

Instructions How to inject the CFS Flexible Material

Important to following before beginning.

1. Turn on the surface 15min before the first injection
2. Is necessary the cylinder be placed in the furnace as it is warned up
3. Between cycles, the cylinder should be allowed to warm for at least 7 minutes before a tube is place in the cylinder for melting.

- A. Turn on the Furnace 15 min before first injection. It must stabilize at the temperature indicate on the specification tag attached to your furnace.
- B. Spray the inside of the plasticizing cylinder with the silicone. Mold Release Spray and insert in the furnace.
- C. When the temperature of the furnace has stabilized spray an aluminum tube with the Mold Release Spray insert all the way into the cylinder, after that spray the correct size bronze disc. Use the thin bonze disc for the large CFS flexible tubes and the thick for medium and small CFS flexible tubes.
- D. Allow the CFS resin material in the furnace for 11 min. make sure the position of the flask is correctly.
- E. After 11 minutes, remove the cylinder from the furnace maintaining it in its horizontal position and then turn it vertically, leaning the end of the cylinder on the projection so the tube does not fall out.
- F. Turn the levers of the Manual Press with a rapid motion and you going to fell a little resistance until the shaft reaches the tube. After the tubes bursts continue to apply firm pressure by turning until the tube bursts, after that continue the handle quickly until the springs have fully compressed. Levers will lock into this compressed position and you should be left this way 3 to 4 min.
- G. Remove the flask and separate the cylinder from the flask with a twisting motion. Clean out the remnants of the compressed aluminum tube using the knock-out ring as a platform, and hammering the knock-out provided. Be sure not to discard the bronze disc along with the remnants of the aluminum tube.

Note: Be sure to clean out the cylinder thoroughly and the bronze disc will slide easily through the cylinder and always keep a cylinder into the furnace for 7 min before to the next injection.

H. After removing the cylinder from the flask allow it to cool naturally for at least 20 min.