

HEY! WHO STOLE MY CLOTHES?

WHY CANT I SEE ANYTHING?

WHO TOUCHED MY ARSE?

BIT NIPPY IN HERE, ISNT IT?

QUIET AT THE BACK THERE...

Silicon fanny

What's it like making fuck-puppets for a living? loaded clocks in at California's famous RealDoll factory to find out

SEX DOLLS Words JEFF MAYSH Pics JEFF RAYNER

“We need six new vaginas down here! Right now!” barks the supervisor, tapping his watch urgently. Day one at the sex doll factory, and *loaded* is trying to drizzle pink silicon into a jelly mould shaped like ladies bits. The last batch of vaginas we made went a bit wrong. Now the race is on to ship out this week's consignment of RealDolls - the world's most realistic sex machine. Because when we

heard the Abyss Creations factory in San Marcos, California, was advertising for workers to help make these famous, super-expensive plastic chicks, *loaded* was straight on the plane.

rubbery jubbly

Since 1996, this factory - hidden in a lonely industrial estate - has been creating revolutionary sex dolls with moveable skeletons, flesh-like rubber skin,





I LIKETO KEEP ABREAST OF THINGS



"Yeah, Madame Tussauds wanted me, but their nipple work is just plain shoddy," says loaded's Maysy



SO I WAS DOWN THE PUB THE OTHER NIGHT



What the hell does a 'new style' penis look like?



and faces sculpted by Hollywood special-effects artists. Such is their quality, these rubber girls cost £3,400 each – more than a second hand Vauxhall Corsa. What's more, the RealDoll has become a worldwide sensation. The movie *Lars And The Real Girl* was inspired by them, Mötley Crüe have RealDolls on their tour bus and a signed poster from Bruce Willis hangs on the factory wall. But first, *loaded* is given the health and safety tour. "We offer an extensive list of options, including 10 female body types and 16 interchangeable female faces," boasts Blake Bailey, head of production for RealDoll, and *loaded's* new boss. "RealDolls are completely customisable, all the way down to the shape of her pubes," he says proudly. "This isn't just a factory, this is where we bring fantasies to life." Behind him, a worker listening to his iPod rushes past with a tray full of tits. Today is Wednesday, and *loaded* joins the production line on their busiest day. Six dolls have to be finished by 6pm and shipped off to Sweden, England, America, Finland and Japan.

batch of titties
 "It's hard to find staff," admits Blake, while his engineers start to assemble moveable skeletons in the workshop. Made from Meccano-style parts, they look like kinky Terminators before these metal labours of love are laid in a fibre glass bath full of medical grade platinum silicon. "We get lots of applications from people who get turned on by sex dolls," he sighs. "But we just couldn't leave them alone in here."
 Justin, 25, is the factory new boy, and tells *loaded* how he really loves his job. "I'm cutting breast shells right now, getting ready to pour a new batch of titties," he grins. Concentration creases his face as he lovingly moulds the C-cup breasts. "It was weird at first, but I soon got used to it," he says. "My girlfriend thinks it's cool too." Adverts for these jobs say applicants have to be skilled in moulding and airbrushing, but they also need to 'know their way round the female body'.
 "Our vaginas are moulded directly from porn star Jessica Drake," smiles Blake. "She came into the office and we poured plastic inside her. That was a fun day at the office," he admits. "It's funny, no one was late for work that day!" But today, it's nothing but hard work for *loaded*. The dolls weigh as much as real women, so it feels like carrying home drunk girlfriends all shift long. "Bring over those body sevens, pal," orders Blake, "They're nearly ready for the faces." Groan.

do you take plastic?
 'Body seven' is the most popular body that RealDoll create. Her creators at the factory say, "She's like Angelina Jolie, or what we call a 'stripper body'. She's got a nice small body, and cans that are not super-big." Many customers want a replica of their wife or ex-girlfriend, but the company needs consent from the woman first, and most refuse. Today, *loaded* is working on a body seven which is being custom-made for a super-rich guy who wants her to live at his home in Beverly Hills, and an exact replica to be made for his penthouse in New York. You see, thanks to RealDoll, sex dolls are no longer shitty pink airbags with perma-shocked expressions.
 "I wanted to revolutionise the sex doll industry," explains Matt McMullen, the millionaire owner of the RealDoll company. The boss started making mannequins in his garage decades ago, now his firm turns over millions of dollars a year. McMullen's work transformed the sex doll, which hadn't evolved since the French invented them in the early 1900s. 'Dames de voyage' were made of old clothes, and used by horny French seamen who were isolated at sea during long voyages. In the 1970s dolls became inflatable, mass-market products, and by the millennium a Japanese company began renting sex dolls by the hour, and delivering them to homes. But it was McMullen, with his background in special effects, who started to make them ultra-realistic. And ultra-expensive.
 "People are amazed at the cost. They always ask the same questions," says artist Derek Trunk as we report to the special effects department to work on some faces. "Like, do I get a free one for my home? And have I fucked one." He sighs. "Yeah, I fucked a plastic vagina once," he confesses. "I had to know what it felt like. People think it's like working in one big orgy." His hand searches inside his toolbox, which



face off
 'RD2' models have magnetic skulls, so the pouty faces are simply stuck on with a satisfying clunk, while *loaded's* proudly moulded vaginas are nice and dry and ready for insertion. A man's got to take a pride in his work. And as the sun sets outside, an embarrassed FedEx driver arrives to take away the six crates, and the RealDoll team clock off for the day. Over a beer, Derek, the face artist, admits that his job at the sex doll factory has changed his outlook on life: "I was standing at a bar this weekend, and I looked at the barmaid and I thought, she's exactly a 'body six!'"
 But as the dolls are loaded on the truck, it's unsettling to think that tomorrow six strangers are going to take our works of art to bed and make sweet love to them. On an internet forum, 'Arnold', a customer from France, gushes: "Her beauty talks to my heart!" We swell with pride, yet shagging one is still something we can't imagine. King of the dolls, Matt McCullen, says that in a few short years his sex dolls will be able to perform rude acts. "I'm working closely with the robotics industry," he says, with a wry smile. Thinking about it, though *loaded* would want the simpler things in life: we'd much prefer one that could play snooker. ■ **loaded**

"One guy wanted a doll copy of his dead wife – with the eyes closed..."

(Plastic) girls on film From the old telly to the silver screen, silicon lovelies have seen a fair bit of action over the years...

- SHOOTING FISH (1997)**
 Brit flick that sees two wily conmen (and Kate Beckinsale) using dolls for a dance (don't ask), and as a part in their plot to steal loads of cash.
- LOVE OBJECT (2003)**
 French thriller that sees a weirdo become obsessed with the doll he bought. When he finds love with an actual girl, he starts pumping the poor lass full of embalming fluid.
- AIR DOLL (2009)**
 A life-size sex doll comes to life. Realising she's not keen on being banged by her creepy owner, she falls in love with a video store clerk. Like a fucked up, sex-crazed *Pinocchio*.