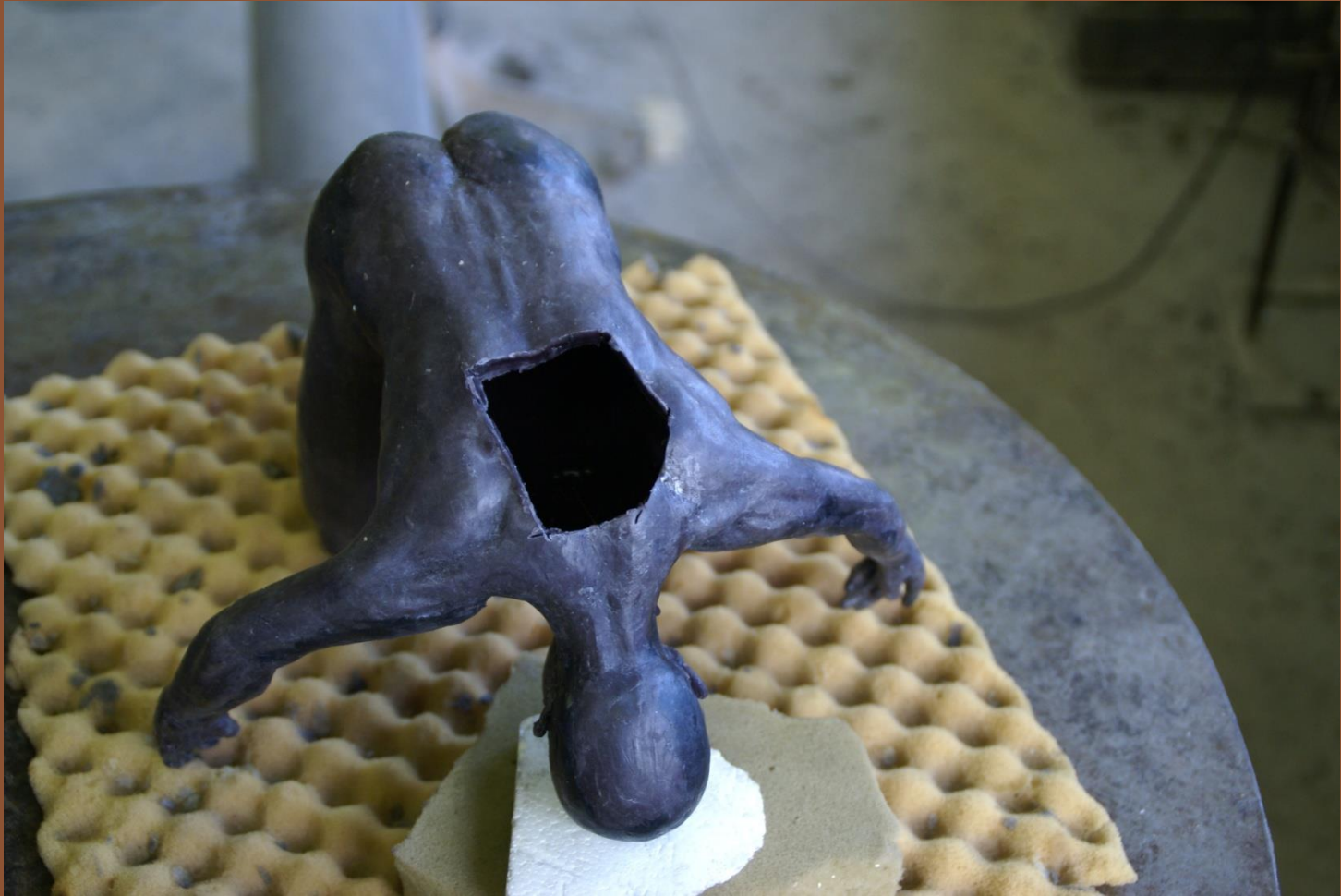
Opening the mold when the wax is cooled





Copy in wax before removing the casting seams

- **3. The lost wax technique**
- Mounting the pour channels and the vent channels
- Covering the wax sculpture with fireproof plaster
- Warming up in the oven : the wax is lost
- Casting in bronze











All elements in wax are mounted.





Detail of the wax casting pipes on
the hand







Covering with fireproof plaster



First layer of fireproof plaster































Ready for warming up in the oven



Intersection of the molding cilinder with the wax sculpture inside



Molding forms in the sand box
ready for casting



Liquid bronze on 1,350°C ready
for casting



Pouring the liquid bronze into the casting forms



A few minutes after the casting
ready to cool off for 3 days

- **4. Finishing off the bronze sculpture**
- Extrication out of the molding cylinder
- Removing the casting channels
- Grinding and sand blasting
- Patinating



Molding cilinder with bronze
sculpture inside



Removing the fireproof plaster



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Bronze sculpture with casting pipes and plaster layer



Cutting off the casting pipes



Removing the plaster inside



Sculpture after removing the casting pipes



After sand blasting



Finishing off





After sand blasting
Ready to be colored



Warming up



Brushing the primer



Primer is fixed



Second patina layer





Dark wax on second patina layer



Ready after rubbing up with
cleaning cloth



finished