

TUBE VULCANIZER INSTRUCTIONS

MODELS 100 , 150 AND 200

These Tube Vulcanizers are designed to permanent repairs on tubes at a lower cost than any other method. Detachable flat plate allows vulcanization of replacement valve stems, both rubber covered and rubber base metal stems.

TUBE REPAIR

The following steps should be followed to obtain satisfactory repair.

- 1 Open vulcanizer by unscrewing handwheel screw far enough to release trigger in rear, lift handle and swing heat unit completely back. Plug cord into a electrical outlet and allow vulcanizer to preheat for 15 to 20 minutes.
 - 2 If tube is torn, round out ends and any sharp corner with shears to prevent further tearing. Trim edge to slightly widen injury so that the new patch rubber will flow into and fill injury. Buff tube thoroughly 1/2" in all directions beyond injury.
 - 3 Apply a good brand of vulcanizing cement or solvent to the buffed area (use according to manufacturer recommendations). Fill the injury with tube repair material, then place a piece of tube repair material 1/4" - 1/2" larger than the hole diameter over filled injury and stitch down thoroughly.
 - 4 Place tube on rubber pad with patch facing up and centered on pad. Lower heat unit and tighten handwheel screw firmly. Cure according to time and temperature data furnished with repair material.
- NOTE: Vulcanizer temperature is set operate at approx. 300 degrees F.

VALVE STEM REPLACEMENT

The following steps should be followed in preparation to vulcanizing a replacement valve stem.

- A. Detach flat plate by unscrewing wing nut on top of heat unit. Cavity in heat unit will accommodate passenger valve stems and small tractor stems. No 17 & No 18 adapter plates are available for truck and 3-1/4" large bore stems.
- B. Using a sharp pointed knife, cut the damaged valve or spud out of the tube. Hold the knife tightly against the valve barrel in a tilted position to provide a beveled edge to the cavity and keep the hole in the tube as small as possible. NOTE: If the tube is torn or damaged at the valve or spud, close the hole or repair the damaged as for ordinary puncture repair. Relocate the valve or spud at a corresponding spot elsewhere on the tube.
- C. Buff off as much of old valve on spud location as possible for an area slightly larger than the base of new stem and as near to the tube stock as will provide an even surface.
- D. Wash buffed surface with rubber solvent and apply one coat of vulcanizing cement.
- E. When cement has dried, remove holland covering from new valve or spud, being careful not to touch adhesive surface with fingers.
- F. Place center hole of valve over hole cut through tube, then press down firmly and stitch tightly with stitcher.
- G. With vulcanizer in open position place tube over rubber pad with valve stem in up position. Lower heat unit, making sure the valve is centered through the hole in heat unit. Check to make sure trigger in rear is in position and tighten handwheel screw firmly.
- H. Plug cord into electrical outlet and allow 15-20 minutes for heat up, plus required for curing stem base (Usually 8-10 minutes for small stems and 12-15 minutes for larger stems)