

Cure Schedule – Phenolic

Mold Size Diameter	Number of Scoops	Powder Amount (g)	Cure Time (min:sec)	Temp (°C/°F)	Cool Time (min)	Mold Pressure (psi)
1" & 25 mm	1	11-13	4	200/392	4	4400
1.25" & 30 mm	2	23-25	4		4	4000
1.5" & 40 mm	2.5	28-31	5		5	3800
2" & 50 mm	4	45-50	6:30		6:30	3500

Notes:

- For single mounts. If duplexing, 1 minute may need to be added to the cure time.
- Powder amount may vary depending upon the size of each sample.
- All samples must be ultrasonically cleaned and dried to remove any debris and/or grease.
- A mold release agent must be applied every time before a mounting cycle; Allied's mold release for hot mounting (#200-10004) is recommended.
- Cure cycle times and temperatures may vary for non-Allied presses.