

# Automatic welding machine type BELTON P

## OPERATING MANUAL



## SAFETY

**Danger to life**

Unplug the tool before opening it as live components and connections are exposed.



**Danger of fire and explosion** in case of incorrect use of the automatic welding machine, especially near combustible materials and/or explosive gases.

**Danger of burns**

Allow the tool to cool down.



Connect the tool to a socket outlet with protective earth conductor. Any interruption of the protective earth conductor within or outside the tool is dangerous! Use only extension cables with a protective earth conductor.



The **voltage rating** stated on the tool should correspond to the mains voltage.



For personal protection, we strongly recommend to connect the tool to a **RCCB** (Residual Current Circuit Breaker) before using it on construction sites.



**Do not leave the tool unobserved.** The tool must not be used by children or people with limited physically, sensory or mental ability. Children must be supervised to prevent that they play with the tool.



**Protect the device from damp and wet!**

## WARRANTY AND LIABILITY

Warranty and liability apply from the date of purchase (documented by the invoice/delivery note) according to the currently valid general terms of business from BAK. BAK refuses to honour any warranty for devices which are not in their original condition. BAK devices may never be reconfigured and/or modified.

BAK reserves the right to deny any responsibility if this is ignored. No liability can be assumed by BAK for incorrect installation and/or use as well as natural wear and tear of components (e.g. heating elements).

**Note:**

This operating manual must be available to the installation and operating personnel at all times. Read those operating instructions carefully before installing and using the device.

**Copyright:**

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## **INTENDED USE**

The BeltOn is a welding machine to weld on tapes (tape size 50 to 150mm) and profiles. The tool is suitable to weld tapes and profiles made from PE, PVC, TPO, ECB, EPDM, CSPE and bitumen.

The welding machine BeltOn is manufactured according to the latest technology and in compliance with safety requirements.

Any improper use may result in danger for the operator or third parties or may adversely affect machines and assets.

Only use the automatic welding machine if in technically perfect condition and for the purposes for which they are intended while observing the operating instructions.

The tool can be used for the applications mentioned in the present operating instructions only!

### **Stop operating the automatic welding machine if:**

- Connecting line or plug have been damaged
- Safety installations have been damaged
- Changes occur in the operating state

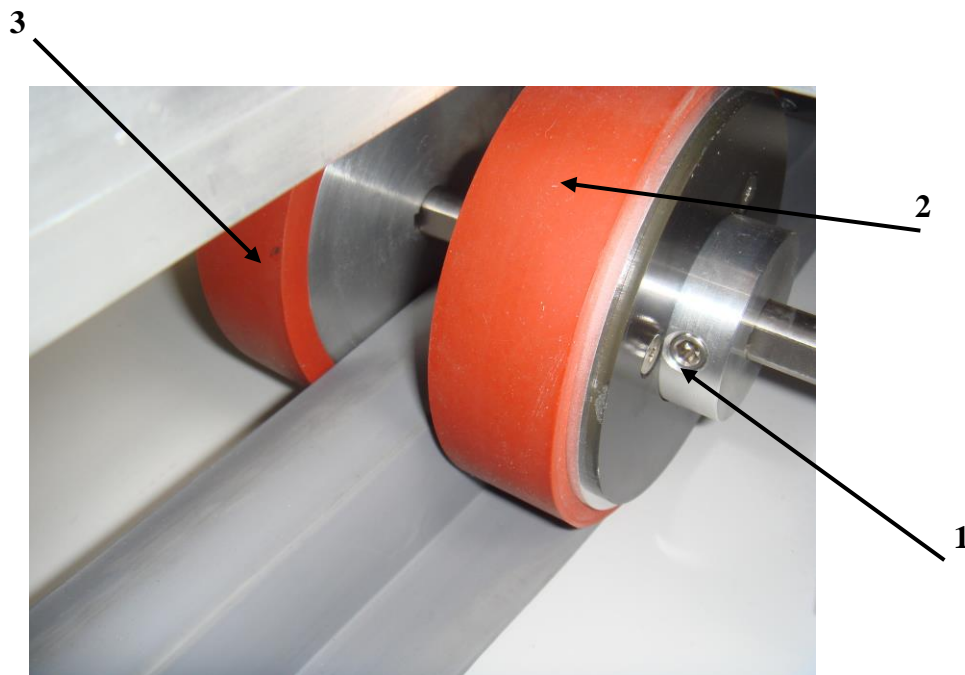
## **EXTENSION CORDS**

When using extension cords the minimum diameter of cables must be observed.

Extension cords must be approved and marked for their place of utilisation.  
Before operating the machine examine the tool adjustment.

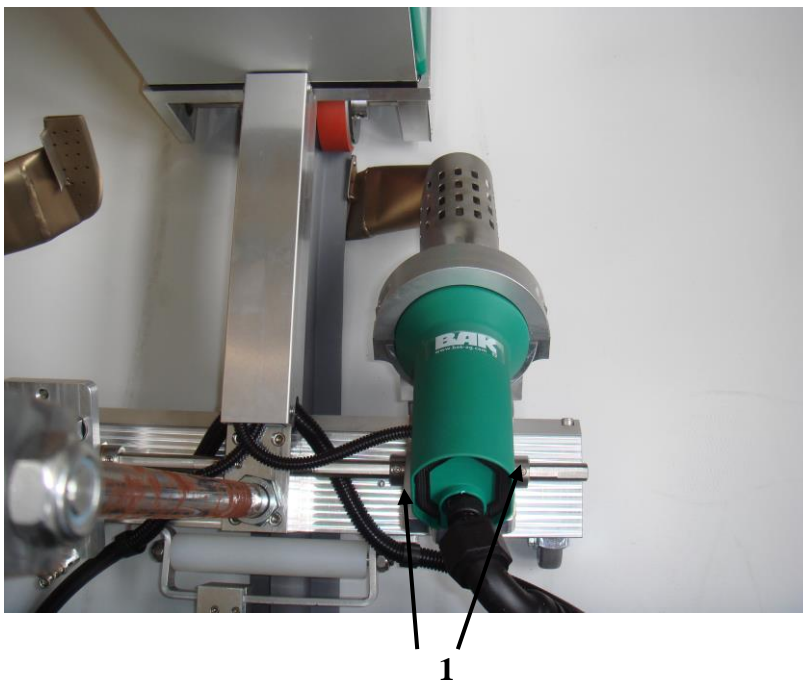
**Proceed with adjustments only in cold condition (burn danger).**

## PRESSURE ROLLER ADJUSTMENT



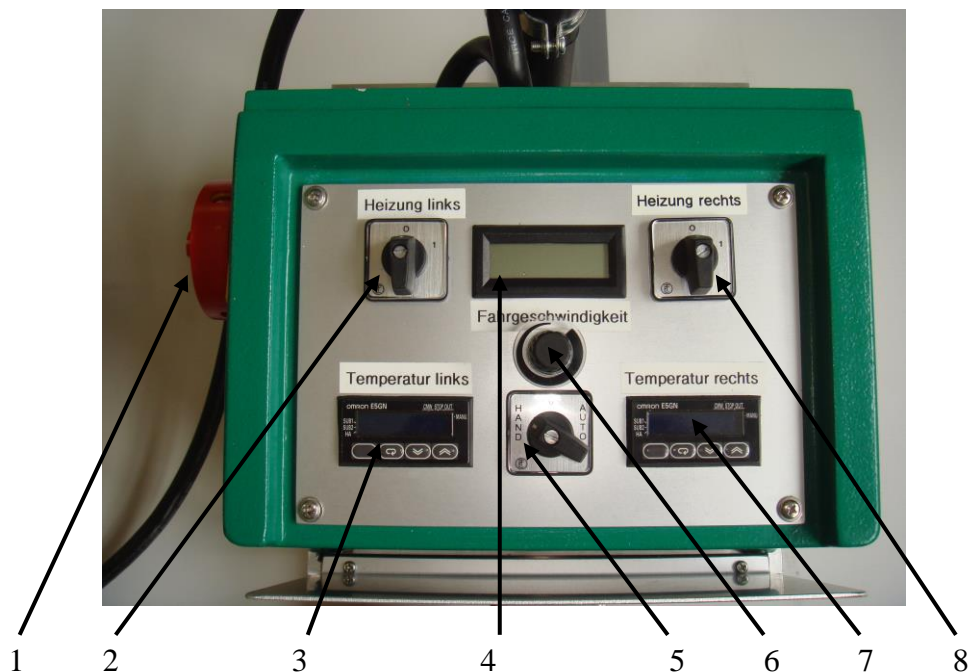
Release the head cap screw (1). Adjust the pressure rollers (2 und 3) to the profile or the tape to be welded. Afterwards tighten the head cap screw (1).

## NOZZLE ADJUSTMENT



- The distance between the two nozzles should correspond to the profile/tape width.
- Changes on the nozzle adjustment can be done by using the clamping rings (1) on both sides of the clamp of the hot air tool.

## START UP OF THE WELDING MACHINE



### **Before connecting the tool to the mains supply please check, that:**

- the main switch is in position 0 OFF.
- drive switch (5) is in position 0.
- heating switches (2 and 8) are in position 0.
- the hot air tools are in position: stand by (lifted up).

### **After:**

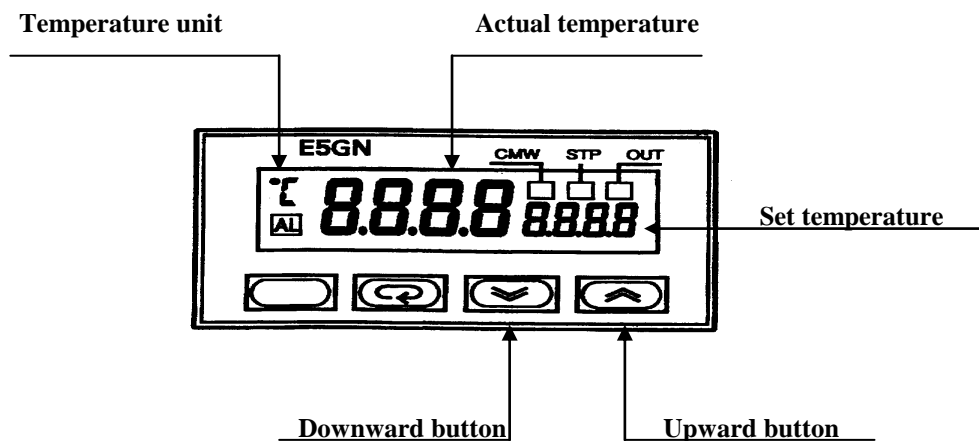
- Connect the tool to the mains.
- Switch the main switch (1) to position 01 ON.
- Turn the heating switches (2 and 8) to position ON.

The tool now heats up to the last selected set temperature.

To change the set temperature, check the section of the controller adjustment.

To get a constant quality of the welding seam, adjust the same set value on both controllers (3 and 7).

## CONTROLLER ADJUSTMENT



Select on the potentiometer (6) the desired welding speed.

### Switch driving speed (5):

In position ON the drive motor starts immediately and keeps running.

In position AUTO the drive motor only starts if at least one nozzle is in welding position and stops after the nozzle has been slide out.

- After finishing the welding slide out hot air tools and let them cool down.
- To separate the automatic welding machine from the electric system, turn the main switch to position „OFF“ and unplug the mains plug.

## MAINTENANCE

- Clean the nozzles with a wire brush (5201330) at the end of a working day.
- Clean the drive/pressure rollers with a wire brush.
- As required, treat the chain with a suitable spray.
- After use, always check that the mains cable and plug are not damaged.

## **ASSISTANCE AND SUPPORT**

The BAK group and its authorised service centres offer free support and assistance in the area of applications technology.

Our specialists will be pleased to help you.

### **Customer service and orders:**

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## **ACCESSORIES**

Get the best results by using BAK-accessories and spare parts.

Further information can be found in our brochures.

## **SERVICE AND REPAIR**

Repairs should only be carried out by authorized BAK service centres. These guarantee a professional and reliable 24-hour repair service with original spare parts. A heating element can be changed by qualified personal.

If the mains connection of the device is damaged, it should be replaced by the manufacturer, from an authorized BAK service centre or a qualified person to avoid danger.

## **SHIPPING**

For repairs, please return the device appropriately packed for transport to your next BAK service centre.

### **Shipping to CUSTOMER ACCOUNT.**

Technical modifications reserved. In case of doubt, consultation with BAK is required. Images and drawings may deviate from the original. Changes reserved.

## TRANSPORT – HANDLING – STORAGE

### Transport:

The welding machine is packed appropriately and must be protected from moisture.

### Handling:

The shipment must be checked if complete and for transport damage. In the event of transport damage, the defect must be confirmed in writing at the time of the delivery by the carrier. The seller must be promptly informed in writing!

### Storage:

In the case of temporary storage, the welding machine should be kept packed and must be protected from moisture. In the case of damage resulting from improper storage, no warranty claim will be honoured.

## DISPOSAL



Power tools, accessories and packaging should be sorted for environmental friendly recycling.

**Do not dispose power tools together with household waste!**

Only EU countries: According to the European Directive 2002/96/EC on waste electrical and electronic equipment and its incorporation into national law, power tools that are no longer operational must be separately collected and sent to be environmental friendly recycled.

## TECHNICAL DATA

Technical Data		BeltOn P
Voltage	VAC	400
Frequency	Hz	50 / 60
Power consumption	W	max. 6400
Temperature	°C	20 – 620, stepless adjustable
Drive	m/min	0.5 – 24, stepless adjustable
Weight	kg	39
Size LxWxH	Mm (LxBxH)	900 x 530 x 340
CE	CE	
Protection of class 1		

Technical data are subject to change without prior notice.