



# Shanghai Pengwang Machinery Co., Ltd.

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## PW603 Extrusion Welder

# Manual

### Notice:

- 1、 The welder must reach the set temperature, the press the motor switch for welding, otherwise the cold machine will be overloaded and burn the motor and damage the tool bar.
- 2、 When replacing or rotating the welding tip, please keep heating, and can be operated after the solder in the cavity has melted, otherwise the machine head and the welding tip will be damaged.
- 3、 The hot-air welding nozzle fastening screw is reverse thread, loose clockwise and tightened counterclockwise. Excessive force or wrong direction will damage the bolt.
- 4、 After the welding operation is completed, the heating switch must be turned off first, and the power supply can be turned off after the temperature of the standby head is completely cooled to room temperature.
- 5、 It is strictly prohibited to use when the environment temperature is lower than 5 degrees.
- 6、 The power supply of the welder must be equipped with a leakage protector, and the power plug cannot be unplugged or plugged with wet hands.
- 7、 The power supply voltage is 220 volts, remember not to plug it into a 380 volt power supply.

- 8、 The welder cannot be constructed in flammable and explosive environment. .
- 9、 When the welder is stored, it must be placed in a dry and ventilated place to prevent water from getting rusty.
- 10、 After the welder has been running continuously for 50 hours, please check the carbon brush. When the effective length of the carbon brush is less than 2.5mm, the carbon brush must be replaced.

### **Technical Parameters:**

Voltage: 220V      Frequency: 50HZ      Power: 3000W

Welding rod:  $\varnothing 3 - \varnothing 4$       Extrusion: 1.6 — 3.2 kg/h

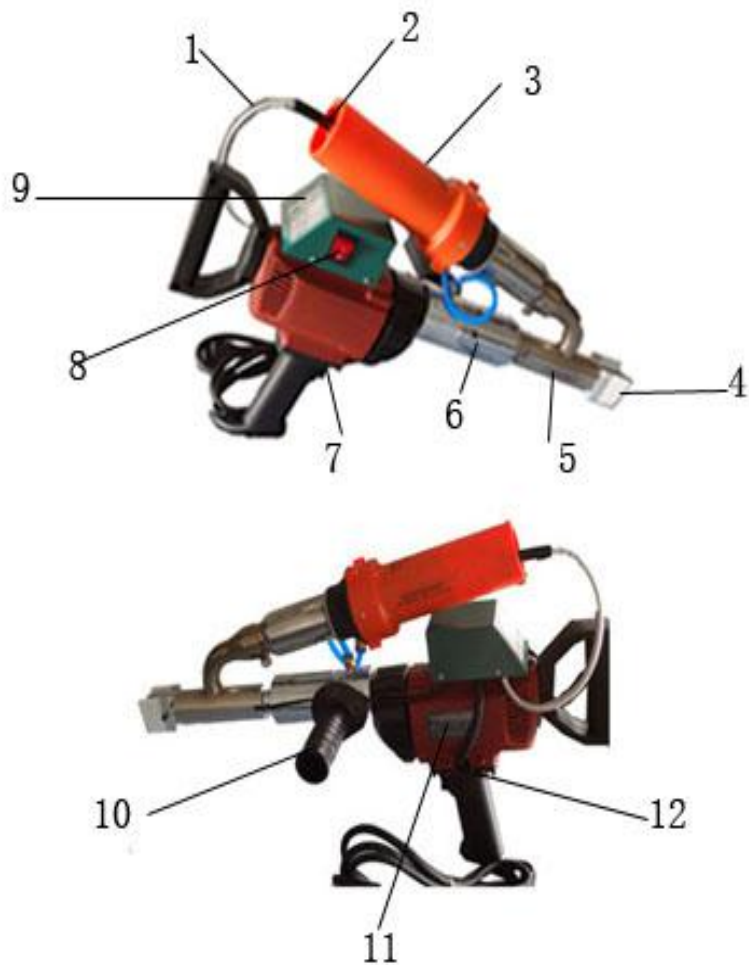
Application: PP/Pe container, sheet, pipe and membrane structure

Total Weight: 6.5kg

Feature : Hot air heater is integrated with the welding nozzle, and the welding nozzle can rotate freely.



## Main parts and name



1—Power Cable	2—Heating switch	3—Heater	4—Welding tip
5—Melting cavity	6—Feeding hole	7—Motor switch	8—Power switch
9—Control box	10—Handle	11—Motor	12—Motor lock button

## Work Principle:

The motor drives the feeding screw--the feeding screw drives the welding rod--the rotating blade cuts the welding rod into 1.5mm thick slices--feed into the melting chamber through the feeding screw (the hot air heater simultaneously heats the melting chamber) to melt and squeeze--Press the melted welder evenly on the base material to be welded through

the welding tip.

## Instructions:

- 1、 Plug in the power and turn on the power switch.
- 2、 Turn on the heating switch and select the temperature. When setting the temperature, press the letter T on the panel of the control box with your finger. The selected temperature will be displayed at this time, press the  $\triangle$  character to increase the temperature, and press the  $\nabla$  character to decrease the temperature (do not press the letter V). Generally choose 275°C-285°C. After setting the temperature, release your finger, the display panel will not show the temperature (heating) at this time, but the yellow light will be on. When the set temperature is reached and after a delay, the red light is on and the actual temperature is displayed, then start the motor switch to work. As shown on the right



- 3、 Feed the welding rod from the feeding hole, start the motor switch, and start working.
- 4、 **Emphasis:** Only when the welder reaches the set temperature (after completing 2 items), the motor switch be turned on for welding. Otherwise, the residual welder in the melting chamber is not completely melted. At this time, the switch may damage the transmission device and cause the motor to overload and burn.
- 5、 During the welding process, the molten welder extruded from the welding nozzle is evenly pressed against the surface of the welded mother village along the welding seam, and the sound of the motor should be paid attention to at any time. If there is any abnormal noise, immediately stop the machine for inspection. At the same time, in the long-term welding process, press the motor lock button, the motor will be connected and run, and there is no need to press the motor switch by hand for a long time.
- 6、 There are two types of feeding holes, but 3mm and 4mm electrodes are not allowed to feed at the same time, otherwise the motor will be burnt due to overload.
- 7、 During the working gap, do not turn off the heating switch and power switch, just put the

welder on the bracket. When placing the welder, the welding tip is lower than the horizontal position.

8、 When the machine is not in use, turn off the heating switch first, do not turn off the power switch, and turn off the power switch after the temperature of the standby head is completely cooled to room temperature.

### **Bracket installation:**

There are two fixed screws on both sides of the bracket bottom plate, loosen them, insert the Y-shaped frame, and lock the screws.

### **Packing List:**

Welder	1	Manual	1
Bracket	1	Magnetic core	1
screwdriver	1	Hexagon key	2
Active wrench	1	Carbon brush	3

## **Product Qualification Certificate**

The product has passed the inspection of all technical indicators and is quasi-factory.

Model: \_\_\_\_\_

Serial number: \_\_\_\_\_

Factory date: \_\_\_\_\_

Inspectors: \_\_\_\_\_

**Maintenance records:**

Date	Maintenance record	Signature	Remark

**PW603 Extrusion Welder Warranty**

Note for users:

- 1、 This machine is guaranteed for one year. In order to protect the rights and interests of users, please return the warranty receipt to our factory for free warranty procedures within one month from the time of purchase. If the time limit is exceeded, the warranty will be automatically waived.
- 2、 Please read the "Instruction Manual" carefully before using this machine to ensure personal safety. And prevent the loss of warranty treatment due to

improper use and artificial damage.

**Please fill out the following warranty slip and send it back to our factory**

Company name:

Phone:

Address:

Zip code:

Contact:

Phone:

Model:

Serial number:

Purchase date: