



Cure Schedule - Phenolic Powders

Mold Size Diameter	Heat Time (min)	Heat/Temp (°C/°F)	Cool Time (min)	Pressure (bar)	Mold Pressure (psi)
1" & 25 mm	4-5		3-4	4.0	4200
1.25" & 30 mm	5-6	150/300	4	4.5	3700
1.5" & 40 mm	6-7		4	5.0	3500
2" & 50 mm	6-7		5	6.0	3200

Notes:

- 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).
- Duplex mounting requires 1-2 min longer heating time and 10 °C higher heating temperature.
- Cure cycle times and temperatures may vary for non-Allied presses. Please refer to the user's manual of your press for recommended cure cycles.