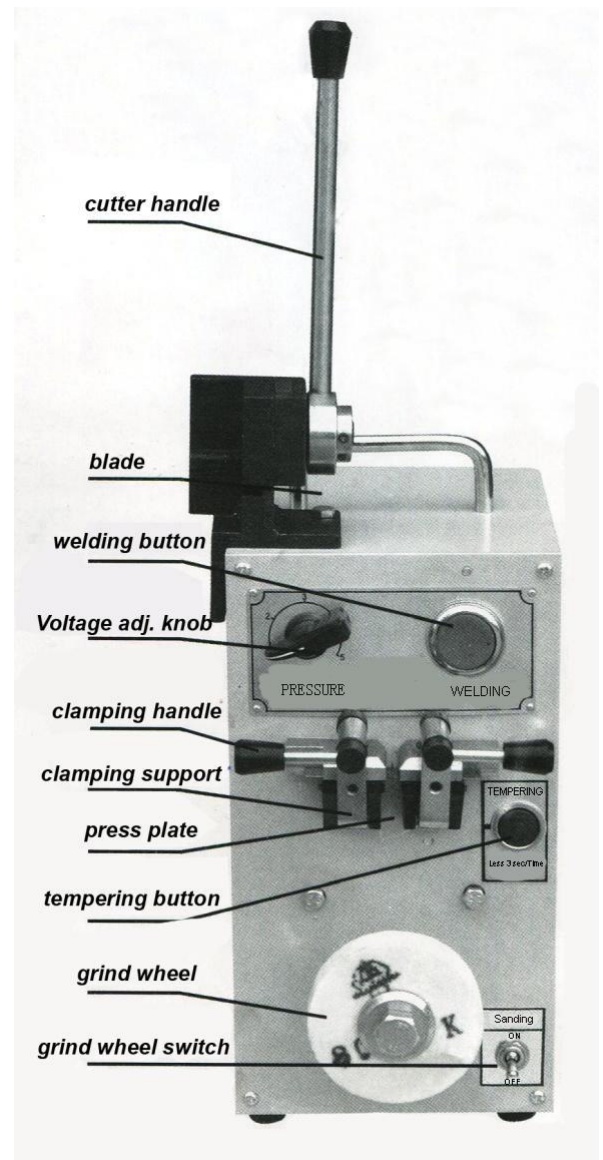


Blade Welding machine Manual

Operation instruction:

1. Prepare before welding
 - a. Cleaning the blades and cut the two ends straight with the cutter. Use grinding wheel deburring the ends if necessary.
 - b. Put the blade ends on the clamping points separately, and make sure the two ends contact closely. Then, turn the clamping handles to outsides and lock the electrode to blades.
 - c. Adjust voltage knob according to the blade thickness. The more thickness, the higher voltage (Turn the knob clockwise for higher voltage). The normal setting is 4 position.
2. Welding operation
 - a. Use your Thumb to press the Welding Button, then blade change to Red color and activities electrode driven the blade feed for welding. Please do not release the Weld Button during the welding until the blade back to black color.
3. Tempering operation
 - a. Press the tempering button until the welding points begin to appear red color. Then, after the blade back to the normal color, do the previous action again. Repeat this pressing 5-7 times. Please do not keep pressing over 3 seconds each time. Before tempering, please release the two clamping points first, then re-fix them in 1.b step.
4. Weld dressing
 - a. Turn the clamping handles in vertical

position and take blade out. Start the grinding wheel to polish the over parts. Then, the blades can be reused.



Pic. 1

Maintenance and trouble shooting

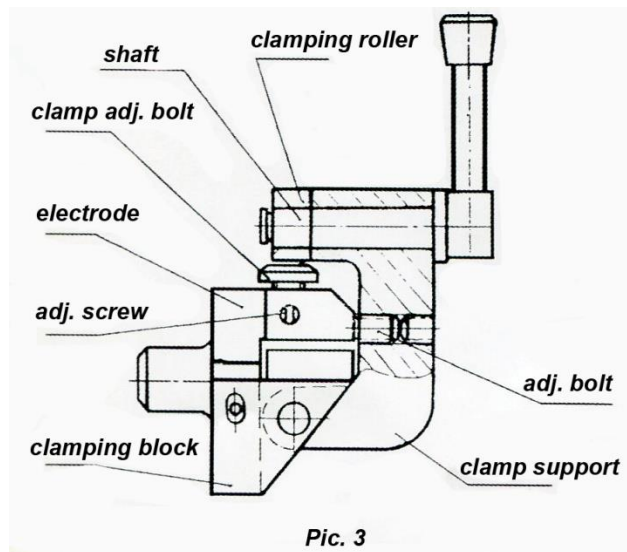
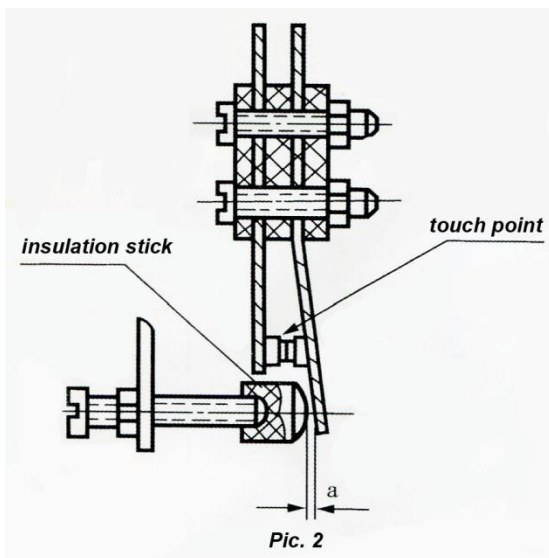
1. Maintenances

- a. put the voltage adj. knob back to mark of “i” when the machine is not working
- b. after half hour working, the machine can only be continue to work when the temperature is lowing down to the ambient temperature

2. trouble shooting

If the cut welding is not work, then open the panel, removal the switch of cut welding according to picture 2, polish the touch point by sand cloth,, then put on the switch of cut welding again, at this time, the insulation stick should jack-up the switch of cut welding, separate the second touch point. According to the time of welding needed to adjust the distance A. The bigger distance in A, the longer time for welding melt.

Trouble	Possible Reason	Solution
Welding seam broken	<ul style="list-style-type: none"> a. Blades welding end is dirty b. Not proper welding voltage c. Two ends is not align d. Two ends do not melt at the same time. 	<ul style="list-style-type: none"> a. Cleaning the blades with clothes. b. Increase the welding voltage. c. Align the blade Two ends. d. Adjust the “adjusting screw” in the clamping plate, to align the center of clamping roller and the bottom bolt.



Trouble	Possible Reason	Solution
Blade do not melt	<ul style="list-style-type: none"> a. Blade two ends is not straight and flat b. Electrode is broken or worn. c. Cut welding switch not work d. Blade two ends do not contact. e. Blade clamping points have rust. 	<ul style="list-style-type: none"> a. Cut the two ends straight and flat. b. Repair the electrode. c. Polish the touch points of the switch by sand cloth. d. Re-cut the blade two ends. e. Remove the rust by sand cloth.

Blade cannot clamp tightly	The distance between the clamping roller and bottom bolt is big.	Adjust the "adjusting screw" in the clamping plate, to align the center of clamping roller and the bottom bolt.
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