

Leco Mounting Press



1. QUICK RUN

2. DETAILED RUN

3. REMOVING SAMPLE

1. Have ready at least 15ccm of black phenolic powder (1 big scoop)



2. Screw top until its snug, then turn back ¼ of the way.



3. Pump to 4200psi (red dot, 1.25" diameter, middle line). You may have to keep pumping to maintain 4200psi



4. Heat for 8 minutes, turn of the heat and allow to cool for 5 minutes.



1. Turn the power switch to HEAT (knob 1).
2. With Top enclosure removed, rotate the RAM DOWN (Knob 2)
3. Turn RAM DOWN knob clockwise until the closed position is reached
4. When the Knob stops rotating, stop turning it. You can damage the knob if you over tighten it
5. Pump the pressure with the handle until the bottom ram is showing about $\frac{1}{4}$ of an inch
6. Check the ram and top enclosure for cleanliness. If old residual black phenolic powder is left over, it can be removed with a bristle brush
7. At this point you load the sample on the mount, and rotate the RAM DOWN knob, until the ram is in the down position





1. Once ram is in down position, add in the mounting medium. It takes approximately 20 grams of powder, 1 big scoop and 1 small scoop.

2. Put top enclosure back on, and twist until tight. Then turn back $\frac{1}{4}$ of the way. **IT IS IMPORTANT TO TURN BACK TO REDUCE STRESS ON MOLD THREADS AND MAKE IT EASIER TO REMOVE TOP LATER**

3. Rotate the RAM DOWN knob clockwise to the full close position

4. Pump the handle on the side until you reach 4200psi. We use a 1.25 inch mold, so use the middle scales red dot for reference.

5. Turn on the heat and set heating timer (knob 3) to 8 minutes when using black phenolic resin (bakelite)

6. As the bakelite melts, it takes less volume, thus requiring you to keep pumping to maintain 4200psi until pressure stabilizes, then periodically check to maintain pressure.

7. Turn heat off once timer is done and allow to cool for 5 minutes. (keep at 4200 psi)



1. Rotate RAM DOWN knob counterclockwise. This will release the pressure inside the mold cylinder.

2. Unscrew the top enclosure from the mold cylinder. The spring inside the top enclosure will hold the threads apart during the injection process.

3. Rotate the RAM DOWN knob clockwise to full closure.

4. Pump pressure handle until the top enclosure and sample can be seen.
NOTE: SAMPLE WILL BE VERY HOT | USE HEAT RESISTANT WEAR TO REMOVE

5. Remove the mounted sample. After removed, clean the flashing off of the bottom ram, top enclosure and machine with a bristle brush. This will allow ease of movement of the bottom ram inside the mold cylinder.

