

Using a Pressure Chamber To Create Bubble-Free Castings

CAUTION: EXPLOSION RISK

Recommended working pressure is up to 60 psi (4.14 bar). Do not exceed. The safety relief valve is designed to protect the tank against excessive pressure. DO NOT attempt to make any adjustments to this valve. If the valve begins to vent air pressure, reduce the setting on the inlet regulator. DO NOT alter the tank in any way by welding, drilling or machining as this may weaken the structure of the tank. Be sure the tank pressure is completely relieved before attempting to remove the tank cover. Shut off the main air supply to the tank and vent the pressure using the tank vent valve located on the tank cover.

Using the Pressure Chamber on Wheels in a Vertical Position



1 Unpack the pressure pot, the wheel assemblies and the bracket hardware.



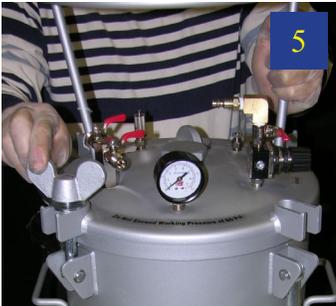
2 Attach the four wheel assemblies and secure tightly with a wrench.



3 Pressure chamber is fully assembled and ready to go.



4 Place a filled mold inside the pressure chamber



5 Place the lid on the pressure chamber and tighten the wing nuts.



6 Be sure to secure the lid properly by tightening the wing nuts in tandem diagonally for best results.



8 Attach an air supply hose. The regulator is preset at recommended. 60 psi.



9 Flip the air control valve lever from the down position to the up position to release the air flow into the pressure chamber. Air will flow at 60 psi.



11 Do not exceed recommended 60 psi (4.14 bar).



12 Keep the air supply connected and the material under pressure for a duration at least equal to its demold time.



13 Release the air pressure valve.



14 When the demold time is up, remove the mold from the pressure chamber.



15 The result is a bubble-free casting that is identical to the original model.



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