

Technique Tips from **Kerr**

Mold Rubber

CONDITION	CAUSE	CORRECTION
Cut mold does not seal evenly (Warping)	Rubber used in packing has begun to vulcanize Mold underpacked Mold overpacked Rubber strips laid in different directions	Use new rubber Use sufficient rubber. Close platens down so they are in contact with mold frame. Review mold packing procedure. Lay strips in same direction, invisible grain
Voids in mold (air entrapment)	Model not filled in with rubber Platens not at curing temperature Platens closed down too quickly Mold not cured for recommended time	Pack rubber pieces into and around model Preheat vulcanizer to 310°F/154°C Tighten vulcanizer 1/2 turn past first resistance. Repeat every two minutes until platens are in contact with frame and handle cannot be turned without resistance Allow 15 minutes at 310°F/154°C for every 1/4 inch. For intricate molds allow 20 min at 290°F/143.33°C for every 1/4 inch
Mold delaminates after curing	Surface of strips not clean	Use new strips. Do not contaminate surfaces with hands and protect from extraneous dirt or dust
Mold soft and sticky in center	Underheated Cure cycle too short	Check temperature of platens Cure 15 minutes for each 1/4 inch
Mold has pebbly surface Mold is sticky and scorched Excessive shrinkage Lack of flexibility	Overheated	Check calibration of vulcanizer

(OVER)

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