

# TECHNICAL BULLETIN

## ARTMOLDS VACUUM CHAMBER

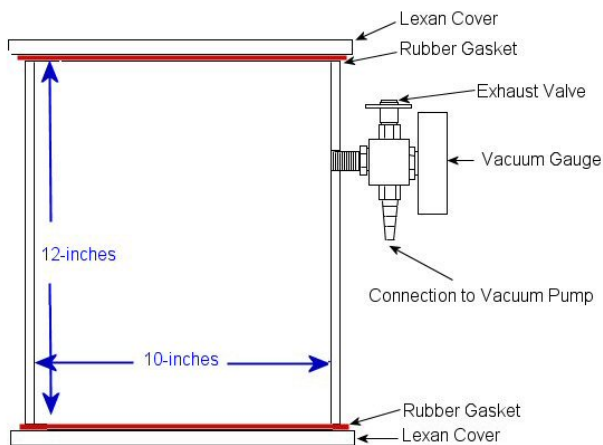
To assure a bubble-free mold when mixing rubbers and silicones a vacuum chamber is required. The ArtMolds Vacuum Chamber is designed for deairing (eliminating air bubbles) in rubbers. This PVC chamber, along with ½-inch Lexan plates make a safe and efficient unit. The vacuum chamber comes with all fittings, gauge, rubber gaskets, and top and bottom ½-inch plates. All you need is your power source and a vacuum pump that will pull 29-inches of mercury needed to deair your materials.



Specifications	
<b>Capacity</b>	4-gallons +/-
<b>Internal Dimensions</b>	10-inches diameter by 12-inches tall
<b>Maximum Pull</b>	29.9 inches of mercury
<b>Weight</b>	20-pounds

**Vacuumping Process:** Mix your rubber according to the manufacturers directions. The mixing container must hold at least four times the amount of material you are vacuuming, to allow for the expansion of the material. Once your vacuum reaches 29-inches of mercury, the material will begin to rise (resembling foam). When the material falls it will plateau and not rise any more. You will want to continue to vacuum for another 2- 3-minutes to make certain all of the air has been removed from your material. Release your vacuum, remove your material from the chamber. Pour the material slowly starting from the corner of the mold box, or mold, letting the material to flow freely into the box or mold cavity. This method will usually not introduce any new bubbles into the vacuumed material. To insure that the material is totally devoid of air bubbles you can place the entire mold/mold box into the chamber for an additional few minutes. This will assist the material into difficult areas of the mold/mold box.

### VACUUM CHAMBER DETAILS



**Vacuum Pump:** Our ArtMolds Vacuum Chamber was constructed to be compatible with the Robinair 6 CFM two stage vacuum pump. The pump is powerful enough to provided a rapid vacuum to 29.9 inches of mercury and to provide many years of trouble-free service. Simply connect the plastic tubing provided with our vacuum pump to the intake port of your vacuum pump

**Operation:** Close the exhaust valve on the vacuum chamber. Make certain both gaskets are centered on the rim and your cover plates are centered. Turn on your vacuum pump and monitor your gauge to 29.0 to 29.9 inches. When deairing has completed, turn off the vacuum pump and open the exhaust valve. When air pressure inside the chamber has returned to normal you can easily remove the lid and your deaired material.



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