

Trautman Vacuum Station

from Fillauer LLC

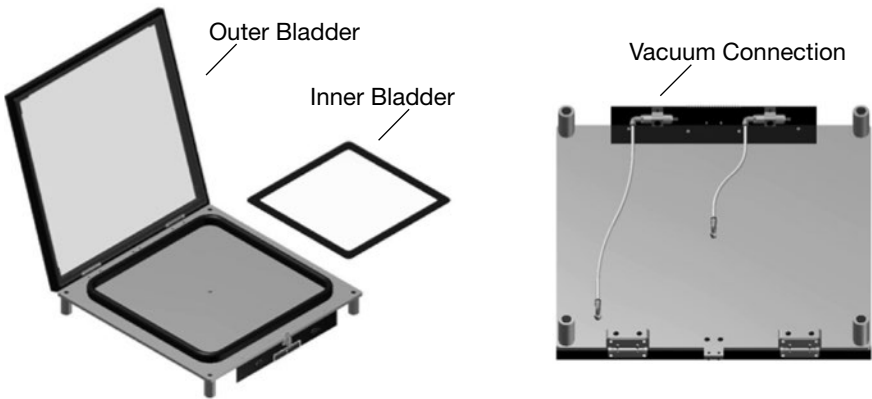


**PRODUCT
MANUAL**

Fillauer
COMPANIES

DESCRIPTION

The Single and Double Bladder Vacuum Stations are supplied with durable heat resistant translucent silicone bladders for longer life. The Double Bladder Vacuum Station is designed with an inner and outer vacuum bladder made from silicone. The inner silicone bladder serves as a mold separator and seals the mold to protect the fabrication material from contacting the mold directly. The outer silicone vacuum bladder is used to form the fabrication material over the mold.



SETUP & INSTALLATION

1. Place the Vacuum Station in a level, well lit area.
2. Attach vacuum lines to the barbed fittings on the vacuum control valves.
 - a. Dual bladder setup requires two vacuum lines: one for the inner bladder and the other for the outer bladder.
 - b. A splitter can be used to supply both control valves from a single vacuum source. If using a splitter (“Y” or “T” type), ensure the splitter is located as close as possible to the vacuum source.
 - c. If you are using the Single Bladder Vacuum Station, only one vacuum line is needed.
3. Turn on the vacuum source and open the control valves and verify vacuum is achieved.

OPERATION

1. Ensure the interior of base is free from debris and place the mold in the center of vacuum station.
2. Place wicking material (such as felt) under the mold. Allow for wick to come into contact with the vacuum port located in the center of base.
3. Place the inner silicone vacuum bladder over the mold.
4. Apply a strip of wicking material along the outer vacuum port (top left hand corner of base) to the center of the frame. Close the frame lid.
5. Turn both vacuum control valves to the “on” position. Allow the silicone bladders to form tightly to the mold.
6. Once the inner bladder has sealed, release the vacuum on outer bladder by turning the outer bladder control valve to the “off” position.
7. Open the outer bladder. Heat and apply fabrication material over the silicone covered mold.
8. Once the fabrication material is in place, apply wick and close the outer bladder.
9. Turn the outer bladder control valve to the “on” position. Allow the silicone bladder to form tightly to the model.
10. Set times for fabrication materials vary. Allow the fabrication material to cool before releasing the vacuum.
11. Once the fabrication material has cooled, turn both control valves to the “off” position. Open the frame, retrieve the device, and continue fabrication as normal.

SILICONE BLADDER REPLACEMENT: OUTER BLADDER

1. Remove the outer bladder frame from the station by disengaging the quick release hinges located on the back of the station.
2. Place the bladder frame on a clean flat surface for silicone bladder removal.
3. Gently remove the retainer cord from the interior of frame.
4. Remove the old silicone bladder.
5. Center the new silicone bladder on the frame.
6. Starting in the center of the back of the frame, press the silicone retainer cord and replacement bladder into the channel groove. Use your fingers or a blunt instrument to prevent damage to the bladder or cord.
7. Once the cord is fully seated, carefully trim the excess silicone.
8. Reattach the frame to the vacuum station. Ensure the quick disconnect hinges are fully engaged before using the vacuum station.

SILICONE BLADDER REPLACEMENT: INNER BLADDER

1. Remove the inner silicone bladder frame from the vacuum station.
2. Peel off the old silicone bladder. A putty knife may be used to assist in the removal.
3. Remove the old adhesive by lightly sanding with a medium grit sand paper.
4. After removing the adhesive, clean the frame with isopropyl alcohol. **Do not use acetone.**
5. Once cleaning is complete, apply silicone adhesive (P/N 600323) to the frame. Use a flat tool (such as a tongue depressor) to smooth the adhesive. Ensure that the adhesive covers the frame from edge to edge.
6. Lay the new silicone bladder on a clean flat surface. While keeping the adhesive side facing the new silicone bladder, apply the inner frame to the bladder. Inspect the silicone bladder to make certain that there are no wrinkles or folds. Pay particular attention to the areas of the frame.
7. Allow 24 hours for the adhesive to cure.
8. Once the adhesive has cured, trim away the excess material along the edge of the frame with a sharp knife or scissors.



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