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## RR D1 Rubber Mold Vulcanizing Requirements:

### 1. Vulcanizing time and Temperature:

310 - 315 F.[154 - 157 C.]

15 minutes for each 6mm of thickness. [about 1 hour total for a 25mm thick mold]

2. Gradually increase the pressure during the first 9-10 minutes and then maximum pressure at 10 minutes. Regarding maximum pressure, use whatever maximum pressure you normally use. If the rubber does not fill into every small space then increase the maximum pressure at the end an additional 5% above your normal maximum pressure.

A good method used by many of my U.S. customers is to drill 2mm holes in the side of the mold frame [ one 2mm hole every 60 - 70 mm around the side]. This allows some of the rubber to "bleed" out of the frame like black spaghetti. The purpose is to allow the rubber to move into the fine details of your design and also to allow any air inside to escape.

3. The mold should be about 60-65 Shore A hardness if vulcanized correctly.

Regards,

VERY TRULY YOURS,

BOB ROMANOFF  
PRESIDENT