

JC-3600-TM

Table-Mounted Hot Air Welder

User Manual

1) Introduction

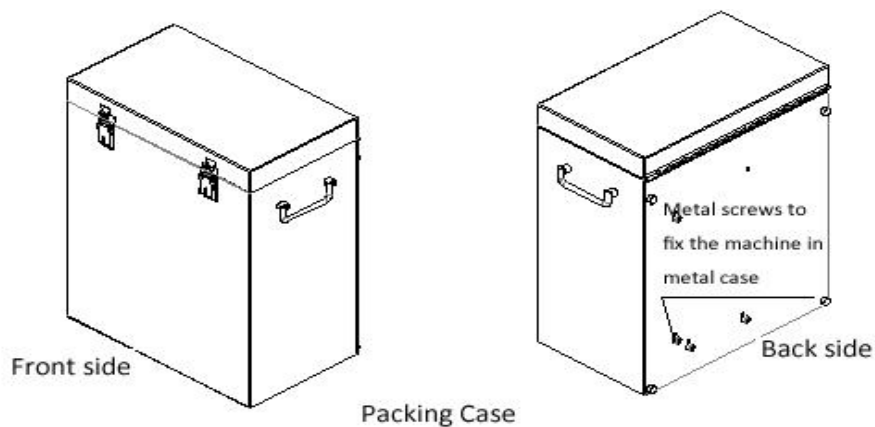
This machine is designed for heat-seaming of banner, tarpaulin and tents. It can be applied on wide range of applications such as connecting keders, grommet hems, welding pocket and overlapping.

2) Technical Parameters

Power:	Voltage:110V
	Frequency 50/60HZ
	Power 3600W
Heating Temperature:	50-620℃
Air Volume:	70%-100% (adjustable)
Welding speed:	0-12m/min
Nozzles :	20/ 30/ 40mm
Dimension:	350x350x560mm
Net Weight:	20KG (Including table mounting frame)
Welding width:	0—43mm

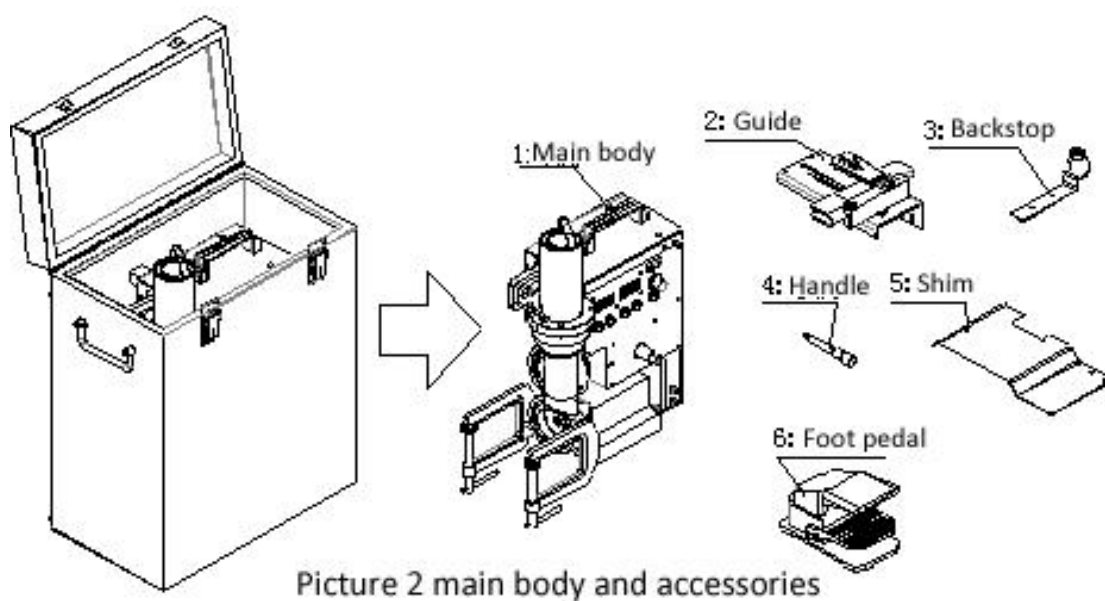
2) Installation

1、 To be safe and have better protection, the machine is packed by a metal case and laid flat during transportation. Please lift it up when the package is received, shown as Picture 1 below.



2、 Take out tools and accessories from the metal case. Use the tools loosening 4 metal screws (See Picture 1). These are 4 screws used to fix the machine tightly without swinging in the box during transportation. Keep it well if the machine will be packed again in the future.

Attention: Machine net weight is 20kgs. Make sure hold the handles tightly when removing from the case. (See Picture 2)



(See Picture 2) Package of delivery (standard equipment and accessories)

#1: main body 1pc

#2: guide 1pc

#3: Backstop 1pc

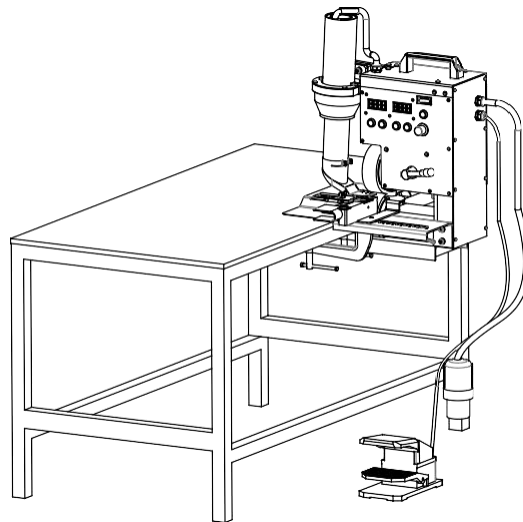
#4: handle 1pc

#5: shim 1pc

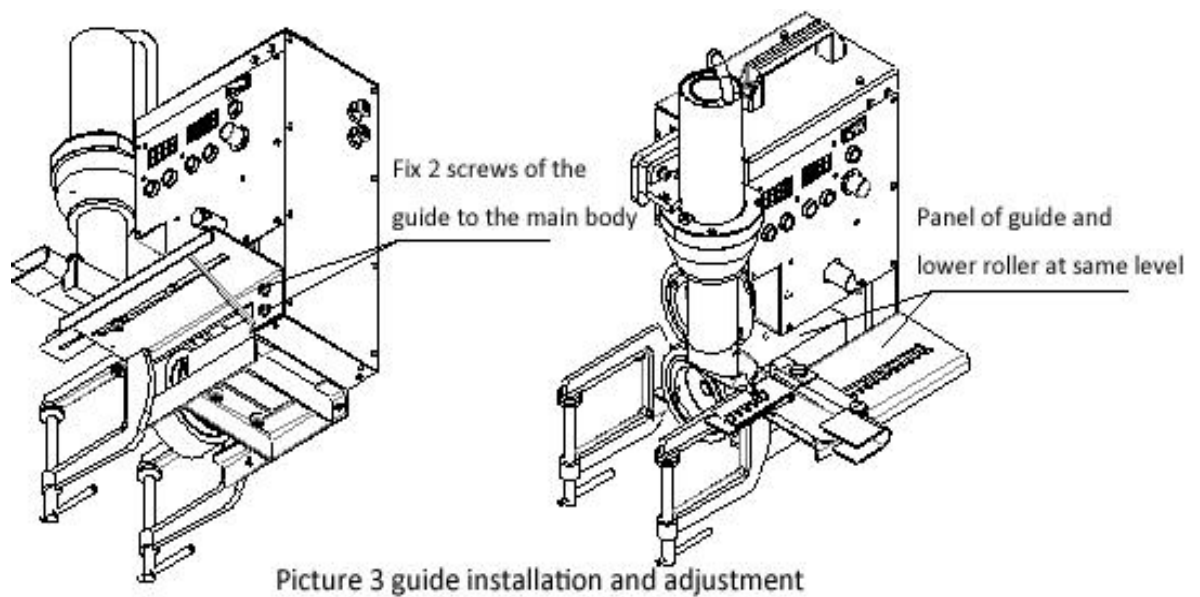
#6: foot pedal 1pc

1 set of installation tools

3、Loose the clip bar and put it on the working table, and then screw it tightly. Make sure the machine is well fixed to avoid falling down (see Illustration)

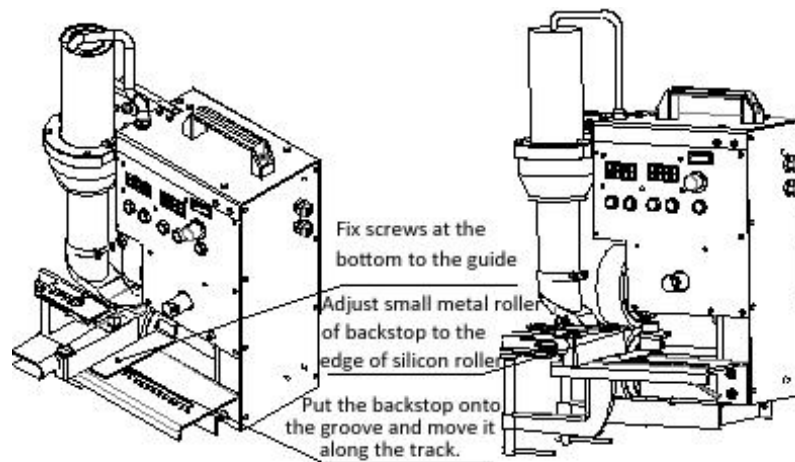


4、Put the guide in front of the main body (aside the control panel), as Picture 3. Fix two screws of the guide to the main body. Adjust the panel of the guide and the lower roller of main body are same level.



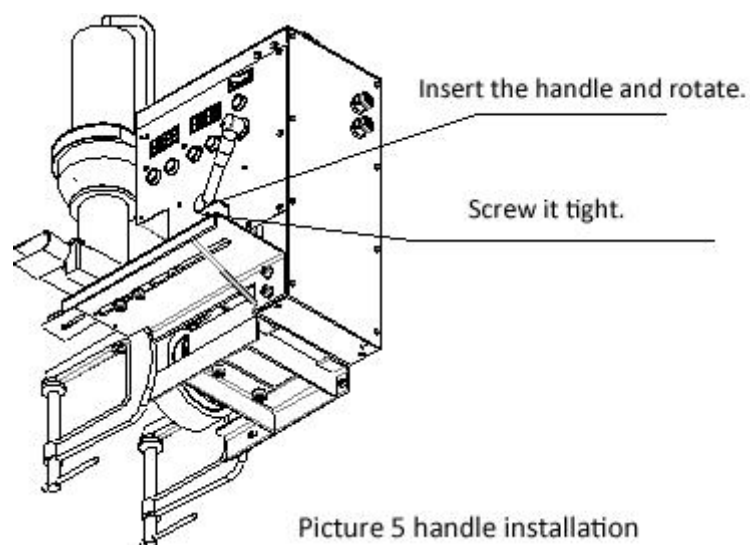
4 、 (Only for keder welding) Put the backstop onto the groove of the guide. Move it

along the track of the guide until its small metal roller attached to the edge of the silicon roller and fix it. (Picture 4)



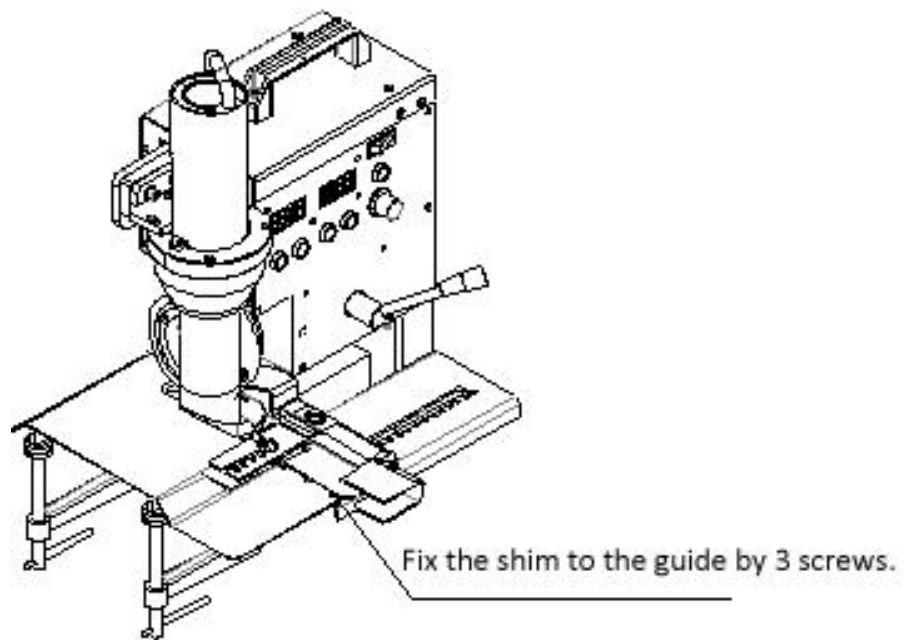
Picture 4 backstop installation

5、 Insert the handle to appointed location (Picture 5) and screw it tight.



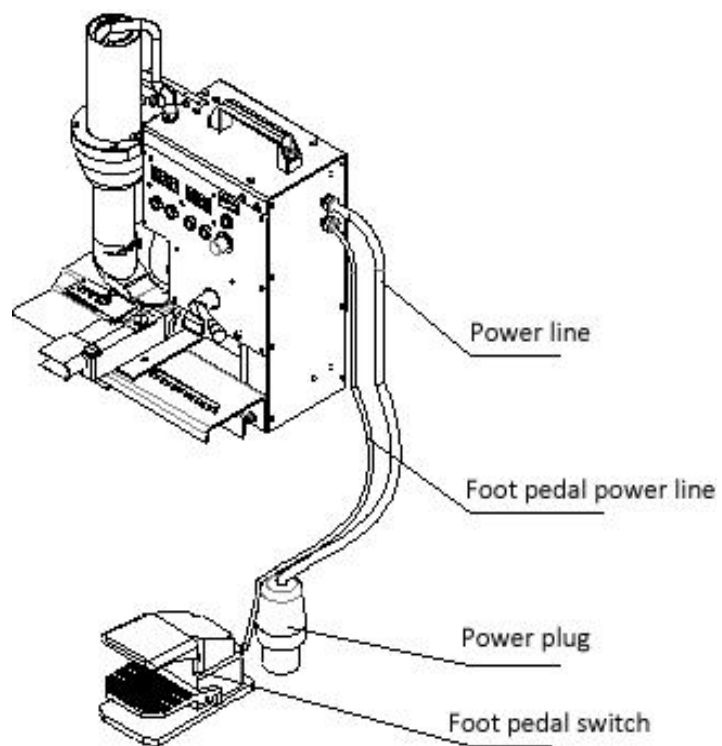
Picture 5 handle installation

6、 The function of shim is to avoid welded materials scratched by supporting frame. Put the shim on the frame and fix it onto the guide. (Picture 6)



Picture 6 shim installation

7、The whole machine looks like Picture 7 after installation. There are two wires, one is power line, and one is for foot pedal.



Picture 7 standard equipment after installation

3) Control Panel



- ✓ Air Volume adjustment (1)
- ✓ ON/OFF switch(8) is used to switch on and off the main power of the welder
- ✓ ON/OFF switch on (8), LCD display (as figure 1), the hot air gun is under natural wind without heating.
- ✓ Press the button (7) and (6), LCD display shows as Figure 2, the hot air blower starts to heat up until to the setting temperature.,
- ✓ If press the bottoms (7) and (6) at the same time, LCD display shows as figure 1, the hot air blower is in “Pause” condition that is under natural wind without heating.
- ✓ When the welding nozzle is moved to correct position, press the moving switch (9) and the welder starts to move and weld. It will stop move if you press the moving switch again.
- ✓ When the welder starts to move, the LCD display shows as figure 3.



Figure 1



Figure 2

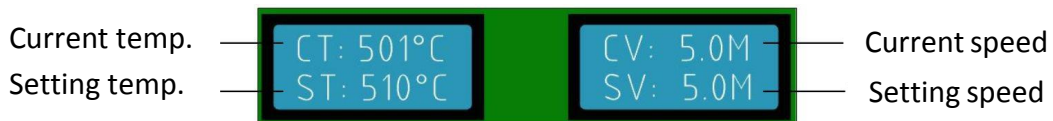






Figure 3

1. Welding temperature

Using bottoms Temperature setting knob+  and Temperature setting knob-  on the panel to set the required temperature. You can set the temperature according to the welding materials and the ambient temperature. LCD display will show the set temperature and the current actual temperature.

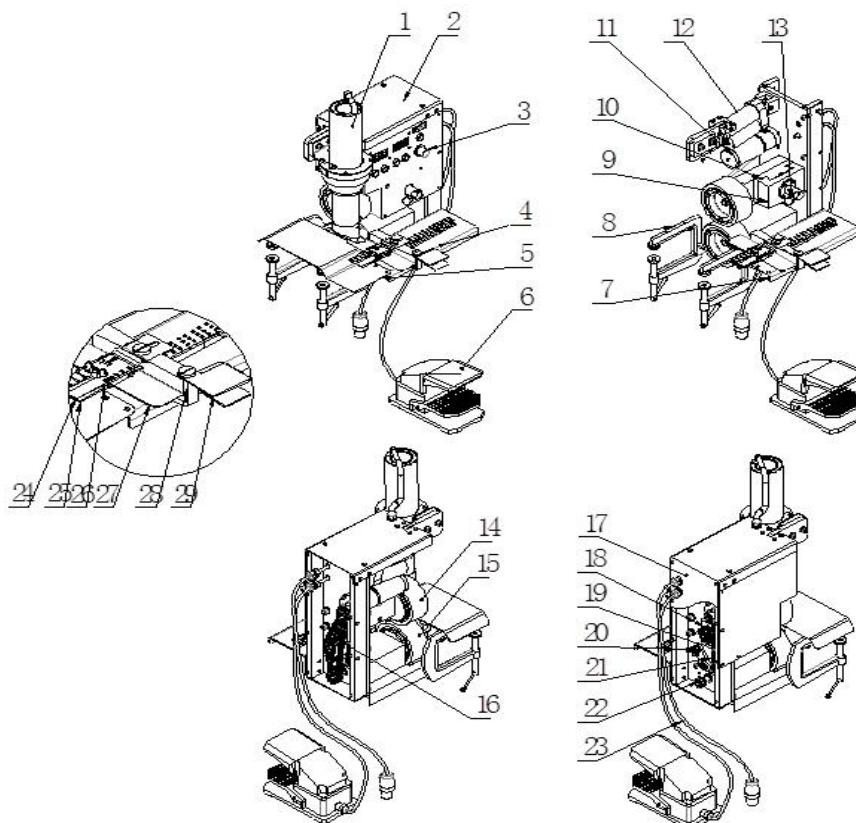
2. Welding speed:

Using bottoms Speed setting knob+  and Speed setting knob -  on the panel to set the required speed according to the welding temperature. LCD display will show the set speed and the current actual speed.

3. The machine has a memory function parameters, namely when you use the welder next time, the welder will automatically use the last set of parameters without having to re-set parameters.

4) Structure

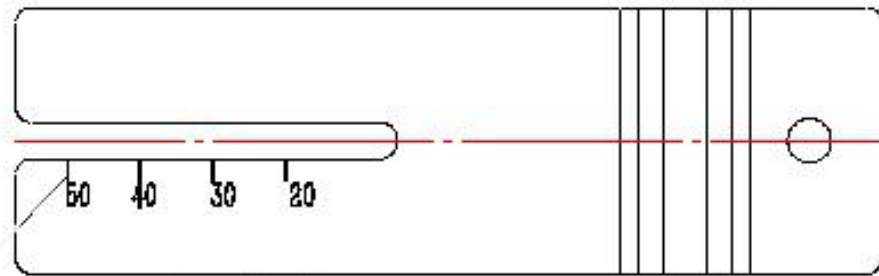
1	Hot air blower	2	Frame	3	Control panel
4	Materials guide	5	Metal plate of mounting frame	6	Foot pedal
7	Fixed plate of guide	8	Clipping bar	9	Controller of upper roller
10	Upper roller height adjustment	11	Motor for speed adjustment	12	Electric cylinder
13	Lift handle	14	Upper silicon roller	15	Lower silicon roller
16	Metal chain	17	Metal case	18	Gear
19	Pendulum rod	20	Tension gear	21	Draw spring
22	Double gear	23	Power cord	24	Upper plate of guide
25	Lower plate of guide	26	Width adjustment and clamp plate	27	Bottom guide
28	Guide adjustment	29	Backstop		



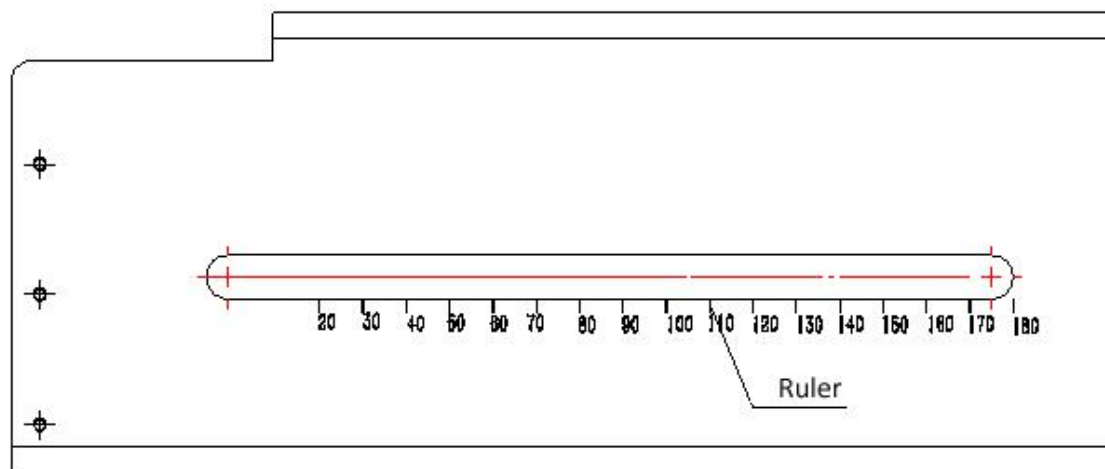
Picture 8 Structure

5) Usage of guide measurement

There is a ruler on upper plate of guide. (see pictures 9 & 10)



There is a ruler on upper plate of guide.



Picture 10 Plate of guide

When use the ruler, the screw must be fixed to avoid moving during welding process.

6) Precaution

- 1, Before welding, make sure the hot gun reach to pre-set operation temperature. Usually it takes 3-5 minutes.
- 2, Welding speeds and welding temperatures are various on different materials and thicknesses. It has to be tested and trial in order to get the optimal results.
- 3, For thin materials, be sure there is no extra tension when feeding to avoid wrinkle.
- 4, When welding process finished, press the foot pedal again and the hot gun will be lifted up. Make sure the gun is cool down to room temperature and then power off the machine.
- 5, The power must be off when open the metal cabinet.

6, Check out appropriate operation voltage (specification is indicated on each machine cabinet)