



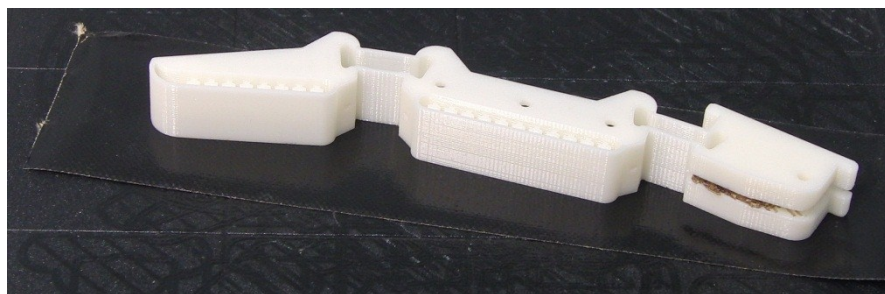
SDM Pouring Guide

Model T

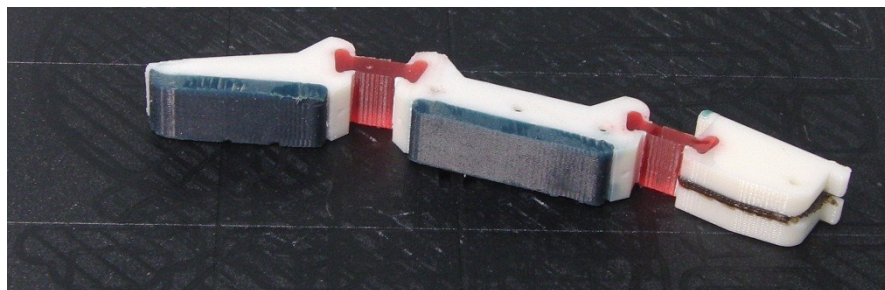
Ver. 0.4



Overview



1. Print fingers
2. Pour joint material
3. Pour pad material
4. Cure (24-48 hours)
5. Cut away frame material





Materials List

- PMC-780 Urethane [[link](#)]
 - Two-part rubber compound
 - PMC-790 too stiff for general use cases
 - Demold time: 48 hours
- Vytaflex-20/30 Urethane [[link](#)]
 - Two part urethane rubber
 - Demold time: 16 hours



Pre-Pour Preparation



- Seal bottom of printed fingers
- Do not pour directly on top of 3D printer support material
 - Fingerpad urethane can leak through support material
- Heat duct tape works best for sealing



Fingerpad Pouring



- **1A : 1B** part ratio
- Viscosity low relative to that of flexure joint material
 - De-gassing not necessary
 - Susceptible to leaking – pour more than necessary if possible





Flexure Pouring



- **2A : 1B** part ratio
- High viscosity
 - Joint will work without de-gassing
 - More consistent behavior if vacuum and de-gassing is used
- Pour more material than necessary
 - Excess urethane can be removed later





Vacuum, De-Gassing

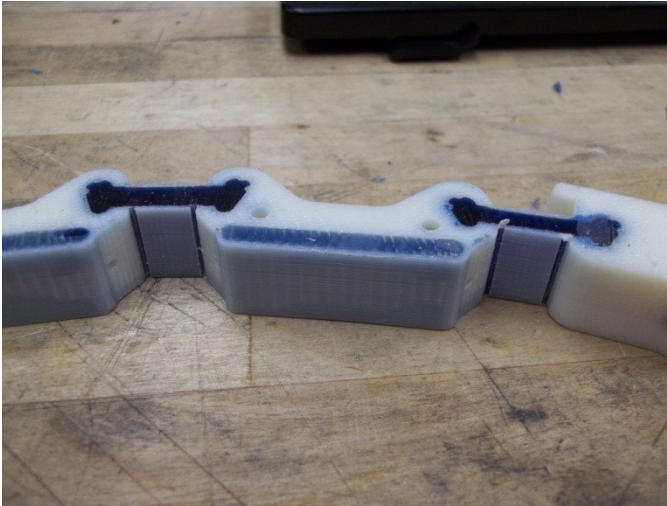


- vacuum setup

- Material de-gassed prior to pour
- Urethane will rise 2-3x initial level during de-gassing
 - ~ 30 seconds
 - Remove urethane from chamber after initial rise in level subsides



Frame Removal



- ABS frame ~0.7-1.0 mm thick
 - Bandsaw or file used to cut out frame elements
 - Compliance of joints/pads minimizes damage if cut is excessive
 - Can partially cut and then “snap” frame elements apart
- File or belt sander used to smooth, file-down excess ABS or urethane material

