828/DEA/GMB Process

**Materials**

828/DEA (71C)
GMB (107C)
Semco Tube w/ tape on end, plunger (black low density) & tip (71C)
Mixing Cup w/ Stirrers (71C)

**Process**

*Sift GMB in #100 150 micrometer, 0.0059 opening in inches
*After sifting place in metal pan no more than 2 inches in height then place into 107C oven for a min. of 6 hours.
*Place 828/ DEA & Cups into 71C oven for a min of 1 hour.
*Pour out required amount of pre-heated 828 into preheated cup on scale.
*Place back into oven.
*Pull out GMB out of 107C oven. Pull out 828 in cup place back on scale pour in required amount of GMB into 828 & mix w/ pre-heated stirrer.
*Mix for ~ 2-3 minutes. After mixing place back into 71C oven ~ 2-3 minutes
* Pull back out of 71C oven along w/ DEA pour in required amount of DEA & mix 2-3 minutes.
* Pull vacuum in heated 71C vacuum chamber for 2-3 minutes after material breaks.
*Place back into 71C oven ~ 3-4 minutes until viscosity is thin.
*Pour into Semco Tube w/ tape on end of Semco Tube & place upright in a container & place into heated vacuum chamber pull vacuum for ~ 1-2 minutes.

**MUST POUR INTO SEMCO TUBE CARFULLY AS NOT TO INTRODUCE BUBBLES**
* After vacuum place plunger on tube. Cut 2 small slits into tape to vent using a large handle screw driver & VERY CAREFULLY push plunger up to front of tube.
   Afterwards remove tape & place Semco tip.
*Place tube into pre-heated (71C) Semco sleeve
*Screw onto Semco Gun
Actual Semco gun is not pre-heated.
**Side Notes**
Steps listed in red must be done quickly to maintain temp & viscosity. Typically, can be done in ~ 1-2 minutes.