
EXTRUSION MEASUREMENT EXM-1

TEST PROCEDURE

Thaw frozen adhesive to room temperature (25°C). Use a 3cc syringe 2/3 to 3/4 full. The rubber stopper inside the syringe should be removed.

Preset the pressure on the epoxy dispenser at 60 psi when the test is being conducted.

Stabilize the temperature of the adhesive at 25°C. This can be done by placing the syringe in a plastic bag and hanging the bag in a 25°C water bath. Stabilize for approximately five minutes.

Remove the syringe from the water bath and install a #21 gauge needle (.50 inch long). Be sure there is no adhesive on the tip of the syringe when the needle is installed; otherwise the needle may come off under pressure. Immediately connect the syringe to the syringe adapter that is connected to the dispenser.

Extrude a small amount of adhesive through the needle. Discard this adhesive. Using a tared weighing dish extrude adhesive for exactly 30 seconds and weigh.
(Note: Extrusion can also be extended to 60 seconds if desired.)

Multiply the 30 second value by 2 to calculate extrusion rate in grams/minute.