

Operation Manual for Hot Air Gun Welding

- Use Hot Air Gun Manual
 - Use HDPE welding rod, black, Ø 3 mm
- 1) Switch the power on: Power on / off switch is at top of the tool (green).
Vent is working now.
 - 2) The potentiometer for the air temperature is at the handle bar, next to the power cable. Turn potentiometer on 5-6 at the scale. Let the tool run for 10 minutes without welding, to get a constant temperature.
 - 3) Scrape surface of basic material to remove oxygen layer for best welding quality
 - 4) Measure the welding temperature at the air outfall with thermometer
Temperature should be between 300° and 350° C
 - 5) Unroll Ø 3 mm welding rod from drum for easy welding
 - 6) Scrape welding rod before welding to remove oxygen layer
 - 7) Execute welding quality test
 - 7.1) Cut 30 cm of welding rod
 - 7.2) Prepare test pieces of basic material
 - 7.3) Insert welding rod into the nose at air outfall from top, press nose to the basic material and slide Hot Air gun continuously for welding. Feed welding rod accordingly
 - 7.4) Weld 15 cm of the welding rod to the test piece
 - 7.5) After 5 minutes cooling time tear the 5 cm loose end to remove welding rod.
 - 7.6) Check the break. The break needs to be in the welding rod and not in the welding zone.
If temperature is too high the material becomes shinning and glancing and might start burning.
If temperature is too low welding rod does not get a compound with the HDPE material of the pipe / strips and only lays on the surface of the ground material
In case of problems to reach satisfying results, try to vary heat at the potentiometer slightly
 - 8) After successful test, start welding