

OPERATING INSTRUCTIONS FOR LFW—1 and LFW—2

Mount the welder securely on a bench or clamp it in a vise. Plug the welder into the control box and plug the control box cord into a 3 wire grounded outlet.

Choose the die set you need for the job and mount it securely on the welder using the bolt and nuts and washers provided with the die.

Set the temperature control at the desired setting (see chart #1) and allow the die set to warm-up, up to 45 minutes according to die size.

When the proper temperature is reached you insert the pipe into the female end of the die and slip the fitting over the male end. When ready (see chart #2) remove pipe and fitting and shove them together in a straight motion.

*** CAUTIONS ***

Pipe should be beveled at a 15° angle. Always keep the die sets as clean as possible. The dies are coated with Ryton for easy release and should be wiped with a cotton cloth.

BEWARE—The dies are hot and the hot plastic material can cause serious burns—**WEAR GLOVES**.

Pipe and fittings must both be set **SQUARELY** on the dies and the fitting must also be fitted squarely on the pipe as soon as possible after taking them off the die.

DO NOT OVERHEAT AND KEEP THE DIES CLEAN:

CHART #1 — CONTROL SETTING

	1/2" to 1" 16mm to 40mm	1-1/2 to 2" 50mm to 63mm	3" to 4" 75mm to 110mm
POLYPROPYLENE	5.5	6	6.5
KYNAR or SYG—EF	6	6.5	H

These settings and times are a guide and should be adjusted with working conditions (indoors or out) and with ambient temperatures.

CHART #2 — HEATING TIMES

	1/2" to 1" 16mm to 40mm	1-1/2" to 2" 50mm to 63mm	3" to 4" 75mm to 110mm
POLYPROPYLENE	30 Sec.	60 Sec.	75 Sec.
KYNAR or SYG—EF	40 Sec.	75 Sec.	90 Sec.

ABBEON CAL, INC.

800.922.0977 805.676.0720 WWW.ABBEON.COM
1363 DONLON STREET UNIT 1, VENTURA CA 93003-8387

