

MOULDING LATEX RUBBER

EQUIPMENT AND SUPPLIES REQUIRED

Vulcanising Press - Jackson 'PP' Series
Mould Plate (Moulded Matrix board or Engraved Board)
Bearer Bars
Mould Release
Talcum Powder
Release cloth or sheet.

PROCEDURE

1. Preheat the press to 150°C for at least 30 minutes before proceeding to stabilise the temperature of the platens.
2. Paint the mould board with mould release paying particular attention the sides and bottom faces of the characters and ensuring an even coat over the entire surface of the board. Allow to dry thoroughly.
3. Cut the stamp rubber to the size of the mould board dust with **talcum powder on both sides** and place on the board.
4. Place the release cloth or sheet on top of the rubber to prevent the rubber from sticking to the top platen of the press. DO NOT use steel or aluminium sheet metal as the rubber will stick to these materials.
5. Place the board and rubber on the moulding tray and position the bearer bars one on either side of the board. The bearer bars should be 0.9 to 1.15mm thicker than the moulding board.
6. Load the moulding tray into the press and raise the lower platen to within 12mm (½ inch) of fully closed.
7. Pause for 1 minutes to allow the rubber to soften prior to moulding.
8. Slowly raise the lower platen fully and apply pressure until the bearer bars cannot be moved (the force required will vary according to the area of the board). WARNING - Most presses are capable of clamping with many tonnes of force. DO NOT apply excessive pressure as this can damage the platens.
9. The rubber will start to cure after approximately 3 minutes and we recommend that the timer be set to 7 minutes to ensure that complete curing is achieved. It is advisable to check for pressure loss from time to time and to adjust if necessary.
10. Remove the entire assembly from the press and allow to cool for 2-3 minutes.
11. Slowly peel the rubber off the mould board and check for defects.