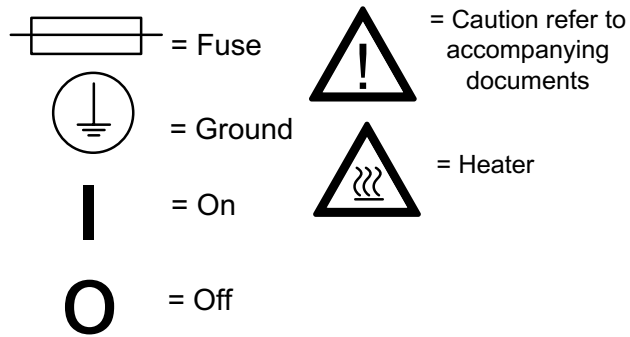


**Vacuum Forming Machine Symbol Key**



**1 Post**

**VACUUM  
FORMING  
MACHINE**

Fuse Replacement:  
240 volt(Max) 1 Post - 6.3A 250V  
115 volt 1 Post - 15A 125V

**MANUFACTURED BY:**

Keystone Industries-Myerstown  
Myerstown, PA 17067, USA

Phone: 1-800-333-3131 856-663-4700 Fax: 856-663-0381

UL Listing# : E194439 (115 Volt only)



**Operating and  
Instruction Leaflet**

# Pro-form 1 POST VACUUM FORMING MACHINE OPERATION

## Intended Use

This vacuum forming machine is intended to be used for the thermoforming of thermoplastic materials in the fabrication of dental appliances.

## UNPACKING AND SETUP

### 1. Handles

Remove the red cap from left handle hole. This cap is used to hold the handle locking pin in place during shipping. Be certain the pin does not fall out of the hole when the cap is removed. Attach the handles into the threaded holes at the rear of the hinged frame.

### 2. Placement

The Vacuum Former should be placed on an open counter, within 4' of a standard properly grounded electrical outlet away from any wet surfaces.

Caution: The unit should not be placed closer than 6" from walls, cabinets, combustible materials or other equipment while in operation because of the temperature emitted from the heater. Under no circumstances should this unit be operated while located under or in a cabinet.

### 3. Electrical Cord

Install the power cord onto the inlet. Plug into a properly grounded electrical outlet. The unit's power cord should not be placed near the heater or any other hot surface. Do not block access to the power inlet or electrical outlet. The power supply cord is the disconnect device for the unit. Do not position so that it is difficult to operate the disconnecting device.

## BASIC OPERATION

4. Swing the heating unit to the rear of the unit then turn on the right switch by lifting upward to start the heater. The light on the heater switch will illuminate to indicate when the heater is turned on.

Note: Smoking from the element may occur when the heater is first operated due to the oil on the heater or post.

5. To open the plates, pull the large black latch knob. Place the desired thermoforming material between the material frames then reengage the latch knob. (Refer to the Technique Booklet for material selection and usage guidance) Use caution when operating the machine as the heater is Very Hot.

6. Move the heater to the front position and raise the frame to its upper position. Lock the plates into the upper position by turning the left handle toward you.

**Important Note:** Ensure material plates are locked properly in the upper position to prevent possible hand/finger injury.

**DO NOT TOUCH THE HEATER HEAD DIRECTLY. USE THE KNOB ONLY.**

7. Place the dry cast on the vacuum plate. After a sufficient droop in the plastic has developed, lower the frame onto the model/study cast. Please note, some materials do not droop (for example Dual Laminate, Bleaching Laminate and ASD Base).

Caution: DO NOT leave the machine unattended while heating materials.

8. Switch the vacuum heater off and the motor on. Do not power the heater and the vacuum at the same time. Move the heater to the rear position using the handle. Allow the motor to run for 10 to 15 seconds before turning off the vacuum.

# TECHNICAL SPECIFICATIONS

Pro-form 115 V 1 Post: Rating 115 V 50/60 Hz 1475 W

Pro-form 240 V 1 Post: Rating 240 V Max. 50/60 Hz 1150 W Max.

## USER INSTRUCTIONS

Note: Allow the heating unit time to cool for at least 10 minutes between operations (or placement near a wall). Do not allow the heating element to rest over the handles at anytime as they become very hot.

Warning: The heater should be operated for a maximum of 2 minutes followed by a maximum 20 seconds vacuum time. Turn the heater off before turning on the vacuum motor. Turn heater switch off before positioning heating unit in rear of machine to avoid excessive heating of electrical cord. Failure to follow could damage the above and void warranty.

The Vacuum Forming Machine is intended for indoor use in a standard dental laboratory environment.

Ambient Operating Temperature: 5-40°C

Relative Humidity: Max 80%

Altitude: Maximum 2,000m

Installation Category: Nominally II

Pollution Degree: Nominally 2

Mains Supply Fluctuations not to exceed +/- 10% of the nominal voltage.

Overvoltage Category II

## CLEANING AND MAINTENANCE

1. A slightly damp cloth can be used as necessary to wipe down the unit. No other cleaning should be required. Clean only when the unit has cooled and is unplugged. Allow the unit to dry completely before resuming operations.

2. Periodically inspect the power cord for wear (ie., fraying, etc.) and check the plug to insure that the connectors are fully seated. If power cord is worn or damaged, please contact your authorized dental distributor for a manufacturer's genuine replacement power cord.

3. Only the finest quality materials are incorporated into this product however, after years of use, the heater or other parts may need replacement. If a part requires replacement, please contact your authorized dental distributor.

## WARRANTY TERMS AND CONDITIONS

The 1 Post Vacuum Former is warranted for its designated use, in accordance with the instructions, against original defects in material and workmanship for a period of 60 months\* from date of purchase. This warranty extends only to the original purchaser.

\*Exclusions: Warranty void if unit is tampered with. Serial Number and Ratings label must be intact. Gaskets, fuses, broken castings and electrical cord are excluded from warranty terms

Note: If the equipment is not used in the manner specified by the manufacturer, the protection provided by the equipment may be impaired.

## REPAIRS

Contact your authorized dental distributor for repair procedure.

Do NOT pack unit in styrofoam chip material for shipping. The material may lodge into the heater mechanism and become a fire hazard. Remove handles.