

## **MOULDED EMBOSSING SEAL COUNTERS FROM ENGRAVED METAL DIES**

### **EQUIPMENT AND SUPPLIES REQUIRED**

Vulcanising Press set to 150°C (304°F)  
Bearer Bars - 5.5mm (0.217")  
Bakelite biscuit

### **PROCEDURE**

1. Spray the face of the engraved metal die with silicon mould release.
2. Place the metal die on the lower platen and preheat for 2 to 3 minutes with the platens closed.
3. 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).
4. Place a thin piece of sheet metal or holland cloth over the bakelite to prevent it from sticking to the upper platen of the Vulcaniser.
5. Raise the platen *slowly* until the bearers are tight up against the upper platen. Hold at pressure for 3 to 3.5 minutes for 41mm round dies; or 4 to 4.5 minutes for 50mm round dies and rectangular dies.
6. After lowering the platen remove the die and counter but do not separate at this stage. Allow both parts to cool to room temperature.
7. Break away the excess bakelite and file the edge with a smooth to fine file.
8. Sand the back of the counter using emery paper; 600 grit or similar. This will remove the glaze finish and ensure that the counter is flat.
9. Using a marking pen make a mark on the side of both parts to assist in realignment.
10. Separate the counter from the metal die. You may like to file the edge of the counter at this time to remove the sharp corner on the image side.
11. Attach an adhesive wafer to the back of the die and place the die into the die holder making sure to rotate it to the correct position before finally pressing the die home.
12. Attach an adhesive wafer to the back of the counter and place the counter on the die (the die should be image side up) ensuring that the counter is properly aligned with the die. Do not force the parts together - when the alignment is correct the counter will drop into the die easily.
13. Place the holder into a press and emboss plain paper several times to bed both parts down in the holder.