

Duraline[®]

Single Pole Vulcanizing Press



Duraline®

DA300106-2 Press Specs

Heating Element:

- Part number D200704-2, 250WATT

Temperature Range:

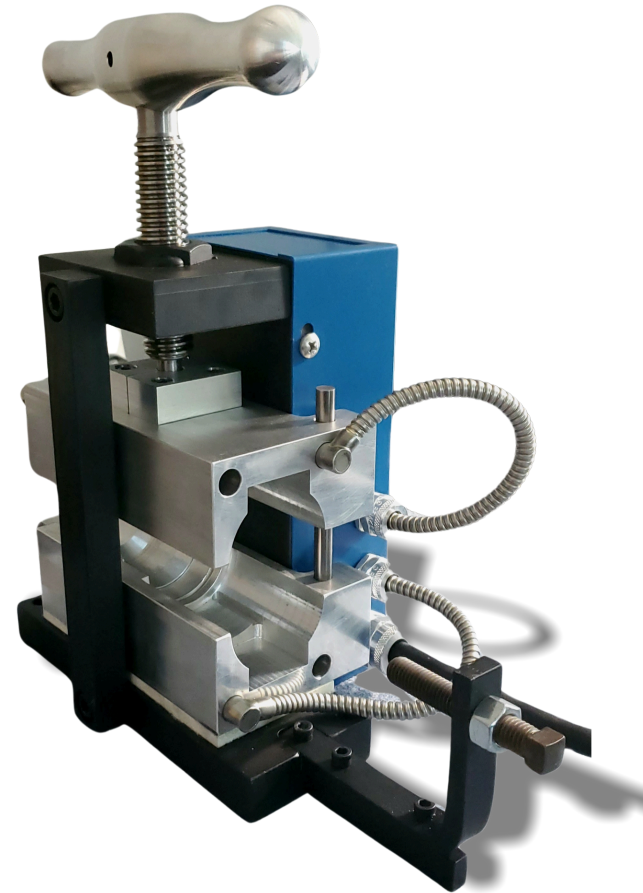
- Factory set at 325 to 350 for optimal use to vulcanize Neoprene and Hypalon

Power Requirements:

- Standard 110V AC outlet

Included:

- Bushing set for 500 -535 MCM Cable (DA200006-5)
- 10', 14/3 cord with molded NEMA 5-15 Male Plug
- Male and Female Stop Blocks



MOLDING PROCEDURE - MALE OR FEMALE CONNECTOR

Strip approximately 1-3/4" of cable jacket. Insert bare conductor into contact crimp

- 1 tube and crimp with hydraulic hand or bench press (20,000 PSI minimum), or other suitable crimping die. Die must be fully closed and sized for specific cable type/size.

- 2 Roughen cable jacket approximately 6-1/2" behind contact to remove all dirt and wax. A coarse rasp, coarse wire wheel, coarse emery cloth or abrasive sanding belt may be used. Then coat roughened cable jacket with neoprene cement such as Cam-Lok No. 238. Allow to dry, until tacky.

- 3 Wrap cable with neoprene tape keeping tension on tape. Wrap tape from contact back so that approximately 1/2" will extend beyond end of sleeve. Build tape up until it will give a snug fit on ID of sleeve. Wrap last layer of tape from cable toward contact for easier assembly into sleeve.

- 4 Roughen up about 1" of the I.D. and O.D. of the insulator sleeve at cable end. Apply "Spray Lube" into the I.D. of the insulator and over contact, cable and neoprene tape. Use sparingly.

- 5 Insert proper COME-A-LONG * tool into connection end of sleeve and push it through the insulator. If binding occurs, spray COME-A-LONG with "Spray Lube."

MOLDING PROCEDURE - MALE OR FEMALE CONNECTOR

- 6** A pair of COME-A-LONG tools are available to pull contacts and cable into insulator sleeves. The male COME-A-LONG is used to pull the female connector into its insulator, the female COME-A-LONG is used to pull the male connector into its insulator. Move forward or rotate in insulator. When properly seated a groove turned on COME-A-LONG lines up with end of insulator. Spring lock ring locks behind sleeve ring to hold contact.
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- 7** Connect COME-A-LONG to contact and pull contact and cable into insulator sleeve until pin on contact touches metal ring inside of insulator. Rotate insulator while pulling on COME-A-LONG until pin seats into groove in ring. Then pull forward until pin stops against U-shaped slot in ring. This locks contact into ring, so it will not 11. Wipe off excess "SPRAY-LUBE" from contact and rear of sleeve.
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- 8** Paint roughened portion of sleeve with Chem-Lok 238 and wrap two or three layers of tape over rear end of insulator and continue back onto the cable jacket approximately 1/2". This wrapping should fill in the offset at the point where cable jacket enters the insulator.
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- 9** Place connector sleeve in mold. Check to be sure that mold bushing is proper size for cable. Mold bushing I.D. should be approximately 1/64" smaller than cable O.D.
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- 10** Male connectors having positive latch release button should be placed in mold so that button is up. The ribs and grooves in sleeve must be aligned with mating ribs and/or grooves in mold.
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- 11** Close top half of mold. Mold must be completely closed. Close slowly, tightening clamping screw as tape heats up. Mold should be bolted to top of workbench to securely anchor it.
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- 12** Mold at 325-350°F. for approximately 30 minutes. Neoprene tape will be firm and tough when completely cured.
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- 13** Remove from mold. Allow to cool. Trim off excess flash with razor blade or sharp knife or scissors.
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*Part Numbers Listed on Back Cover

Duraline Vulcanizing Press Parts & Accessories



Duraline Brass Come-A-Longs

DA200020-6	Duraline Brass Come-A-Long for Female Single Pole Connectors
DA200020-5	Duraline Brass Come-A-Long for Male Single Pole Connectors

Assembly Materials

A003069	Vulcanizing Molding Tape
A006996	Copper Shims for Cam Lok Single Pole Connectors

Maintenance Materials

M182700	Duraline Maintenance Kit
7447	Stoner Silicone Lubricating Spray
7449	Stoner A500 Cleaner Degreaser

Additional Bushing Sets

DA200006-2	2 Piece Bushing Set 250 & 262 MCM
DA200006-3	2 Piece Bushing Set 350 & 373 MCM
DA200006-4	2 Piece Bushing Set 400 & 444 MCM
DA200006-40	2 Piece Bushing Set 4/0 W
DA200006-5	2 Piece Bushing Set 500 & 535 MCM
DA200006-7	2 Piece Bushing Set 750 & 777 MCM

Industrial Strength Electrical Products for Industrial Strength Users

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