

828/DEA/GMB Process

Materials

828/DEA (71C)

GMB (107C)

Semco Tube w/ tape on end, plunger (black low density) & tip (71C)

Mixing Cup w/ Stirrers (71C)

Process

*Sift GMB in #100 150 micrometer, 0.0059 opening in inches

*After sifting place in metal pan no more than 2 inches in height then place into 107C oven for a min. of 6 hours.

*Place 828/ DEA & Cups into 71C oven for a min of 1 hour.

*Pour out required amount of pre-heated 828 into preheated cup on scale.

*Place back into oven.

*Pullout GMB out of 107C oven. Pull out 828 in cup place back on scale pour in required amount of GMB into 828 & mix w/ pre-heated stirrer.

*Mix for ~ 2-3 minutes. After mixing place back into 71C oven ~ 2-3 minutes

* Pull back out of 71C oven along w/ DEA pour in required amount of DEA & mix 2-3 minutes.

* Pull vacuum in heated 71C vacuum chamber for 2-3 minutes after material breaks.

*Place back into 71C oven ~ 3-4 minutes until viscosity is thin.

*Pour into Semco Tube w/ tape on end of Semco Tube & place upright in a container & place into heated vacuum chamber pull vacuum for ~ 1-2 minutes.

MUST POUR INTO SEMCO TUBE CAREFULLY AS NOT TO INTRODUCE BUBBLES

* After vacuum place plunger on tube. Cut 2 small slits into tape to vent using a large handle screw driver & **VERY CAREFULLY** push plunger up to front of tube.

Afterwards remove tape & place Semco tip.

*Place tube into pre-heated (71C) Semco sleeve

*Screw onto Semco Gun

Actual Semco gun is not pre-heated.

Side Notes

Steps listed in red must be done quickly to maintain temp & viscosity. Typically, can be done in ~ 1-2 minutes.