

# The Sand Casting Method of Bronze Casting

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There were two distinct methods for casting bronze sculptures during the 19th century: the lost wax method and the sand casting method.

With the sand casting process, a master model made from bronze, terra-cotta, plaster, or wax-covered plaster was used. A rectangular metal frame was filled with specially prepared fine, wet sand into which the model was half buried. A second metal frame was placed over the first and filled with more sand until the model was completely encased. The frames were then separated and the model was removed, leaving a detailed impression in the sand. Before the two frames were reassembled, channels were prepared for pouring in the molten bronze and for allowing gases to escape. A core of sand was often created to fill the majority of the mold's interior before the bronze was poured. The hollow bronzes created by this method reduced both the cost of metal and the weight of the sculpture. Complex sculptures were often composed of fragmentary sand casts that were welded together.

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