

Plastic Extrusion Welder

JC-1600-JMR / JC-3400-JMM

User Manual



JC-1600-JMR



JC-3400-JMM

i. Product Overview

Extruding plastic gun is a new type of hot air welder which is imported foreign advanced technology, well-developed. The major components (hot air gun and drive motor) are made of imported brand-name accessories, stable performance, long service life; They are two independent systems, one is for preheating raw material, another is for welding rod extrusion. Reasonable structure, convenient operation, continuous welding, high working efficiency, powerful extrusion, to make the weld strength is greatly improved. It is the ideal product for a variety of thermoplastic welding processing.

This product is with two major components, preheating raw material's hot air part and welding rod's extrusion part. Hot air part with adjustable temperature controller to heat automatically, and extrusion part with independent thermostatic heating control system to send hot air independently, It is easy to adjust extrusion speed and use screw extruding for powerful extrusion pressure. Using power supply uniformly to weld plastic sheets, tube and other thermoplastic products, especially for both ends of large diameter hollow wall pipe, producing pipe and repairing pipe and so on.

Available welding materials: thermoplastic HDPE, PP, PVDF, especially PE .Do not apply in a conductive plastic (PE-EL), or cause the machine to produce a conductive short-circuit.

Replacement of the different welding nozzle, can be applied:

- 1) Plastic container's welding, stitching, etc.;
- 2) The large diameter plastic pipe's pipe welding, repairing, splicing, sealing, etc.;
- 3) The thicker plastic membranes, geomembrane splicing, patching and so on.

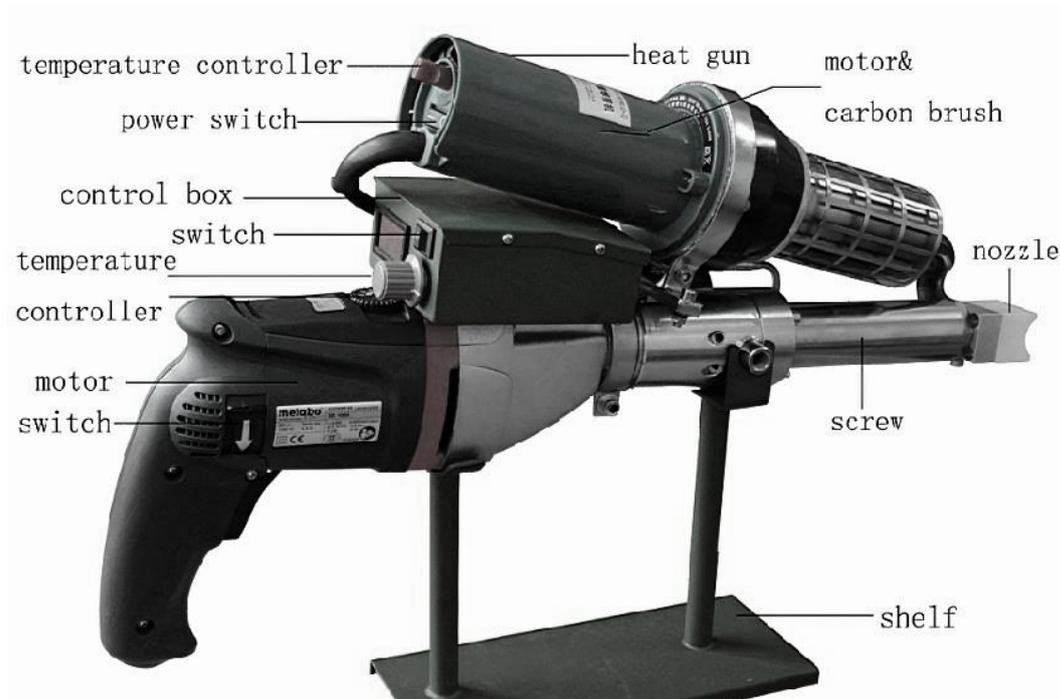
ii. Main Technical Parameters**JC-1600-JMR High Power Hand Extruder**

Model	JC-1600-JMR
Voltage	230 V
Frequency	50 / 60 Hz
HITACHI Extruding Power	800 W
Hot Air Power	1600W
Welding Rod Heating Power	800W
Air Temperature	20 - 600 °C Adjustable (68 - 1112°F)
Extruding Temp	200 - 380 °C Adjustable (392 - 716°F)
Welding Speed	2.5 kg/h
Welding Rod DIA	φ3 mm- 4mm
Weight	6.5 KG
Extruding Motor	HITACHI

JC-3400-JMM High Power Hand Extruder

Model	JC-3400-JMM
Voltage	230 V
Frequency	50 / 60 Hz
Metabo Extruding Power	1100 W
Hot Air Power	3400W
Air Temperature	20 - 600 °C Adjustable (68 - 1112°F)
Welding Speed	2.5 kg/h
Welding Rod DIA	φ3 mm- 4mm
Weight	7 KG
Extruding Motor	METABO

iii. Appearance and Components (JC-3400-JMM for Example)



iv. Operation Procedures

- 1) Put the welding gun on the shelf, install the handle, plug in the mains plug.
- 2) Open the control box switch, welding temperature is generally set at 300°C (572°F), when the temperature reach 270°C (518°F) the motor switches off, you cannot start, when the temperature reaches 270°C (518°F), the motor switch is turned on, you can start properly. Open the hot air machine power switch, thermostat knob, heated a few minutes to operate.
- 3) The right hand pulls the motor switch, the motor starts to rotate. The new machines have noise, probably it mostly is relevant to the resonance between the tool and the base or the close of the parts inside the tool. If the motor is very smooth, and the internal sound disappears after sending welding rods.
- 4) It is better to re-standby 5 to 6 minutes after ensuring the motor can be started. Then put welding rod into machine to operate. Adjust the temperature carefully depending on the thermoplastic case.

- 5) Motor's rotating speed is fast without thermoplastic and will become heavier when sending welding rod, if become very difficult, please stop, probably screw heating time is too short or low temperature.
- 6) Different welding methods require different welding nozzles, our company provides a standard nozzle.
- 7) Need pressure on machine then can be pressurized on the welding seam. Extruding some plastic material to heat nozzle, then make weld surface not smooth.
- 8) Welding speed, extruding, angle, nozzle structure will determine welding seems looking, but the most important thing is air temperature and air volume. It determine welding's strength. Usually hot air temperature is 260 ~ 400 °C (500-752 °F). Certainly, the faster welding speed, the higher required temperature.
- 9) Hot air with the welder moves. It is alright as long as can make the surface to be welded after the hot air blowing. The higher temperature of the welding is not the better. Select the correct temperature is very important.
- 10) Please do not knock when replace the PTFE welding head. It is better to heated then take down.
- 11) Hot air motor carbon brush life is about 800 hours, attention to early replacement, do not wait until the carbon brushes to run out.
- 12) When shutdown, please circumgyrate hot air thermostat knob to the minimum, a few minutes blowing before they shut down the hot air machine.
- 13) Retain a little of welding rod when shutdown to avoid extruder screw's damage.
- 14) Clean up welding nozzle when shutdown.

v. Product Features

- 1) Imported hot air welding torch and imported driven system, high temperature, big torque, long service life, stable performance.

- 2) Light weight, easy to handle and available to operation at different angles.
- 3) Big extrusion volume can be welded more than 10mm welding seam.
- 4) Different welding shoes can be applied to different types of welding.
- 5) It is used in the tank and pipe and complies with Part 4 of the DVS standard (Germany Welding Association).

vi. Product Warranty

- 1) This welding machine warranty period from the date of purchase for one year.
- 2) After receiving the machine, user should immediately check whether the machine is in good condition, no comments in two days will be as a complete, through acceptance.
- 3) No warranty for damage caused by the following circumstances:
 - a) no feedback for problems in time or not in accordance with the requirements to take timely measures to cause serious damage;
 - b) willful damage or overload;
 - c) Demolition, repair and maintenance work without the manufacturers permission ;
 - d) To make alterations or install attachments without being approved by the manufacturer;
 - e) User fails to manual operation;
 - f) The ceramic heating tube or non-company sold products.
- 4) Normal wear and tear is not covered under warranty.
- 5) No warranty for force majeure (lightning, floods, fires, accidents and other non-manufacturing business reasons) caused by damage.
- 6) Above terms shall be invalidated after the warranty period.

vii. Safety Precautions

- 1) Prohibited the extrusion nozzle facing the person or object of any likely to be scalded when devices work.



- 2) Stop using the equipment or start using must ensure that the head nozzle is not covered with plastic, and if so may result in poor extrusion, resulting in a backflow or injection, reflux causes the damage, spray may cause burns.
- 3) When the device is working, any metal part is prohibited to touch, otherwise there will be danger of burns.
- 4) The device is turned on, there must be supervised, or may cause equipment damage and cause a fire hazard.