

PRODUCING BAKELITE EMBOSSING COUNTERS FROM AN ENGRAVED METAL DIE

EQUIPMENT AND SUPPLIES REQUIRED

Vulcanising Press - Jackson PP912 or similar.
Bearer Bars 5.5 mm (0.218 ") thick.

PROCEDURE

1. Temperature on the Vulcaniser should be set to 150 - 160°C (300 - 320°F).
2. Spray the face of the engraved metal die with mould release.
3. Place the metal die on the lower platen and preheat 2-3 minutes with the platens closed.
4. Lower the bottom platen and place half a bakelite biscuit on the die. (Each unbroken biscuit will yield 2 counters for either circular or rectangular dies).
5. Place a sheet metal over the bakelite, ensuring that the bearer bars are also covered, to prevent the bakelite from the sticking to the upper platen of the Vulcaniser.
6. Raise the platen slowly until the bearers are clamped tightly. Maintain light to moderate pressure for 3 to 3.5 minutes for 41mm" circular dies; 4 to 5 minutes for larger dies.
7. Lower the platen and remove. Do not separate the counter from the metal die.
8. Remove the excess bakelite and file the edge to improve the appearance.
9. Sand the back of the counter using emery paper, 600 grit or similar, to remove the glaze finish and ensure that the counter is flat.
10. Apply a double sided adhesive wafer to both the metal die and counter.
11. Remove the adhesive cover from the metal die and place into the holder ensuring the correct angular alignment.
12. Remove the adhesive cover from the counter and close the jaws of the holder firmly to ensure adhesion.
13. Place the holder into a press and emboss plain paper several times to bed both parts down in the holder.