



**DELUXE VULCANIZER
WITH DUAL HEAT CONTROL**
Deluxe Model No.164.50 Available 120V & 240V

USER INSTRUCTIONS

Mount the Unit to a sturdy workbench or table.

SET UP:

1. Unpack and remove the Vulcanizer from its container. Check for any damage that may have occurred during shipping. If there is damage, report it immediately to the carrier. If the box was damaged or slightly damaged, this is to be reported as concealed damage to the carrier. You as the recipient must file a claim with the carrier.
2. Place and secure the Vulcanizer to a sturdy work bench.
3. Clean the Vulcanizer of any oil or dust which may have occurred during assembly.
4. Plug in the Vulcanizer to the proper power supply. If the unit was ordered to operate on 120V, the proper male plug has been provided. If the unit requires 240V, you will have received it with no plug and you must supply the correct male plug that applies to your outlet.
5. The on switch is integrated into the timer switch. Move the timer knob to preheat and both vulcanizing platens will begin to heat.
6. Follow the following calibrating instruction to ensure proper vulcanizing of rubber molds.

CALIBRATING:

The new Pepetools DHC Vulcanizers are tested at our factory to insure proper functioning.

Mold making rubber vulcanizes at temperatures between 290 °F and 350 ° F.
We recommend the working temperature to cycle between 305 °F to 315 °F.

To calibrate the Vulcanizer, please follow these instructions:

1. Use a stem type thermometer that has a range to at least 390 °F. (This type thermometer can be found in most department stores in kitchen wares.)
2. Insert the stem of the thermometer in the hole on the front, leading edge of the upper platen.

PLEASE NOTE that the **HEAT/ ON** lamps located on the control panel indicates when the heating element is on. The left lamp indicates the lower heating element and the right lamp, the upper.

3. Turn the timer switch on to preheat and turn the upper knob to the maximum. Monitor the temperature. When the temperature reaches 315 °F turn the upper knob until the left heat lamp goes off. This is controlled with the upper thermostat. Turn the thermostat clockwise (CW) to increase the temperature and CCW to decrease. The left heat lamp should come on when the temperature reaches approximately 295 °F and go off when it reaches approximately 315 °F. A plus 10 °F on the low or high side is acceptable.
4. Perform the same procedure on the lower platen.

5. After calibration of both heating elements, place the thermometer between the platens and close the platens carefully on to the stem of the thermometer. Allow a few minutes and read the temperature. It should cycle close to 310 °F. Please note that a plus 10° F is acceptable.

HELPFUL INFORMATION:

The correct vulcanizing time for the rubber mold is determined by the thickness of the mold. Allow seven and one half minutes for each 1/8” thickness.

Set the timer for the time required.

Place the packed mold frame between two aluminum plates.

Close the Vulcanizer platens firmly on the rubber mold. For the next 4 minutes, tighten the platens at 1 minute intervals.

Caution:

Do not apply excessive pressure to the platens as this will result in damage to the Vulcanizer.

REMEMBER

The secret to a good rubber mold is in the packing. Be sure to fill in all the cavities. Do not depend on the flow of the rubber to fill every space by the pressure applied.

