

Shogun Warrior Reproduction and Custom Parts

Figure	Item	Resin type	Amount of each A and B	Drop of each color
	Alumilite bottle re-drilled to 1/16" hole (original hole too small): Blue, Red, Yellow			
	Smooth-On: Black, White, Purple, Orange			
	Castin Craft from Hobby Lobby: Blue			
	Testors Enamel Paint, using cut tooth pick for drips (100 drips was at 3.5 ml)			
	Task 2 will likely replace Task 8 or 9. And 65D has replaced most of Cast 326			
Mazinga				
	Condor Brain	Cast 326	20ml each pressure cast	1 white 3 orange 1 red
	Sword	Cast 326 or 320	15ml ea	1 white 3 orange 1 red
	Leg Missile Clip 5 missile position	65D	7.5ml ea	5 black
	Fist	65D	10ml ea pours 2 separate rotational pours for better thickness	4 blue 3 purple 6 black
	Cuff	65D	20ml ea	4 blue 3 purple 6 black
	Tall Mazinga Head	65D or 45D	70ml 6 lines up	4 drops black for gray head
GaiKing				
always stir Part B	Custom Wing and Jet	Cast 305	If top then 90 ml 75ml each 5 oz cup use top line on 5oz cup to have more than enough	21 red 15 orange
	Wing attachment	65D	22 ml each	15 yellow
	Fist	65D	10ml ea pours 2 separate rotational pours for better thickness	1 blue 1 purple 11 black
	Sleeve	65D	20ml ea	1 blue 1 purple 11 black
	Shooting fist insert	Task 9	15ml ea old solid version pressure cast	1 blue 1 purple 11 black
D17				
	D17 Cuff	65D	15ml	8 drops sun devil

Raydeen							
	Custom Missile	Cast 326	5ml each for one	3 white			
	Bow Fist	65D	50ml total ea 5oz cup 3rd line from bottom 20 ml pour 20ml pour 10 ml pour	10 blue 7 purple 17 black	old notes '----->	10 blue 9 purple 10 black	
	Bow Parts original version	65D	30ml each for 2 (1 set)	white 10 yellow add scrapes of orange for dark yellow			
	Hawk launcher	cast 320	10ml ea extra, but to keep from getting soft	2 purple 3 black			
	Custom bow	65D	30 ml each for making 2	10 yellow add orange to suit			
	Custom bow base	65D	20ml for 2	10 red 6 orange			
Dragun							
	Star Cover	not sure yet 65D or 326	7.5 ml ea	black			
	Axe	cast 326	7.5 ml ea				
	Star Clip	65D	10ml ea	black			
Taekwon V							
	Shoulder	65D	15 ml ea	15 black			
	Chest	65D	50ml 3 lines up on 5oz cup	20 red 16 orange			
	Head	45D	around 70 ml to be safe 5 lines up on 5 oz cup pressure cast	6 red 16 orange 11 white			
	Sleeve uses Grendizer sleeve insert	65D	20ml pour into mold first, then add insert	20 black			
Godzilla							
	Fist	45D	22 ml for solid	1 blue 6 green	?? Have not continued ?? testing with		

Dangard							
	One wing		65D	75ml ea solid fill 6 lines up on 5oz cup	18 red 12 orange	26 red 26 orange	
	Leg Lance		65D	20ml ea pressure cast	8 red 5 orange	7 red 7 orange	
	Post for hand piece for leg		65D	20ml for 2 sets	8 red 5 orange	7 red 7 orange	
	For Leg Lance and Post		65D	30ml pressure cast	12 red 7 orange	11 red 11 orange	
	Lance leg holder		65D	7.5ml	7 black		
	Fist		65D	2 pours of 10ml each from 20ml batch	1 blue 1 purple 11 black	Marvel --->	7 blue
	Cuff		65D	20ml	4 blue 2 purple 7 black	Marvel --->	7 blue
	Shoulder		65D	2 pours of 20ml	10 drops sun devil		
	Ball adapter		65D	10 ml	5 drops sun devil		
	Head		45D	50 ml 2-1/2 lines up on 5oz cup	20 black		
	Horn for Helmet		65D	20ml for both molds	65D	5 drops of Sun Devil	
	Helmet		65D	50ml 3 lines up on 5oz cup	22 red 26 orange		
	Torso		65D	2 pours of 100ml top line of 5oz cup	35 red 35 orange	Marvel --->	33 blue
	Chest Cover		65D	20ml pour into open mold first	20 black	Marvel --->	7 blue
	Upper Leg		65D	2 pours of 25ml	13 drops sun devil		
	Lower Leg		65D	2 pours, 45ml 2 lines up on 5oz cup	2 blue 1 purple 25 black	Marvel --->	15 blue
	holes: 15/64"						
	Foot		65D	2 pours, first 45ml 2 lines up on 5oz cup	2 blue 1 purple 25 black	Marvel --->	15 blue
	brass tubing 1-1/4" long 15/32 inside of 1/2"			second pour, 25 ml	1 blue 1 purple 12 black		7 blue
	Wheel and Leg Holder		65D	15ml	15 black	1/8" brass tube insert	

T28							
	Rocket Pack		65D	20ml	6 blue		
					3 black		
			65D	then 15ml for more thickness			
	Sleeve		65D	20ml	6 blue		
					3 black		
	Fist		65D	20ml	6 blue		
				2 - 10ml pours	3 black		
	Crown		65D	20ml ea	10 UV	3/16" tube for pin	
Daimos							
	Leg Missile		65D	7.5ml for hollow	4 yellow		
				7.5ml for hollow	3 red		
					2 orange		
	Fist		65D	10ml ea pours	1 blue	Famosa-->	4 purple
				2 separate rotational pours	1 purple		4 blue
				for better thickness	11 black		
	newer shooting cuff for Mattel Daimos version		65D	make 20 ml mixes	1 blue		
					1 purple		
				do 2 - 10ml slushes	11 black		
	Sleeve		65D	20 ml ea	1 blue		
				15ml for main sleeve	1 purple		
				5ml for top cap	11 black		
	Shooting fist insert	Task 9		15ml ea	1 blue		
				for old solid version	1 purple		
				pressure cast	3 black		
	chest leg pieces	17ml sep 15ml sep	65D	17 ml for mold	20 yellow	pour in first, then top off	
				30 ml ea for all 3			
				pressure cast			
	General Daimos cuffs		65D	2 pours, 20ml each	7 red	Famosa -->	6.66 red
					12 yellow		8 orange
	General Daimos Chest Cover		65D	20 ml	7 red		
					12 yellow		
	Ball adapter		65D	10ml each	4 red		
					6 yellow		
	Daimos Ear		65D	10ml each	5 drops of sun devil		
Getter 2							
	Drill Screw		65D	30 ml each		Ugly Orange	10 yellow
				plus 30ml aluminum powder			3 red
	Drill Base		65D	15 ml each	8 blue		
					1 black		
	Clamp Arm		65D	25ml (all one piece)			
				15ml			

Combattler						
Shoulder / Waist yo-yo			30ml for 4 7.5 pours	12 red 12 orange		
Ankle yo-yo		65D	20 ml for 2	8 red 8 orange		
Custom yellow torso		65D	10ml ea	6 yellow		
antenna replacement		65D	7ml ea	2 orange 3 red		
Chest piece		cast 326	10ml ea pressure cast	4 white 2 red 4 orange		
Sleeve and endcap		65D	30ml ea	4 blue 1 purple 23 black	Marvel --->	22 red 14 orange
Fist		65D	10ml ea pours 2 separate rotational pours for better thickness	4 blue 1 purple 15 blacke	Marvel --->	15 red 9 orange
Insert for shooting fist		Task 9	15ml ea pressure cast	4 blue 1 purple 4 black	Marvel	4 white 8 red 6 orange
Rubber Track		Econ 80	5ml for each	5 black		
Grendizer						
Fist		65D	10ml ea pours 2 separate rotational pours for better thickness	14 blue 6 black		
Sleeve		65D	20 ml ea	14 blue 6 black		
Red Blade		45D	15 ml ea	5 orange		
went to 65D to keep old mold going. 5 red, 4 orange		80A rubber		1 red		
			80A will stretch without breaking if needed (normally use 45D)	3 white	was 2	
Mattel sickle or popy		65D	30 ml for set of sickles	15 drops of sun devil		
Mattel Chest Piece		65D	30ml + ea	8 orange 4 red	Popy chest, need to slush mold	
knee piece		65D	5ml ea	4 orange 2 red		
front neck part and wheels		Task 9	7ml ea pressure cast	1 white 2 purple 2 black		
Original shooting insert		Task 8	30ml	10 black		

Mini Grendizer						
	Mini harken	65D	7.5ml		4 drops of Sun Devil	
Spazer Ship pieces						
	Vertical Fin	65D	70 ml ea pours 2 separate rotational pours for better thickness On 5 oz cup, 6 lines up from bottom		37 red 28 orange	
	Fin base piece	65D	25ml ea		12 red 9 orange	
	Side cutter	65D	15ml ea		8 red 6 orange	
stir Part B	Wing (new)	Task 2 (113 grams)	60ml ea On 5 oz cup, 5 lines up from bottom to be safe		25 white 25 drips of sun devil (1% = 1 gram)	1,1 grams Sun Devil
	Pod for wing	65D	2 rotaional pours 1st pour 30ml ea pour plug with this mix		16 red 12 orange	
		2nd pour	15ml ea		8 red 6 orange	
Plastic	1/16" ABS white, got some from Industrial Plastic Supply (IPS), could likely get from anywhere .09" Black Styrene, got from IPS above 1/8" ABS white, this is a crap shoot. Sometimes a really nice white, sometimes more beige Got nice white from ebay "Pop Displays" first time, search 1/8 x 23-7/8 x 23-7/8 Heat to dry the 1/8" ABS for 1 hour to minimize any moisture bubbling Full heat is approximately 3 to 3-1/2 minutes. Ensure you clamp the plastic down extra to prevent air leak					
Paint	Adhesion Primer from Advance Auto Parts or Valspar clear Plastic Primer Bosny River Blue or am testing Rustoleum Gloss Maui Blue Duplicolor Cardinal Red					
Wheels	Shepherd 9489					
Poseidon						
	Missiles	65D	30ml ea 5 ml pours for one missile		15 yellow touch of orange	
	Pump	65D	2 pours of 15ml		7 Castin craft blue	
Jeeg						
	Fist	65D	22ml		3 black (so far, may go darker)	
	3/4" brass tube		2 slushes; 12 then 10		10 blue	
	Shooter inserts	Task 2	20ml			
Kamen Rider						
	Fist	65D	30ml 10ml again for fist area		10 red 12 orange	White ---> 15 drops of sundevil
	Belt	65D	15ml		7 drops of sun devil	

Voltron						
	Sword	65D	30 ml ea	4 black		
	Jaw clamp	65D	15ml ea	4 white	7 drops of Sun Devil	
	Voltron Wing	65D	50 ml 3 lines up on 5 oz cup	16 red 14 orange		
	Wing Button	65D	5ml	5 black		
Liger						
	Wing missile tip	65D	5 ml each	5 yellow		
	Head and Base	65D	75ml 6 lines up on 5oz cup Pour base first, then head Pour into head mold first Pressure cast	48 blue 5 green 11 black		
****	Left shooter arm	Task 8	25 ml pressure cast	20 Castin Craft blue		
	Left arm parts button and pin	Task 8	7.5ml	4 Castin Craft blue		
	Flower	65D	15 ml	7 Castin Craft blue		
	Left shooting missile and reducer hole mold	65D	12ml	3 red 4 orange		
	Right Arm	65D	25 ml could be a bit darker 15 ml second pour	1 alumilite blue Castin Craft blue, 4 grams 4 blue		
	Feet wing pieces	65D	7.5ml	3 UV white		
****	Drill final srew hole with .106" bit for 4-32 screws					
Voltes						
	Sleeve using Daimos mold	65D	20 ml ea 15ml for main sleeve 5ml for top cap	5 blue 5 black		
	Chest piece	65D	30ml 20ml	12 red 18 orange 8 red 12 orange		
	Head	45D	50ml 3 lines up on 5oz cup Pour into mold, then plug	12 orange 3 red 8 white		

U5 Mazinger					
Chest piece	65D	25ml ea	6 orange 3 red		
D17					
wing	Task 9	15ml ea	20 white		
X Bomber					
Fist	65D	10ml first pour 7.5ml second pour	7 blue 5 blue		
Shoulder pad	65D	10ml per pad make 20ml batch	15 yellow touch of orange		
Sword handle and sword	65D .44 tubing	20ml, may need reduced most likely need another 10ml batch for thickness	4 black		
Hilt Guard	65D	15ml first pour 7.5ml second pour 2 pieces of .44 tubing	15 yellow ? 7 yellow ?		
Daikengo					
Fist	Task 8	10ml for both catch pin molds	10 black		
7/16" brass tubing for fist holes	65D	make 20ml, but 2 - 10ml pours	14 blue 6 black		
Missile	65D	15ml open top of mold to pour	4 red 5 orange		
Hip Wheel	65D	17 ml	6 red 5 orange		
Front Foot Wheel	65D	12ml for complete fill	12 black	1/8" brass rod	
Battle Fever conversion					
BF torso	65D	100ml top line 5 oz 70 ml 6 lines up on 5oz cup 70 ml	100 black (5ml)		
Arm through piece	65D	80ml 7 lines up on 5oz cup	80 black		
Neck piece	65D	10ml	10 black		
BF" emblem	65D	15ml	8 red 6 orange		
BF head	65D	30ml fill horn area and rotate some around	16 red 12 orange		
torso shooter pieces	Task 9	10ml	10 black		
2 nuts	65D	10ml + 10ml of aluminum			

GodMars						
	Fist		65D	20ml total 10ml ea pours 2 separate rotational pours for better thickness	1 blue 1 purple 11 black	7/16" brass tubes for fist holes
Granzel / Skyzel						
	Fist		65D	25 ml each Granzel	9 blue 1 black	
				1-1/2" brass insert slow tilt to get bubble out		
			65D	Skyzel 25ml	10 red 8 orange	close to Dragun red
			Task 8	7.5 ml for shooting insert	1 red 2 orange	
	Granzel wheel		65D	10 ml each	10 black	
	Granzel rim		65D	20 ml makes 4 so 5 ml each after mixing	10 red 6 orange	
Nakajima Missile						
	Missile head		65D	15ml mix use 2.5ml, enough to cover cup bottom completely	5 orange	
	Missile body		65D	20 ml mix use 2.5ml, enough to cover cup bottom completely	5 drops of Sun Devil	
Daltanious						
	Cuff		65D	12ml	12 black	
BioMan						
	Shoulder		65D	20+ ml	20 black	
	Head		65D	2 pours of 20 ml	10 drops of sun devil on 1st pour	
	Neck piece		65D	10 ml	10 black	
Mekanda						
	Leg Shield		65D	15+ ml maybe 305	6 blue 3 purple	
	Outer Arm Shield		Task 2	22 ml	3 orange 3 yellow 3 white	
	Inner Arm Shield		Task 2	30 ml	4 orange 4 yellow 3 white	
	Blades and Spikes		45D	make 60ml batch then 15 ml for molds	1 blue 2 purple	
	Whole Arm		65D	2 - 25ml slushes	10 red 8 orange	
	Lt Blue Cover		65D	12 ml	4 castin blue	
Elbow Shooter						
	Elbow shooter parts		Task 8	18ml	10 black	

Minos						
	Head		65D	First pour 3 lines up (50ml) 30ml second pour	1 black	
	Horns		65D	15ml ea	1 or 2 black (no notes)	
Samurai Destroyer						
	Fist		65D	20ml 2 - 10ml pours	8 red 8 orange	
Getter 3						
	Main Tank		65D	1st pour 200ml (2 top lines of 5oz cups) 2nd pour 100ml (top line of 5oz cup)	write down UV grams 3.2 grams	
	Tank Nose		65D	1st pour 50ml (3 lines up 5oz cup) 2nd pour 25ml	write down UV grams .9 grams (20 drops)	
	Rear Nozzles		65D	20ml fill up to grooves	5 red 11 orange	
	Forward Track Mount		65D	20 ml	7 castin blue	
	Outer Rim		65D	12 ml	12 black	
	Inner Hub		65D	5 ml	5 black	
	Waist Latch		65D	7.5 ml	4 drops of sun devil	
	Missile		65D	5 ml insert 7/32 tube after pouring in mold	1 red 1 orange	
	Head shooter, mount		65D	7.5ml	2 red 4 orange	
	Spring		MSC Industrial 05368139	.375x.026x1.5		
	Head shooter, front		65D	5ml pour into upper mold first, then into lower	5 black	
	Head shooter, clip		65D	2.5ml	1 drop sun devil	
	Shooting Upper Arm		65D	20ml	20 black	
	Shooting Cuff		65D	12ml	12 black	
	Flexy Arm Upper		65D	18ml	18 black	
	Flexy Arm Middle		65D	13ml	13 black	
	Flexy Arm Lower		65D	12ml	12 black	
	Flexy Ball Joint		65D	15ml just enough	15 black	
Vex through hole drill bit size for hubs .166" for the 8-32 screws						
Aluminum bar for tank: 1/2" x 3/8" x 5-1/2"						

Tryger						
Wing		Task	35ml	15 yellow	Not a great original match	
Tough to cast and not have voids or air bubbles						
Chest Emblem		65D	20ml	1 white to help get color match	8 yellow touch of orange	
Complete full fist		65D	25ml	25 black		
Other special items						
5 missile clip		65D	7.5ml	8 black		
In-shoulder shooter for all parts		Task 8	15ml ea	10 black	30ml for the 2 smaller shooting inserts	
Leg Missile Clip (5)		65D	7.5ml ea	5 black		
newer standard shooting inserts		Task 8	15ml ea	4 black	to fill both I-beam type	
Shooting fist insert		Task 8	20ml ea	1 blue 1 purple 3 black	to fill both I-beam shooting inserts	
Springs from MSC Industrial Supply						
Liger			06810253: .18 x .016 x .625 03308475: .48 x .035 x 1.5	cut down to 1-1/2" ebay spring Servalite #94; 2-1/2" x 9/16 od x .026		
Raydeen chest shooter			068115411: .42 x .028 x 1.75			
Getter 3, head missile shooter			05368139: .375 x .026 x 1.5			
Battle Fever, lower torso			05367958: 7/32 x .02 x 1	?? may fit Gaiking chest & 3 missile fist		
In-shoulder shooter	new try		03308954: .85 x .054 x 2			
	new try		00612861: .24 x .022 x .3125			
	new try		06810238: .18 x .016 x .375 (for Godzilla pin)			
	old used		03308806: .72 x .047 x 2			
	old used		02085447: .24 x .026 x .375 (cut down)			

Weights			
GaiKing fist: original 1.17 oz, reproduction 2.46 oz			
GaiKing sleeve only: original 0.34 oz, reproduction 0.73 oz			
Daikengo fist: Kitsir repro was 131 grams, mine 31 grams			
T28: Kitsir solid rocket pack 200 grams, mine 57 grams			
Sun Devil usage: 25 drops per gram (single ml value divide by 2, for # of drops)			
5oz cup lines (approximate) at Walmart, Great Value, 80 count			
30ml, not quite to 1st line			
45ml, 2 lines up, maybe 2-1/2			
50ml, 3 lines up			
60ml, 5 lines up ?			
70ml, 6 lines up			
80ml, 7 lines up			
90ml, 8 lines up			
100ml, top line			
3d Prints: See document titled 3d Filament Used and Orders			