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GENERAL 'LY SPEAKING

Week of June 25, 2018

Dispatches From
The Eisenhower Memorial Commission

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Creation of the Eisenhower Memorial Sculptures

Part II: Making the Bronze with Sculptor Sergey Eylanbekov

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*The sculptor looking up at the completed bronze sculptures of two of the soldiers
Images and sculpture courtesy of Sergey Eylanbekov*

"The sculptures in this project are created for the public, for the people to observe them, to think and respond emotionally. That is where the visual power of art is most evident. I hope the bronze images will be strong enough to impress the visitors to the memorial and live in their memories."

- Sergey Eylanbekov, Sculptor

Last issue's special edition, in honor of the 74th anniversary of D-Day, featured the Commission's first of

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sculptor [Sergey Eylanbekov](#) and his multi-step process for creating clay models of the sculptures. If you missed Part I, you can catch up [here](#).

This week we present Part II, a look at how the full-size clay models are transformed into the final bronze statues. The process, called lost-wax casting or investment casting, has been used by artisans around the world for thousands of years. The goal is to take an artist's clay model and reproduce them in bronze, a medium that will stand the test of time.

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*Bronze sculpture of the General
Images and sculpture courtesy of Sergey Eylanbekov*

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Bronze sculptures of the soldiers

Images and sculpture courtesy of Sergey Eylanbekov; Photo by F. Martinelli

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The lost-wax process requires a series of positive and negative replications of the original clay models. Beginning in the sculptor's studio, rubber and plaster molds are made. A layer of rubber is applied to the clay, followed by an application of plaster for stability. Once the mold is set, it is divided in such a way that it can be removed in pieces from the clay surface. The mold sections are then sent to the foundry. During the process of removing the mold from the clay, the models are destroyed and the clay can be recycled.



*Finished clay sculptures (left) are coated in rubber (right) and then plaster
Image and sculpture courtesy of Sergey Eylanbekov*

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*Sections of the plaster and rubber mold are sent to the foundry
Image and sculpture courtesy of Sergey Eylanbekov*

Wax Models

After the plaster molds arrive at the foundry, they are used to cast wax models. Wax models are then encased in a liquid ceramic. After the ceramic hardens they are put into a hot furnace or kiln where the wax melts out leaving a void into which the bronze is poured.

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*Layers of melted wax are applied to the mold (top). The hardened wax model (left) is removed from the mold for further refinement and adjustment before being coated with a ceramic slurry (right).
Images and sculpture courtesy of Sergey Eylanbekov*

Cast Bronze

The statues are cast in pieces and then adjusted and precisely welded together. Seams are removed and residual elements from the casting process are sanded and cleaned. Although there are several ways to cast bronze, the lost-wax method allows for an excellent finish and accurate replication of the artist's details.

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*Examples of the bronze sculpture pieces coming together to form the full statue
Images and sculpture courtesy of Sergey Eylanbekov*

Completed Statues

The final step in the process is to apply a corrosive material to form a patina. This application will be done following the casting of the entire sculptural grouping and before the sculptures are set in place at the memorial.

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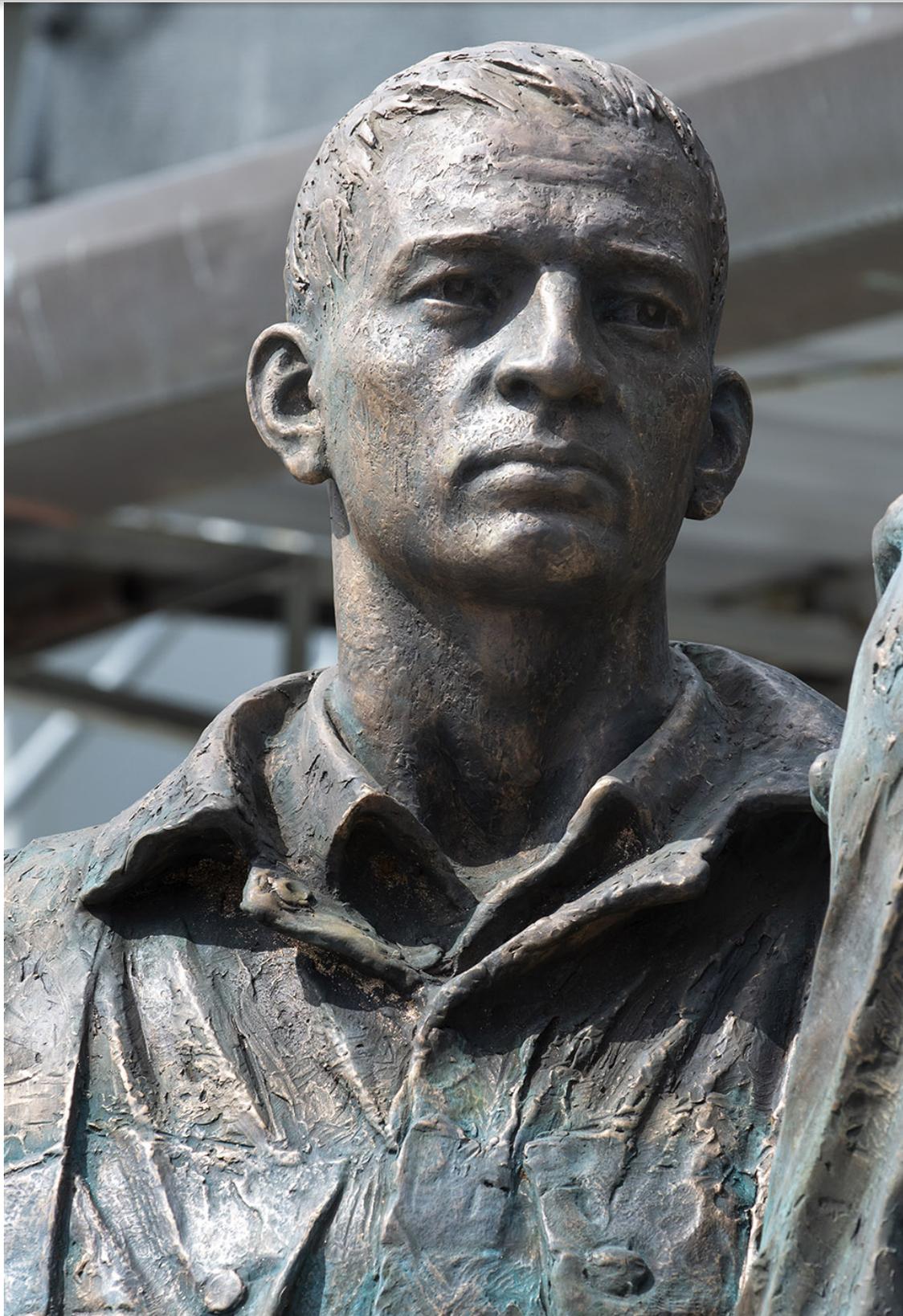
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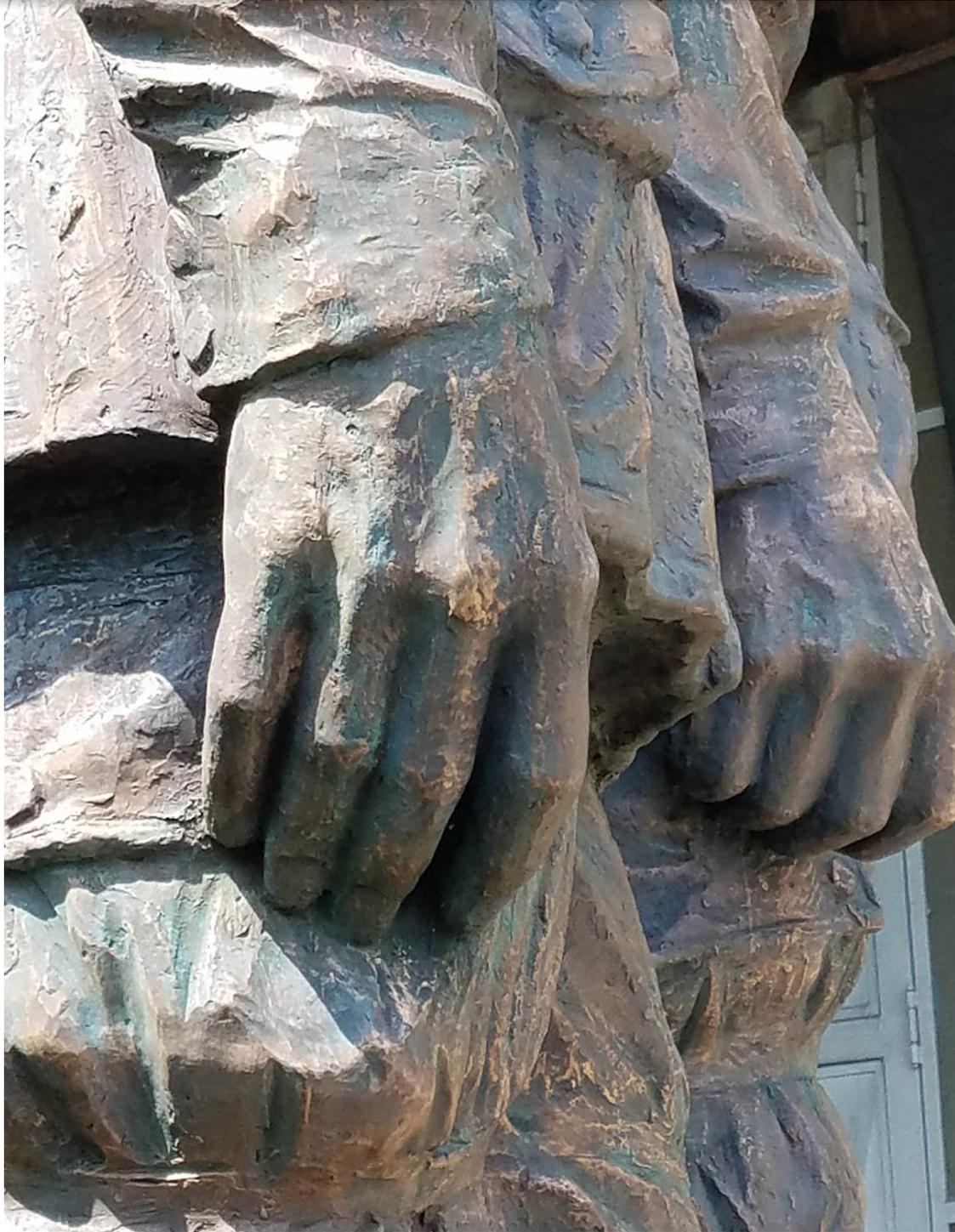
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*Bronze sculptures of General Eisenhower and details of two soldiers
Images and sculpture courtesy of Sergey Eylanbekov*

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