

Sample Preparation for Durometer

1. Weigh out appropriate mass of each part of material per the mix ratio.
2. Thoroughly mix material.
3. If necessary, de-air material using a vacuum chamber or centrifuge.
 - a. If material is placed in vacuum chamber, pull the vacuum until the material rises to the top of the beaker. Release the vacuum and repeat until material is de-aired (approximately 10 -15 minutes).
 - b. If using the centrifuge to de-air the material do not exceed a maximum speed of 20 and ensure it is balanced to prevent extreme vibration of the machine. Centrifuge until material is de-aired (approximately 10 to 15 minutes)
4. Clean chase and 2 cover plates with isopropyl alcohol and paper towel.
5. If necessary, spray mold release spray onto chase and release sheets.
6. Place release sheets upon each of the cover plates.
7. Place chase on one of the release sheets.
8. Insert material into center of chase and cover with remaining release paper and plate.
9. Verify that press has reached $\pm 2^{\circ}\text{C}$ of set temperature.
10. Place assembled chase in the center of hydraulic press platens.

11. Close platens as rapidly as possible, stopping when reaching marked maximum pressure.
12. Allow material to remain in press for cure time.
13. Remove chase assembly from press using insulated gloves.
14. Remove cover plates and release sheets and allow the slab to cool under ambient conditions on cooling rack for 15 minutes minimum. Remove sample from the chase when material has cooled.
15. Unless otherwise specified, allow slab to stabilize under ambient conditions for 1 hour minimum prior to testing.
16. Verify thickness of slab is uniform throughout using thickness gauge.