

Seem Preparation for extrusion welding

1. Positioning of welding parts

Fixing with a tacking nozzle is for small assembling parts sufficient (picture 1). You have to connect the plastic pieces by hot air welding in advance for bigger component parts (hot air welding procedure (picture 2). Normally, a 3 or 4 mm round wire is used (scraping of joining area and welding rod is necessary).

Picture 01: Fixing by a tacking nozzle



Picture 02: Hot air welding



Alternatively to the prior welding, the plastic parts can also be adjusted mechanical.

Important:

- Make sure that the component parts not move under welding pressure!
- The joining area and the surface zone have to be scraped before welding (picture 03 and 04)

Preparation of the seem before extrusion welding

The joining area and the surface zone have to be scraped immediately before welding procedure (e. g. picture 03 und 04)

Picture: 03



Picture 04



3. Start up of Extruder

Please switch on the extruder and wait another 5 minutes after reaching the mass temperature on the display to heat up the extrudate properly:

Mass temperature



Air temperature



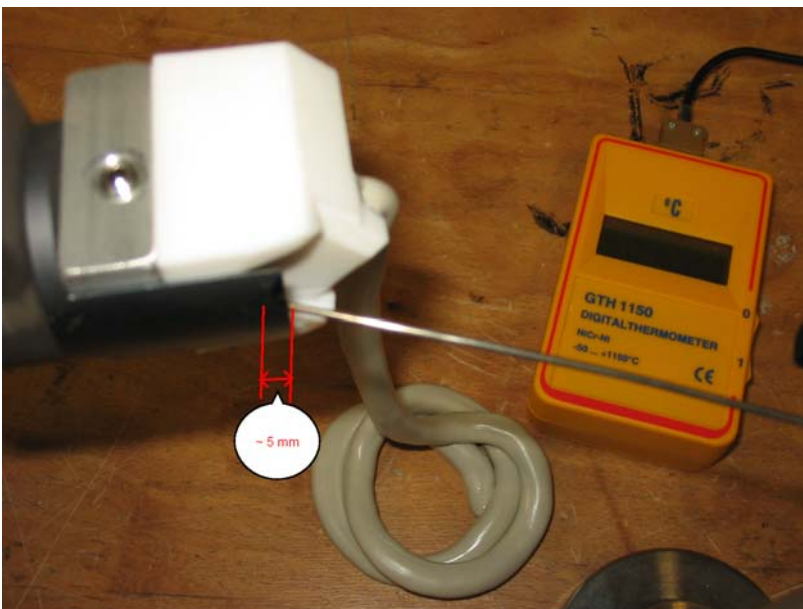
4. Temperature control of air and mass

Caution! Please let run the extruder approximately 1 minute before starting the measurement!
The air and mass temperature measurement, have to be done during the extruder is in operation.



Sensor approx. 5 - 10 mm,
in centre of the out coming
material.

For temperature measurement have
to be done during the extruder is in
operation!



Sensor approx. 5 mm,
in centre of the air channel.

For temperature measurement have
to be done during the extruder is in
operation!

5. Check of the preheated ground material

Lead the welding shoe in the corresponding corner of the welding part.



Checking the preheating

Press in the material with a 2 mm thick control stick or a small screwdriver between preheating nozzle and the nose of welding shoe.

Make sure that the control stick can be pressed approximately 0,2 to 0,5mm into the material (with low pressure)