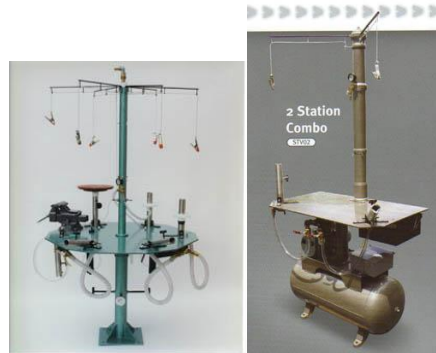
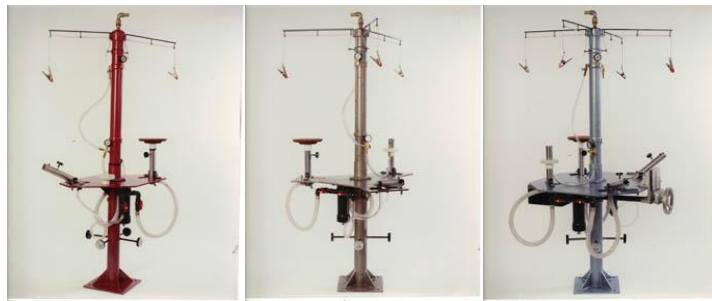


OPE

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The Table

ALL MODEL WORK STATIONS SET UP AND OPERATING INSTRUCTIONS



Models: ST002, STV02, ST003, ST004, ST006
Read these instructions before using the equipment.
Failure to do so can result in serious injury.
SAVE THESE INSTRUCTIONS.

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FOR TECHNICAL QUESTIONS OR PARTS PLEASE CALL 800-607-7677

Table of Contents

Safety, Caution Symbols and Precautions.....	3-6
Installation.....	7-10
General Specifications.....	11
Operating Precautions and Operation.....	12
Maintenance and Troubleshooting.....	12
Parts List	13
One Year Limited Warranty	14

SAVE THIS MANUAL

Keep this manual with the corresponding safety warnings, precautions, assembly, operating instructions, maintenance, and troubleshooting procedures.

Write the product's serial number in the back of the manual near the illustration for your model.

Keep this manual and any other purchase documents in a safe and dry place for future reference.

Safety and Alert Symbols and Words

There are several safety and alert symbols and words used in this manual:

This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid serious injury or death.



DANGER

DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury



WARN

WARNING indicates a hazardous situation which, if not avoided could result in death or serious injury.



CAUTION

CAUTION indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

NOTICE

NOTICE is used in reference to procedures not related to personal injury.

IMPORTANT SAFETY INSTRUCTIONS

INSTRUCTIONS RELATED TO FIRE RISK, ELECTRIC SHOCK, AND OTHER TYPES OF INJURY HAZARDS.

WARNING – When using tools on should use general safety precautions to prevent injury to oneself and others. The following basic rules of safety should be followed:

Read all instructions first before using equipment. Avoid electric, fire, dust inhalation hazards. Wear eye protection.

A. Work area.

1. Keep work area clean and well lighted. Clutter on top of benches and dark areas increase the risk of accidents and injury to persons.
2. Do not operate equipment in explosive atmospheres, such as those created by volatile flammable liquids, plastic resins and solvents, gases, and/or dusts. Equipment caused sparks can ignite these fumes and dust.
3. Keep non-work related personnel, visitors, children, away while operating the equipment. Avoid distractions that can cause accidents and loss of control of the equipment.

B. Personal Safety.

1. Maintain yourself alert, watch what you are doing and use common sense when using the equipment. Do not use the equipment while tired or under the influence of any medication or drug. Do not drink alcohol and use the equipment.



2. Dress properly. Do not wear loose clothes or jewelry. Keep long hair tied back and watch any moving parts to avoid injury through entanglement and being caught in moving parts.

3. Follow all safe operation rules for the equipment.
4. Remove any adjusting tools or wrenches before turning the equipment on.
5. Keep proper footing and balance at all times.
6. Use safety equipment.



7. Always wear eye protection. Wear ANSI-approved safety goggles.



8. Always wear dust mask whenever dusts are being generated by the equipment. Use the appropriate dust removing attachments.

C. Tool Use and Care

1. **Do not use the tool if the switch does not turn the tool on or off.** Any tool that cannot be controlled with the switch is dangerous and must be repaired.

2. **Always turn the equipment off before making any adjustment, changing accessories, or attachments.** These preventive safety measures reduce the risk of starting the equipment unintentionally and causing personal injury.

3. **Maintain the equipment with care.** Keep the equipment clean. Follow any required maintenance.

4. **Check for misalignment of binding of any moving part, broken parts or any condition that affects the equipment operation.** If any damage is noted, have the equipment repaired

before using. Many accidents are caused by poorly maintained equipment.

5. Use only the approved optional equipment for the specific model. Use of accessories not approved by OPE for its equipment can increase the risk of injury to persons.

Installation - All Work Station models – ST001, ST002, STV02, ST003, ST004, ST006

All Work Station models – ST001, ST002, STV02, ST003, ST004, ST006:

- **WARNING:** All Table Work Station models should be bolted firmly to the floor with four, ½ in. anchor bolts, nuts, and compression washers (not provided). See Section D below.

A. Tower Installation



1. On models with external vacuum supply, place vacuum line on quick attach fitting on tower top.



2. Apply silicone sealant on table surface between tower attachment bolt threaded holes.



3. Place gasket on silicone and align attachment bolt holes.



4. Apply sealant to top side gasket surface.



5. Place tower over the gasket, align attachment holes. Place mounting bolts and tighten with wrench.

B. Vacuum Gage and Attachments



1. Unpack vacuum gage and double bag lamination attachment.



2. Connect components as shown. Vacuum supply to gage and to lamination attachment.



3. Position double bag lamination attachment on lamination pipe below lower Allen set screw. Unscrew set screw.



4. Use tape to seal around lower attachment to pipe.



5. Attach vacuum gage to tower vacuum supply using vinyl hose.



6. Unwrap bubble forming plate.



7. Place bubble forming plate on work station pipe as shown. Seal with tape.



8. Vacuum is supplied through individual valve.

C. Outrigger Installation.



1. Unwrap outriggers



2. Adjust locking nut on outrigger attachment threads.

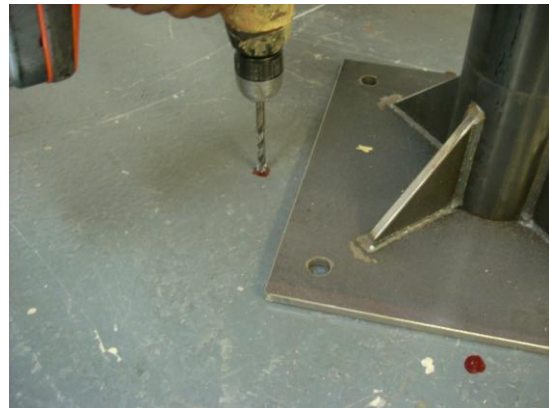


3. Thread outrigger into central vacuum tower top and tighten lock nut with wrench as shown. Do not overtighten.

D. Bolting Table to Floor



1. Mark base holes on floor.



2. Drill first hole in floor



3. Use expansion bolt to attach base to the floor. Position into mounting hole to guide further drilling.

General Specifications

Table Model	Number of work stations	Vacuum source	Tool Drawer	Overall Height	Table height	Double bag lamination	Bubble forming plates
ST001	1	external	no	86 in (218 cm)	36 in (91 cm)	Y	Y
ST002	2	external	no	86 in (218 cm)	36 in (91 cm)	Y	Y
STV02	2	incorporated	no	86 in (218 cm)	36 in (91 cm)	Y	Y
ST003	3	external	no	86 in (218 cm)	36 in (91 cm)	Y	Y
ST004	4	external	yes	86 in (218 cm)	36 in (91 cm)	Y	Y
ST006	6	external	yes	86 in (218 cm)	36 in (91 cm)	Y	Y

Optional Equipment: Metal Vise (VISEM), Prosthetic Vice (VISEP), Vacuum Press (VP001)

Operating Precautions

Warning: Read instructions before use

Safety warnings:

- Misuse of machine can cause injury.
- Do not modify the machine.

Operation

Thermoplastics:

1. Set mold on the working station and place plastic in the oven.
2. When plastic is ready, drape over mold.
3. Seal plastic and open vacuum valve.

Laminations:

1. Set mold on the working station and seal with PVA bag.
2. Set up and mix chemicals.
3. Place second PVA bag, open vacuum valve and pour chemical.

Turn the table to another station and repeat the process.

Maintenance



Drain water weekly.

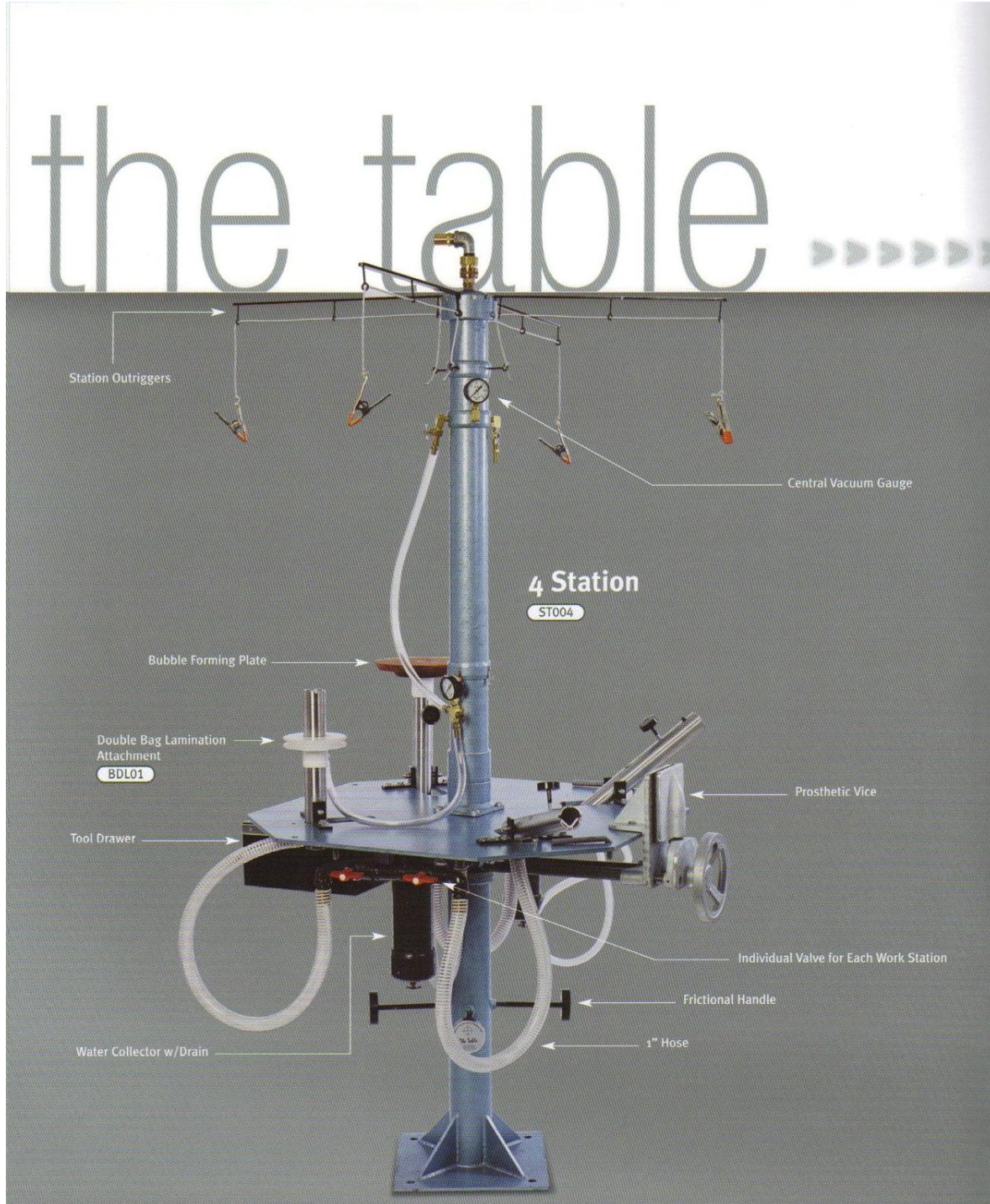
Spray lamination pipe with WD40 or silicone lubricant weekly to lubricate valves.

Trouble Shooting

Detailed repair instructions can be obtained upon request from our technical support staff.

Please call 1.800.607.7677 to speak to one of our technicians.

Parts List



Please call our technical support staff at 800-607-7677 for assistance with parts and/or trouble shooting.

ONE YEAR LIMITED WARRANTY

The Company hereby warrants to the original retail purchaser of this product that should this product or any part thereof, under normal use and conditions, be proven defective in material or workmanship within one year parts and 90 days labor from the date of original purchase, such defect(s) will be repaired or replaced with reconditioned product (at the Company's option) for parts and repair labor. This limited Warranty is the purchaser's exclusive remedy for any such defect(s).

This Warranty does not apply to any product or part thereof which, in the opinion of the Company, has suffered or been damaged through alteration, improper installation, mishandling, misuse, neglect, accident, or by removal or defacement of the factory serial number/bas code label(s). The opinion of the Company with respect to this matter shall be final. THE EXTENT OF THE COMPANY'S LIABILITY UNDER THIS WARRANTY IS LIMITED TO THE REPAIR OR REPLACEMENT PROVIDED ABOVE AND, IN NO EVENT, SHALL THE COMPANY'S LIABILITY EXCEED THE PURCHASE PRICE PAID BY PURCHASER FOR THE PRODUCT.

To obtain repairs or replacement within the terms of this warranty THE PURCHASER will send the product to the Company.

Model: _____ Serial No. _____