

Instructions for welding plastics with hot air equipment and welding iron

1. Preparedness

First you clean the spot on the workpiece to be machined (1). For painted parts, the paint is about 10mm left and right of the crack away (2), and to prevent further cracking, drilled at the endpoints an 4mm large hole (3). Then the crack is widened evenly with a milling head. Pay attention to the welding wire diameter is used, usually 3 to 5 mm. The resulting groove should ideally be V-shaped (4).



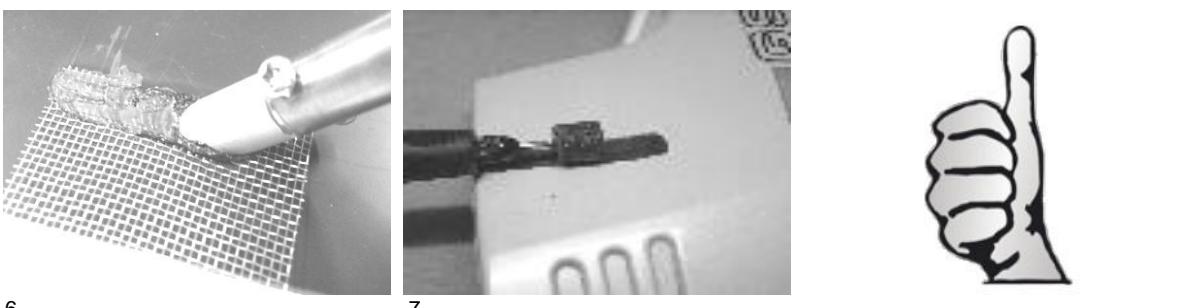
2. Welding

Select your available welding attachment for the heat gun or welding iron. Turn the unit on and let it run for a short time, so that it reaches the desired temperature. You start the welding process a bit before the actual crack and then pulls without pressure and under uniform feeding the welding wire, the notch along (5). Even at the end of a piece, is longer than the crack, weld a little bit more. The weld should be increased evenly and easily. For welding of reinforcing mesh is milled first 1-2 mm from the workpiece and then sets the reinforcing mesh into the prepared cavity. After welding, the area is filled with welding wire again so that the reinforcing mesh can be found in the material (6).



3. After welding

After the welding let cool the weld. Now, the welding seam with appropriate abrasives, such as Milling head, grinding wheel, abrasive paper, refinished (7). Then the repair may still fine with revised plastic putty and then can be painted.



Recommended temperatures for plastic welding

	with welding iron	with hot air	with extruder
ABS	255 - 285 °C	275 - 310 °C	275 - 300 °C
ABS/PC	285 - 300 °C	280 - 320 °C	285 - 300 °C
ASA	255 - 285 °C	275 - 310 °C	275 - 300 °C
PA	285 - 320 °C	280 - 320 °C	285 - 300 °C
PC	275 - 285 °C	280 - 300 °C	275 - 290 °C
PE	250 - 280 °C	260 - 285 °C	250 - 275 °C
PET	265 - 280 °C	265 - 285 °C	270 - 285 °C
PP	250 - 280 °C	260 - 285 °C	250 - 275 °C
PP-EPDM	250 - 275 °C	255 - 280 °C	250 - 280 °C
PS	255 - 285 °C	275 - 310 °C	275 - 300 °C
PVC	250 - 280 °C	250 - 280 °C	250 - 275 °C
TPE	250 - 270 °C	255 - 275 °C	250 - 270 °C