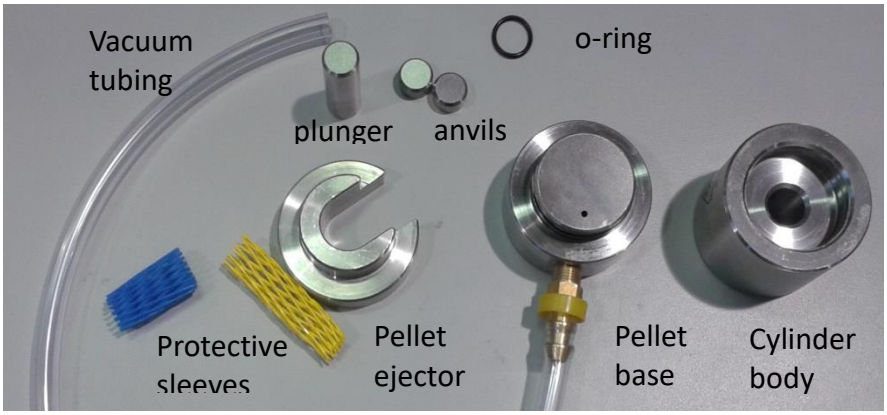
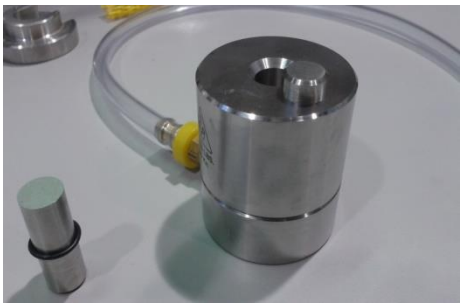
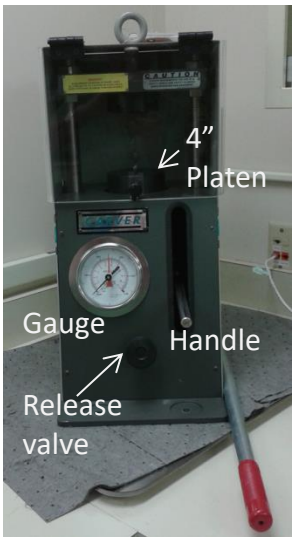
Locate hydraulic press (Bldg. 131, Rm. 209). Read the manuals for the press and pellet die.



1. Push snugly the cylinder body onto the base.
2. Place o-ring over the plunger.
3. Insert one anvil and into the cylinder body with beveled surface facing **down**.
4. Pour in the powder. 150-200 mg produces a 13 x 1 mm pellet.



5. Insert the second anvil into the cylinder with beveled surface facing **up**.
6. Insert the plunger beveled surface **up**. Press the o-ring snugly against the body cylinder.
7. Put the assembled die in the hydraulic press. Base should sit in the recessed area of the lower 4” platen.
8. Make sure the pressure release valve is closed (clockvise). Pump the handle until the gauge shows 1 Ton, and keep it at 1 Ton for 1 min.
9. If desired, attach the evacuation tubing to a vacuum pump. Turn on the pump and evacuate for 2 min. Increase pressure in 1 Ton steps and evacuate 1 min after each step until 5 tons is reached. Shut off the vacuum pump, disconnect the tubing.
10. Apply 5 tons of pressure and keep it so for > 30 seconds.
11. Open pressure release valve (anticlockwise) and lower the pellet die about 1”. Close the release valve.
12. Take the die out of the press and remove the base from the body. If the anvils stay in the die body, take them out by steps 13-16.
13. Insert the pellet ejector into the pellet die body.



14. Return the assembly to the hydraulic press.
15. Slowly start pumping the handle; no pressure should be read at the gauge while the plunger goes deeper into the cylinder body. Once anvils drop out the cylinder body you will notice the resistance and gauge indicates pressure. **Stop** pumping. Do not exceed ½ Tons!
16. Lower the platen about 3”. Close pressure release valve.
17. With the die still in the press, carefully lift the cylinder body with the plunger. The two anvils and the pressed pellet lie in the ejector. CLEAN ALL STAINLESS STEEL PARTS AFTER USE.