

Cure Schedule – Graphite-Based Conductive

| Mold Size Diameter | Number of Scoops | Powder Amount (g) | Cure Time (min) | Heat Temp (°C/°F) | Cool Time (min) | Mold Pressure (psi) |
|--------------------|------------------|-------------------|-----------------|-------------------|-----------------|---------------------|
| 1" & 25 mm | 1 | 21 | 3 | 200/392 | 4 | 4400 |
| 1.25" & 30 mm | 1.5 | 31 | 4 | | 4 | 4000 |
| 1.5" & 40 mm | 2 | 41 | 5 | | 5 | 3800 |
| 2" & 50 mm | 3.5 | 72 | 5 | | 6 | 3500 |

Notes:

- For single mounts. If duplexing, may need to add 1 minute to cure time.
- Powder amount may vary depending on the size of each sample.
- All samples must be ultrasonically cleaned and dried to remove any debris and/or grease.
- Mold Release agent must be applied every time before a mounting cycle (200-10006 PTFE Spray is recommended).
- Cure cycle times and temperatures may vary for non-Allied presses.