

Using a pressure chamber to create bubble-free castings.

CAUTION: EXPLOSIVE RISK

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 settings on the intake 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 lid.



1 Place a filled mold inside the pressure chamber.



2 Place the lid on the pressure chamber.



3 Be sure to secure the lid properly by tightening the wing nuts in diagonal fashion for best results.



4 Make sure all valves are closed.



5 Connect your air supply hose. The maximum recommended pressure is 3.5Bar.



6 Open the inlet valve to release air flow into the pressure chamber.



7 While the Pressure tank is rated at >70psi (4.8Bar) it is not recommended to exceed 3.5Bar (50psi)

CAUTION

Although the pressure tank is rated at >4.8Bar (70psi), it is not necessary to exceed 3.5Bar (50psi) when casting. SET the air pressure regulator to 3.5Bar. Read and observe all safety precautions.



8 Keep the material under pressure for the duration at least equal to its demold time. Then close the air inlet valve.



9 Open the air release valves to release the air pressure inside the tank.



10 Open the pressure chamber.



11 Remove your bubble free casting.



12 The pressure chamber can be mounted horizontally.



13 Make sure the chamber is level in all directions.



14 Place a wooden board to use as a level surface inside the pressure chamber then follow steps 1 - 11.