#0540 & #0541

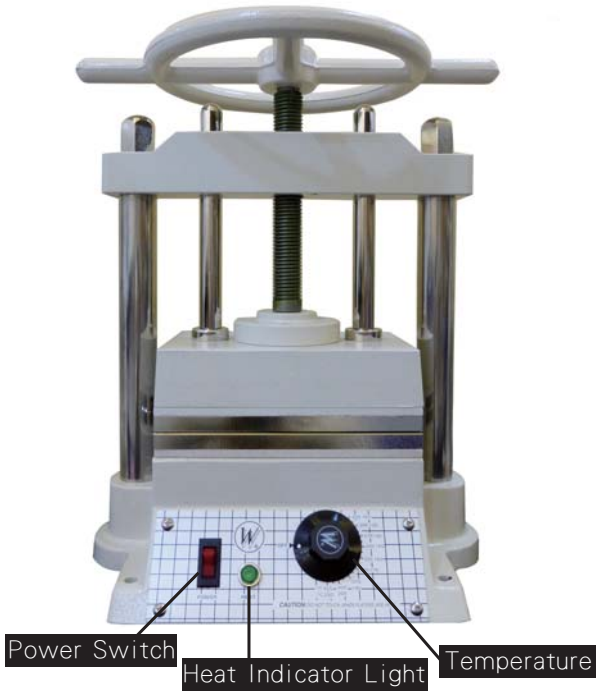
STANDARD VULCANIZER INSTRUCTION

DEMO VIDEO QR CODE

ONLINE SHOP QR CODE

24HR SERVICE QR CODE

PARTS NAME



SPECIFICATION

Model#	0540	0541
Power Source	120V/6A/60Hz	240V/3A/50Hz
Max. Output	650W	
Max. Temperature	220℃(428℉)	
Platen Dimensions	5¼" × 8"(13cm × 20cm)	
Max. Platen Opening	4" (10cm)	
Dimension (Platens closed)	14⅛"× 9½" × 17¾" (36cm × 24cm × 45cm)	
Net Weight	21kg	

SET-UP & OPERATION:

1. Screw or bolt the unit to a bench.
2. Plug line cord into grounded receptacle.
3. Turn **power switch** on and power indicator light will glow.
4. Set **temperature** to 155ºC (operation temperature depends on actual conditions). **Heat indicator light** will glow. Allow time to reach temperature. This takes about 15 minutes. As temperature reaches the desired value, heat indication light will come on and off alternately to keep that temperature.
5. Prepare to make rubber mold:
   1. Choose a proper aluminum mold frame and place it on a 5 by 7 inch vulcanized plate.
   2. Cut necessary pieces of rubber sheets of proper size to fit in mold frame. Note: Use 9 pieces of 1/8-inch-thick rubber sheets to pack in one-inch-thick mold frame.
   3. Clean rubber sheets with alcohol and clean cloth. Pack rubber sheets in mold. Make sure that model is located directly in center of mold. Cut away rubber as necessary to provide space for model. Pack careful and firmly in order to minimize air entrapment.
   4. Place another 5 by 7 inch plate on top of mold frame.
6. Put the mold prepared in Step 5 on lower platen. Close vulcanizer until platens are firmly in contact with the mold. The correct vulcanizing time for the rubber mold is determined by overall thickness of mold frame.
7. Remove mold frame from vulcanizer after done and remove rubber mold from mold frame when it is cool.

CAUTION :

1. Check receptacle voltage before plugged in.
2. Lubricate screw regularly to avoid rust. Clean platens after use.
3. **DO NOT** use cheater-bar, wrench, pipe or any other aid when tightening platens on mold frame. Excessive pressure can result in damage to the machine.
4. Use protective gloves and tongs at all times.
5. If a platen is not heated, check power indication light and heat indication light first.
6. Do not touch when platens are heated hot!

TROUBLESHOOTING:

Problems	Possible causes	Solution
No heat from upper and bottom platen.	· Damaged upper platen & bottom platen. · Damaged temperature control. · Damaged power switch.	· Replace upper & bottom platen. · Replace temperature control. · Replace power switch.
Can heat up but temperature un-contorllable.	· Damaged temperature control.	· Replace temperature control.
	· Thermocouple is not in contact with the temperature control.	· Ensure that the thermocouple is intact and tight.
Heat from upper platen but no heat from bottom platen.	· Damaged heating element on bottom platen.	· Replace heating element.
Heat from bottom platen but no heat from upper platen.	· Damaged heating element on upper platen.	· Replace heating element.
Hard to turn wheel.	· Damaged bearing.	· Replace bearing.
Noise comes out when turn the wheel.	· No grease on thread.	· Grease it.