

Shutdown Procedure

The shutdown procedure is **VERY IMPORTANT** for maximizing the life of your heating element. You **MUST** shut down power to the unit first, then let clean, dry, oil-free air flow until the heating element is completely cool. **You** are in control of your heating element's life... Urethane Supply Company cannot warrant the heating elements for this reason.



19. To maximize the life of your heating element, you must cool the element off completely before turning off the air. First, push the temperature control knob on the hot air welder to turn off the power (power light should go off). Then unplug the power strip to remove all power from the cart.



20. Let air continue to flow through the heating element for at least 10 minutes. You may increase the airflow to shorten the cooling time. Do not turn off air until you can hold your hand comfortably directly in front of the nozzle.



21. Remove shop air from the cart.



22. Close the valve on the nitrogen tank. Lower pressure at nitrogen regulator by turning pressure control knob counter-clockwise. Pull up the knob on the nitrogen-air controller to purge the nitrogen line.



Contact info@urethanesupply.com or call 800-633-3047 with any other technical questions. You may also visit www.urethanesupply.com or become a fan on our Facebook page to get the latest information.

6056 Nitrogen Welding Cart Quick Start Guide

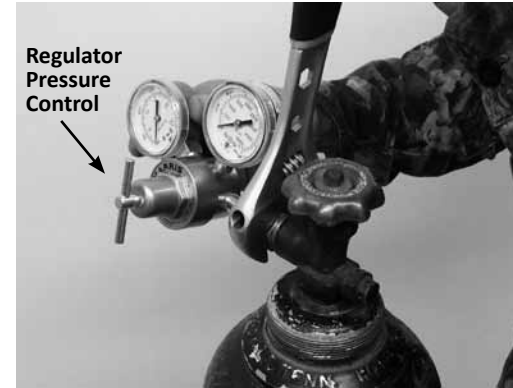
Initial Setup Guide



1. Unbox and unwrap cart. Remove components from boxes.



2. Install nitrogen tank (argon may also be used). Install safety chains around tank.



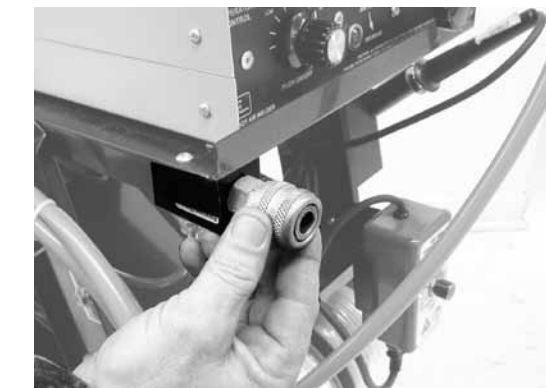
3. Remove regulator from box. Thread into nitrogen tank. Turn regulator pressure control counter-clockwise until it is loose.



4. Insert green flexible tube from the "N2" side of the nitrogen-air controller into the fitting on the regulator. Push tube in firmly until it stops.



5. Install your shop's quick disconnect plug into the air manifold.



6. Install your shop's air hose or quick-disconnect chuck into air manifold (has 3/8" NPT threads; you may need an adapter). Connect your die grinder or other air tool to this hose.

Start-Up Procedure



7. Connect clean, dry, oil-free shop air to air inlet. Supply pressure should be set between 60-80 psi.



8. Slowly open valve on nitrogen tank. Turn pressure adjustment control clockwise until outlet-side gauge reads 60-80 psi.



9. With nitrogen controller knob pushed down (air side), turn regulator knob on controller to adjust pressure to 40 psi.

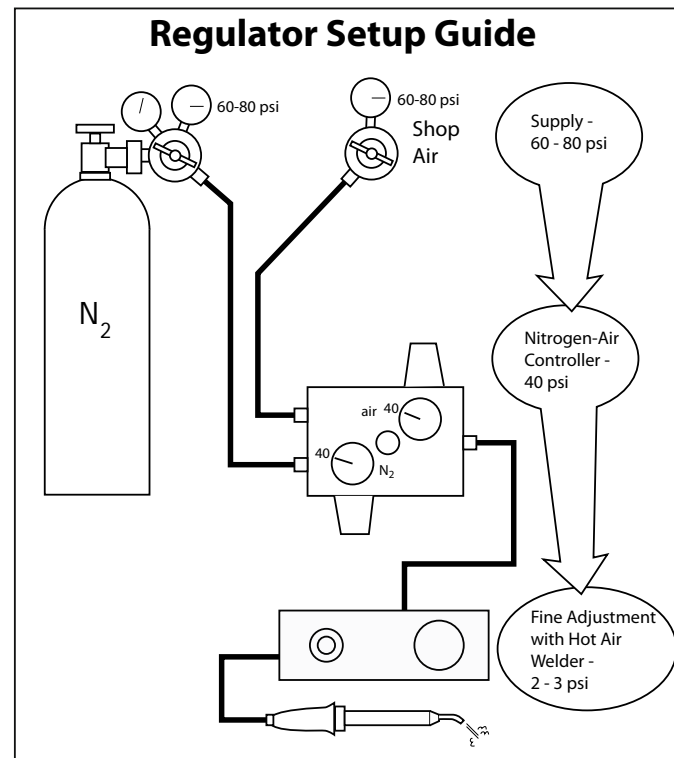


10. Pull knob up on nitrogen controller to switch to nitrogen. Adjust nitrogen regulator to 40 psi.

11. Push down and pull up on the knob a few times to switch between air and nitrogen. You should see the regulator needles move a bit--they will drop on the side that's flowing and rise on the side that's not flowing. There should be no perceptible difference in flow coming out of the welder nozzle between air and nitrogen when the regulators are set properly.

12. Leave the knob in the air position normally. You only need to pull up the knob for nitrogen when you're actually welding. This will conserve the bottled nitrogen.

NOTE - you must use CLEAN, DRY, OIL-FREE air for the hot air welder. Water and/or oil inside the heating element will drastically shorten its life span.



13. Final adjustment of the airflow is done with the knob on the hot air welder. The airflow should be turned down low for work on thin plastics and higher for thicker plastics. Because the proper pressure for welding is only 2-3 psi, a gauge is not provided. You will need a bit of experience to set the flow properly. For thin plastics, you just need a "whisper" of air coming out.



14. Once you have confirmed proper air and nitrogen flow, you may plug in the power strip. Note that there is a lighted rocker switch on the power strip; make sure it is in the "on" position.



15. Push the temperature control knob on the hot air welder to turn on power. The power light on the welder will come on. Adjust the temperature setting to the type of plastic you are welding. (for most car bumpers, use the "PP/TPO" setting)



16. You will notice the airflow will increase as the element heats up. Turn regulator knob on the hot air welder to adjust airflow as necessary.

17. Allow about five minutes for element to reach proper operating temperature. Leave knob on the nitrogen-air controller in the "air" position while warming up or anytime you're not actually welding.



18. When you're ready to weld, pull up on the knob to switch to nitrogen. Nitrogen acts like a shielding gas; it prevents contamination of the weld and makes it stronger. When you're done welding, push the knob down to switch back to air. This conserves your bottled nitrogen.

CAUTION - you must ALWAYS maintain airflow through the welder while it is hot or the power is on. Failure to do so will burn out your heating element. Urethane Supply Company DOES NOT WARRANT the heating element because its life is completely under YOUR control.