



Shanghai Pengwang Machinery Co., Ltd.

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PW603 Extrusion Welder

Manual



Notice

1. The welder must reach the set temperature, 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 welder 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 is completed, the heating switch must be turned off firstly, 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 220V, remember do 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

Model	PW603
Voltage	220V
Frequency	50HZ
Power	3000W
Welding rod	φ 3 - φ 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 be rotated freely

Main spare parts



1	Power cable
2	Heating switch
3	Heating core
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 Δ character to increase the temperature, and press the ∇ character to decrease the temperature (do not press the letter V). Normally 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, 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 firstly, 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

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