

Nitro Fuzer Lite Plastic Welding System

This guide is designed to provide basic parameters for setting up the 6049 Nitrogen Welding system and provide starting points for welding various types of plastic substrates. Although this guide will get you started, it may be necessary to make adjustments based on variables like material thickness, welding rod size and shape, ambient temperature, and airflow settings.

Connecting the air and nitrogen:

- 1: If not installed, connect the 1/4" short green hose to the fitting on the bottom of the air manifold and to the "AIR IN" fitting on the back of the welder. Note: there are holes in the welding cart for routing the hoses to the welder from the air and nitrogen supply.
- 2: Connect the nitrogen regulator to the bottle and the long green hose to the regulator and to the "N2 IN" fitting on the back of the welder. Set the Nitrogen pressure between 10 and 100 PSI; 30 psi is more than sufficient.
- 3: Connect a clean, dry compressed air supply to the air manifold on the front of the cart. Air inlet pressure can be anything between 10 and 120 psi.

Set the airflow:

- 1: With the RED flow control knob pointed to "AIR," use the precision flow regulator on the front of the welder to set the AIR flow to 12 LPM on the flow gauge.
- 2 Turn the RED flow control to "N2" and repeat the process with the nitrogen. When the RED control knob is flipped from one side to the other, the ball should stabilize at the same place regardless of the flow source. NEVER SET THE RED KNOB IN ANY POSITION EXCEPT TO AIR OR N2, THE FLOW STOPS BETWEEN THOSE SETTINGS.
3. With the power to the welder on, but the temperature controls "OFF", the green "PRESSURE SAFE" light will illuminate, indicating power to the air side of the welder is active. It's now safe to turn the temperature up.

Starting temperature settings @ 12 LPM:

PP, TPO, TEO, PP/EPDM, PP + EP, TSOP (polypropylene) 6.5 - 7.0
PE, LDPE, HDPE (polyethylene) 7.0 - 7.5
ABS 5.5 - 6.0
PA (nylon) 8.0
PC, PC + ABS, PC + PBT (polycarbonate) 6.0 - 6.5
PUR, RIM, RRIM (polyurethane) 7.0 (Airless Welder only)
PVC 6.0 - 6.5
PET 6.5 - 7.0
ASA 5.5 - 6.0
PA/PPE (GTX) 8.0



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WARNING: To prevent damage to the heating element, always maintain airflow when the power is on.

SHUT-DOWN:

- 1) Turn off power.
- 2) Allow air to flow until completely cool.
- 3) Turn off air.



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