

Instructions for welding perfluoroalkoxy PFA with WELDPLAST S1 F

These instructions apply as a supplement to the standard operating instructions of the WELDPLAST S1.

Attention: Please read the instructions thoroughly before starting any work!

Read the safety data sheet for the plastic material to be welded. Highly fluorinated plastics can cause damage to health during processing. Use the protective equipment recommended by the material manufacturer.

Hot gas extrusion welding PFA with WELDPLAST S1 F requires a special procedure which must be strictly adhered to. Failure to follow these instructions will result in damage to the machine.

Processing PFA causes a heavy load and shortens the life of some components. Warranty claims of any kind will be rejected.

Commissioning



Necessary tools:

- | | |
|-----------------------------|--------------------------|
| 1. Thermal protection glove | 5. Special welding shoe* |
| 2. Pliers | 6. 13mm hexagon key |
| 3. Allen key 3mm | 7. Brass brush |
| 4. Special nozzle* | |

*in the scope of delivery



The preheating nozzle is mounted in the downward position.

Turn the unit **ON**

Select predefined program **PFA** The required parameters can only be set in the PFA program.



After the drive is released, install the extrusion nozzle.

Attention: left-hand thread!



Install the special welding shoe.

Attention: standard welding shoes made of PTFE must **not** be used!



The welding shoe must be heated up with a preheating reflector for at least 10 minutes.



Turn on and lock the drive with 100% output.

Attention: only use $\varnothing 3\text{mm}$ welding rod!



Then insert the welding rod and **extrude**.



During breaks, the output can be reduced, but **never turned off**.

Switch off



1 Stop the welding wire supply and run the extruder until empty. Keep the drive running.



2 Remove the welding shoe while the drive is running and clean it immediately.

The bore must be free.

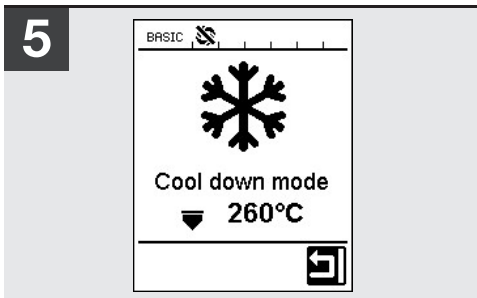


3 While the drive is running, disassemble the extrusion nozzle and clean it immediately.

The bore must be free.



4 Stop the drive and remove remaining material with pliers.



5 Shut down and turn off the WELDPLAST S1 F according to the operating instructions.





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