



Eden Materials

Sublym™ Kit User Guide

Compact Hot Embossing Machine for Flexdym™ Molding

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1. Description

The Sublym™ embossing machine allows fast and easy molding of Flexdym™ polymer sheets. The machine is compact, measuring 33 x 34 x 11 cm³, allowing molding to be performed anywhere. The machine enables plug & play, and does not require a pressure source. It is adjustable to up to 180°C and suitable for molds up to 4 inches (customization may be possible upon request). The Sublym™ allows Flexdym™ molding to be accomplished within a few minutes.

2. Safety Notes

The aim of this quick start guide is to illustrate how to use the Sublym™ system, to easily and rapidly create Flexdym™ chips. Please, always consult the safety notes or procedures that may be related to your specific heat press system prior to use.

As in all laboratory activities, gloves and lab coats should be worn at all times during the process. It is the user's responsibility to consult the manufacturer's recommendation for the chemicals used and - if required - to ensure adequate ventilation/extraction (e.g., via a fume hood) prior to proceeding.

The biggest risk for the user during the process is burning themselves. The equipment is hot and one must always wear heat resistant gloves while operating. As for all technical equipment the heat press has to be used only by a trained person to prevent any injury to the user or damage to the equipment.

3. List of Buttons



Power



Run



Program 1



Heating



Temperature
Setting



Program 2



Vacuum



Time Setting

4. Equipment Required

Material	Quantity
Sublym™ embossing machine	1
Screw spacers	4
Master Mold to create micron features on Flexdym™	1
Counter mold to create a smooth surface on the opposite side of the Flexdym™ sheet	1
Flexdym™ sheet	1
Protective PTFE sheet	1
Scissors	1
Dry silicone spray	1
Tweezers	1
Isopropanol	1
Heat resistant gloves	1

5. Operating Instructions

Plug in the Sublym™ & switch the machine on 

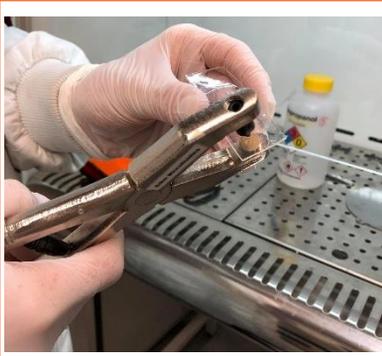
Step	Description	
1	<p>Pre-heating</p> <p>Close the machine and pre-heat the mold chamber for a few minutes.</p> <p>Press  for 5 s to adjust & set the temperature</p>	

Step	Description	
1	<p>Press  to start heating.</p> <p>When pre-heating is complete, the machine beeps.</p> <p>Press  2x to turn off sound & stop pumping.</p> <p>Tip: To change the temperature units between °C and °F, press “+” and “-” buttons at the same time.</p> <p>To monitor the processing capacity (i.e. countdown of the number of runs), press 2s on “+” button and then press the “-” button.</p> <p>Note: The temperature & time of molding will depend on several parameters, e.g. sheet thickness, desired thickness, and channel resolution.</p>	
2	<p>In a ductless fume hood, cut the Flexdym™ sheet using scissors, according to the size of your mold.</p> <p>Note: Keep protective PTFE sheets to cover Flexdym™ after molding process.</p>	

Step	Description	
3	<p>Remove one protective PTFE sheet from the Flexdym™ and place the Flexdym™ on the counter mold using tweezers.</p> <p>Note: The counter mold can be treated with silicone spray to improve releasing (of large mold surfaces).</p> <p>Use isopropanol or ethanol to clean the counter mold beforehand.</p>	
4	<p>Remove the second protective PTFE sheet from the other side of the Flexdym™. Place the mold face down on the Flexdym™ sheet.</p> <p>Note: The mold in the image is made of SU-8 on glass. However, Flexdym is compatible with other molds, e.g. SU-8 on silicon or epoxy molds.</p>	
5	<p>Open the Sublym™ & check the inner deformable membrane is attached correctly.</p>	

Step	Description	
6	<p>Setting Up a Program</p> <p>To set up a program press  or </p> <p>Press  to adjust the temperature.</p> <p>Press again  to set the temperature.</p> <p>Press  to adjust the time.</p> <p>Press again  to set the temperature.</p>	
7	<p>Using protective gloves & tweezers, place Mold-Flexdym-Counter mold sandwich in Sublym™ molding chamber.</p> <p>Tip: The final thickness of Flexdym™ can be adjusted using different spacers. An estimate calculation:</p> <p><i>Height of Spacers =</i></p> $Mold_{Thickness} + Flexdym_{Final\ Thickness} + 5\ mm$	
8	<p>Ensure a thin PTFE sheet (red) is placed on top of the sandwich to avoid sticking to inside of the metal cover.</p>	

Step	Description	
9	<p>Close the molding chamber & the Sublym™.</p> <p>Press  to start pumping & molding.</p> <p>This process usually only takes a few minutes. Once done, the vacuum pump will automatically stop, and the machine will beep.</p> <p>Press  to turn off sound.</p> <p>Note: The pressure inside the chamber should stabilize between 0.08-0.06 MPa.</p>	
10	<p>Once molding is complete, remove the Mold-Flexdym-Counter mold sandwich from the Sublym™ molding chamber. (Isothermal Process)</p> <p>Allow to cool down at room temperature for 1-2 minutes.</p> <p>Note: To speed up the process, you may use an air gun.</p>	
11	<p>Unmolding</p> <p>Remove Mold-Flexdym ensemble from counter mold very gently, using tweezers.</p>	

Step	Description	
12	The addition of a small amount of isopropanol solution to the Flexdym™ helps to release the counter mold.	
13	Gently remove the molded Flexdym™ from the mold.	
14	Cover both sides of the Flexdym™ with the protective PTFE sheets. Cut neatly around the molded design.	
15	Optional: Use metal hole punch pliers to create inlet/outlet holes in the design.	

6. Advanced Sublym™ Features

There are additional advanced features in the Sublym™ system:

- To set an automatic pre-heating step delay (up to 2min long), press  for 5 s.
- To set a pre-heating temperature, press  for 5 s.
- To change the temperature unit of the machine between °C and °F, press the “+” and “-” buttons at the same time.
- To monitor the processing capacity (countdown of the number of runs), press the “+” button for 2 s, then press the “-” button.

7. Machine Maintenance

The Sublym™ system requires very little cleaning and maintenance. If Flexdym™ flows out of the molding chamber or sticks to the chamber lid, make sure you clean it as soon as possible using isopropanol.

For any additional questions, please do not hesitate in contacting us at support@eden-microfluidics.com.

8. Terms & Conditions

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