



READ MANUAL BEFORE OPERATING
KEEP MANUAL FOR FUTURE REFERENCE

MACHINE MANUAL

★ BUILT **USA** TOUGH ★

J-MAXX



RIGHT IN THERE WITH YOU.



DURACABLE[®]
— MANUFACTURING CO —

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WARRANTY

Duracable Manufacturing Company warrants the J-Maxx machine to be free from defects in material and workmanship for a period of two years from the date of purchase. Warranty service can be obtained by contacting Duracable Manufacturing Company at the address listed below. If a defect is covered by warranty, Duracable Manufacturing Company will repair or replace the defective machine or component without charge for labor or materials (freight is not included).

Warranty of the machine is limited to the original purchaser. Duracable Manufacturing Company assumes no responsibility for damage or injury from accident, neglect, abuse, misuse or from damage due to repair or alterations by others. This warranty does not cover damage to the machine from use of parts other than genuine Duracable brand parts.

Duracable Manufacturing Company's sole obligation and the original purchaser's sole remedy under this warranty shall be for repair or replacement as described above. All other warranties, expressed or implied, including but not limited to, implied warranties of merchantability and fitness for a particular purpose, are disclaimed. In no event shall Duracable Manufacturing Company be liable for any incidental or consequential damages.

PARTS AND SERVICE INSTRUCTIONS

Parts can be purchased from Duracable Manufacturing Company. Service work is also available. Service is performed by trained factory personnel. Machines sent to the factory for evaluation and repair can be estimated and quoted prior to service work. When sending a machine, be sure to include the return address and include instructions on how the repair should be handled. Instructions can either be included with the machine, explained to your account manager over the phone (800-247-4081), or faxed (515-223-6109).

IMPORTANT

Keep this manual in a safe, convenient place for future reference. Important information about this machine, its diagrams and warranty information are included in this manual.

Serial Number: _____ Date of Purchase: _____

Duracable Manufacturing Company
300 Ashworth Road • West Des Moines, IA 50265

SAFETY LABELS

Duracable Manufacturing uses three signal words on its safety labels and instructions. These words have the following definitions:

⚠ DANGER

A 'Danger' label indicates an imminently hazardous situation that, if not avoided, will result in death or serious injury. This signal word is to be limited to the most extreme situation, typically for machine components that, for functional purposes, cannot be guarded. The word 'danger' will be in white letters on a red background.



⚠ CAUTION

A 'Caution' label indicates a potentially hazardous situation that, if not avoided, may result in minor or moderate injury. It may also be used to alert against unsafe practices. The word 'caution' will be in black letters on a yellow background.



⚠ WARNING

A 'Warning' label indicates a potentially hazardous situation that, if not avoided, could result in death or serious injury, and includes hazards that are exposed when guards are removed. It may also be used to alert against unsafe practices. The word 'warning' will be in black letters on an orange background.



INFORMATION AND SPECIFICATIONS

Safe Machine Operation

Read this machine manual thoroughly before assembling or operating the machine. Become familiar with its controls and proper use before operating. Keep this manual in a handy place for reference and parts replacement referral. This machine is designed specifically for the purpose of opening and cleaning drains. Use it for this purpose - do not use it for other purposes.

Use gloves to protect your hands. Wear them to feed and retrieve cable. Use a material that cannot be easily grabbed by the cable. Most leather gloves and certain rubber gloves work well. Duracable Manufacturing has each type available through the Duracable Product Catalog. Also, avoid the use of loose-fitting clothes or jewelry when operating this machine.

Keep guards in place to protect the operator from the electric motor and electrical wiring. These guards are for safety protection and must be in place when running the machine. Each machine is equipped with an air foot pedal. Use of the air foot pedal to operate the machine is required for safe operation. This allows the machine operator to turn the machine on or off with the foot while keeping both hands on the cable.

Select a work area free from obstruction with room to work. Keep the machine within three feet of the pipe opening, allowing only enough room to work. This is required to shorten the length of exposed cable, thus providing maximum control in high-torque situations. Take a position that is comfortable to the left or right side of the machine for feeding or retrieving cable. For high work openings, the machine can be placed on its back as conditions require.

When performing a job, use the smallest blade first. Rinse the pipe after each blade is run through the line in order to clean out loosened debris. Then follow with the increasing sizes of blades until the size used is one that actually scrapes the side of the pipe or sewer. The blades are flexible and can be compressed to enter most cleanout openings. Centrifugal force created by the spinning cable forces the blades to expand to their natural diameter or to the walls of the pipe. It is advisable to maintain a very keen cutting edge on the blades at all times.

Place two hands on the cable between the outlet of your machine and the cleanout, and keep them there at all times during operation. Your hands placed in the proper position, will provide a guide for the cable. Keep the machine within three feet of the pipe opening.

As the blade makes contact with an obstruction in the line, it stops the blade from turning and builds torque in the cable. Do not permit the blade to get hung up in an obstruction for more than three seconds. Torque buildup can be both helpful and dangerous. It is helpful when pulled from the obstruction in a timely manner. When the cable is pulled away, the tension is released and the blade turns at a high speed. When the blade is free, feed it back into the obstruction to make use of the built-up power to clean the line. It is dangerous because excess torque can cause looping over of the cable. Serious injury to fingers

and hands is possible unless precautions are observed. When retrieving cable from the line, feed the cable into the machine until the blade is close to the cleanout opening. Shut off the machine and hand-feed the remaining cable into the machine.

Unpacking Your Machine

The J-Maxx is shipped to you with the following parts: the base machine, a drum, and a revolving arm. When it arrives, remove the parts immediately and inspect for damage. If any of the contents are damaged, contact your motor freight carrier immediately.

Moving Your Machine

Break the machine down into lighter-weight components to move it to and from the job site. To do this, wrap the GFCI cord and the air foot pedal cord in a convenient spot on the machine, remove the revolving arm from its assembled position (leave the cable inside it and keep it with the drum), and remove the drum assembly. Various accessories are available from Duracable Manufacturing to assist and protect the operator during the moving process.

Assembling Your Machine

- Attach the D3L Drum Attachment to the male end on one end of the cable. Position the cable end with attachment inside the cable and snap into place. Feed the cable into the drum.
- Set the base machine in a down position on its rails.
- Pick up the drum, loaded with cable, with the cone shape to the front of the machine (toward the switches) and slide it onto the drum shaft. Be sure the orange drive lugs slide into the openings in the back of the drum and engage fully.
- Feed the cable through the revolving arm until it is flush with the end of the arm.
- Position the revolving arm inside the drum.
- Position the extension shaft on the revolving arm into the center of the drum bearing.
- Place the revolving arm with cable extended into the rear side of the head bearing.
- Slide the collar forward using an Allen Wrench to loosen and tighten the collar.
- Slide the cable through the head bearing.

Disassembling Your Machine

To disassemble the J-Maxx machine, reverse the assembly process.

INFORMATION AND SPECIFICATIONS

Lubrication Maintenance

Caution: Do not over oil these points.

- Head Bearing Assembly - The roller bearing, located in the front assembly, requires monthly lubrication. Use a grease gun to lubricate the zerk fitting with multipurpose grease. A lithium-base grease is recommended.
- Drum Shaft and Drum Bearings - The drum shaft requires monthly lubrication. Use a multipurpose grease or heavy oil. Keeping the shaft lubricated means the drum will slide and will not 'freeze' to the shaft and need to be repaired. The drum bearings require some light oil monthly.
- Belt - Check tension during the first 24 to 48 hours of operation.
- Belt Tension - Ideal deflection is 1/4". Over tensioning shortens belt and bearing life.
- Air Foot Pedal - Check for wear or stress cracks.

Cable Care Instructions

Take care of your cable for optimum performance. The recommended care procedure is as follows:

- Break in a new cable. To relieve the stress on new cable that has been coiled since its manufacture, put it in a clean line and run it for 10 minutes.
- Oil the cable once a week.
- Rinse the cable immediately after each use with the hottest water available. This is especially important if the cable was in acid or alkali during use.
- When one end of the cable begins to show wear, rewind and use the opposite end. (Tip: order the same kind of end fittings on both ends of the cable.)
- If the cable kinks, cut out the kink and splice the cable ends together.

J-MAXX

1/3 HP Motor

200 RPM

Belt Drive

19" Reel

1/2" x 75' Cable

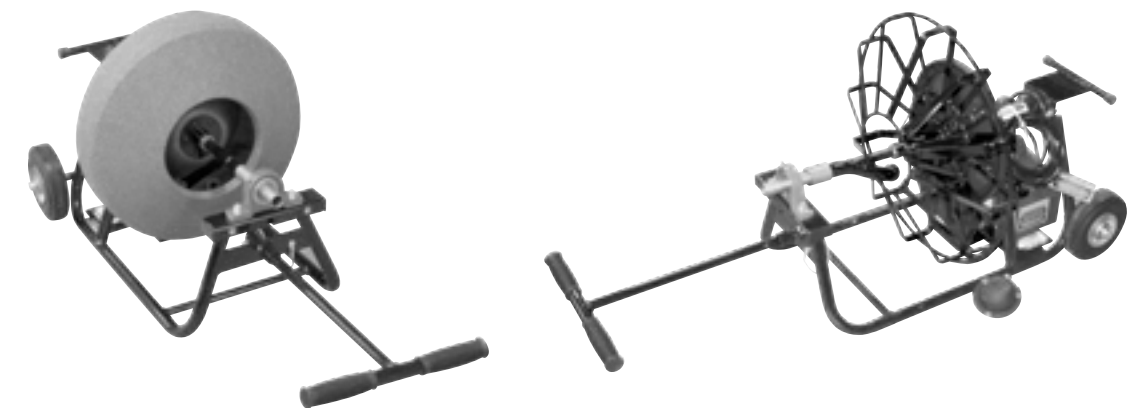
Detachable "T" Handle

2-Year Warranty

Continuous Weld
Uni-body Frame

USES:

1-1/4" to 3" lines,
Residential, Sinks,
Roof Vents,
Floor Drains



The J-Maxx with 16PRS, 16" enclosed polyethylene reel

The J-Maxx with D1S1, 19" open spoke reel (standard package)



INFORMATION AND SPECIFICATIONS

Frame

The J-Maxx's frame consists of a uni-body construction which allows the motor, head bearing and reel shaft assemblies to be bolted directly to the frame.

Electrical Wiring

The J-Maxx's electrical wiring is located in the conduit box on the right side of the motor, housing both the forward/reverse switch and the air foot switch. The Ground Fault Circuit Interrupter (GFCI) is built into the electrical cord for added safety. The air foot pedal is standard equipment on The J-Maxx. This switch allows operators to turn the machine on and off with their foot while their hands stay on the cable.

RPM/Drive

The J-Maxx has a 1/3 HP motor and operates at 200 rpm. The heavy-duty, self-aligning head bearing for The J-Maxx has a cast housing which reduces stress and prevents premature wear.

Maneuverability

The J-Maxx has optional 6" wheels and a detachable "T" handle.

Cable and Reel Selections

The J-Maxx was designed to handle several reel sizes. The reel selected is set in place and slipped onto the reel shaft. Drive lugs are mounted on the drive plate and slip through the openings in the back of the reel. The reel is held in place by the revolving arm.

Standard Package

The J-Maxx's standard package (part number J-Maxx SPA) comes with the following items: revolving arm, 1/3 HP motor at 200 rpm, 19" open metal spoke reel, 1/2" x 75' cable, reel attachment, and choice of cable end fittings. (Wheels and handle are not standard.) See the machine packages and accessories chart on the next page for additional options.



The J-Maxx shown above with 19PRS, 19" polyethylene reel. (See options on the next page.)

MACHINE SPECIFICATIONS (APPROXIMATE)

Length of Machine	26"
Length of Machine with Wheels and Handle	44"
Width of Machine	13"
Width of Machine with Wheels and Handle	17.5"
Height of Machine	17"
Weight of Machine	44.5 lbs
Weight of Machine with Wheels and Handle	56.5 lbs
Weight of Narrow Wheels	13 lbs
Weight of D1S, 16" Open Spoke Metal Reel	9.5 lbs
Weight of 16PRS, 16" Polyethylene Reel	10.9 lbs
Weight of D1S1, 19" Open Spoke Metal Reel	10.5 lbs
Weight of 19PRS, 19" Polyethylene Reel	12.4 lbs
Line Size	1-1/4"-4"

RECOMMENDED USE: residential lines, sinks, bathtubs, shower drains, roof vents and laundry drains

INFORMATION AND SPECIFICATIONS

REELS			REEL ATTACHMENTS	FLOATING RINGS	FLOATING RING ATTACHMENTS	REVOLVING ARM	CABLES*	
Part #	Dimensions	Description	Part #	Part #	Part #	Part #	Part #	Dimensions
D1S	16" Diameter	Open Spoke Metal Reel	D3L	D2JS	D3E	D8SL2A with 31021 Arm Extension	_38-090 _50-075	3/8" up to 90' 1/2" up to 75'
D1S1	19" Diameter	Open Spoke Metal Reel (standard)	D3L	D2JM D2JR	D3E D3R (male end) D3RJ (slip joint)	D8SL9A with 31020 Arm Extension	_50-090 _62-080	1/2" up to 90' 5/8" up to 80'
D1SE	16" Diameter	Enclosed Metal Reel	D3S	D2JS	D3E	D8SL2A with 31021 Arm Extension	_38-090 _50-075	3/8" up to 90' 1/2" up to 75'
D1S1E	19" Diameter	Enclosed Metal Reel	D3S	D2JM D2JR	D3E D3R (male end) D3RJ (slip joint)	D8SL9A with 31020 Arm Extension	_50-090 _62-080	1/2" up to 90' 5/8" up to 80'
16PRS	16" Diameter	Enclosed Polyethylene Reel	N/A	N/A	N/A	D8SL2A with 31021 Arm Extension	_38-090 _50-075	3/8" up to 90' 1/2" up to 75'
D1S1E	19" Diameter	Enclosed Polyethylene Reel	N/A	N/A	N/A	D8SL9A with 31020 Arm Extension	_50-090 _62-080	1/2" up to 90' 5/8" up to 80'

* Add **CH** in front of cable part # for Hollow Core.

* Add **CI** in front of cable part # for Inner Core.

* Maximum length of cable is not always the recommended length.

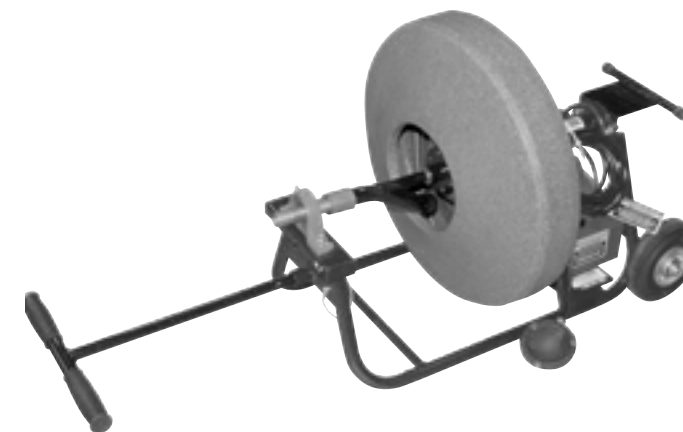
* Custom lengths are available.

MACHINE PACKAGES

Part #	Horse Power	RPM	Reel	Cable
J-MAXX SP	1/3 HP Motor	200 RPM	D1S	3/8" x 75'
J-MAXX SPA	1/3 HP Motor	200 RPM	D1S1	1/2" x 75'
J-MAXX SPB	1/3 HP Motor	200 RPM	16PRS	3/8" x 75'
J-MAXX SPC	1/3 HP Motor	200 RPM	19PRS	1/2" x 75'

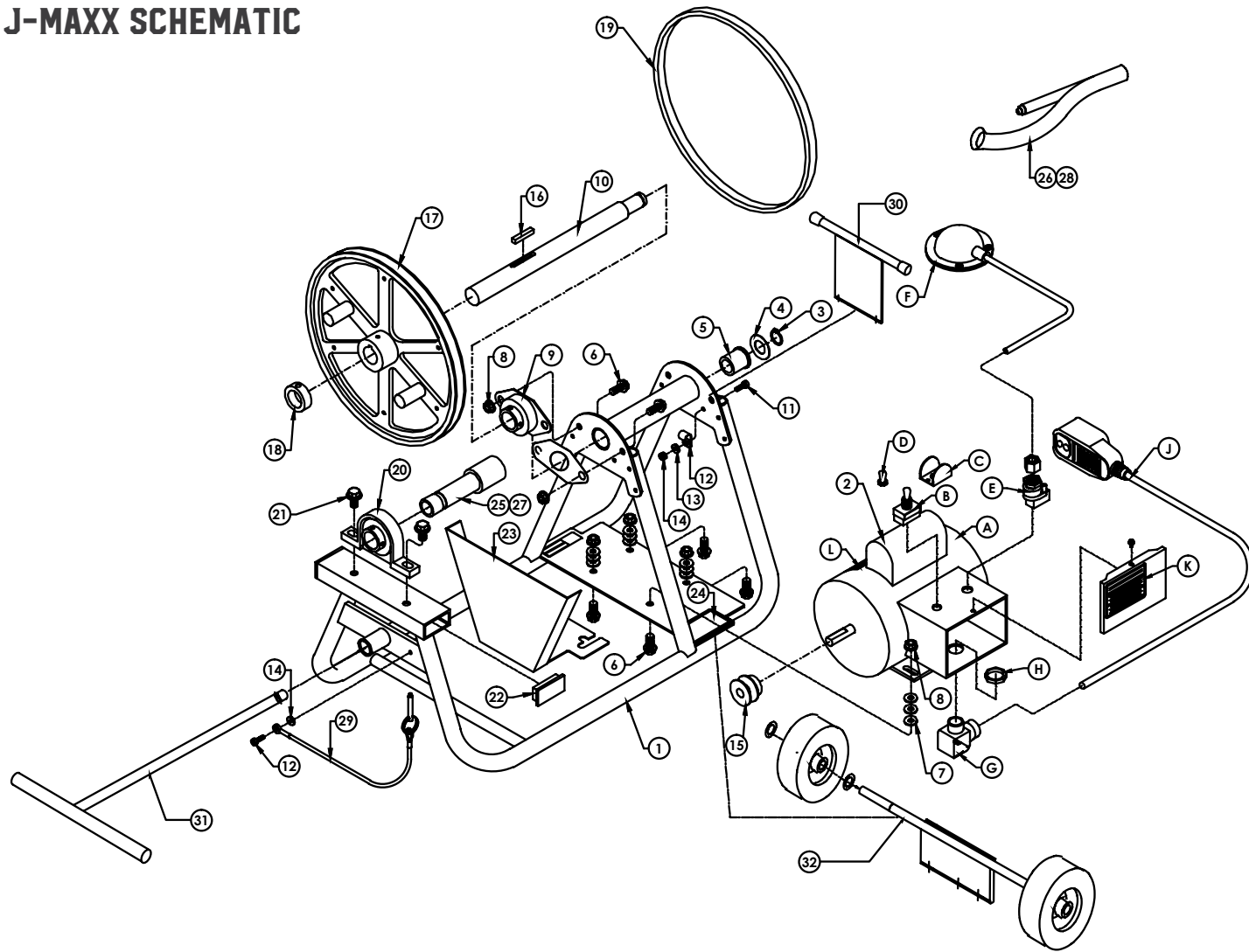
MACHINE ACCESSORIES / REPLACEMENT PARTS

Part #	Description
31005	1/3 HP Motor
25074	Air Foot Pedal (<i>rubber</i>) with 10' Tubing
25061	Air Switch with Strain Relief Nut
DRC16	Cover for 16" Open Spoke Reel (D1S)
DRC19	Cover for 19" Open Spoke Reel (D1S1)
31001	Replacement Mobility Kit (wheels and handles)
DKIT1	Blade Kit



J-Maxx with 19PRS, 19" enclosed polyethylene reel

J-MAXX SCHEMATIC



The entire line item in **bold** identifies the name of an entire assembly. The "Z" shaped arrow identifies all the parts that make up that assembly. You can purchase the entire assembly, or just the individual parts.

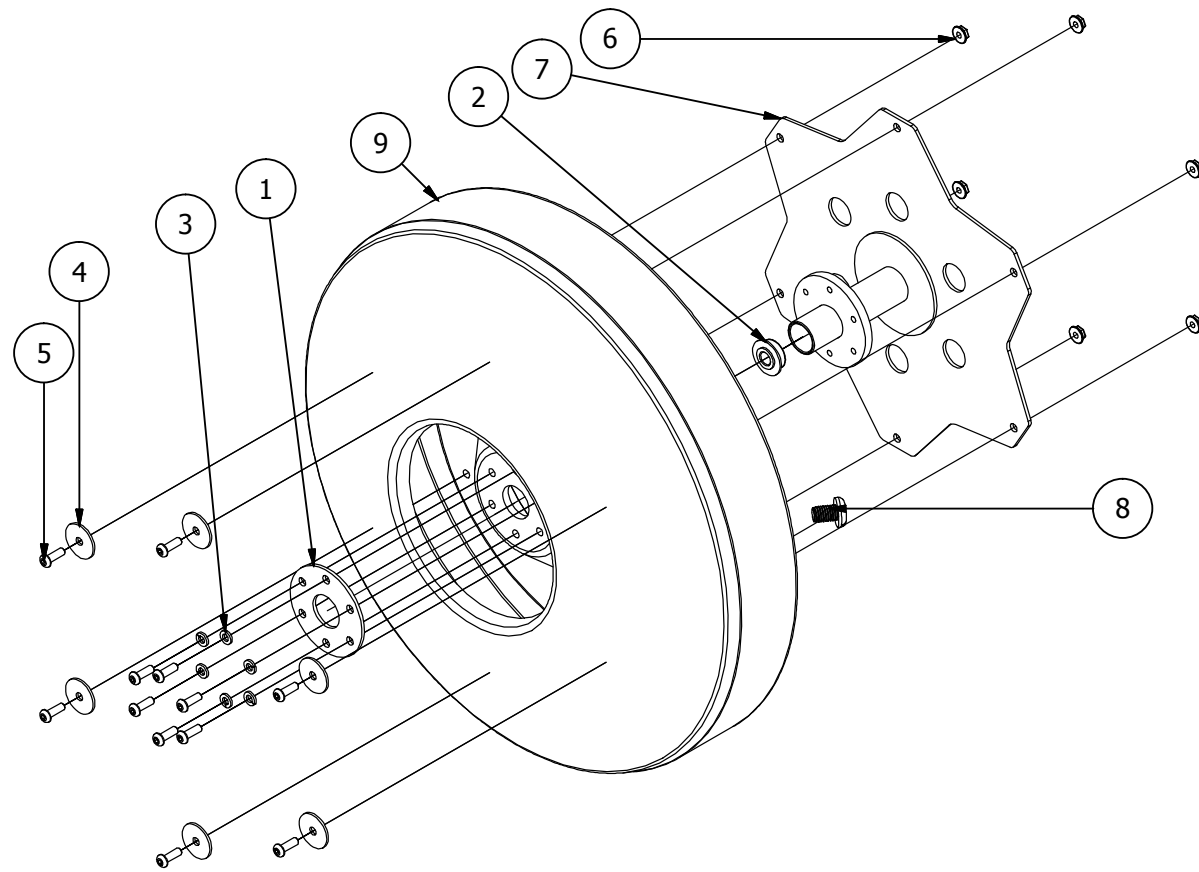
ITEM	QTY.	PART#	DESCRIPTION
1	1	D31015	Frame, Red
2	1	31005	Motor Assembly
A	1	31005A	Motor, 1/3 HP
B	1	25002	Switch, Detent - Forward/Reverse
C	1	25015	Switch Guard
D	1	ECT26	Rubber Switch Boot
E	2	25061	Air Foot On/Off Switch with Nut
F	1	25074	Foot Pedal with 10' Tube
G	1	ECT34	1/2" Strain Relief, 90° Snap Elbow with Dome Nut
H	1	ELN1	Electrical Nut, 1/2" NPT (National Pipe Thread)
J	1	25166	GFCI Cord, 16/3 x 22"
K	1	25064	Decal, Forward, Reverse Caution
L	1	25212	Decal, GFCI Rotating Danger

J-MAXX SCHEMATIC

The entire line item in **bold** identifies the name of an entire assembly. The "Z" shaped arrow identifies all the parts that make up that assembly. You can purchase the entire assembly, or just the individual parts.

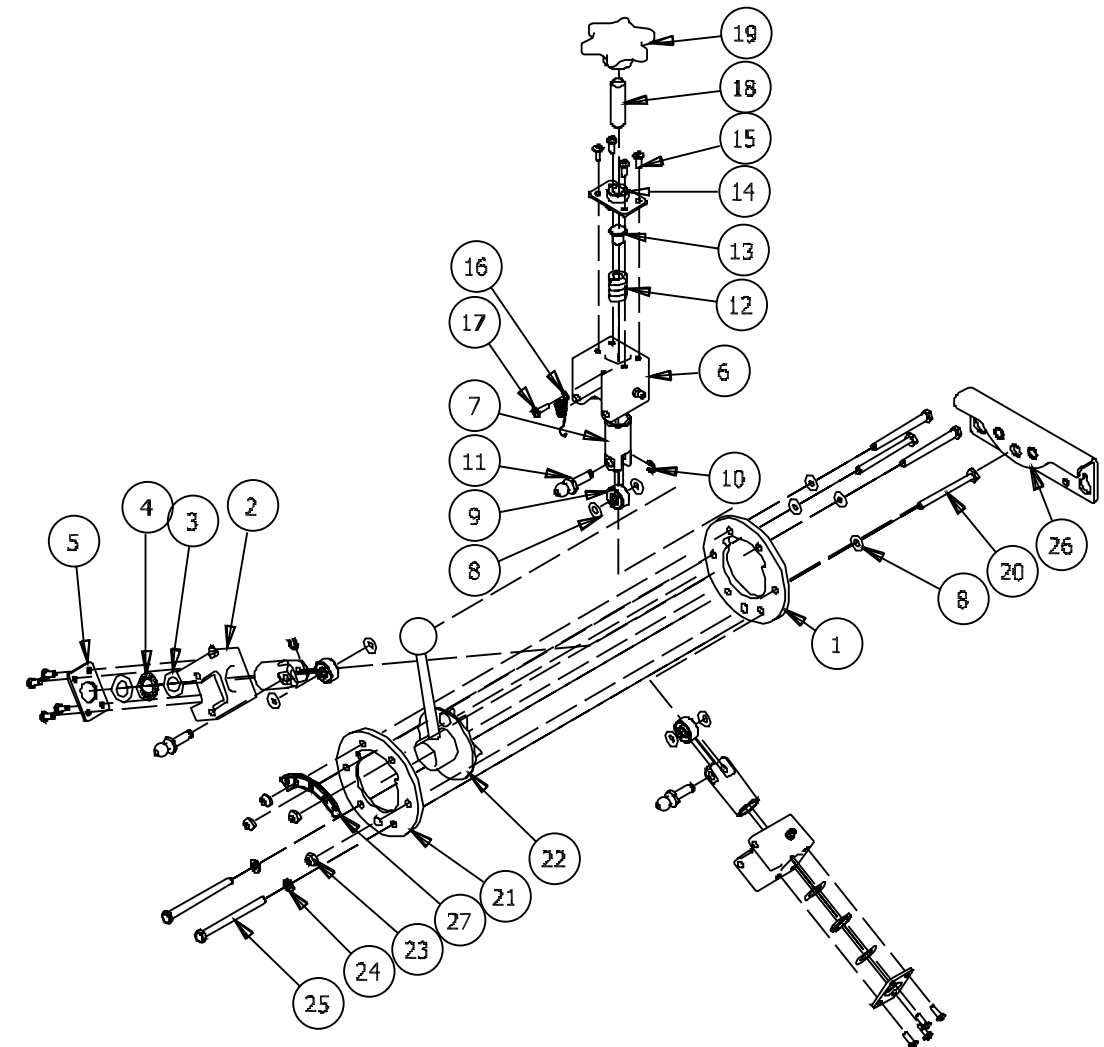
ITEM	QTY.	PART#	DESCRIPTION
3	1	RRING14	External "E" Ring
4	1	WA32	Machine Bushing
5	1	SB19	Drum Shaft Bearing
6	6	FLSC1	5/16"-18 x 3/4" Hex Head Flange Screw
7	12	WA15	1/3" x 3/4" x .07" Stainless Steel Flat Washer
8	6	FLNUT3	5/16"-18 Hex Flange Nut, Locking
9	1	SB5	Bearing, Drum Shaft
10	1	31040	Drum Shaft
11	2	PHSC5	#10-32 x 1/2" Pan Head Thread Cutting Machine Screw
12	1	CCL1	Cable Clamp, Black
13	2	WA5	#10 External Tooth Lock Washer
14	1	HXNUT3	#10-24 Hex Nut
15	1	41010A	Sheave, 4L x 1-1/2" Outside Dia
16	1	KEY6	1/4" x 1-3/8" Square Key
17	1	41010B	Sheave, 4L x 11-1/4" Outside Dia with Drive Lugs
	2	25090A	Drive Lug
	2	MM4	Drive Lug Cap, Red
	2	WA10	3/8" Split Lock Washer
	1	41008	Guard, Sheave
18	1	25120	Drum Shaft Bushing
19	1	41010C	Belt, 4L x 37"
20	1	SB8	Head Bearing
21	2	FLSC7	3/8"-16 x 5/8" Hex Head Flange Screw
22	2	MM16	End Cap, Black
23	1	41009	Motor Guard
24	1	D25000	Decal, Machine Logo
25	1	31020	Revolving Arm Extension (D8SL9A revolving arm only)
26	1	D8SL9A	Revolving Arm without Collar for 19" Reel
27	1	31021	Revolving Arm Extension (D8SL2A revolving arm only)
28	1	D8SL2A	Revolving Arm without Collar for 16" Reel
29	1	JWKL	Detent Ring with Attached Lanyard
	1	31001	Mobility Kit
	2	FLSC1	5/16-18x3/4 Hex Head Flange Screw
	2	FLNUT3	5/16-18 Flange Lock Nut
30	1	31050	Vertical Support Assembly
31	1	31025	T-Handle with Grips
32	1	31045	Wheel Axle Assembly

19PRS (19" POLYETHYLENE REEL) SCHEMATIC FOR J-MAXX

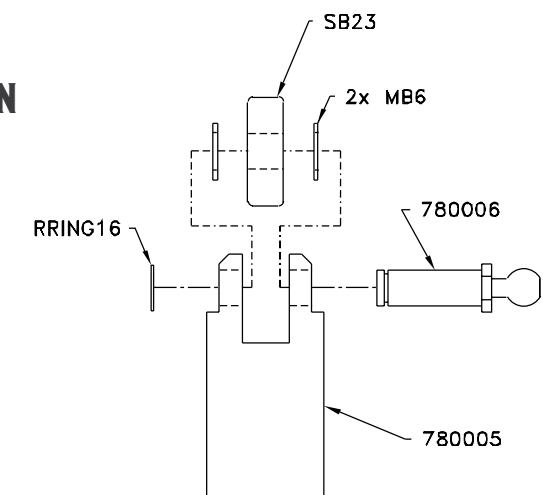


ITEM	QTY.	PART#	DESCRIPTION
1	1	D1HF	Inner Clamp Washer
2	1	D6A	Reel Bearing
2	6	WA22	.25 Lock Washer
3	6	WA47	.25 Body Washer
4	12	SHCS34	1/4-20 x 7/8 SBHS
5	6	FLNUT5	.25-20 Flange Nut
6	1	771409	Sled Plastic Drums Drive Hub Finished
8	1	MM60	.5-13 x .75 Std. Threaded Plug
9	1	771900	19" Sled Machine Plastic Drum

MINI POWER CABLE FEED AND RETURN SCHEMATIC



MINI POWER CABLE FEED AND RETURN PISTON KIT SCHEMATIC (OPTIONAL)



MINI POWER CABLE FEED AND RETURN SCHEMATIC

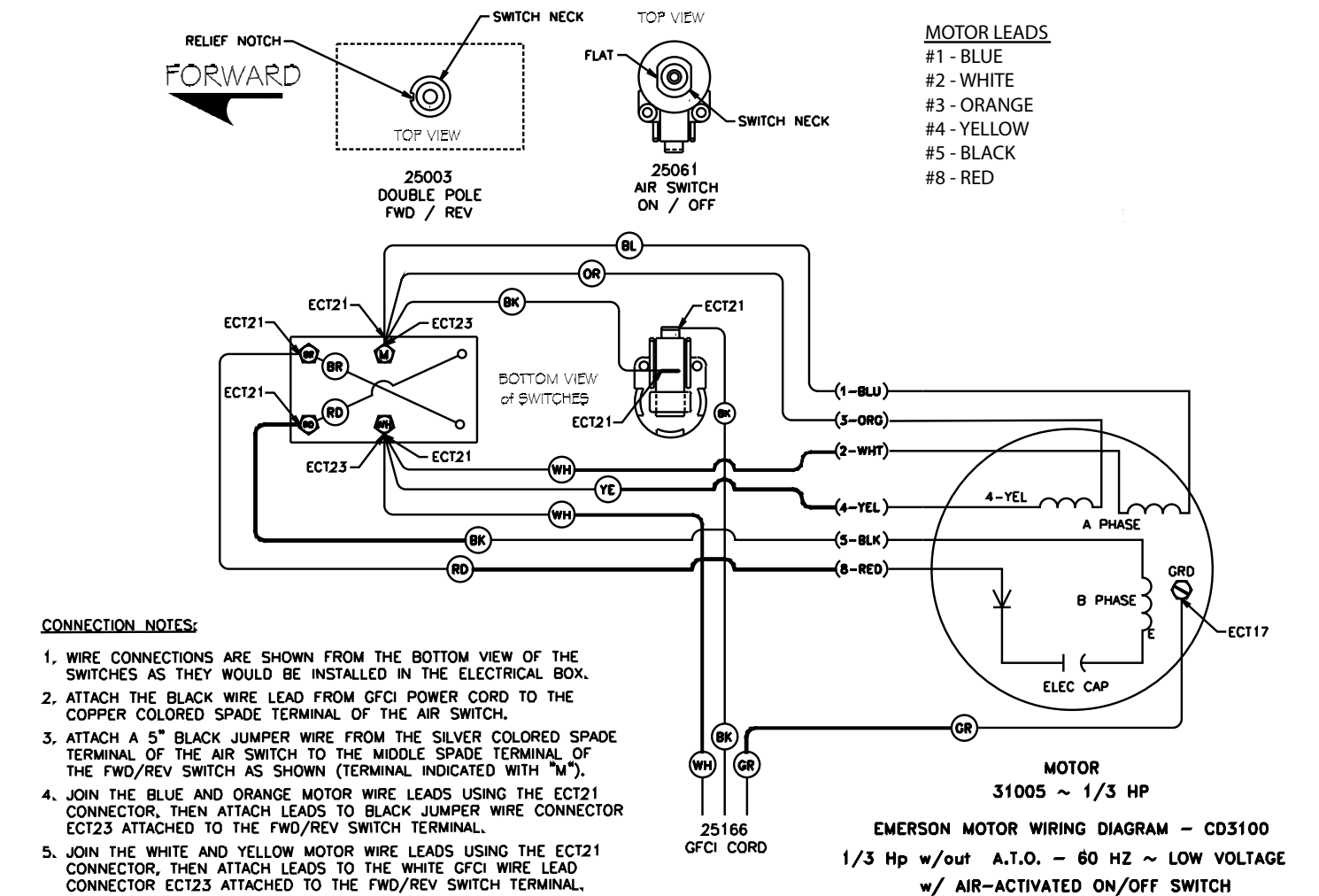
The entire line item in **bold** identifies the name of an entire assembly. The "Z" shaped arrow identifies all the parts that make up that assembly. You can purchase the entire assembly, or just the individual parts.

ITEM	QTY.	PART#	DESCRIPTION
1	1	780009	Rear Plate
2	2	780001	Extruded Base Piston Housing w/Zirc3
3	4	MB5	.570 ID x .980 OD x .030 THK Thrust Washer
4	2	SB24	.566 ID x .986 OD x .078 WD Needle Thrust Bearing
5	2	780003	Base Piston Housing Back Plate
6	1	780002	Extruded Adjustable Piston Housing w/Zirc3
7	3	750005	Piston
8	10	MB6	.281 x .625 x .047 Stainless Thrust Washer
9	3	SB23	7 x 22 x 10.3 MM Roller Bearing
10	3	RRING16	7MM 'E' Clip
11	3	780006	.5 Ball Pivot Pin
12	1	SPR1	.15 x .75 x 1 Comp Spring
13	1	780007	.375 x .625 x .1875 Rest Pad
14	1	780004	Adjustable Piston Housing Backplate Weldment
15	12	PHSC13	10-24 x .5 PH Screw
16	1	SPR2	.042 DIA x 1.656 LG Expansion Spring
17	1	PHSC23	10-32 x .25 PH Screw
18	1	CPSS19	.5-13 x 2.5 Socket Set Screw
19	1	KNOB5	.5-13 x 2.75 Knob
20	4	HHCS53	.25-20 x 2.75 Hex Screw
21	1	780011	Front Plate
22	1	780008	Feed Directional Shifter Assembly Weldment w/Knob2
23	4	LN1	.25-20 Hex Lock Nut
24	2	WA22	.25 Lock Washer
25	2	HHCS54	.25-20 x 3.25 Hex Screw
26	1	780012	1100 - 3100 - 5200 Mount Bracket
27	1	780010	Arc R-N-F Decal

POWER CABLE FEED AND RETURN KITS (OPTIONAL)

Kit Part #	Description	Included Parts	Quantity	Description of Included Parts
780005K	Mini Power Cable Feed and Return Piston Kit	780005 780006 SB23 MB6 RRING16	1 1 1 2 1	Upper/Lower Piston Ball Pivot Pin Roller Bearing Thrust Washer 'E' Ring Clip
SB23K	Mini Power Cable Feed and Return Bearing Kit	SB23 MB6	1 2	Roller Bearing Thrust Washer

ELECTRICAL SCHEMATIC



The wiring diagram for the basic J-Maxx is shown above. If you experience any electrical difficulties in operating your machine, or you notice any frayed or inadequate wiring, or wiring that does not conform to the diagram, discontinue use of your machine immediately and have a qualified electrician repair it, or return it for repair to Duracable Manufacturing.

ELECTRICAL SAFETY

Handle with Care

Most of us take electricity for granted. It has been with us since the day we were born. We use it every day for light, phone, home appliances, tools, and other equipment that helps us maintain our standard of living. Although electricity is one of the safest energy forms, we tend to forget how powerful and dangerous it can be if not used properly.

Every year many people are injured or killed by electricity. Most of these accidents could have been prevented with simple precautions and careful use of electricity. Following are some tips to help avoid electrical accidents. Read through this information. Be sure you understand its importance. If you have questions or feel you may have a potential electrical hazard, tell your supervisor or call a qualified electrician immediately.

General Electrical Guidelines

Remember, electricity is always trying to make a circuit. It can travel through an electric wire, metal pipe, or even your body. Electrical shock can occur when you come in contact with an energized electrical unit and a good conductor. Shock can range from a slight tingle to a severe burn, or death by electrocution.

Electrical accidents happen in everyday situations. Most electrocutions occur in a wet environment or when an electrical product is being repaired or installed. Think about, and take precautions against, potentially dangerous situations. When disconnecting electrical cords, pull on the plug rather than the cord to avoid damage. Use rubber gloves and rubber boots or insulated shoes to protect yourself, especially if you are in a wet or damp environment. Before using this machine, make sure a properly grounded, three-prong, 110-volt outlet is available. Where it is not available, use a three-prong adapter and connect the grounding lug to a known ground. Never cut off a grounding prong to fit a two-prong outlet. This eliminates the ground protection.

Electrical Procedures

Do not leave the machine plugged in when not in use. Even with the switch off, a machine can shock or electrocute its handler. The J-Maxx machine must be grounded to protect the operator from shock. This is accomplished by using the Ground Fault Circuit Interrupter Cord (GFCI) to ensure proper grounding.

Check electrical cords before each use for signs of damage. Repair or replace cords which are pinched, cracked, frayed, or worn. Remember, the GFCI offers no protection against electric shock for wiring preceding it in the system. Your GFCI is direct-wired to the machine, plug the GFCI into the power source receptacle. Discontinue use and repair immediately any machine that causes the slightest shock or is damaged in any way. It could lead to a serious electrical shock or electrocution. Inspect the machine daily for wear or damage that might expose live electrical parts.

Ground Fault Circuit Interrupters (GFCI)

A GFCI works by detecting changes in electrical current flow. It breaks the circuit before serious injury can occur. For your protection, heed the "DANGER" warning on the machine cover and use the GFCI cord. The GFCI must be tested before each use. Use the following procedure:

- Insert the unit into a 110-volt, AC-grounded receptacle;
- Push the "test" button in - the red indicator light should go off;
- Push the "reset" button in - if the red indicator light goes on, the unit is ready for use;
- Do not use the unit if the light does not go on when reset;
- Do not use the unit if the indicator light remains on when the test button is pushed.

Extension Cords

- Use extension cords only when necessary.
- Position cords in use to prevent tripping hazards. Do not place them in areas where they can be damaged by traffic.
- Avoid coiling extension cords during use to prevent possible overheating of the cord.
- Discard cracked or damaged cords.
- The following cord sizes and lengths should be observed according to the National Electrical Code when using this machine:
 - 12 gauge wire - 75' of cord, including 25' of GFCI cord.
 - 14 gauge wire - 50' of cord, including 25' of GFCI cord.
- Cord sizes smaller than 12 gauge should not be used for 3/4 HP motors. Larger gauge cords can be run greater distances, but are not practical because of their size and weight.
- To protect your motor, observe the guidelines mentioned. If you have a run more than 75'; use a generator to reduce your cord length from the power source to a working distance within these guidelines.

Overhead Power Lines

- When working outdoors, keep clear from overhead power lines in all directions.
- Check the location of power lines before using a ladder. Use approved ladders made of non-conductive material.
- Never place a ladder where it can slide into a power line.
- When carrying or moving a ladder or equipment, lower it to avoid touching a power line.
- Never assume that a wire is safe to touch.

HOW TO SPLICE DURAFLEX® CABLE



1. Cut a few inches off of each cable end and remove any burrs with a grinding disk or file.



2. Spray Loctite Primer in and around the cable end and splice core to thoroughly remove grease and grime.



3. Apply Loctite Retaining Compound to splice core.



4. Insert splice core into cable one turn.



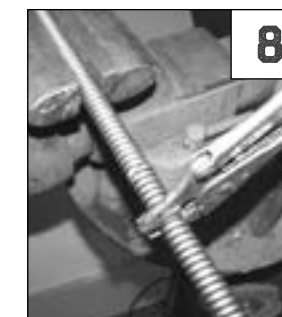
5. Apply Loctite Retaining Compound to other end of splice core.



6. Align other piece of cable onto splice core.



7. Place vise grips on free cable end and turn counterclockwise.

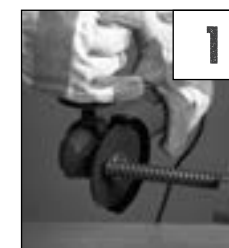


8. Continue turning and the cable ends will meet at the center of the splice core.

HOW TO BOND END FITTINGS TO DURAFLEX® CABLE

You can attach end fittings and splice cores to DuraFlex cable using a chemical bonding process, which means you can make quick cable repairs on the job—without welding. With Loctite Primer and Loctite Retaining Compound, you can quickly create a dependable bond that is as strong as a conventional weld. Please note that these products are not the same thread-locking compounds available in hardware stores and plumbing-supply houses, they are heavy-duty, permanent-bonding compounds made especially for jobs such as bonding cable fittings.

1. Cut the cable end and remove any burrs with a grinding disk or file.



2. Spray Loctite Primer in and around the cable end to thoroughly remove grease and grime.



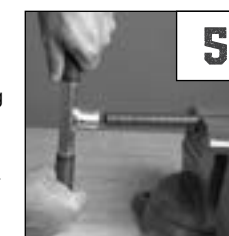
3. Spray Loctite Primer on the end fitting to thoroughly remove grease and grime.



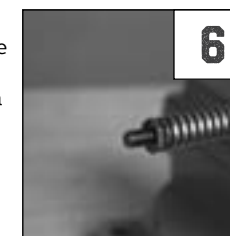
4. Apply Loctite Retaining Compound to the end fitting.



5. Using the wrench (part number EW), screw the fitting into the cable end until fitting is totally sealed.



6. The Retaining Compound will be fully bonded to the cable in just a few minutes.



J-MAXX MACHINE MANUAL

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