

# Drader Injectiweld

# Model W30000

Instruction Manual  
and  
User Guide

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Congratulations on your purchase of Drader Manufacturing's plastic welding equipment. To get the most out of your purchase, be sure to read this manual carefully and keep it on hand for future reference.

The Injectiweld plastic welding system uses a combination of heated tip and injection pressure to form its welds. The hot (interchangeable) tip melts the surface of the plastic and creates a weld zone into which molten plastic is injected. There is a physical mixing of the weld bead and the plastic.

While every effort has been made to ensure the information in this manual is accurate and complete, no liability can be accepted for any errors or omissions. Drader Manufacturing reserves the right to change the specifications of the products described herein at any time without written notice.

## 1. Read these instructions - protect yourself and others





Be aware, serious injury or death may result if welding equipment is not properly installed, used, and maintained. Misuse of this equipment and other practices can be both hazardous and dangerous to the operator and any persons in the general work area. The operator and supervisor must read, and understand the following safety warnings and instructions before using this welding equipment

The Drader Injectiweld is to be operated by qualified people in accordance with this manual. Only authorized service personnel should perform any maintenance that requires opening the welder housing. **Opening the welder housing voids the Drader Warranty.**

## 2. General Information

Information, presented in this manual should be read, understood and followed for the safe and effective use of this equipment. Safety instructions specially pertaining to this unit appear throughout this manual, highlighted by a symbol that identifies levels of hazard. There are also welding tips and hints throughout this manual that will make your welds better and your welder usage more effective.















### Symbols used throughout this manual

|   |  |
|---|--|
|  | HIGH VOLTAGE - The lightning flash symbol will alert the user to the presence of "dangerous voltage" that may be of sufficient magnitude to constitute a risk of electric shock. |
|  | HOT SURFACE - The heat symbol will alert the user to the fact that they might get a serious burn if they touch the part.   |
|  | WARNING / CAUTION - The exclamation point symbol will alert the user to important operating and maintenance instructions.  |
|  | TIP - The Injectiweld symbol identifies tips and hints to obtain the most efficient operation of this tool.  |

### 3. Safety

The operation, maintenance and troubleshooting of the Injectiweld requires practices and procedures which ensure personal safety and the safety of others.

**Read and follow the safety instructions in this manual.**

|   |   |   |
|---|---|---|
|    |    | The Injectiweld is equipped with a ground-contact plug. The Injectiweld must be plugged into an outlet that is properly installed and grounded. If you do not know if your power outlet is grounded check with a qualified electrician. Do not modify the plug. If it will not fit the outlet, have the proper outlet installed by a qualified electrician. |
|    |    | Never touch the welding tip at any time, unless you are absolutely sure that it is cool. <b>Severe burns may result.</b> Wear heat resistant gloves, when handling hot welder parts.  |
|    |    | Always unplug the unit before examining it or when leaving the welder unattended. Air line may remain connected to cool the welder.   |
|    |    | Never allow the welder's hot tip to touch the power cord as it could melt the wire's insulation and cause a dangerous condition. Purchase a replacement cord if your hot tip touches the power cord.  |
|  |  | Protect your eyes from hot plastic. While operating the welder wear safety glasses.   |
|  |   | Consider your work environment. Do not immerse the welder in water, expose it to rain, or use it in excessively damp or wet environments.   |
|  |   | Use the welder in well ventilated areas. Some plastics may give off noxious gasses as they melt. Know the plastic that you are working with and use breathing protection if warranted.  |
|  |   | Keep the work area well lit and clean for maximum safety.   |
|  |   | Use only certified Drader replacement parts.  |

## 4. New Welder Details

Please fill out the information below for future reference. **Once completed, photocopy this page and fax it to Drader Manufacturing. This will register your welder.**

Company Name: \_\_\_\_\_

Serial Number: \_\_\_\_\_ Date of Purchase: \_\_\_\_\_

Name of Distributor (if applicable): \_\_\_\_\_

### Technical Data

|                           |   |
|---------------------------|---|
| <b>Model:</b>             | W30000  |
| <b>Power:</b>             | 120 Volt / 60 Hz<br>240 Volt / 50 Hz  |
| <b>Watts:</b>             | 400 Watt  |
| <b>Weight:</b>            | 4.4 lb<br>2.6 Kg  |
| <b>Temperature Range:</b> | 392 °F - 572 °F<br>200 °C - 300 °C  |
| <b>Air Consumption:</b>   | 4 cfm @ 90psi<br>0.113 m <sup>3</sup> @ 6.2 bar   |
| <b>Air Requirements:</b>  | Min. 80 psi, Max. 100 psi<br>Min. 5.5 bar, Max. 6.9 bar   |
| <b>Rod Diameter [Ø]:</b>  | 5/32 inch (.156")<br>4 mm   |
| <b>Fuse Rating</b>        | 1 x 4A Fuse (120 Volt)<br>2 x 4A Fuse (110 Volt - UK model)<br>1 x 4A Fuse (240 Volt - UK model)<br>2 x 4A Fuse (240 Volt - all others) |
| <b>Max Output (HDPE):</b> | 2 lb per hour<br>0.9 kg per hour  |
| <b>Warranty</b>           | One year - parts and labour   |

## 5. Parts and Service

Call Drader Manufacturing (or your distributor) if you need to purchase parts, or to have your welder serviced. Have the welder serial number on hand.

### Head Office

Drader Manufacturing Industries Ltd.  
5750 – 50 Street  
Edmonton, AB T6B 2Z8, Canada  
Tel: +1 780 440 2231  
Toll Free (North America):  
800 661 4122  
Fax: +1 780 440 2244  
Email: plasticwelding@drader.com  
Web: www.drader.com

### Service Center

#### **(For US Clients only)**

Drader Service Center  
4420 North Highway Drive  
Tucson, AZ 85705  
USA

### Your Distributor

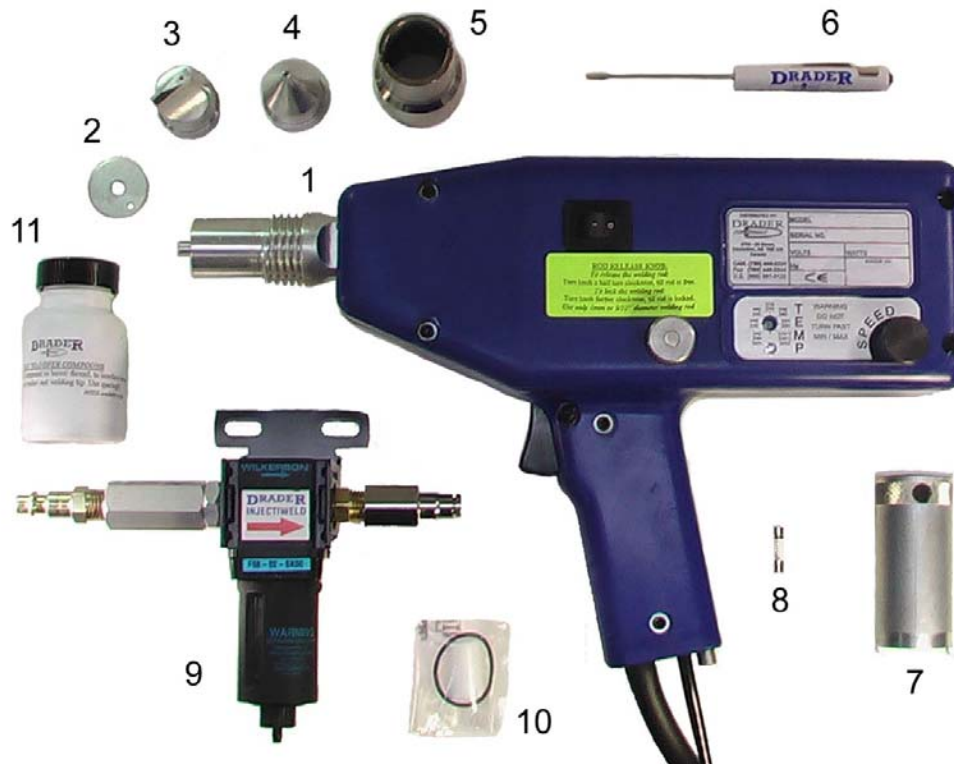
## 6. Operating Instructions

This section will provide you with an overview of using the Injectiweld. Follow these steps to learn how to operate your welder.

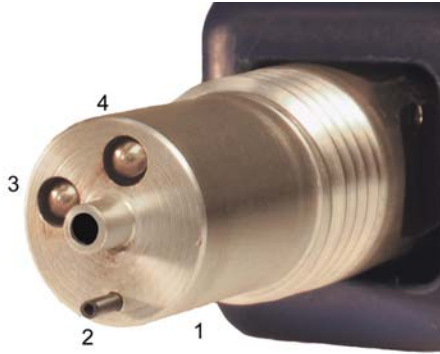
- Unpack the welder and inspect the contents
- Select welding tip
- Connect the air supply
- Plug the welder into an appropriate electrical outlet
- Set temperature then turn the welder on
- Feed the welding rod into the welder
- Make welds

**Unpack the welder and inspect the contents.**

| #  | Description                | Item ID #      |
|----|----------------------------|----------------|
| 1  | W30000 Injectiweld         | Various models |
| 2  | Barrel Washer              | IPAR-A-BARWSH  |
| 3  | 3/16" Fillet Weld Tip      | ITIP-2F6       |
| 4  | Conical Tip                | ITIP-2CO       |
| 5  | Tip Nut                    | IPAR-A-TIPNLO  |
| 6  | Screw Driver               | ISHO-A-SCREWD  |
| 7  | Tip Nut Wrench             | IPAR-A-TIPWRN  |
| 8  | Extra Fuse                 | ISHO-A-FSEALL  |
| 9  | Air Filter Assembly        | IASS-A-AIRFILT |
| 10 | Air Filter Replacement     | IPAR-A-FLTREP  |
| 11 | Heat Transfer Compound     | IPAR-A-HTTRCO  |
|    | Manual (not shown)         | IPAR-A-MANW30  |
|    | Carrying Case (not shown)  | IASS-A-CASCRY  |
|    | Stick Scraper (not shown)  | IPAR-A-SCRSTK  |
|    | Scraping Blade (not shown) | IPAR-A-SCRBLD  |



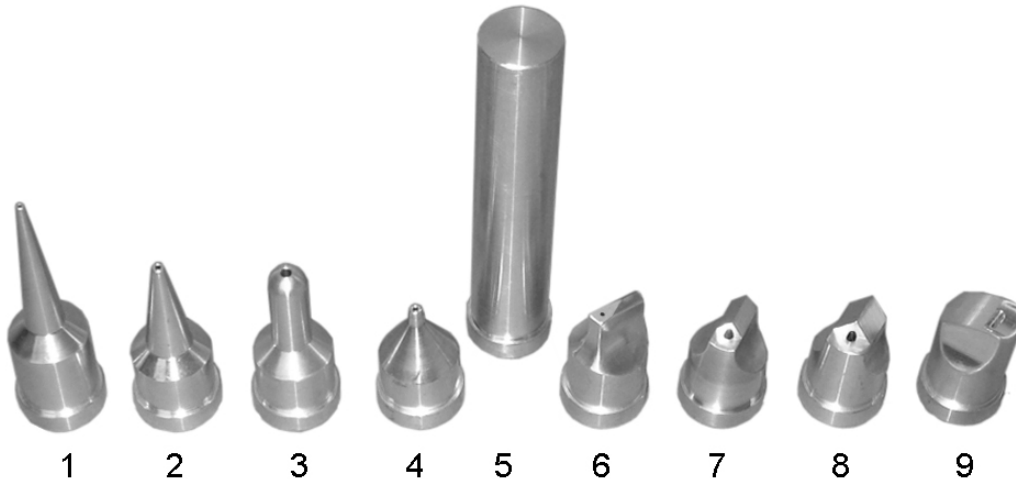
## The heated barrel and tip system



| #  | Description   | Item ID #            |
|--|---------------|----------------------|
| 1  | W30000 Barrel | IPAR-A-BARW30        |
| 2  | Indexing Pin  | (Shop Supply)        |
| 3  | RTD Sensor    | IPAR-A-RTDSEN        |
| 4  | Heater        | (Various ID numbers) |
| Please note, there are other barrel parts that are not listed here |               |                      |

## Welding tip selection









The correct tip will make a difference on quality and appearance of the weld. There are different tips for various applications. The two welder kit tips are the conical tip (# 4 in photo) and the 3/16" fillet weld tip (# 6 in photo).



| # | Description          | Item ID      | Main Usage  |
|---|----------------------|--------------|---|
| 1 | Prototyping tip      | ITIP-2PR     | Prototyping, repairs, filling holes, spot welding tight areas |
| 2 | Repair tip           | ITIP-2RP     | Repairs, filling holes, spot welding tight areas, prototyping |
| 3 | Bull-Nose tip        | ITIP-2BN     | Repairs, filling holes, filling voids                         |
| 4 | Conical tip          | ITIP-2CO     | Repairs, filling holes, spot welding tight areas, prototyping |
| 5 | Blank tip            | ITIP-2BL-5.5 | Custom tips; design your own for your special application     |
| 6 | 3/16" fillet tip     | ITIP-2F6     | 90° fillet welds, butt welds, repairs                         |
| 7 | 1/4" fillet tip      | ITIP-2F4     | 90° fillet welds, butt welds, repairs                         |
| 8 | 3/8" fillet tip      | ITIP-2F8     | 90° fillet welds, butt welds, repairs                         |
| 9 | 5/8" Ribbon weld tip | ITIP-2RW     | Sealing; re-enforcement; non-pressure welds                   |

The Injectiweld kit comes with 2 tips. Both tips are versatile and can provide the operator with numerous types of welds. Tip choice is important as it determines the type of plastic weld. Use this manual to assist you in your tip choice.





### Changing tips – The welder should be hot, but turned off.

|  |   |  |
|--|---|--|
|   |  | The tip and barrel will be hot. <b>Wear protective gear to protect yourself from burns</b>   |
|   |  | <b>When removing the tip nut do not use excessive force. Excessive force will twist the barrel</b> , ruining it, the heater, and the RTD sensor.   |
|   |   | The tip must be hot before changing, but the welder should be off. The tip needs to be hot in order to melt the plastic in the transition area between the tip, and the barrel. If the tip nut is hard to loosen, wait 3 to 5 minutes, then try again. Tip nuts have a different expansion ratio than barrels. The tip nut is easier to remove if you have patience. |
|   |   | Use heat transfer compound frequently. Heat transfer compound makes it easier for the barrel heat to transmit to the tip. Apply the compound at every tip change or every 8 hours of operating time.   |
|   |   | Use a copper, or brass brush to clean away burned heat transfer compound. Clean parts make heat transfer more efficient.   |
|  |   | Make sure you always use the Barrel Washer (IPAR-A-BARWSH). It goes between the barrel and the tip.  |

- Place the welder on a flat, stable surface, with the on/off button facing up.
- Loosen the tip nut (IPAR-A-TIPNLO) with the tip nut wrench (IPAR-A-TIPWRN).
- Turn the tip nut wrench counter clockwise, until the tip nut is free.
- Using pliers, take the tip nut off and place it on a heat resistant surface.
- Using pliers, pull the tip from the barrel and place it on a heat resistant surface.
- Separate the barrel washer (IPAR-A-BARWSH) from the tip.
- Use a copper, or brass brush to clean the old heat transfer compound from the barrel, barrel washer, and tip.
- Open the jar of heat transfer compound (IPAR-A-HTTRCO) and apply the compound onto the welder barrel threads, both sides of the barrel washer, and on the tip's collar. Since the welder is hot, there might be smoke from the heat transfer compound. **Be careful not to inhale fumes.**
- Place the barrel washer onto the barrel. The small hole on the barrel washer goes over the barrel's indexing pin. **There must always be a barrel washer between the barrel and the tip.** The barrel washer blocks molten plastic from backing up into the barrel.
- The tip goes next onto the barrel. The locating pin fits into one of the tip's holes.
- Slide the tip nut over the tip, and screw it onto the barrel using the tip nut wrench.



## Connect the air supply.

|   |  |
|---|--|
|  | <b>Never use air compressors with automatic oiling systems. Too much oil in the compressed air will cause damage to the printed circuit board and to the air valve.</b>  |
|  | <b>The air filter's bowl guard has an indicator arrow that must line up to the indicator arrow on the air filter. Failure to line up the arrows may cause the bowl to separate from the air filter. This may cause personal injury</b> |
|  | Keep the compressed air as dry and oil free as possible. Always use the Drader supplied air filtration units and keep them well maintained.  |
|  | In order to operate at maximum efficiency, mount the air filter in a stable, upright position.   |

The Drader Injectiweld, Model W30000 requires compressed air. The welder operates at 90 psi (6.2 bar) and consumes 4 cfm (113 lt) at maximum output. The air compressor requirements are:

- Air pressure: Minimum: 80 psi (5.5 bar), Maximum: 100 psi (6.9 bar)
- Horsepower: At least 1.5 horsepower per welder (1120 Watt)

The W30000 kit ships with an air filter assembly. The filter helps to remove particulate, water and oils from the compressed air. Use it at all times.

- The Air filter assembly attaches directly to the welder's air line.



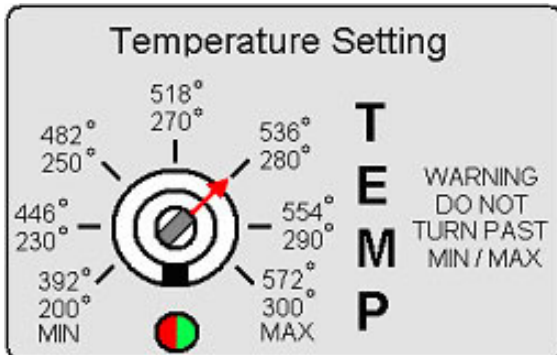
IASS-A-AIRFILT (AW20025 Air Filter Assembly)

| # | Description               | Item ID #       |
|---|---------------------------|-----------------|
| 1 | Quick Disconnect Fitting  | IPAR-A-FITQUICK |
| 2 | W10031-7 Inline Filter    | IPAR-A-FLTINL   |
| 3 | W30025 Air Filter Unit    | IPAR-A-FLTAIR   |
| 4 | W30025-1 Pipe Nipple      | IPAR-A-PIPNIPI  |
| 5 | W10031-8 Air Line Fitting | IPAR-A-ARFITN   |
| 6 | W30026 Air Filter Bracket | IPAR-A-V-BRKAIR |

## Plug the welder into an appropriate electrical outlet

- Plug the welder in the appropriate electrical outlet (120V or 220V).

## Set temperature, then turn the welder on

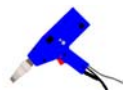


**The temperature control is a dial that does not rotate more than 360 degrees. Overturning the dial will damage the temperature dial. Only authorized people should touch the temperature setting dial. Do not exceed the MIN/MAX limits**

- Set the temperature on the welder using the Drader screwdriver. Gently turn the dial to the required temperature mark. The next page has some suggested temperature settings.
- Turn the On/Off switch on.
- When first turned on, the LED will start off solid red, then, as the welder heats towards the set temperature it will start flashing red. At the set temperature the LED will turn green. During operation, the LED will alternately flash green and/or red when it is maintaining the set temperature.



**The high temperature cutoff switch [HTCO] may shut the unit off if the temperature inside the welder housing exceeds the temperature limit. Once the welder cools off, the unit will operate normally. This feature should not be used on purpose.**



Proper temperature is crucial for high quality welds. Set the proper temperature.



If you change welding materials and decrease the temperature, by the time you purge the original welding rod from inside the barrel, the welder should be cool enough to resume welding at the right temperature. If in doubt about the temperature, wait a few minutes.




If the Injectiweld is not being used for a period of ½ hour or more, either turn the welder off or turn it down to the lowest temperature level.

## Temperature settings – Drader Injectiweld

Please contact your Drader representative, before using a material that is not listed below.

| Material | Description                        | Temperature in °C | Temperature in °F |
|----------|------------------------------------|-------------------|-------------------|
| HDPE     | High Density Polyethylene          | 265°C             | 509°F             |
| LLDPE    | Linear Low Density Polyethylene    | 265°C             | 509°F             |
| HMWPE    | High Molecular Weight Polyethylene | 280°C             | 536°F             |
| PP       | Polypropylene                      | 280°C             | 536°F             |
| ABS      | Acrylonitrile Butadiene Styrene    | 265°C             | 509°F             |
| HIPS     | High Impact Polystyrene            | 255°C             | 491°F             |
| PA 6*    | Polyamide                          | 300°C             | 572°F             |
| PC*      | Polycarbonate                      | 300°C             | 572°F             |
| TPU      | Thermoplastic Polyurethane         | 300°C             | 572°F             |

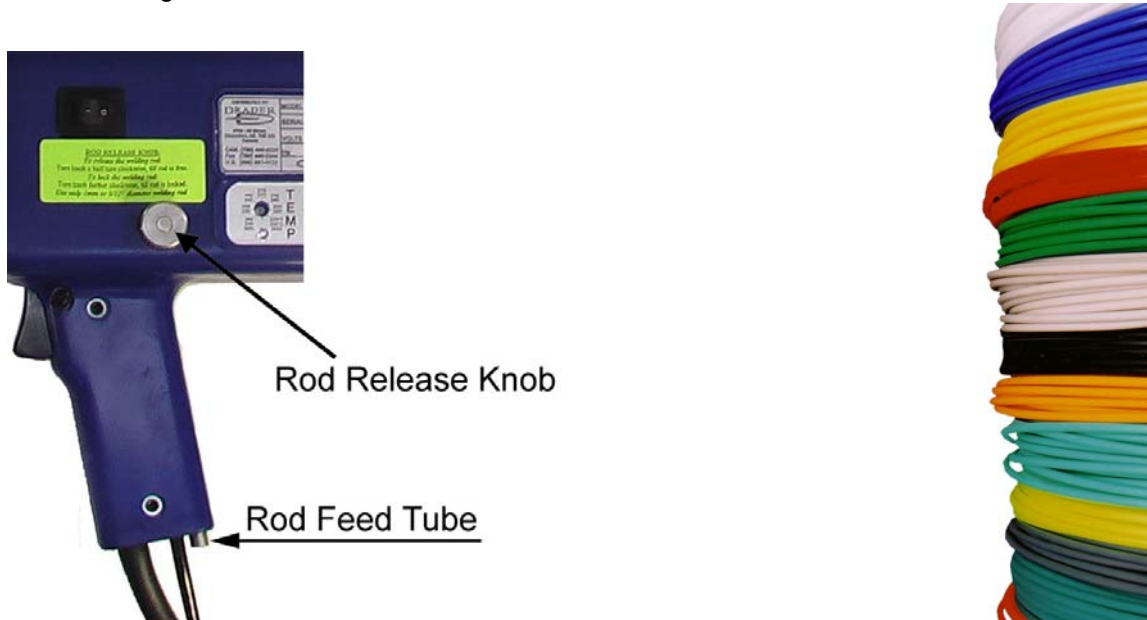
\*Requires butane pre-heater. Please contact Drader for more details.







|   |  |
|---|--|
|  | <p><b>WARNING / CAUTION - Do not use PVC [Polyvinylchloride] with the Injectiweld. The temperature and pressure used by the Injectiweld will degrade PVC and chlorine gas will be released. This aggressive gas is harmful and it can damage the aluminum parts of the welder.</b></p> |
|---|--|

## Feed the welding rod into the welder

The Injectiweld Model W30000 accepts 0.156-inch (4mm) diameter welding rod. The feed is automatic once the welding rod is properly fed into the welder.

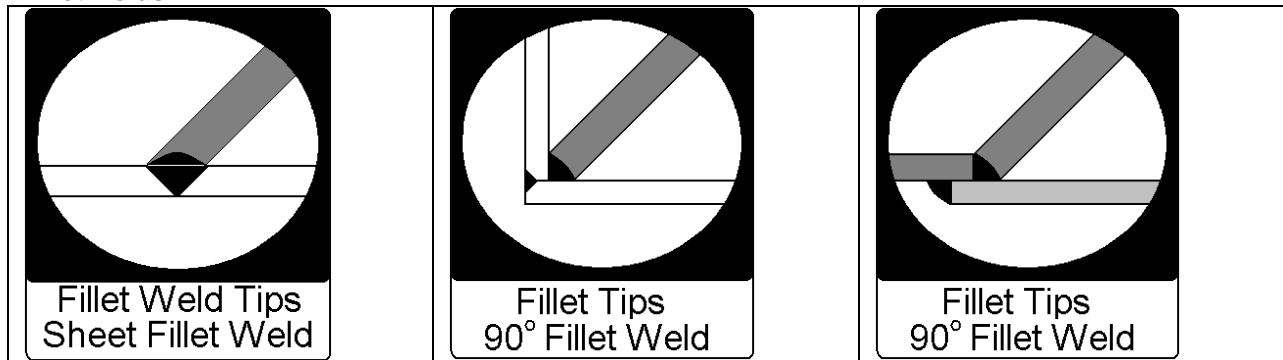
- Turn the rod release knob until the knob feels tight. This opens the rod drive wheels and allows them to accept welding rod.
- When the welder is powered up and the desired temperature is reached, feed the welding rod into the rod feed tube and push it into the welder until it comes to a stop.
- Turn the rod release knob until the knob feels loose. This locks the rod into the feed mechanism.
- Depress the trigger and the welding rod should feed automatically into the welder.
- To remove the welding rod, turn the rod release knob until it is tight, then gently tug on the welding rod out of the welder.



|   |  |
|---|--|
|  | <p><b>Do not operate the welder without plastic welding rod.</b> Running the welder without welding rod may result in feed mechanism damage.</p>   |
|  | <p>When finishing off a roll of welding wire, remove the last remaining welding rod from the welder and start a fresh roll. This will reduce the chances of a rod jam.</p>   |
|  | <p>When switching from one welding rod to another, clear the previous rod material by removing it from the feed tube, then feed the new welding rod. Let the welder pump out about one meter (one yard) of molten welding rod to ensure old material has been purged.</p>                |
|  | <p>If the welding rod does not feed, make sure the rod release knob is loose, depress the trigger then apply gentle pressure on the welding rod, pushing it into the welder. The feed mechanism will grab the welding rod and start the automatic feed.</p>                              |
|  | <p>The rod release knob rotates 360+ degrees, When the knob feels loose the welding rod is locked into the feed mechanism. When the knob feels tight the welding rod is not locked into the feed mechanism</p>   |
|  | <p>Different types of welding rod (i.e. polyethylene, polypropylene, polycarbonate, ABS etc, have different durometers. Because of this, slightly undersized welding rod is better than oversized welding rod. With very hard welding rod (i.e. polycarbonate, try 1/8 inch (3.2mm).</p> |

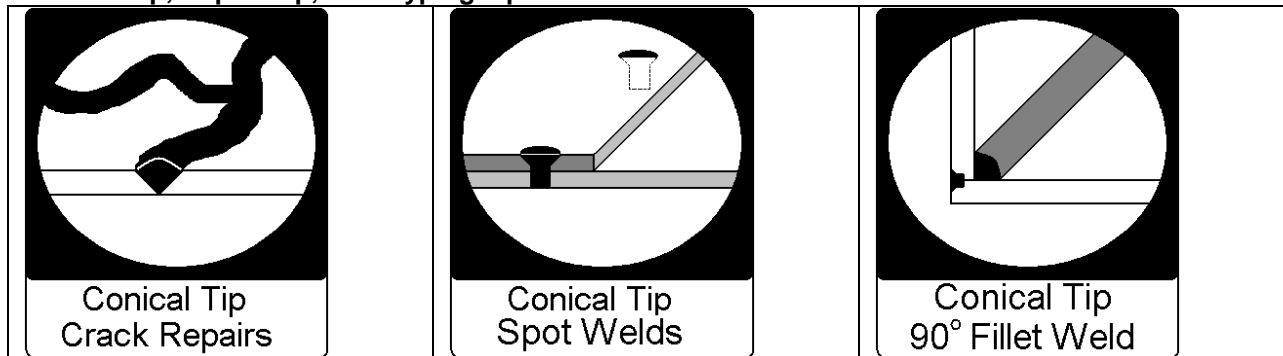
## Make welds

### Fillet welds



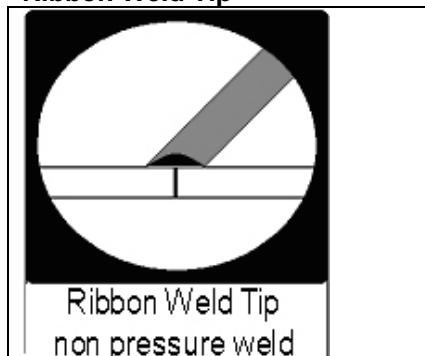
Fillet tips are used mainly for fillet welds [90°] and butt welds. The style of those tips allows one to weld from inside corners out and be able to seal the corners without changing to another tip style. Fillet tips can also be used for crack repairs, as long as the crack is somewhat straight. The longer preheat section allows faster welding speed than welding cracks with the conical tip.

### Conical Tip, Repair Tip, Prototyping Tip



Conical tips are used for crack repairs, filling small holes, spot welding, for reaching tight areas, and for prototyping. Because of their conical shape, the repair tip and prototyping tip offer similar types of welds. Choose the size that best suits your application

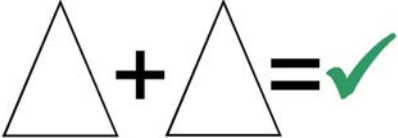
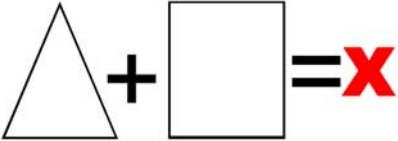
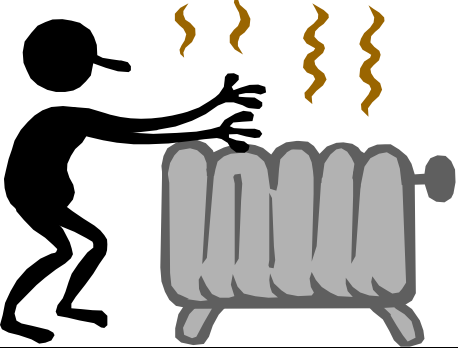
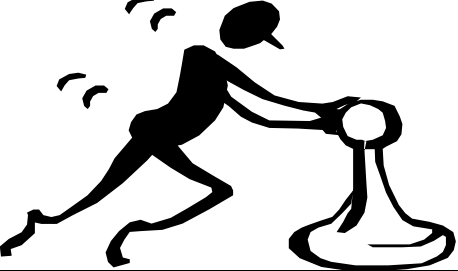
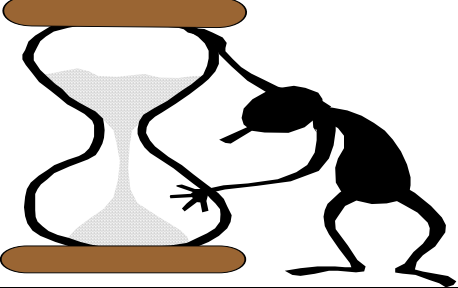

### Ribbon Weld Tip



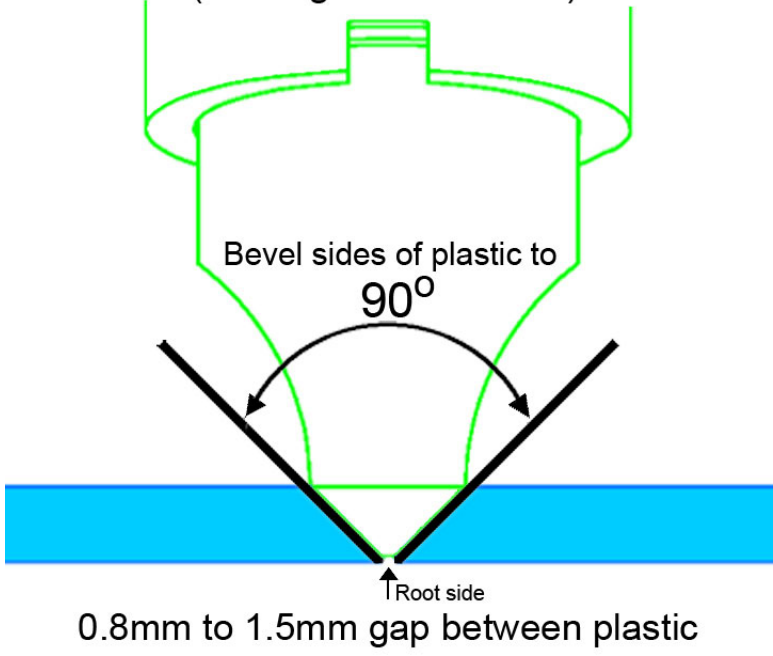
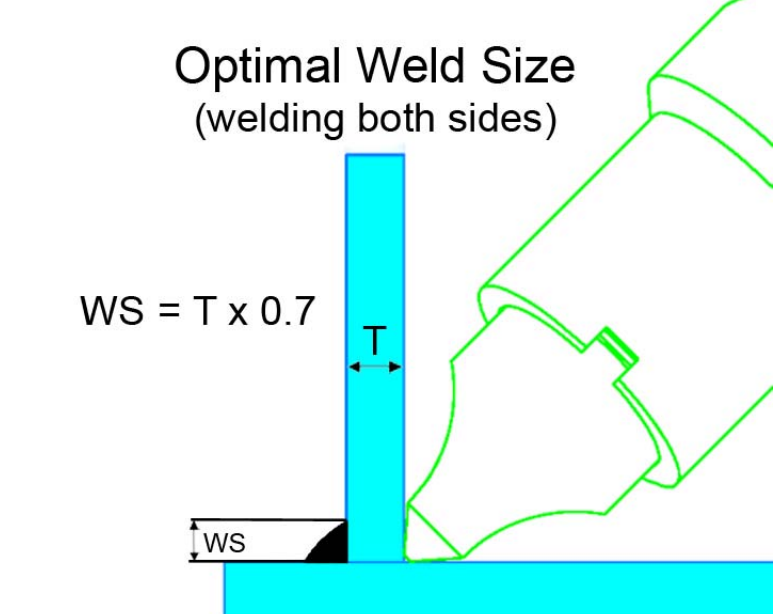
The Ribbon weld tip is used to make a seam weld on thermoplastic materials such as belting and thin sheets. Because this welding tip does not weld down to the root side, it should not be used for regular butt welds.

## 7. Proper Welding Techniques – General Considerations

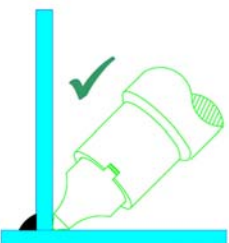
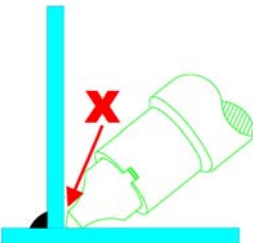

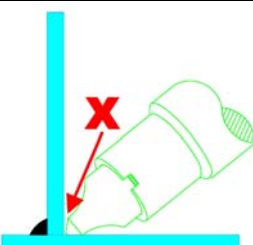

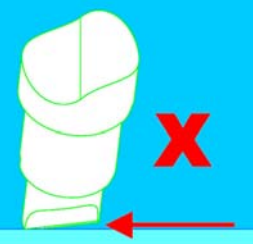

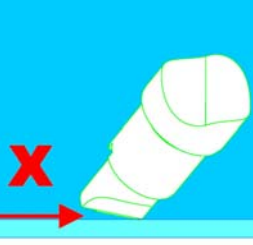
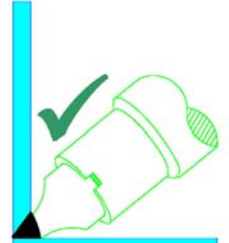
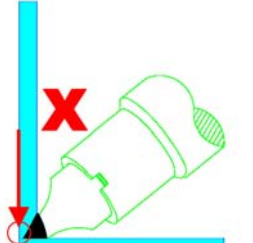
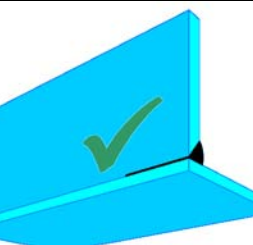
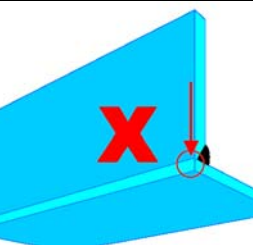
Consider these variables when welding plastics.

|  |  |
|--|--|
| <br> | <p style="text-align: center;"><b>Material</b></p> <p>In order to achieve quality welds, ensure that the welding rod matches the parent material. For example, match polyethylene with polyethylene rod and match polypropylene with polypropylene rod.</p> <p>Do not expect a quality weld if the parent material and welding rod do not match.</p> |
|    | <p style="text-align: center;"><b>Heat</b></p> <p>Each plastic melts within a certain temperature range. When you drift outside this zone, the weld quality diminishes.</p> <p>Some people turn up the heat in order to weld faster, yet they sacrifice weld strength. Do not be tempted to weld faster by raising the weld temperature!</p>         |
|   | <p style="text-align: center;"><b>Pressure</b></p> <p>Pressure allows the plastic molecules of the materials to mix. Best bonding occurs when there is a physical mixing of the plastics.</p> <p>Pressure, when too high or too low, reduces weld quality.</p>   |
|   | <p style="text-align: center;"><b>Time</b></p> <p>Plastic needs a time to melt and time to cool down.</p> <p>Do not speed up the cooling time. After welding, plastic molecules need 24 hours to come to a complete rest.</p>  |
|   | <p>Plastic should be at “room temperature” for at least 24 hours before it is welded.</p>  |

## 8. Proper Welding Techniques – Drader Injectiweld

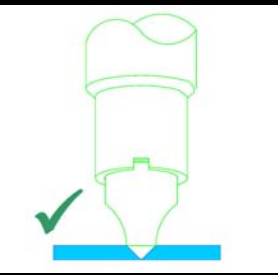
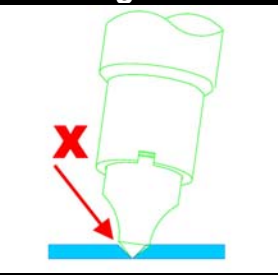
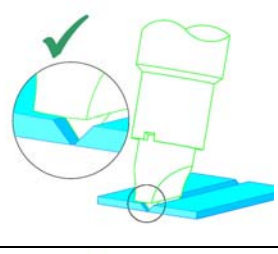
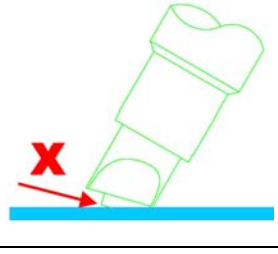
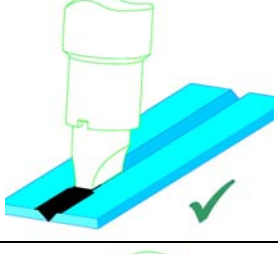
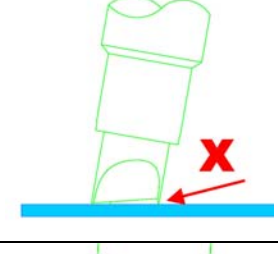
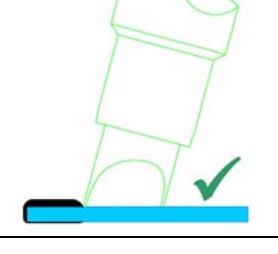
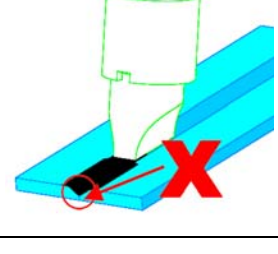
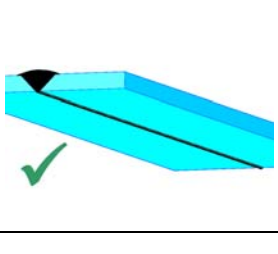
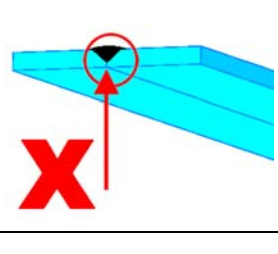
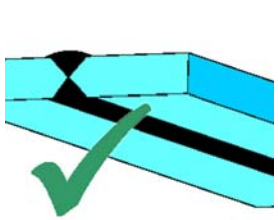
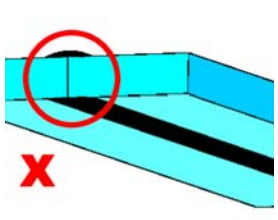
|   |  |
|---|--|
| <p>Optimal Root Welds<br/>(welding from one side)</p>  <p>Bevel sides of plastic to 90°</p> <p>Root side</p> <p>0.8mm to 1.5mm gap between plastic</p> | <p><b>Welding from one side</b></p> <ul style="list-style-type: none"> <li>• <b>Butt welding two sheets together</b></li> <li>• <b>Plastic crack repair</b></li> </ul> <p>Bevel each side of the plastic so that their combined angle is 90 degrees.</p> <p>You may use the stick scraper to give you the proper angle.</p> <p>Leave a gap between the parent materials so that molten welding rod can penetrate the root.</p> <p>Excess welding rod may be trimmed off (after it cools). You may use the scraping blade to perform this function.</p> |
| <p>Optimal Weld Size<br/>(welding both sides)</p>  <p><math>WS = T \times 0.7</math></p> <p>WS = Weld Size<br/>T = Plastic Thickness</p>              | <p><b>Welding from two sides</b></p> <ul style="list-style-type: none"> <li>• <b>Fillet welding two sheets together</b></li> </ul> <p>The amount of welding rod injected onto the parent material should be about 70% of the thickness of the plastic sheet.</p> <p>Increase or decrease welding rod thickness by:</p> <ul style="list-style-type: none"> <li>• Changing tips</li> <li>• Adjusting speed control bolt</li> <li>• Adjusting the speed of how fast your welder travels</li> </ul>  |

## 9. Proper Welding Techniques – Drader Injectiweld – Fillet welds





| Fillet Welds – Correct Alignment  |  | Fillet Welds – Incorrect Alignment  |   |
|---|--|---|---|
|    | Welding tip is in correct alignment when it is at a 45° angle  | Welding tip is not in correct alignment when the fillet weld tip is not at a 45° angle or when it does not come into contact with both sides of the parent plastic material |    |
|    | Welding tip is in correct alignment when it is at a 45° angle  | Welding tip is not in correct alignment when it does not come into contact with both sides of the parent plastic material   |    |
|   | Welding tip is in correct alignment when it is flat against both sides of the parent plastic material            | Welding tip is not in correct alignment when the bottom edge is not flat against the parent plastic material  |   |
|  | Welding tip is in correct alignment when it is flat against both sides of the parent plastic material            | Welding tip is not in correct alignment when the bottom edge is not flat against the parent plastic material  |  |
|  | When welding from one side, leave a root gap of 0.8 to 1.5mm so that welding rod can penetrate to the other side | Lack of penetration to the root will result in a poor weld  |  |
|  | Welding rod should penetrate to the root side of the parent plastic  | Since molten welding rod did not penetrate the root, a poor weld will result  |  |



## 10. Proper Welding Techniques – Drader Injectiweld – Butt Welds

| Butt Welds – Correct Alignment  |  | Butt Welds – Incorrect Alignment  |  |
|---|--|---|--|
|    | Welding tip is in correct alignment when it is at a 90° angle  |    | Welding tip is not in correct alignment when it is not at a 90° angle                        |
|    | Welding tip is in correct alignment when it can reach the root of the other side of the parent plastic         |    | Welding tip is not in correct position when its melting surface does not contact the plastic |
|   | Welding tip is in correct alignment when its edges contact each side of the parent plastic material            |   | Welding tip is not in correct position when its melting surface does not contact the plastic |
|  | Welding tip is in correct alignment when molten welding rod penetrates the root of the parent plastic material |  | Welding tip is not in correct alignment if molten welding rod cannot penetrate the root      |
|  | If welding from one side, welding rod must fill the root of the parent plastic material                        |  | A poor weld because molten welding rod did not penetrate the root.                           |
|  | If you can weld from both sides, make two 90° bevels before welding  |  | Lack of penetration will result in a poor butt weld  |

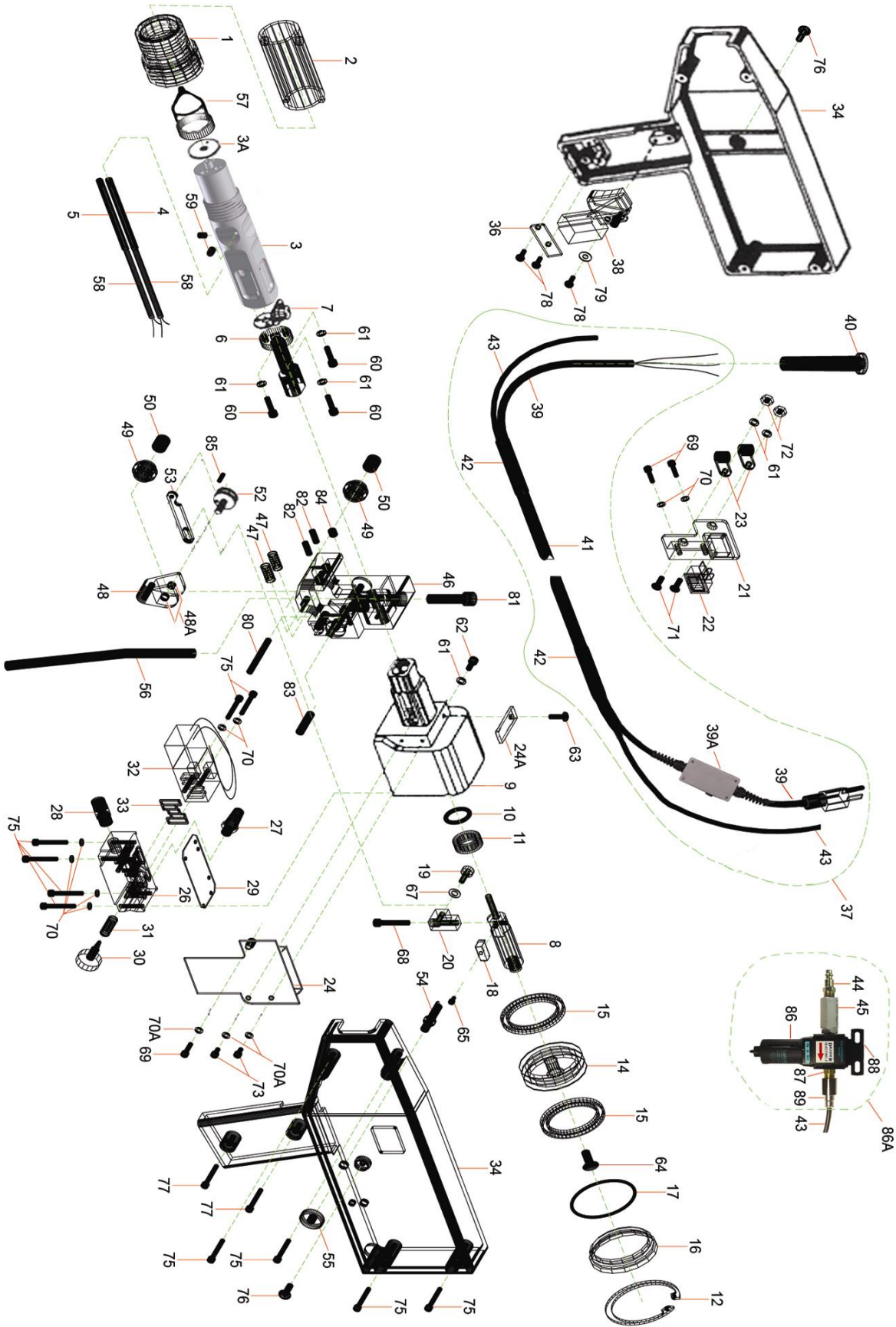
## 11. Daily Maintenance - Injectiweld

|   |  |
|---|--|
|  | A well-maintained welder will give you years of service. Follow the steps in this section to take care of your welder.   |
|  | Compressed air should be as dry and clean as possible. Use the air filtration system supplied with the welder. Use of an air compressor with a dryer / dehumidifier in is recommended.               |
|  | Use heat transfer compound frequently. Heat transfer compound makes it easier for the barrel heat to transmit to the tip. Apply the compound at every tip change or every 8 hours of operating time. |
|  | Use a copper (or brass) brush to clean away burned heat transfer compound. Clean parts make heat transfer more efficient.  |

At the beginning of each shift (or every 8 hours of welder operation):

- Turn welder on and bring up to heat.
- Turn welder off, unplug it from the electrical socket then wait 2 - 3 minutes. (This allows the aluminum barrel to shrink smaller than the steel tip nut).
- Remove tip nut, tip and barrel washer. Be careful – they will be very hot!
- Using copper or brass brush, clean the old heat transfer paste from the tip nut, tip, barrel, and barrel washer.
- Apply a new layer of heat transfer compound to the tip, barrel, and barrel washer.
- Reassemble the welder by placing the barrel washer onto the barrel first. Then place the tip onto the barrel, followed by the tip nut. Use the tip nut wrench and hand tighten the tip nut. Do not tighten the nut too much.
- Plug the welder in, and then turn it on. Bring it up to the set temperature, and then commence welding.
- Make sure the tip nut is snug periodically throughout the day.

# W30000 Exploded view as of January, 2007



### 13. W30000 Kit – Parts List

| #   | Per welder | Item Id          | Description  |
|-----|------------|------------------|--|
| 1   | 1 each     | IPAR-A-TIPNLO    | W20002 Tip Nut Long                                    |
| 2   | 1 each     | IPAR-A-TIPWRN    | W10003 Tip Nut Wrench                                  |
| 3   | 1 each     | IPAR-A-BARW30    | W20004 Barrel  |
| 3A  | 1 each     | IPAR-A-BARWSH    | W20004-1 Barrel Washer                                 |
| 4   | 1 each     | IPAR-A-RTDSEN    | W30006 RTD Sensor                                      |
| 5   | 1 each     | IPAR-A-HT120V    | W10005-12 Heater - 120V                                |
| 5   | 1 each     | IPAR-A-HT240V    | W10005-240V Heater - 240V                              |
| 6   | 1 each     | IPAR-A-BARCTU    | W10007 Barrel - Connecting Tube                        |
| 7   | 1 each     | IASS-A-SWHTCO    | High Temp Cut Out Switch Assembly                      |
| 8   | 1 each     | IPAR-A-PSTNROD   | W10009 Piston Rod                                      |
| 9   | 1 each     | IPAR-A-CYLBDY    | W10010 Cylinder Body                                   |
| 10  | 1 each     | ISHO-A-OR58ID    | S/S-W10010-1 O Ring 5/8 ID X 7/8 OD                    |
| 11  | 1 each     | IPAR-A-BUSOIL    | W10010-2 Bushing – Oilite                              |
| 12  | 1 each     | IPAR-A-SNRING    | W10010-3 Snap Ring Internal                            |
| 14  | 1 each     | IPAR-A-PISTON    | W10011 Piston  |
| 15  | 2 each     | IPAR-A-PSTNSEALS | W10011-1 Piston Seals                                  |
| 16  | 1 each     | IPAR-A-CYLCAP    | W10012 Cylinder End Cap                                |
| 17  | 1 each     | ISHO-A-ORCYLC    | S/S-W10012-1 O Ring                                    |
| 18  | 1 each     | IPAR-A-INTRW3    | W30013 Interrupter for W30000                          |
| 19  | 1 each     | ISHO-A-BOCOLK    | S/S-W10021 Connecting Link Bolt                        |
| 20  | 1 each     | IPAR-A-DRILNK    | W10022 Link Driver                                     |
| 21  | 1 each     | IPAR-A-BRKSWH    | W10023 Switch Bracket                                  |
| 22  | 1 each     | IPAR-A-SWHON2    | W10023-1-24 On/Off Switch                              |
| 23  | 2 each     | ISHO-A-CLMCAB    | S/S-W10023-2 Cable Clamp                               |
| 24  | 1 each     | IPAR-A-PCBW30    | W30024 PC Board for W30000 (comes with 24A, PCB Strap) |
| 26  | 1 each     | IPAR-A-ADBLOC    | W10025 Air Distribution Block                          |
| 27  | 1 each     | IPAR-A-MUFFLR    | W10025-1 Muffler                                       |
| 28  | 1 each     | IPAR-A-FITPSH    | W10025-2 Push On Male Fitting                          |
| 29  | 1 each     | IPAR-A-ADBGAS    | W10026 Air Distribution Gasket                         |
| 30  | 1 each     | IPAR-A-BOSPDC    | W10027 Speed Control Bolt                              |
| 31  | 1 each     | ISHO-A-SPSPCO    | S/S-W10027-1 Spring Speed Control                      |
| 32  | 1 each     | IPAR-A-MA12W3    | W30028-120V MAC Air Valve 120V                         |
| 33  | 1 each     | ISHO-A-GASVLV    | S/S-W10028-1 Valve Gasket                              |
| 34  | 1 each     | IPAR-A-HOUWLD    | W20029 Welder Housing                                  |
| 36  | 1 each     | IPAR-A-CRDSTR    | W10030-1 Cord Strap                                    |
| 37  | 1 each     | IASS-A-CRDAUS    | AU 240V Power Cord Airline Assembly                    |
| 37  | 1 each     | IASS-A-CRDEURO   | EU 240V Power Cord Airline Assembly                    |
| 37  | 1 each     | IASS-A-CRDNAM    | NA 120V Power Cord Airline Assembly                    |
| 37  | 1 each     | IASS-A-CRDUKM    | UK 240V Power Cord Airline Assembly                    |
| 38  | 1 each     | IPAR-A-SWTRIG    | W10031-1-12/24R  |
| 39  | 1 each     | IPAR-A-CRDAUS    | W10031-2-AUS240  |
| 39  | 1 each     | IPAR-A-CRDEURO   | W10031-2-240V  |
| 39  | 1 each     | IPAR-A-CRDNAM    | W10031-2-120V  |
| 39  | 1 each     | IPAR-A-CRDNAM15  | W10031-2-120V 15 FT                                    |
| 39  | 1 each     | IPAR-A-CRDUKM    | W10031-2-UK240V  |
| 39A | 1 each     | IPAR-A-ABSBOX    | W20033-1 ABS Surge Suppression Box                     |
| 40  | 1 each     | IPAR-A-CRDGRD    | W10031-3 Cord Guard                                    |

| #   | Per welder | Item Id         | Description  |
|-----|------------|-----------------|--|
| 41  | 1 each     | IPAR-A-TUBFIB   | W10031-4 Fiberglass Tubing                                       |
| 42  | 2 each     | ISHO-A-TUBHTS   | S/S-W10031-5 Heat Shrink Tube                                    |
| 43  | 1 each     | IPAR-A-ARLINE   | W10031-6 Air Line  |
| 44  |            | IPAR-A-FITQUICK | Quick Disconnect Fitting (Air Filter Assembly)                   |
| 45  |            | IPAR-A-FLTINL   | W10031-7 Inline Filter (Air Filter Assembly)                     |
| 46  | 1 each     | IPAR-A-SUPMAN   | W20014 Main Support  |
| 47  | 2 each     | ISHO-A-SPCOMP   | S/S-W20014-1 Compression Spring                                  |
| 48  | 1 each     | IPAR-A-PVTW30   | W20015 Pivot   |
| 48A | 2 each     | IPAR-A-ROLBER   | W20015-2 Roller Bearings (inside #48, Pivot)                     |
| 49  | 2 each     | IPAR-A-DRIOD    | W20016 Rod Driver  |
| 50  | 2 each     | IPAR-A-ROLCLU   | W20016-1 Roller Clutch   |
| 52  | 1 each     | IPAR-A-STLCRK   | W20017A Steel Crank  |
| 53  | 1 each     | IPAR-A-LKCW30   | W20019 Connecting Link for W30000                                |
| 54  | 1 each     | IPAR-A-RODRPN   | W20020 Rod Release Pin   |
| 55  | 1 each     | IPAR-A-RODREK   | W20021 Rod Release Knob  |
| 56  | 1 each     | IPAR-A-RODFTU   | W20022 Rod Feed Tube   |
| 57  | 1 each     | ITIP-2CO        | T20002 Conical Tip   |
| 58  | 2 each     | Shop Supply     | Fiberglass sleeve 3/16 x 4" (Heater, RTD)                        |
| 59  | 2 each     | Shop Supply     | 8-32 x 5/16" Set screw (barrel)                                  |
| 60  | 3 each     | Shop Supply     | 8-32 x 5/8" SHCS (Connecting Tube)                               |
| 61  | 6 each     | Shop Supply     | #8 Lock washer (Connecting Tube, cable clamps, cylinder body)    |
| 62  | 1 each     | Shop Supply     | 8-32 x 3/8" SHCS (Ground screw on Cylinder body)                 |
| 63  | 1 each     | Shop Supply     | 8-32 x 1/4" Philips stainless steel screw (PCB Strap)            |
| 64  | 1 each     | Shop Supply     | 1/4-20 x 5/8" Flat head screw (Piston)                           |
| 65  | 1 each     | Shop Supply     | 4-40 x 3/16" SHCS (Interrupter)                                  |
| 67  | 1 each     | Shop Supply     | # 10 Flat washer .032" thick (Link Driver)                       |
| 68  | 1 each     | Shop Supply     | 8-32 x 1" SHCS (Link Driver)                                     |
| 69  | 3 each     | Shop Supply     | 6-32 x 1/2" SHCS (PCB, Switch bracket)                           |
| 70  | 8 each     | Shop Supply     | # 6 Lock washer (Switch Bkt, MAC Air Valve, Air Dist'n Block)    |
| 70A | 3 each     | Shop Supply     | # 6 Internal lock washer (PCB)                                   |
| 71  | 2 each     | Shop Supply     | 8-32 x 1/2" Flat head screw (Switch Bracket)                     |
| 72  | 2 each     | Shop Supply     | # 8 Hex nut (Cable Clamp)  |
| 73  | 2 each     | Shop Supply     | 6-32 x 1/4" SHCS (PCB)   |
| 75  | 10 each    | Shop Supply     | 6-32 x 1" SHCS (Air Dist'n Block, Welder Housing, MAC Air Valve) |
| 76  | 2 each     | Shop Supply     | 10-24 x 1/2" Machine screw (Welder Housing)                      |
| 77  | 2 each     | Shop Supply     | 6-32 x 3/4" SHCS (Welder Housing)                                |
| 78  | 3 each     | Shop Supply     | # 6 x 3/8" Self tap screw (Trigger Switch, Cord Strap)           |
| 79  | 1 each     | Shop Supply     | # 6 Flat washer large OD (Trigger Switch)                        |
| 80  | 1 each     | Shop Supply     | 3/16 x 1 3/4" Dowel pin (Main Support / Pivot)                   |
| 81  | 1 each     | Shop Supply     | 5/16-18 x 1 1/4" SHCS (Main Support)                             |
| 82  | 2 each     | Shop Supply     | 3/16 x 1/2" Dowel (Main Support)                                 |
| 83  | 1 each     | Shop Supply     | 1/4 x 1" Dowel (Main Support / Rod Driver)                       |
| 84  | 1 each     | Shop Supply     | 1/4-20 Set screw (Rod Feed Tube)                                 |
| 85  | 1 each     | Shop Supply     | 1/8 x 3/8" Dowel (Steel Crank)                                   |
| 86  |            | IPAR-A-FLTAIR   | W30025 Air Filter Unit (Air Filter Assembly)                     |
| 87  |            | IPAR-A-PIPNIPI  | W30025-1 Pipe Nipple (Air Filter Assembly)                       |
| 88  |            | IPAR-A-V-BRKAIR | W30026 Air Filter Bracket (Air Filter Assembly)                  |
| 89  |            | IPAR-A-ARFITN   | W10031-8 Air Line Fitting (Air Filter Assembly)                  |
| 86A | 1 each     | IASS-A-AIRFILT  | AW20025 Air Filter Assembly                                      |

### W30000 Kit – Parts Not Shown

|             |               |   |
|-------------|---------------|---|
| 1 each      | ITIP-2F6      | T20001 Fillet Tip - 3/16 inch                           |
| 1 each      | IPAR-A-HTTRCO | T1000X-1 Heat Transfer Compound                         |
| 1 each      | IPAR-A-SCRBLD | Scraping Blade  |
| 1 each      | IPAR-A-SCRSTK | Stick Scraper   |
| 1 each      | ISHO-A-SPSPCO | S/S-W10027-1 Spring for 3/16 x 1 3/4" Dowel pin (Pivot) |
| 1 each      | ISHO-A-SCREWD | S/S-Screwdriver   |
| 1 each      | IASS-A-CASCRY | Carrying Case   |
| 1 each      | IPAR-A-MANW30 | Manual  |
| 1 or 2 each | ISHO-A-FSEALL | 4 amp fuse (4mm)  |

### W30000 – Other Available Tips

|              |                                 |
|--------------|---------------------------------|
| ITIP-2BL-5.5 | T20007-5.5 Blank Tip 5 1/4 inch |
| ITIP-2BN     | T20003 Bull Nose Tip            |
| ITIP-2RW     | T20009 Ribbon Weld Tip          |
| ITIP-2F4     | T20004 Fillet Tip - 1/4 inch    |
| ITIP-2F8     | T20005 Fillet Tip - 3/8 inch    |
| ITIP-2PR     | T20008 Prototype Tip            |
| ITIP-2RP     | T20010 Repair Tip               |

### W30000 – Assemblies

The following Injectiweld parts can be purchased pre-assembled.

#### IASS-A-AIRFILT, AW20025 Air Filter Assembly

- 1 x IPAR-A-FLTAIR
- 1 x IPAR-A-PIPNIPI
- 1 x IPAR-A-V-BRKAIR
- 1 x IPAR-A-ARFITN
- 1 x IPAR-A-FLTINL
- 1 x IPAR-A-FITQUICK

#### IASS-A-CRDAUS, AU 240V Power Cord Airline Assembly

- 1 x IPAR-A-ABSBOX
- 1 x IPAR-A-ARLINE
- 1 x IPAR-A-CRDGRD
- 2 x IPAR-A-CRDRES
- 2 x IPAR-A-FSEHLD
- 2 x IPAR-A-FSEHOU
- 1 x IPAR-A-CRDAUS
- 1 x IPAR-A-TERSUR
- 1 x IPAR-A-TUBFIB

#### IASS-A-CRDEURO, EU 240V Power Cord Airline Assembly

- 1 x IPAR-A-ABSBOX
- 1 x IPAR-A-ARLINE
- 1 x IPAR-A-CRDGRD
- 2 x IPAR-A-CRDRES
- 2 x IPAR-A-FSEHLD
- 2 x IPAR-A-FSEHOU
- 1 x IPAR-A-CRDEURO
- 1 x IPAR-A-TERSUR
- 1 x IPAR-A-TUBFIB

IASS-A-CRDNAM, NA 120V Power Cord Airline Assembly

1 x IPAR-A-ABSBOX  
1 x IPAR-A-ARLINE  
1 x IPAR-A-CRDGRD  
2 x IPAR-A-CRDRES  
1 x IPAR-A-FSEHLD  
1 x IPAR-A-FSEHOU  
1 x IPAR-A-CRDNAM  
1 x IPAR-A-TERSUR  
1 x IPAR-A-TUBFIB

IASS-A-CRDUKM, UK 240V Power Cord Airline Assembly

1 x IPAR-A-ABSBOX  
1 x IPAR-A-ARLINE  
1 x IPAR-A-CRDGRD  
2 x IPAR-A-CRDRES  
2 x IPAR-A-FSEHLD  
2 x IPAR-A-FSEHOU  
1 x IPAR-A-CRDUKM  
1 x IPAR-A-TERSUR  
1 x IPAR-A-TUBFIB

IASS-A-ROD-DRIVE, AW20016 Driver Assembly

1 x IPAR-A-DRIROD  
1 x IPAR-A-ROLCLU

IASS-A-PIVOT, Pivot Assembly with Bearings

1 x IPAR-A-PVTW30  
2 x IPAR-A-ROLBER



IASS-A-RODREL, Rod Release Pin Assembly

1 x IPAR-A-V-RODREK  
1 x IPAR-A-V-RODRPN

IASS-A-SURGE, AW20033-120 Surge Suppression

1 x IPAR-A-ABSBOX  
1 x IPAR-A-CRDNAM  
2 x IPAR-A-CRDRES  
1 x IPAR-A-FSEHLD  
1 x IPAR-A-FSEHOU  
1 x IPAR-A-TERSUR

## 14. RoHS and WEE compliance on Drader Injectiweld Products

|   |   |
|---|---|
|  | <p>Drader Manufacturing products that comply with the European Community directive 2002/95/EC in respect of the restriction of hazardous substances in electrical and electronic equipment. EU products will be marked with this RoHS symbol.</p>   |
|  | <p><b>Drader Manufacturing</b> is compliant with the European Community directive 2002/96/EC (Waste Electrical &amp; Electronic Equipment, WEEE) in respect to products sold within the European Union. This directive restricts that the disposal of electronic equipment and states that it has to be marked to indicate it is not to be disposed of in unsorted waste starting August 13, 2005. This marking has been added to Drader products sold in the EU.</p> |

## Declaration of Conformity - CE

**Application of Council Directives**

73/23/EEC    89/336/EEC    92/31/EEC    93/69/EEC

**Standards to which conformity is declared:**

|              |               |              |                |
|--------------|---------------|--------------|----------------|
| EN-50141     | EN-55014      | EN-55104     | CISPR 11/14/16 |
| EN-50082-1   | EN-10004-11   | EN-60-335-1  | EN-50081-1     |
| EN61000-4-2  | EN-61000-4-4  | EN-61000-4-5 | EN-60-335-2-45 |
| IEC-801-2    | IEC-801-3     | IEC-801-4    | EN61000-4-11   |
| IEC-1000-4-5 | IEC-1000-4-11 |              | IEC-1000-4-2   |

**Manufacturer's Name:** Drader Injectiweld Inc.

**Manufacturer's Address:** 5750-50 Street  
Edmonton, Alberta  
T6B 2Z8

**Importer's Name:** \_\_\_\_\_

**Importer's Address:** \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_

**Type of Equipment:** Plastic Welder

**Model Number:** W30000

**Date Approved:** June 24, 1997

We, the undersigned, hereby declare that the equipment specified above conforms to the above Directives and Standards.

Signature:   
 Full Name: Alfred Bitzer  
 Position: Production Supervisor

Signature:   
 Full Name: Gordon McTavish  
 Position: General Manager



