

# Plastic Extruding Welder

LZ(J)-5001B



# LZ(J)-5001B Extruding Welder User Manual

(Please read the user's manual before operation, and keep in for reference)

In the present years, our company also developed automatic plastic board butt-welding machine, automatic plastic saw and so on. They supply the equipment with good quality and reasonable price for the processing of plastic products in the line of electro-welding equipment production, PCB equipment production, environment equipment production, chemical container .and it offsets the phenomena such as “poor quality, slow speed, lack of safety, wasteful equipment and leakage of water in the process of handing. The production enjoy good name at home and abroad.

LZ(J)-5001A plastic extruding welder is a new kind of heat blast welder introducing the advanced international technology and being made with extractive technique. Moreover, its technical index has reached the standard of the foreign products with the same level and filled up the blank in China. Heat blast warm-up and the plastic welding rod are combined together to enhance the welding strength with their reasonable structure, convenient operation, continuous welding, high working efficiency and great extruding pressure, therefore they are the ideal products for welding and processing various thermoplastic plastic.

With different welding shoes, it could be used for



1. Welding and splicing the Plastic can
2. Repairing, splicing and sealing for big plastic pipes and plastic parts.
3. Splicing and repairing for thicker plastic membrane or GEO membrane.

Notice: Danger. Please make sure the pin is plugged out when undone the tools.

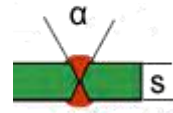
It will result in fire or scald by heating when use the tool wrongly.

1. The voltage in tools should be confirmed with the main voltage in the pin. Supply voltage don't surpassed 10% more or less in rated tools
2. please install overload electrical equipment or electrical leakage based on the protect principle for users
3. No touching welding nozzle and outer part for fearing scald, and even more don't point heat wind to human and animal.
4. Keep away the machine from dampness.
5. Please be intent when op

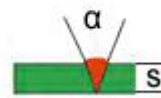
# 1.Technical data

LZ-5001B&B+ Technical data		
voltage	V~	220
power	W	2800
material		PE/PP
Welding rod	ømm	3-4
Hot air temperature	° C	Max 300
Plastify temperature	° C	Max280
PE extrude amount	kg/h	3.0
weight	Kg	7.0 (include 3m power line)
certificate	  	

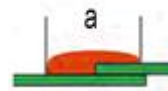
a=vertical dimension of welding line section  
s=material thickness a=cutting angle



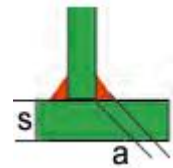
X style welding



V style welding



overlap welding



band welding






## Application scope

1. Thermoplastic plastic HDPE.PP. PVDF, especially PE can show the characteristic best.
2. It is forbidden to use for electric conduction plastic (PE-EL), which can bring electric conduction short circuit of machine.
3. It can once weld the line with width of more than 10mm and plastic board with 40mm below.
4. This machine is used for the fourth part of the barrel bath and the tub and accords to
5. the standard of the DVS(Germany Welding Association)

## Operation instructions

1. Put the tool to the placement frame, fit with the handle, plug the main pin,
2. Switch the power supply of the hot welder on, set the temperature around 300°C when welding, when it is below 270°C, motor would be shut off, above 270°C, turn on the motor, it start working. Switch on the hot air gun, adjust the temperature knob, and then the material in the welding nuzzle will be soften when heat up about 7 to 8 minutes.
3. Button the switch of the motor and then the motor begin to rotate. Big noise may caused by the resonance between the machine and seat or the intensity of spare parts inside the machine. If the motor move smoothly and the inside noise

disappeared after feeding the material , it is qualified.

	Empty welding shoe 50x30x38mm Empty welding shoe 70x50x48mm
	Overlap welding line 25mm Overlap welding line 35mm
	V style welding line 5/6 and X welding line 10/12mm V welding line 8/10 and X welding line 15/20mm
	Banding welding line 8/10mm (a=7mm) Banding welding line 15mm (a=10.5mm)
	Circular bead welding shoe 14mm Circular bead welding shoe 20mm

4. After motor start up, Keep the machine standby for around 5 to 6 minutes, then feed the welding rod. Adjust the temperature knob until the plastic rod is totally soften.
5. It will rotate easily without plastic rod. While it is heavy after feeding material. If it become too heavy, stop the machine immediately, maybe it is heated not enough.
6. Different welding shoes for different welding method, two standard welding shoes is provided.
7. Press the machine to the welding joint. Extruding few rod to heat the welding shoe, and make the welding joint surface not smooth.
8. The welding joint performance would be effected by welding speed, material feeding, welding angle and the design of welding shoe. The strength of the welding joint is depends on the temperature and air volume of pre-heating. the heat temperature normally is about 260'C-400'C. And, the faster it moves, the higher temperature it needs.
9. To set the suitable temperature is very important, heat the welding material until it loose its original shiny is enough.
10. Don't knock the chromosorb welding head hardly when replacing it. It is better to heat up for a while.
11. Please replace the carbon brush of the heat blast motor in advance since the span is about 800 hours. Pls change it before it is used up.
12. It should adjust the temperature of the heat blast knob to the lowest point when the machine stop using. And it shouldn't turn the wind motor off until blowing several minutes.
13. It keep some welding rod in when stop the machine for fear of the scratch when extruding the screw racing screw roller.
14. It must clean the material in the glue tongue when open the machine.

## Maintenance

1. It will be fixed for one year since the product LZ(J) -5001A Extruding welder is sold out .
2. Users should check the machine whether it is in good shape or not, if it is no news within two days, it will be viewed as tact and pass the check NO maintenance for the following situation.
  - 1). Users don't timely report to the problem in the operation or don't follow the Instruction in the manual to take immediately measure to prevent from the bad situation.
  - 2). Users damage or use overload on purpose.
  - 3). Without admit of manufacture, user disassembly the machine and maintenance it by himself.
  - 4). Without the admit of manufacture, user change the structure of add some parts in the structure.
  - 5.) User don't follow the specification in the literary to operate.
  - 6.) Chinaware electric pipe or the production unsold by the company.
4. Normal abrasion or ullage wasn't given to maintenance.
5. Force majeure (thunder shocking, flooring, fire, accidents and so on) resulting in the damage wasn't promise to maintenance.
6. It will lost effect itself after the period of maintenance above the items

## Maintenance and Service

- 1) we are promised to maintenance the products sold by our company
- 2) Our company is responsible for supplying the technical training to customers.
- 3) The property is owed to the company.