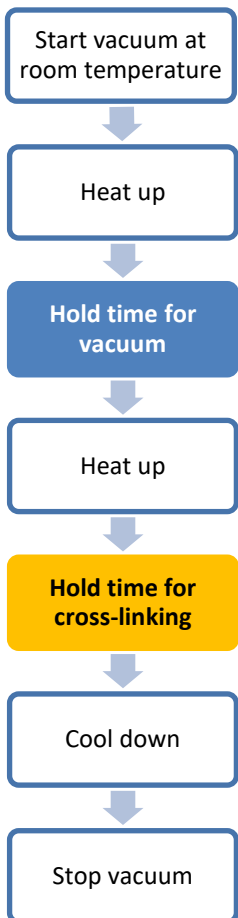


RECOMMENDED CONDITION FOR VACUUM BAG OVEN

Curing at low temperature (115°C)

Laminating Steps



Step	Oven temp. (°C)	Glass system (mm)						
		3+3	4+4	5+5	6+6	8+8	10+10	12+12
Start vacuum	Room	Time (minutes)						
Start vacuum	Room	15						
Heat up	To 50-60°C	1-2°C/min.						
Hold time for vacuum	<u>50-60°C</u>	105	110	115	120	130	135	140
Heat up	To 115°C	1-2°C/min.						
Hold time for cross-linking	<u>115°C</u>	125	135	140	155	170	180	210
Fastest cool down to 50°C								
Stop vacuum								

The recommended conditions are based on experimental results at TPI laboratory. Results can vary between different kind of lamination kilns. So individual adjustment might be necessary. Lamination process should always be confirmed by gel rate measurements at several points and for each tray of the lamination kilns.

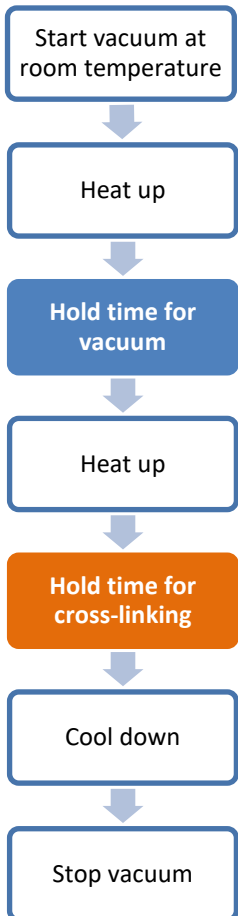
Please check our curing table as additional guideline for further adjustment or contact our technical staff for special requests.

TPI can't be made responsible for any results.

RECOMMENDED CONDITION FOR VACUUM BAG OVEN

Curing at high temperature (135°C)

Laminating Steps



Step	Oven temp. (°C)	Glass system (mm)						
		3+3	4+4	5+5	6+6	8+8	10+10	12+12
Start vacuum	Room	Time (minutes)						
Start vacuum	Room	15						
Heat up	To 50-60°C	1-2°C/min.						
Hold time for vacuum	50-60°C	105	110	115	120	130	135	140
Heat up	To 135°C	1-2°C/min.						
Hold time for cross-linking	135°C	50	60	70	70	80	100	115
Fastest cool down to 50°C								
Stop vacuum								

The recommended conditions are based on experimental results at TPI laboratory. Results can vary between different kind of lamination kilns. So individual adjustment might be necessary. Lamination process should always be confirmed by gel rate measurements at several points and for each tray of the lamination kilns.

Please check our curing table as additional guideline for further adjustment or contact our technical staff for special requests.

TPI can't be made responsible for any results.