

The Dura-Max Elite™ and Extreme™ vacuum bags were designed for VeneerSupplies.com using an advanced thermoplastic polyurethane that can withstand pressures exceeding 3,750+ psi and stretch more than 6 times its width and length (based on ASTM D 412 test methods). Dura-Max polyurethane film has superior resilience, unmatched puncture resistance and is made in the USA.

Each bag is welded on a state-of-the-art custom RF welding machine operating at 7,000 watts and 50 lb/in of pressure. This exact combination of frequency and clamp strength yields the most durable and airtight seam available.

The vacuum bag also includes our new flush-mount valve stem assembly that allows full length use of the vacuum bag without the worry of project surface damage. A specially designed 2.5" diameter 50-mil flange is molded onto the polyurethane valve body and is permanently welded onto each bag. This creates an 80-mil total thickness reinforcement area for maximum durability.



**Dura-Max Vacuum Bags:
Welded with 7,000 Watts
of Radio Frequency**

About Vaxcell™ Infusion

Dura-Max Polyurethane vacuum bags are infused with a non-transferring lubricant called Vaxcell™ that works in several ways to make vacuum bagging easy and trouble-free. Vaxcell lubricant prevents nearly all adhesives from sticking to the bag. If any glue gets on the bag, it simply peels right off. Unlike traditional urethane material, Vaxcell infused polyurethane allows the user to easily slide the platens and project panel into the bag without "blocking" or binding. The slippery surface created by Vaxcell makes inserting project panels a breeze.

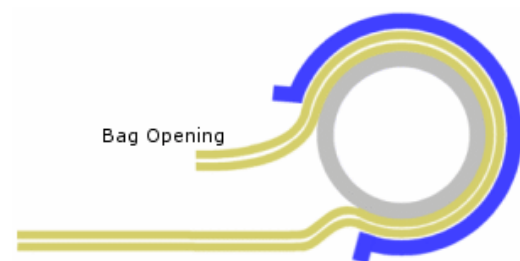
Part A: Preparing Your Dura-Max™ Vacuum Bag

1. Unroll the vacuum bag and locate the polyurethane nipple which is located approximately 15 inches inward from the vacuum bag opening.
2. From the top side of the vacuum bag, fully insert the barbed side of the brass connector into the nipple.

Part B: Using the Bag Closure

The PVC closure system included with your vacuum bag will allow you to easily seal the bag opening. Simply roll the bag end over the PVC tube. Then snap the PVC C-channel over the bag starting from one side and working towards the opposite side. To ensure a perfect seal, be certain that the entire bag opening is secured by the closure and that there are no wrinkles in the bag material.

For additional clamping strength, you can attach spring clamps over the C-channel. This is not necessary under normal conditions but it will provide a better seal if the bag is heavily worn. For the ultimate gripping strength, the bag may be rolled over the tube twice before the C-channel is attached. We do not recommend more than a double roll over the tube due to the difficulty of removing the closure under such clamping pressure.



Bag Closure Cross Section

A light coat of car wax or silicone spray will make it easier to snap the bag closure over the vacuum bag. Be certain that neither of these products is accidentally applied to the inside of the bag where it could foul the work piece for finishing.

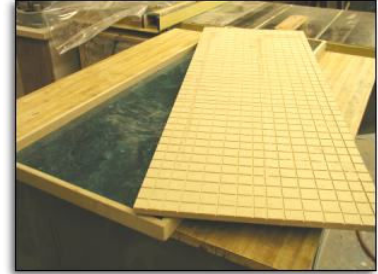
Part C: Vacuum Bag Maintenance

Polyurethane is much more resilient than vinyl and with ordinary use, will last for a very long time. You can extend the service life of the vacuum bag by using and storing it carefully. Be sure to round over the protruding edges of anything placed inside the bag including the platen and cauls. When you're finished with the vacuum bag, store it away from direct sunlight.

In the unlikely event that your bag develops a leak, the easiest way to find it is to place a piece of brown paper in the area where you suspect there is a leak. Then place the platens inside the bag and clamp it shut. Next, turn on the vacuum unit and allow it to achieve as much pressure as possible. Now spray the outside of the bag with water. Any holes in the bag will show up on the paper as the water is absorbed. To repair the leak, contact us for a patch kit.

Part D: Platens, Cauls, and Breather Mesh

The platen system inside the vacuum bag is what keeps the panel flat while the press is in use. It also allows air to flow out of the vacuum bag to the vacuum source thereby creating evenly distributed pressure inside the bag. You'll need to make 2 platens from $\frac{3}{4}$ " melamine. Or if you have plastic laminate available, you can also use plywood or MDF for the platens (be sure to adhere the laminate to one side of each platen). Either of these two types of platens is ideal for vacuum pressing because it will prevent the veneered panel and any excess adhesive from sticking to the platens.



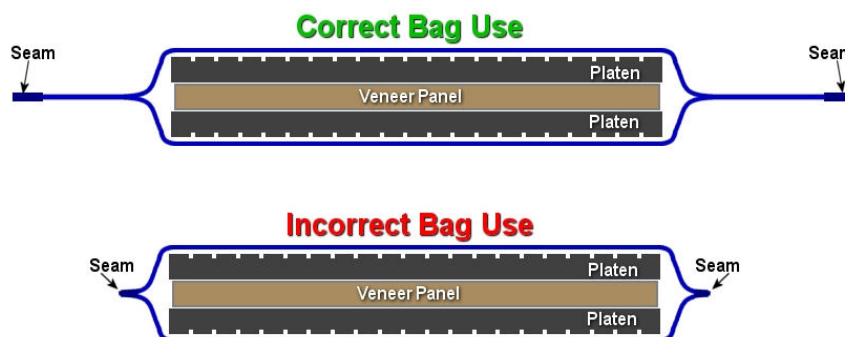
For more information visit www.JoeWoodworker.com/veneering/platenscauls.htm

Breather mesh is an extruded plastic fabric that is used in a vacuum bag to allow air to flow away from the project being pressed and towards the vacuum port (valve stem). It is used in place of a top platen/caul. Without it, the vacuum bag material can seal itself against the veneer causing pockets of air. These pockets have little or no pressure inside and therefore do not provide enough clamping strength for veneer work. By using breather mesh, you allow the vacuum pressure to evenly distribute throughout the bag. This is the key to successful vacuum pressing.

For more information visit www.JoeWoodworker.com/veneering/breather-mesh.htm

Part E: Avoid this Common Mistake

Be careful that you do not stress the seams on your vacuum bag. The seams will surely break if they are being pulled apart by vacuum pressure. With a bag of the correct size, the seams will pull together. Imagine a small project inside a large bag. Under pressure, you would notice that the seams actually pull together and are under virtually no stress.



Part F: Making Large Bags More Convenient

It can be difficult to work with a large project in a large vacuum bag. To make the process easier, you can cut off the seam at the far end of the bag. This will allow unencumbered access to the project panel from both ends. Keep in mind that you will need a second bag closure to seal the end. These are available for immediate shipment at VeneerSupplies.com.