



A fresh look for the lady.

The most recognised trademark in the world had remained virtually unchanged for the past 92 years. During 1999, the Rolls-Royce Motor Car brand was acquired by BMW.

In 2000, the Polycast Ltd management team were approached by the purchasing team in Munich, with a proposal to produce the Spirit of Ecstasy mascot; probably the most famous Investment Casting in the world.

BMW had decided to re-tool the part, back to the original standard as used by Rolls Royce during the early 20th century. This procedure was necessary to match the new design of the Phantom 2 that was to be produced in Goodwood and to improve the delicate features of the Spirit Of Ecstasy, which had been worn away and regrettably replicated during previous re-tooling exercises before the advent of digital technology.

In order to produce the mascot to the original standards Polycast Ltd digitally mapped the old Spirit of Ecstasy. The mapped features were enhanced and manipulated until the desired result was achieved. From this three dimensional model the cast tool was created using cutters as fine as 0.2 mm.

The next stage in the process was to produce a very accurate wax model of the finalised design. The wax model was then coated in a ceramic slurry. Once this had dried the wax was melted away leaving a highly accurate female mould from which the mascot would be produced.

Molten stainless steel at a temperature of 1,600 o C is poured into the ceramic moulds and allowed to cool. Once this has happened the mould is broken open to reveal the cast mascot.

The cast figure is taken to the finishing department where they are inspected and polished using a process called peening, where the casting is blasted by millions of stainless steel balls only 17 thousandths of an inch in diameter. These help to polish the surface without being abrasive. The final operations are machining the base to fit to the RR grill and lastly a mirror polish finish. Once the quality assurance team are happy with the finished figure it is sent to Rolls-Royce where it takes pride of place, resplendent above the trademark grill.




The Rolls Royce 'Spirit of Ecstasy'
The world's most recognised car mascot has evolved since the first sculptures nearly 100 years ago. Polycast Ltd are proud to have played an integral part in the evolution and restoration of a heritage icon.



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