The User Guide to

The X-60 Molding Chamber

by hapco

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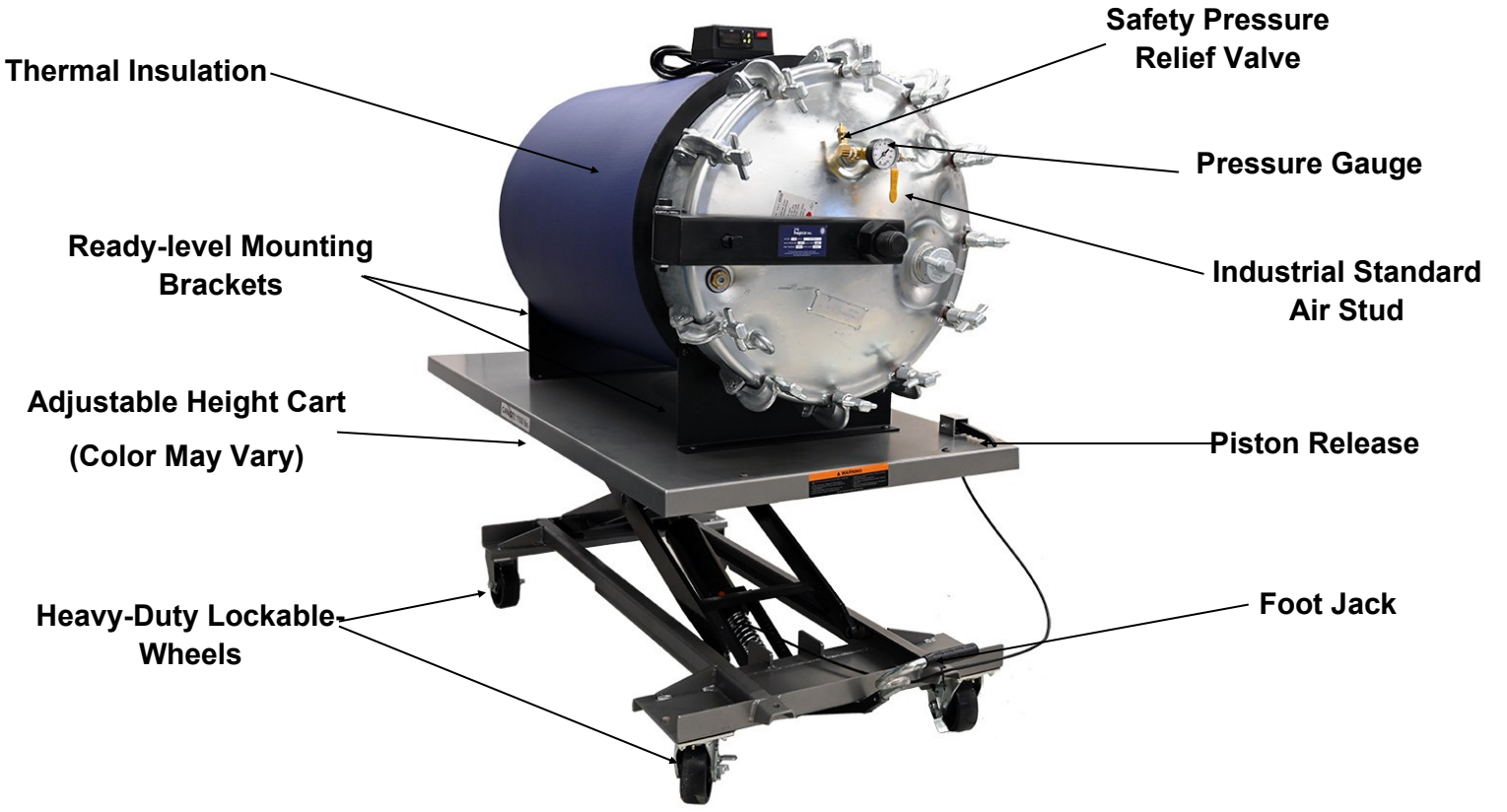
For replacement components, please contact a Hapco representative at: 781-826-8801

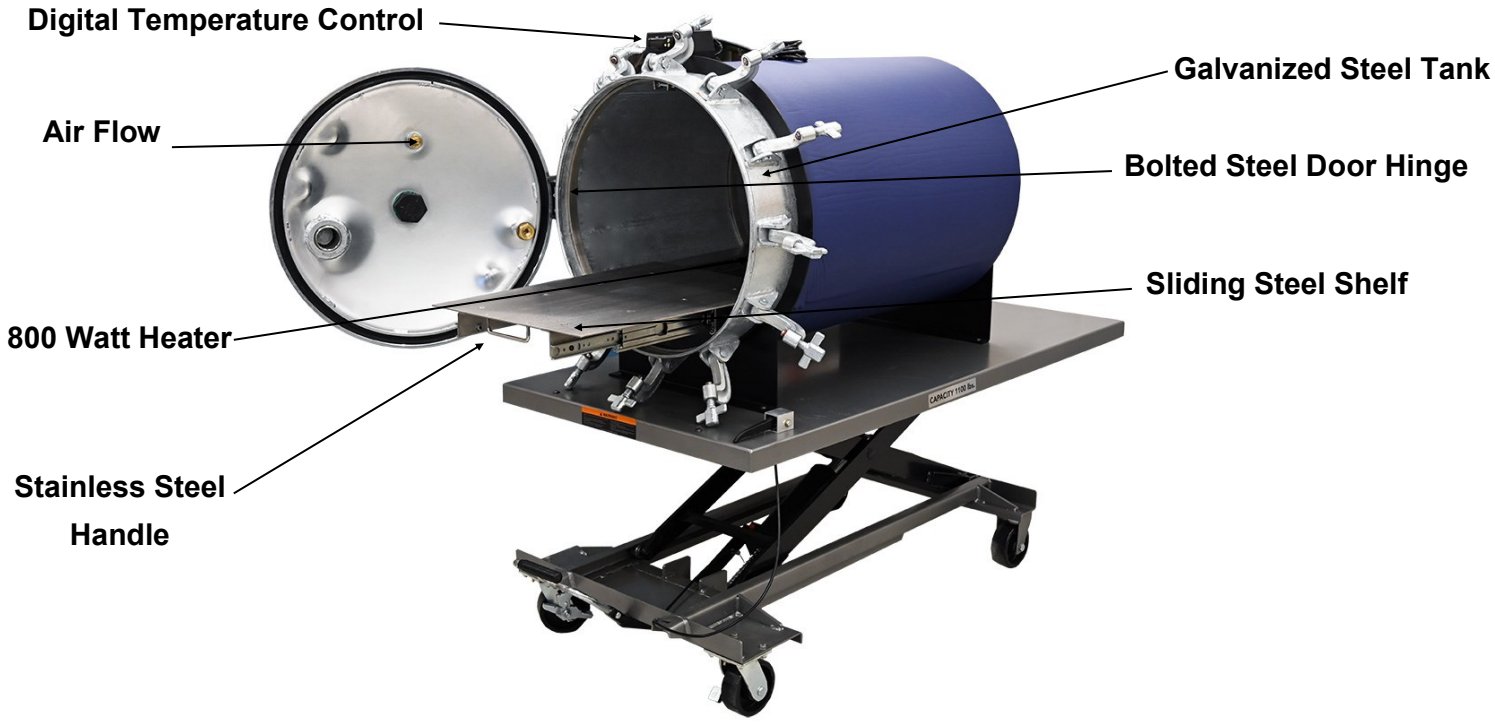
Or email us at: info@hapcoincorporated.com

X-60 Features & Specifications

External Dimensions: 72”L x 31.5”W x 43-68”H
Internal Dimensions: 35.5”L x 24” Dia.
Shelf Dimensions: 33.5”L x 19”W (17” Shelf to Ceiling)

Maximum Temperature: 180˚F
Maximum Pressure: 110 PSI





Safety & Maintenance

Unit will become warm to the touch and possibly hot when in use.

- ◊ No flammable materials (i.e., solvents) should be placed near or inside the X-60 unit.
- ◊ The location of the X-60 unit should provide enough clearance for the swinging lid to open.
- ◊ A suitable 15 AMP, 115 VAC circuit should be within 5’ of the X-60 unit. This device uses 825 WATTS at 120 VAC @ 60 HZ. Users outside the U.S. are responsible for procuring the proper converter that meets the standards and requirements for use.
- ◊ A sufficient clean, dry air supply should be available to pressurize the unit.
- ◊ Use a “DANGER DO NOT OPEN” tag on each machine while they are under pressure.

- ◊ Clean debris from the top of the shelf and underneath daily.
- ◊ Check fittings and valves for pressure leaks weekly.

Initial Startup Preparation

1. Slowly wheel the unit on a smooth, level surface close to electrical and air supply.

2. Secure the X-60 using the wheel locks on the front of the cart. raise to desired height using the foot pump at the front of the cart.

3. Pull the black lever at the front of the cart to lower it.

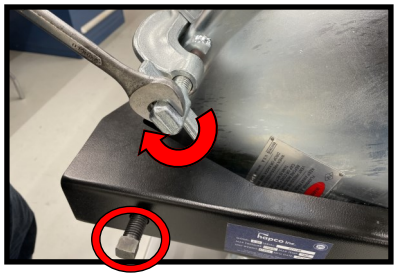
4. Loosen the swing clamps (12) and open the lid.

The molding chamber is now ready to use.

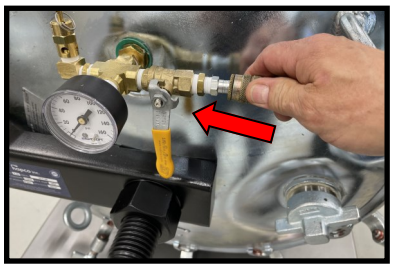
Using The X-60

1. Place molds and parts on the shelf making sure they are level.

2. Close the lid and **securely** tighten the swinging “C” clamps in a criss-cross pattern, as you would tightening lug nuts on a tire. Be sure to tighten the bolt in the black hinged arm (circled in red).

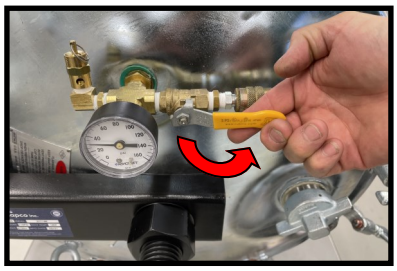


3.Attach the air hose to the unit while valve is in the closed position.

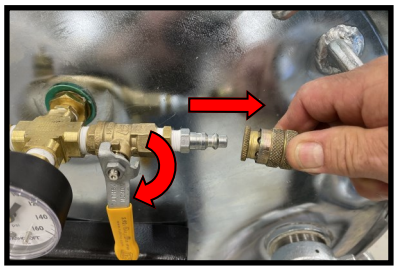


4. **Slowly** open the ball valve by turning it parallel with air hose until desired air pressure is reached.

70-80 PSI is recommended.



5. When the desired pressure is reached, close the ball valve and remove the air hose.

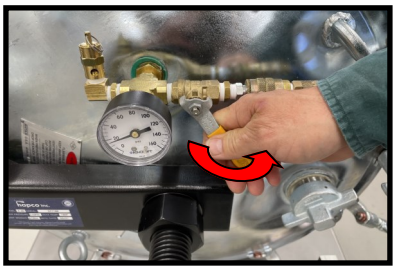


For heating instructions please see page 8.

Using The X-60

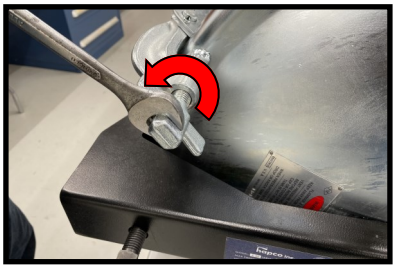
WARNING : DO NOT OPEN DOOR UNTIL PRESSURE HAS BEEN RELEASED!

6. When de-mold time is reached, **slowly** relieve pressure from the tank by turning the valve back to the open position.



A MUFFLER OR EAR PROTECTION RECOMMENDED!

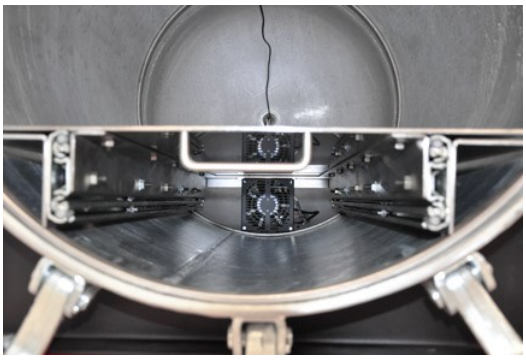
7. Once pressure has been fully relieved, loosen the swing clamps using an adjustable wrench.



8. Open the door and remove the cured items from the unit.

Caution! : Items may be hot when removed!

Using The Heating System



The X-60's heating system is digitally controlled and, unlike similar devices on the market, heated from the inside of the chamber. The digital controller allows the user to easily set the tank's temperature while displaying a digital readout of the current temperature. The heater automatically turns off once it reaches the set point and turns back on when it goes below by a few degrees.

The maximum operating temperature is 180˚F (82˚C).

1. To turn on the heating system, push the red button on the right of the unit.

2. To change the temperature, press the SP (Set Point) button **<u>twice</u>.**

3. Using the "up" and "down" arrow buttons, change to the desired temperature(°F). Press the SP button to enter the value.

4. To exit the set point function and check the current temperature, press the "SP" and "Down Arrow" button **<u>at the same time</u>**.

Temperature Conversion Formulas:	
Fahrenheit	**Celsius**
°F = (1.8 x °C) +32	**°C = (°F-32) x.556**

°C	°F	°C	°F
-65	-85	100	212
-60	-76	105	221
-55	-67	110	230
-50	-58	115	239
-45	-49	120	248
-40	-40	125	257
-35	-31	130	266
-30	-22	135	275
-25	-13	140	248
-20	-4	145	293
-15	5	150	302
-10	14	155	311
-5	23	160	320
0	32	165	329
5	41	170	338
10	50	175	347
15	59	180	356
20	68	185	365
25	77	190	374
30	86	195	383
35	95	200	392
40	104	205	401
45	113	210	410
50	122	215	419
55	131	220	428
60	140	225	437
65	149	230	446
70	158	235	455
75	167	240	464
80	176	245	473
85	185	250	482
90	194	255	491
95	203	260	500

353 Circuit Street * Hanover, Massachusetts 02339

Phone: 781-826-8801 * Fax: 781-826-9544 * Toll Free: 877-SAY HAPCO (729-4272)

Email: info@hapcoincorporated.com * Website: www.hapcoincorporated.com