

Digital Nitro-Fuzer® - Suggested Temperature Settings

Temperature Setting Suggestions*

Material abbreviation	Formal Name	Welding Rod Series	Melting Temperature	Recommended Temperature Setting	Air flow
PUR, RIM, RRIM	Thermoset Polyurethane	R01	N.A.	70-100 (AIRLESS WELDER ONLY)	N.A.
PP, TEO	Polypropylene, Thermoplastic Olefin	R02	160-166 °C (320-331 °F)	52-64	12
ABS	Acrylonitrile Butadiene Styrene	R03	105 (221°F)	44-56	12
LDPE	Low Density Polyethylene	R04	105-115 °C (221-239 °F)	48-60	12
TPO, TEO, PP+EPDM, TSOP	Thermoplastic Olefin, Thermoplastic Elastomeric Olefin	R05	177°C (350°F)	52-64	12
PA, PA-6, PA-66	Nylon, Nylon 66, Polyamide	R06	269°C (516°F)	60-68	12
PC	Polycarbonate	R07	155°C (311°F)	44-56	12
PPE+PS, PPO	Polyphenylene Ether+Polystyrene	R08	249-277°C (480-530°F)	60-68	12
PVC	Polyvinylchloride	R09	177°C (350°F)	48-56	12
FiberFlex	FiberFlex	R10	N.A.	100 (AIRLESS WELDER ONLY)	N.A.
PBT	Polybutylene Terephthalate	R11	223°C (433°F)	48-56	12
HDPE	High Density Polyethylene	R12	190°C (375°F)	48-60	12
PET, PETE	Polyethylene Terephthalate	R13	254°C (490°F)	56-64	12
ASA	Acrylonitrile Styrene Acrylate	R14	220°C (428°F)	52-60	12
PA+PPE, GTX	Polyamide (Nylon) and Polyphenylene Ether Blend	R15	275-300°C (527-572°F)	60-68	12
POM	Polyoxymethylene, acetal, polyacetal, & polyformaldehyde, Delrin®	R16	175 °C (347°F)	52-60	12
Acrylic PVC	Kydex®	R17	<204°C (<400°F)	52-60	12
PP+GF15	Polypropylene w/ 15% glass fiber	R18	160-166 °C (320-331 °F)	52-60	12
HDPE+GF15	High Density Polyethylene w/ 15% glass fiber	R19	190°C (375°F)	56-64	12
PC+ABS	Polycarbonate + ABS	R20	155°C (311°F)	44-52	12

* Most welding operations will be at the recommended settings. Welding outside the recommended range may be needed if the plastic being welded is very thin, thick, or if a higher or lower airflow is used. Extreme care must be taken to avoid overheating the element when using higher temperature settings.

