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1.0 Description:

Envelope Repair kit maybe used to repair holes and tears caused to the envelope during normal use. Repairs are made using a heated and pressurized vulcanizer to cure the repair to the envelope.

2.0 Materials and Methods:

2.1 Elgi Envelope Repair Gum - Butyl Type

Catalogue No	EA40 – 2.2 Lbs
Weight	0.5Kg / 1.1 Lbs
Strip Width	50mm
Strip Thickness	2.5mm



2.2 Elgi Envelope Repair Cement - Butyl Type

Catalogue No	CH08 – 8.4 Oz
Quantity	250ml



2.3 Envelope Spot Vulcanizer:

Model	VE 1
Catalogue No	MC40 1 - D
Dimensions (L X W X H) (mm / in)	600 X 300 X 600 / 23.6 X 11.8 X 23.6
Air pressure (Kg/cm ² / psi)	2.0 / 30
Total Installed power (W)	300
Power supply specifications (V / Hz / ph)	220or 110 / 50 or 60/ 1
Operating temperature (°C / °F)	150 / 302
Weight (Kg / lb)	27 / 60
No. of curing Drums	1
Throat Depth (mm / in)	370 / 14.5



3.0 Accessories Required:

Air Tool with 36 random grit or 170 structured grit wheel, Stitching Tool and Scissors OR Die to cut the repair gum to the size required.

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4.0 Procedure:

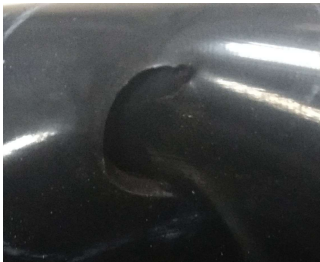
1. Turn on the Spot Vulcanizer to 315°F and set the pressure to 60 psi.
2. Clean the area to be buffed with non-petroleum based solvent.
3. Buff an area 1" larger in diameter than the injury using a 36 random grit or 170 structured grit wheel by using a low r.p.m air buffer (5,000 max). Clean area again with solvent and let dry.
4. Apply a moderate coat of cement to the buffed area and let dry for 15 minutes or until all solvent has evaporated.
5. Cut a section of repair gum 1" larger than the area to be repaired.
6. Place repair gum, non poly side down, on the repair area and stitch down working from inside out. Remove poly from top of repair gum.
7. When the set temperature reaches 150°C/ 315°F at the Vulcanizer, mount the envelope on the bottom of the inflation head with repair gum facing upward. Manually tighten the upper handle until the top plate is hand tight.
8. Start the cure cycle and ensure 315°F and 60 psi are maintained during the curing cycle.

9. Remove and inspect for proper cure.

Note: If the injury is a through envelope, repeat all steps to repair the inside of envelope.



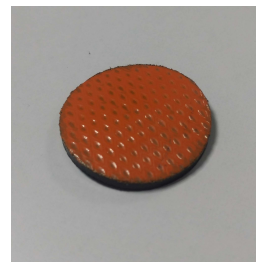
Spot Vulcanizing



Repair Envelope



Area – After Buffing



Repair Gum



Stitching

- End of Procedure

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