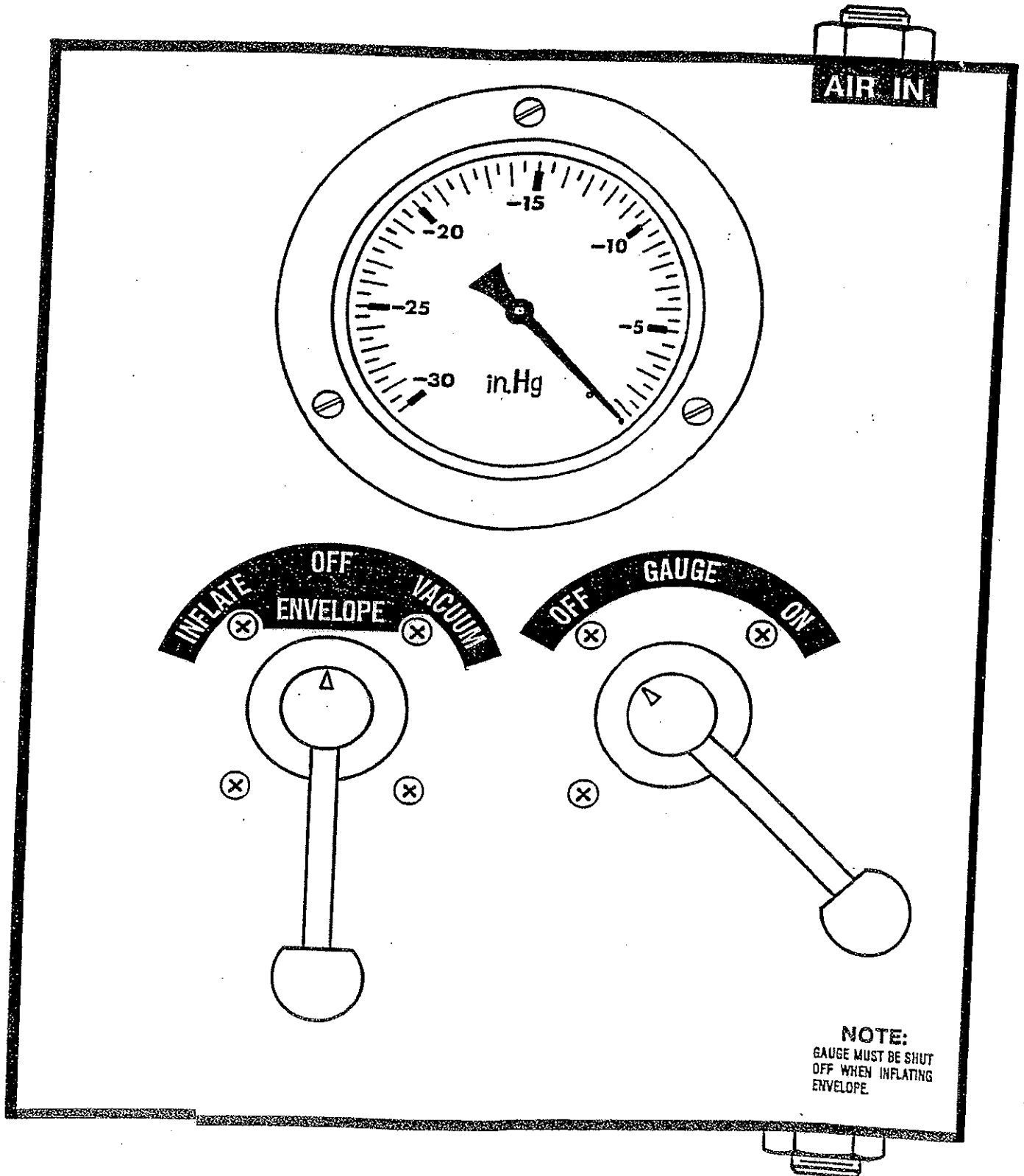


pre-cure envelope test center instructions



"PRE-CURE" ENVELOPE TEST CENTER

● INSTALLATION:

Mount the control box convenient to test station. With Bandag this would be at the tire lift.

● AIR REQUIREMENT:

150 P.S.I. minimum air pressure and an inlet hose or pipe of 1/4 inch minimum inside diameter.

● COUPLING:

Attach proper coupling for envelope stem to test hose. NOTE: All connections, pipe and quick disconnect must be completely air tight or a false leak will be shown on the gauge.

● PURPOSE:

To pull high vacuum on envelope for assurance that the envelope and bead sealing will not leak.

● CONTROLS:

1. Right hand "gauge valve" must be (ON) for vacuum and (OFF) for pressurizing the envelope.
2. Left hand "envelope" valve is centered for off, moved to (VACUUM) to operate the vacuum pump and to (INFLATE) for inflating the envelope.

● OPERATION (VACUUM LEAK TEST):

1. Gauge valve to (ON).
2. Envelope vacuum valve (ON) for 10-20 seconds to pull 20-25 inches gauge reading.
3. Envelope vacuum valve (OFF).
4. Gauge will drop and STOP.

ENVELOPE O.K. - TEST COMPLETE - DISCONNECT HOSE

● NOTE:

The stopping point should be above 10 inches. If not, pull more vacuum. If the gauge does not stop, there is an air leak, and the envelope may be pressurized by:

1. Move right hand "gauge valve" to (OFF).
2. Move left hand envelope valve to (INFLATE) until envelope has enlarged 1 to 1½ inches per side.

3. If leak is found on surface of envelope, apply sealing patch and re-test with vacuum.
4. If leak cannot be found, remounting of the bead sealing may correct the problem.
5. If the vacuum still will not hold, discard envelope.

● OPERATIONAL CHARACTERISTICS:

The volume of air to be removed may vary considerably with various tires, envelopes and methods of sealing the beads.

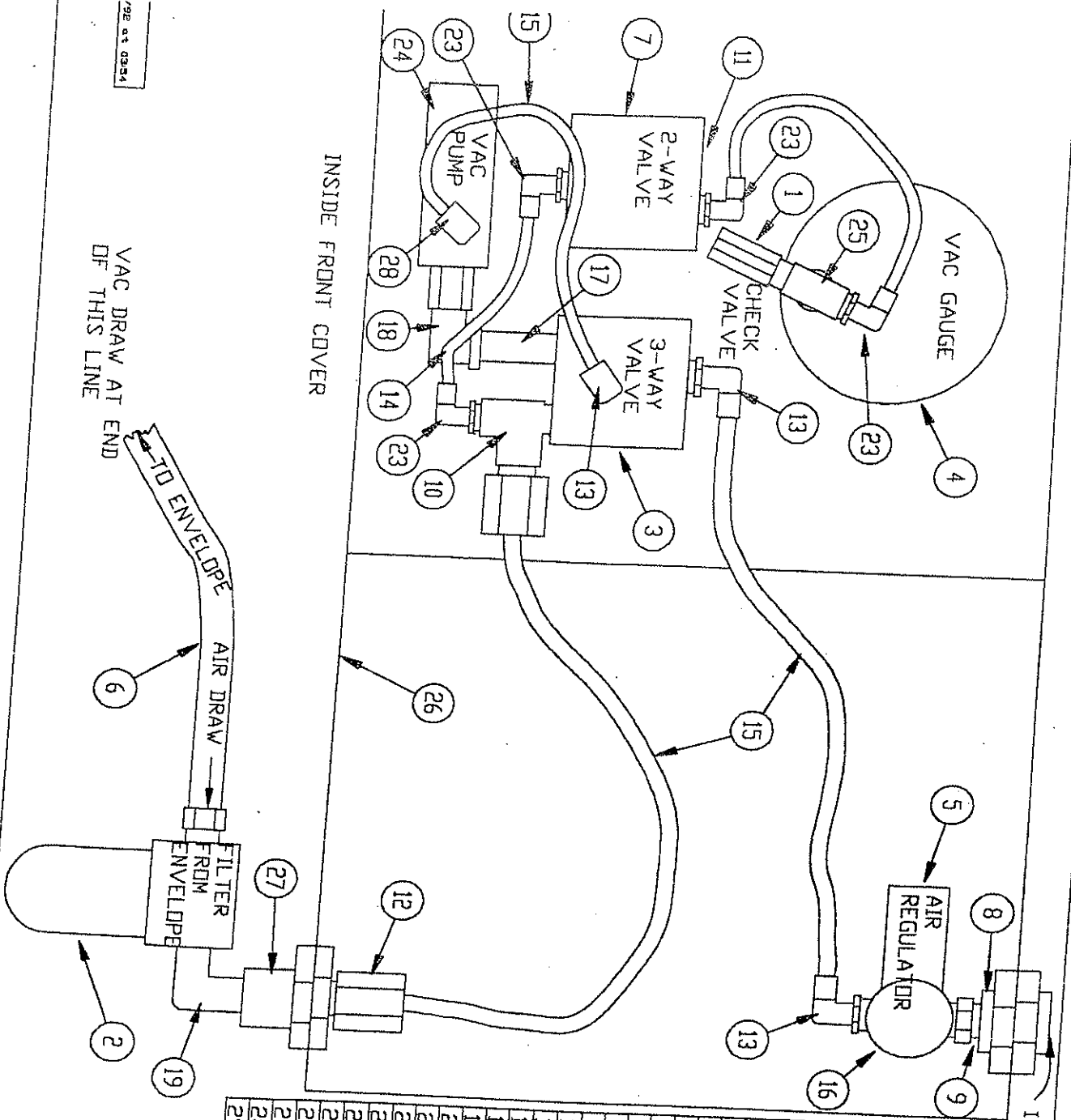
This will vary the time required to exhaust the air and affect the gauge movement after the envelope vacuum valve is shut off. A little extra time is required for the last small amount of air to work its way from the far side of the envelope through the partially closed tread design and this will be shown on the gauge.

If a short vacuum time is applied, the gauge will drop rapidly when the vacuum is shut off, slow, and creep some distance before stopping at a much lower reading.

Applying the vacuum for a longer period at full gauge, around 25 inches, will result in the gauge dropping very little and stopping at a high vacuum reading.

ONCE THE GAUGE STOPS, THE ENVELOPE AND SEALING IS PROVEN GOOD AND THE TEST IS COMPLETE.

VAC DRAW AT
END
OF THIS LINE



ENVELOPE TESTER

ITEM #	DESCRIPTION	QTY
1	33-409 PETIC CHECK VALVE	1
2	33-406 PETIC AIR FILTER	1
3	33-407 PETIC LEFT 3-WAY VACUUM VALVE	1
4	33-408 PETIC GAUGE/LIQUID FILLED	1
5	33-409 PETIC REGULATOR	1
6	33-410 PETIC 1/4 X 6 FT HOSE	1
7	33-411 PETIC RIGHT 2 WAY VALVE	1
8	33-413 PETIC MESH OXIDIZ BURKHEAD FITTING	1
9	33-417 PETIC 1/4 NIPPLE	1
10	33-419 1/4 STREET T	1
11	33-421 1/4 PLUG	1
12	33-429 1/4 TO 3/8 P.F. FITTING	2
13	33-433 1/4 TO 3/8 POLY FLOW ELL	2
14	33-437 1/4 POLY FLOW TUBING	3
15	33-439 3/8 POLY FLOW TUBING	1.8
16	33-410 REGULATOR GASKETS	3
17	33-441 1/4X1/4 STRAIGHT NIPPLE	1
18	33-442 1/4F TO M 90 DEG ELBOW	1
19	33-443 1/4 90 DEG ELBOW	1
20	33-445 10-32 X 2 SCREW	1
21	33-446 10-32 X 3/8 X 13/64 LOCK NUT	8
22	33-447 1/8 SHEET METAL SCREWS	8
23	33-448 PETIC 1/4 PIPE TO 1/4 POLY 90 EL	3
24	33-449 PETIC VACUUM PUMP	4
25	33-450 STREET T GALL FEMALE	1
26	33-475 PETIC BOX ONLY	1
27	33-418-1 PETIC #1299 04/24 BURKHEAD FITTING	1
28	33-433-1 3/8 - 3/8 P.F. ELL	1
29	33-405-1 CHECK VALVE ASSEMBLY	1

IN COMING AIR

INSIDE FRONT COVER