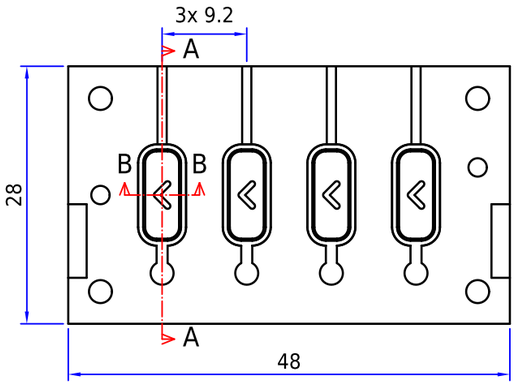
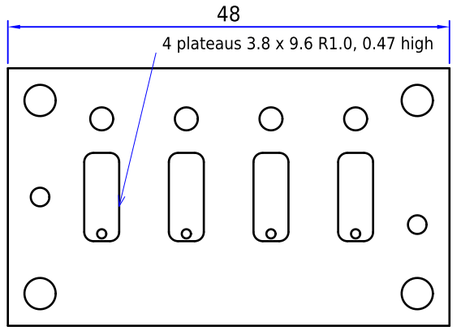
CAVITY HALF from above (parting face), 1.5:1

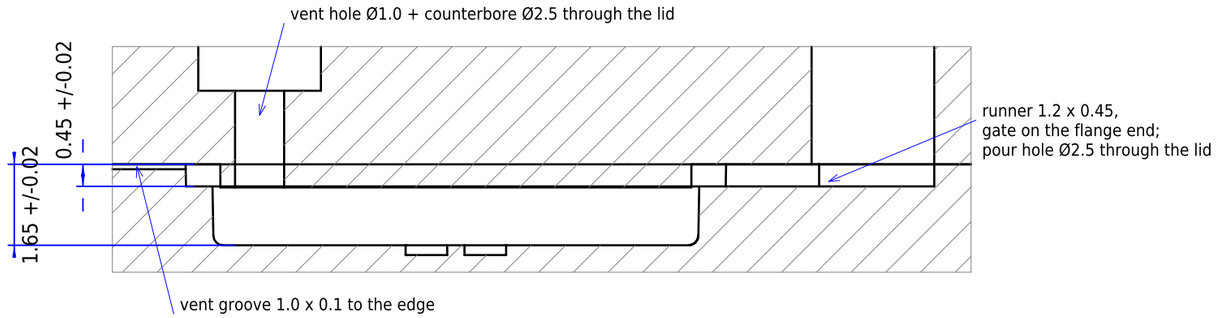


LID from below (mould face), 1.5:1

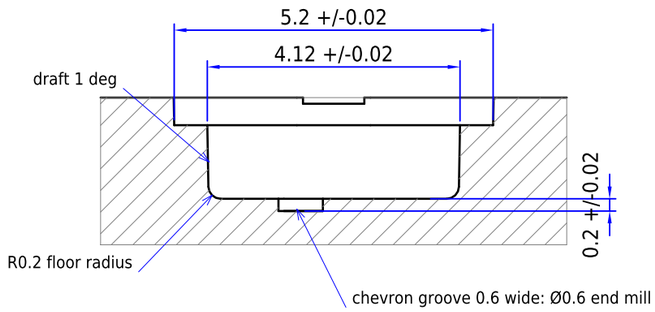


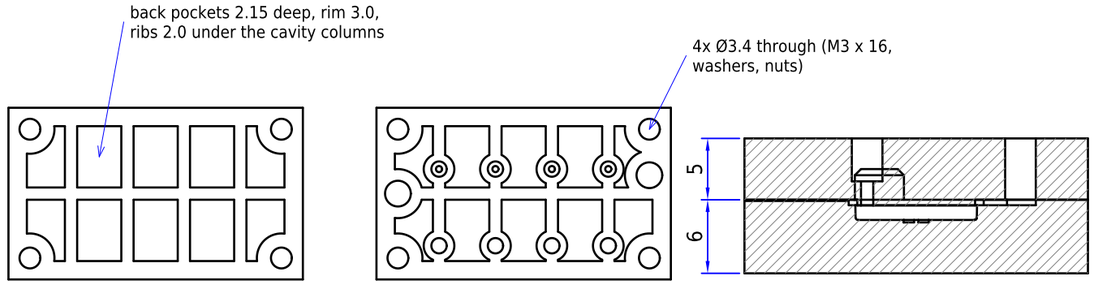
ID	FEATURE	SPECIFICATION	NOTE
1	Material	aluminium 6061-T6, two parts 48.0 x 28.0 x 8.0; 1 set	
2	Finish	cavity half: fine glass-bead blast (matte key face), no anodising; the builder polishes the chevron groove floors (glossy chevron top); lid: as machined; both parting faces flat 0.02	
3	Cavities	4, = side key FK-H-04 face down without its recess; draft 1 deg on cap and flange walls; cap 4.12 x 9.92 at the flange step (key tolerance -0.05/-0.15); no shrink allowance (PMC-780 DRY < 0.1 %)	outlines, depths +/-0.02
4	Cutters	chevron groove Ø0.6 end mill along its centre line (R0.3, the smallest radius); floor radius R0.2: bull-nose or ball cutter; runner Ø1.2; corners of runners, vent grooves and pry slots not dimensioned: tool radius, R0.6 max	
5	Holes	dowels: 2x Ø2.0 H7, 5.0 deep (cavity half), 2x Ø2.02-2.03 through (lid); M3: 4x thread 6.0 deep, drill Ø2.5 x 7.0 (cavity half), 4x Ø3.4 through (lid); per cavity pour hole Ø2.5 and vent Ø1.0 (counterbore Ø2.5) through the lid	H7 reamed
6	Bought	2 dowel pins ISO 8734 Ø2.0 m6 x 8.0; 4 socket head screws ISO 4762 M3 x 12, stainless steel	
7	Resin version (default)	SLA resin print, JLC3DP: the same cavities, plateaus, runners, vents and pry slots; plates 6.0 and 5.0 thick, ribbed back; printed pins Ø4.0 (sockets Ø4.2); 4x M3 x 16 through bolts, washers, nuts; no threads	print parting face up; mould release before every pour

SECTION A-A (closed mould, along a cavity, 8:1)



SECTION B-B (across a cavity, cavity half, 10:1)





RESIN: CAVITY HALF from below, 1:1

RESIN: LID from above, 1:1

RESIN: SECTION A-A (closed), 2:1

NOTES

1 Press the dowel pins into the cavity half; they stand 3.0 above the parting face. They are offset, so the lid fits one way only.
2 Once, on arrival: polish the floor of each chevron groove (sharpened toothpick, metal polish) for a glossy chevron top. Before each pour: clean both halves, spray a mould release made for urethane rubber and let it dry.
3 Stand the cavity half level. Pour the mixed rubber slowly into one corner of each cavity until it is level with the parting face. Lower the lid over the dowels slowly; the surplus leaves through the pour holes and the vents. Fit the four M3 screws, tightened evenly.
4 Gates and vents sit on the flange end and on the hidden inner face, never on the key face. After the cure open the mould with a screwdriver in the pry slots, cut the stubs flush and glue the stiffener in (FK-H-04). Casting steps: 3_rubber_keys/README.txt.
5 JLCCNC: upload FlashKa_key_mould_cavity.step and FlashKa_key_mould_lid.step as two parts with this drawing; each is 48.0 x 28.0 x 8.0 or more.
6 Resin version (7, the cheap default): JLC3DP, SLA resin, upload FlashKa_key_mould_resin_cavity.stl and _lid.stl as two parts; print with the parting face up so that supports touch only the ribbed back. The pins are offset like the dowels. Resin does not hold the aluminium tolerances: check a cast key in its opening. Mould release is needed on every face before each pour (urethane: a urethane mould release; Sugru: petroleum jelly).

CASTING MOULD - SIDE KEYS (4 PER POUR)

Part: FK-H-08 FlashKa_key_mould_cavity.step, _lid.step (aluminium); FlashKa_key_mould_resin_cavity.stl, _lid.stl (resin)	SCALES AS MARKED SHEET 1/1
FlashKa Keychain v0.7 2026-10-23	Units mm | ISO 2768-mK