



# Max Inferno®

Hot Air Curing System



## PARTS AND ACCESSORIES:

- Max Inferno Heater Control Unit
- 4"-6" Manifold with Pressure Gauge
- 3 Wire Dryer Outlet Adapter Cord
- 4 Wire Dryer Outlet Adapter Cord
- (3) 4" Clamps
- (3) 6" Clamps
- 100' 1" LayFlat Hose
- 250' Pull Strap
- Fittings
- 22" Waterproof Toolbox



## OPERATING INSTRUCTIONS:

1. Attach the 1" layflat hose to the manifold as shown and tighten the hose clamp.



2. Clamp the calibration hose to the manifold and attach the Red and Black Hoses to the Heater Control Unit as shown.



3. With the Air lever in the Off position attach the air hose from the compressor to the front of Heater Control Unit as shown. With the Heat switch in the Off position connect the power cable to the side of the Heater Control Unit as shown.



4. With the air relief lever on the front of the Heater control unit in the fully open position (lever facing forward as shown above) , move the Air lever on the control panel to the On position and slowly increase the air pressure to 10 psi by turning the Pressure control knob in a clockwise direction. Once the layfat hose has fully opened the calibration hose inflates and air will begin flowing out of the air relief valve on the front of the Heater Control Unit.

5. Using the pressure gauge on the manifold (not the control panel) adjust the calibration hose pressure to between 8 and 10 psi using the Pressure control knob.



6. Set the Input Air Temperature using the up or down arrow buttons on the Input Air Temperature Controller. The lower **Green** display value will increase or decrease when you press the up or down arrows. When the desired Input Air Temperature is shown press the Set button and the display will stop flickering indicating that the Input Air Temperature is now Set. Refer to the following Table as a guide to the Input Air Temperature settings typically used for different Liner Lengths.



This Table is a guide, showing the Input Air Temperatures settings typically used for various Liner Lengths. These settings may vary depending on liner diameter and the type of epoxy used.

| LINER LENGTH   | INPUT AIR TEMPERATURE |
|----------------|-----------------------|
| 10 to 20 feet  | 200                   |
| 20 to 40 feet  | 250                   |
| 40 to 60 feet  | 275                   |
| 60 to 80 feet  | 300                   |
| 80 to 100 feet | 325                   |

7. With air flowing out of the air relief valve (step 4), the recommended curing pressure on the manifold pressure gauge (Step 5) and the Input Air Temperature set ( Step 6), turn on the heating element by moving the Heat switch to the On position. The **Red** display on the Input Air Temperature Controller will increase and decrease a few times until the Set temperature is achieved and maintained.

8. The Return Air Temperature is shown on the **Red** display of the Return Air Temperature Controller. If the Return Air Temperature is below 130 degrees after 20 minutes, increase the Input Air Temperature by 25 degrees. If the Return Air Temperature goes above 160 degrees, decrease the Input Air Temperature by 25 degrees. Once the Return Air Temperature is above 130 degrees the typical curing time is between 2 and 3 hours depending on the liner length and diameter, and the epoxy being used. If you are not using MaxLiner Resin, consult the resin manufacturer for recommended curing temperatures.



9. After the recommended curing time has been reached, move the Heat switch to the Off position and allow the air to continue flowing for 10 to 15 minutes.

10. Decrease the pressure to 0 by turning the Pressure knob counter clockwise and move the Air lever to the Off position.



- \* To make sure that the liner is fully cured prior to removing the calibration hose you can suck the air out of the calibration hose by placing your vacuum pump or a shop-vac over the air relief valve on the front of the Heater Control Unit. Once the calibration hose is flat you can run your camera down the liner - between the liner and calibration hose - to inspect the liner to make sure it is cured. If it is not fully cured, repeat Steps 4 through 7 and continue the curing process. If the liner is cured repeat Step 5 to re-inflate the calibration hose prior to attempting to remove it. Attempting to remove the calibration hose without re-inflating it will likely cause it to bunch up and make it difficult to remove.

#### **EQUIPMENT STORAGE:**

Store the Heater Control Unit in a climate-controlled environment when not in use. Exposing the Heater Control Unit to extreme heat, cold or humidity may adversely affect its performance and service life.

- \* Initial cure is indicative of the potential state of cure when the subject epoxy system is properly rationed, mixed and held at the captioned temperature. The information contained herein is offered without charge for use by technically qualified personnel at their discretion and risk. All statements, technical information and recommendations contained herein are based on test and data which we believe to be reliable, but the accuracy or completeness thereof is not guaranteed, and no warranty of any kind is made with respect thereto. Contact MaxLiner Technical Support with any questions prior to starting your project or troubleshooting.

**Call our technical advisor with additional questions at 877.426.5948**

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