The User Guide to
The X-60
Molding Chamber
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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)

- Pressure Gauge
- Stainless Steel Handle
- Bolted Steel Door Hinge
- Sliding Steel Shelf
- Air Stud
- Industrial Standard
- Air Flow
- Bolted Steel Door Hinge
- Foot Jack
- Digital Temperature Control
- Thermal Insulation
- Heavy-Duty Lockable Wheels
- Ready-level Mounting Brackets
- Piston Release
- Safety Pressure Relief Valve
- Foot Jack
- Galvanized Steel Tank
- Bolted Steel Door Hinge
- Sliding Steel Shelf
- Stainless Steel Handle
- 800 Watt Heater
- Maximum Temperature: 180˚F
- Maximum Pressure: 110 PSI
- 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)

- Ready-level Mounting Brackets
- Adjustable Height Cart (Color May Vary)
- Heavy-Duty Lockable Wheels
- Digital Temperature Control
- Air Flow
- 800 Watt Heater
- Stainless Steel Handle
- Safety Pressure Relief Valve
- Pressure Gauge
- Industrial Standard
- Air Flow
- Bolted Steel Door Hinge
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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.
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 twice.

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 at the same time.
### Temperature Conversion Formulas:

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