



## Instructions to Operate the School Chalk Machine Manually Manufacture Process for 216 chalk stones

### Material:

- 01 liter of diesel oil
- 100 grams of stearin
- 01 bottle or container
- 01 small piassaba broom
- 01 1" brush
- 01 rake (sink rake)
- 01 spatula
- 780 grams of plaster
- 1100 ml of water
- 01 plastic container size 1½ liter to 2 liters, to prepare the plaster

### 1 – Preparing the Demoulding Agent

- 01 liter of diesel oil
- 100 grams of stearin

Melt the stearin and mix it with the diesel oil, and put it into a bottle or plastic container. Pour a certain amount into a container and use a 1" brush.

### 2 – Starting the Chalk Manufacture

Lift the pins up to the top of the machine base and lubricate with the demoulding agent by using a brush. Lower the pins up to the final topi and lubricate again.

In order to prepare plaster, take a plastic container and put 1100 ml of water and 780 grams of plaster quickly, stir with a small piassaba broom until it gets homogenous.

Pour the plaster on the machine desk with a rake, so that all the molds receive enough quantity.

Remove any excess by using a spatula.

Wait for the chalk to harden, between 5 and 7 minutes (depending on the room temperature).

### Removing:

Tilt the machine until it locks, pull the tray, move the lever until the chalk is removed.

### Note:

Do not allow it to dry fully inside the moulds (remove it when moist, although hard).  
Always clean and lubricate the machine from one day to the next one.

### Drying Process:

Make rectangular sieves with a thin net, in order to place the pieces of chalk, on average for 02 days, to be fully dried under the sun.

### Suggestion:

Sieves made of thin nets measuring: 100 mm high × 700 mm wide × 1,500 mm long.