

OPERATION OF THE FLOOR-MODEL VULCANIZER

#98-026	#98-003A
#98-026A	#98-004A
#98-026-HY	#98-005
#98-026A-HY	

Insert plug into proper electric outlet. Turn clock switch on. Thermostat dial should be set at 310 degrees F (154 degrees C) for vulcanizing temperature. Vulcanizer will take approximately 40 minutes to reach vulcanizing temperature.

PREPARATION OF MOLD

For SILICONE RUBBER - spray mold lubricant #2, Item #98-152 between the two halves of the mold where the models will be placed. For standard BLACK- use graphite spray, Item #98-025-1.

Place mold locks, Item #98-138 about 1" apart on the outer border of bottom disc (rubber without hole) and press them into rubber so that they will not move.

Before placing the top half on the bottom half, lay sprue former on bottom half in the center so that when top half is placed on it, the sprue will come through the hole in the center of the top half. Wide side of sprue former should be downward.

Lay models on bottom half of mold. Place bottom half with models into ring frame set. Then place half of the mold (rubber disc with hole) on top of bottom half.

Steel Mold frame set consists of three (3) sections:

Top plate with ½" (12mm) thick inner lip, bottom plate with ¼" (6mm) thick inner lip and middle ring.

Place top steel plate on top of mold and insert entire frame with mold in it into vulcanizer.

Vulcanizer must be at proper temperature before placing steel frame set with rubber mold into it. Steel frame with mold should be placed at the center point between heating platens before exerting pressure.

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Apply pressure with jack gradually. Middle vulcanizer plate with steel frame set should be raised so that the steel frame is just touching the top of the heating platen and then exert more pressure by pumping the jack handle 2 - 3 times.

Repeat this about four times every 2 minutes, and at the end of 8 minutes, give it full pressure (as much as you can) and permit it to cure for approximately an additional 52 minutes. Standard 1" (25mm) thick mold takes about 1 hour (15 minutes for each 1/4" (6mm) of thickness.

At the end of this period, reverse the operation of the jack and this will lower the middle vulcanizer plate. Remove the frame from the vulcanizer. Remove the top plate from frame and take out mold. Separate both halves of the mold and remove models.

Cut gates and air releases in mold. Mold is now ready for casting.

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