

6071 Bumpersmith 2.0

Setup & Use Instructions

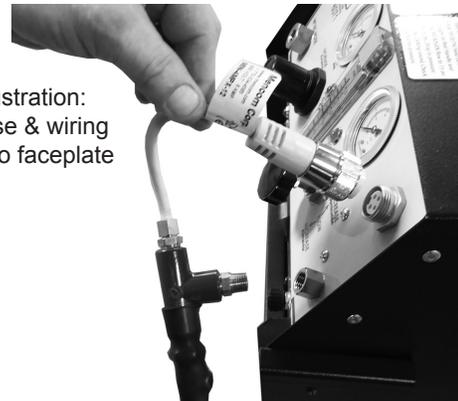
Congratulations on your purchase of Polyvance's 6071 Bumpersmith 2.0 nitrogen plastic welding workstation. Please follow these instructions to prepare your new welder for initial use.

Component List

6071	Bumpersmith cabinet/welder combo unit	5010-2	PP sheet, 10 x 10 x 3/32" thick, natural
6071-10	Right side bumper support assembly	5010-3	PP sheet, 10 x 10 x 1/16" thick, natural
6071-11	Left side bumper support assembly	Accessory Box Contents:	
6071-12	Bumpersmith Hose & Wiring assembly	6050-NR1	Hot air welding tip
6071-13	Work hose assembly	6027HT	Airless welder tube welding tip
6071-14	Torch holster assembly	6031	Airless welder teardrop welding tip
6071-15	(2) bumper support extensions	6145	Hand seamer tool
6071-16	(2) plastic bumper extension pads	6482	Aluminum tape, 2" wide x 10 yard
6056-07	Nitrogen bottle regulator with 3' green tube	6124WB	Stainless steel wire brush
6012-P	Airless heating element with US plug	CHAIN	(2) chains to support bottle
-	(2) yellow bungee cords	-	(2) yellow bungee cords
-	(2) hose hooks	-	(2) hose hooks
-	Cabinet handle	-	Cabinet handle
Complete assortment of plastic welding rod			

Initial Setup

1. Remove loose components from cabinet drawers and enclosed accessory box.
2. Install cabinet handle and hose hooks with included hardware.
3. Install "work hose" into labeled port on left side of control faceplate.
4. Install hose & wiring assembly into port on right side of control faceplate. After threading the air fitting in, plug the electrical cable in.
5. Insert torch holster assembly into the tube provided on the right side of the cabinet. The torch holster can be moved out to the tube on the bumper supports if desired.
6. Plug the airless welding element into the "110AC Receptical" on the front of the control panel. The temperature of the heating element is controlled by the knob on the lower left labeled "Airless Welder"
7. Install your shop's quick disconnect air plug into the port on the back of the welder cabinet.
8. Install a compressed dry nitrogen bottle (not included; obtain from your local welding gas supply company) on the back of the cabinet and secure with the included chains. Recommended bottle sizes are 80 cu ft (33" tall) or 125 cu ft (42" tall). Thread the included nitrogen bottle regulator onto the bottle and connect the green tube to the nitrogen port on the back of the cabinet.

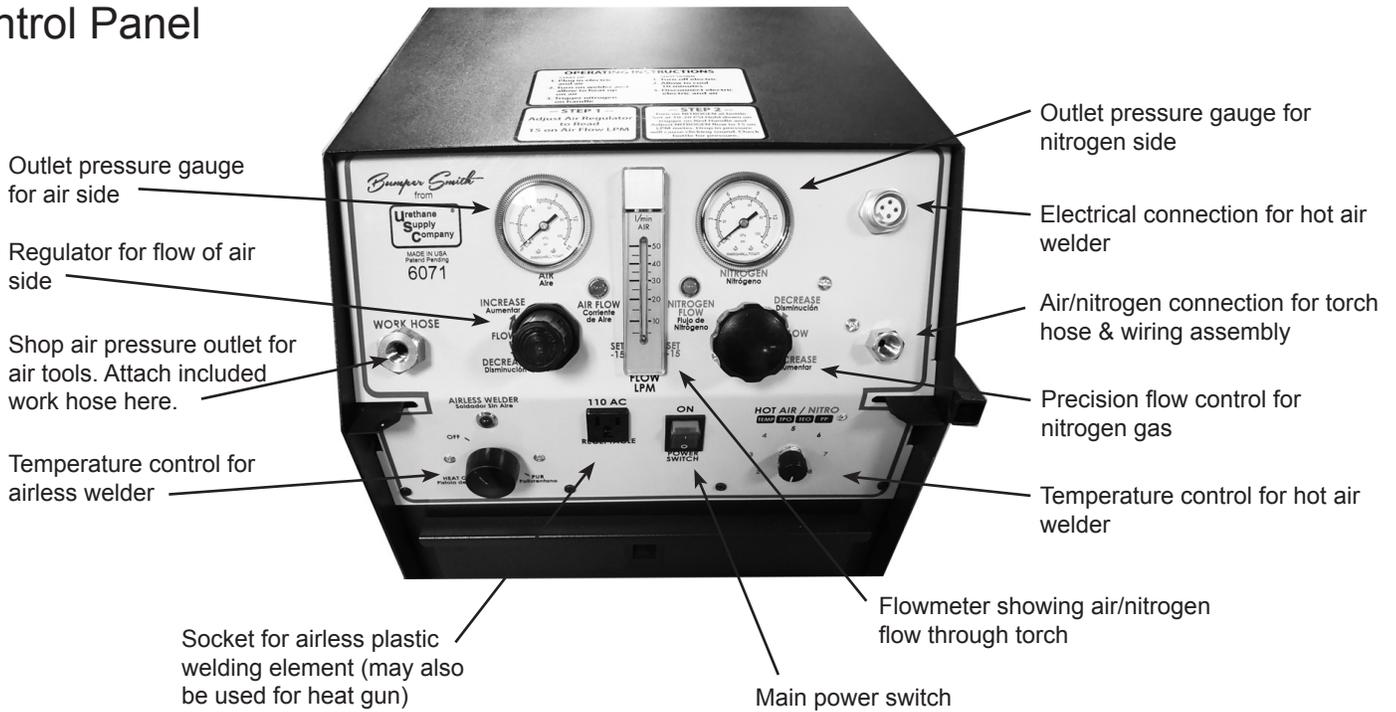


Step 4 illustration:
Install hose & wiring
assembly to faceplate



Step 5 illustration:
Insert torch holster
into tube on right
side of cabinet

Control Panel



Using the welder

1. Hook up shop air to inlet in back of welder. Adjust the pressure on the inlet air regulator on back of the welder to 20 psi.
2. Adjust the air regulator on front of the welder so the flowmeter shows about 12.5 to 15 lpm of flow (about 3 psi on the air pressure gauge). Make sure air is flowing through the hot air welder nozzle.
3. Plug the machine into shop electrical service (115 VAC, 60 Hz, 20 amp minimum).
4. Turn on the main power switch.
5. Open the nitrogen bottle and set the "T-handle" on the nitrogen regulator to establish 20 psi on the low side.
6. Push the trigger in the handle of the welder to switch to nitrogen flow. Adjust the nitrogen flow with the knob on the right side. Set flow to about 12.5 to 15 lpm (about 3 psi on the nitrogen pressure gauge).
7. Release and press the nitrogen switch to make sure the flow on both air and nitrogen sides are set about the same, 12.5 to 15 lpm on the flowmeter.
8. Turn the hot air temperature control to the appropriate setting for the type of plastic being welded. Most bumpers are PP/TPO, so set the knob at about Level 5. DO NOT OVERHEAT... the heating elements are NOT warranted as they are subject to user abuse. If the barrel starts to glow orange, turn down the temperature setting and/or increase the flow setting.
9. To shut down the machine, turn hot air temperature setting to zero and let the air flow until the air coming from the torch is room temperature. Shut down power and air.

