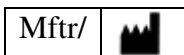


Lyn Socket Port High Vacuum Plug Kit

PA0080

1. Determine location on cast model and flatten/ level area. Use indelible marker in center of dummy hole to mark dummy location.
2. Drill 1/8" pilot hole for dummy holding screw **AND** drill vacuum hole adjacent to the pilot hole. Vacuum hole should extend to the bottom of the cast model.
3. Mount dummy using the screw provided and place self- adhesive foam disc over the screw. **NOTE:** The small air holes in the dummy should be aligned vertically over the pilot and vacuum holes to achieve the best draw.
4. Mold thermoplastic socket taking care to guide plastic around dummy to insure proper molding.
5. Once plastic has cooled, use a disc sander to expose enough area to remove self-adhesive foam disc and screw.
6. Continue sanding until the red dummy face is only **SLIGHTLY SCUFFED** and the plastic is flush with the dummy face. **NOTE: DO NOT OVER SAND.**
7. Blow socket off of cast model and insert housing into socket. **NOTE: Make sure black rubber housing "O" ring is seated properly in the housing groove..**
8. Firmly **HAND TIGHTEN** the aluminum nut. **DO NOT** over-tighten nut.
9. Insert plug into housing threads and **HAND TIGHTEN.**

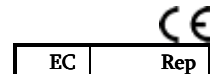


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