



PLASTIPACK LIMITED

Manufacturers of Energy and Resource Saving Products

Pfaff Welding Guide

18/08/2020 V4

Pinch lever

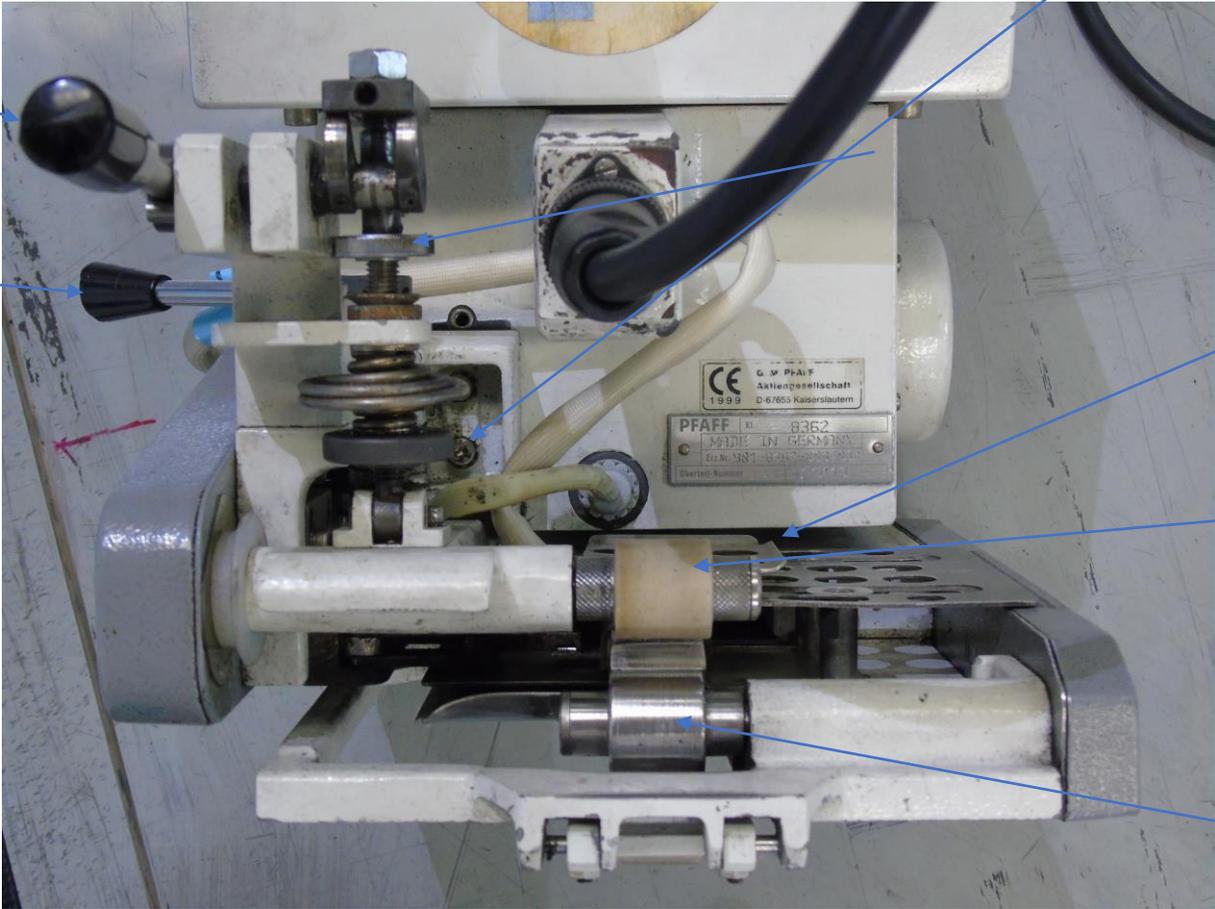
Drive Lever

Pinch adjustment

Material guides

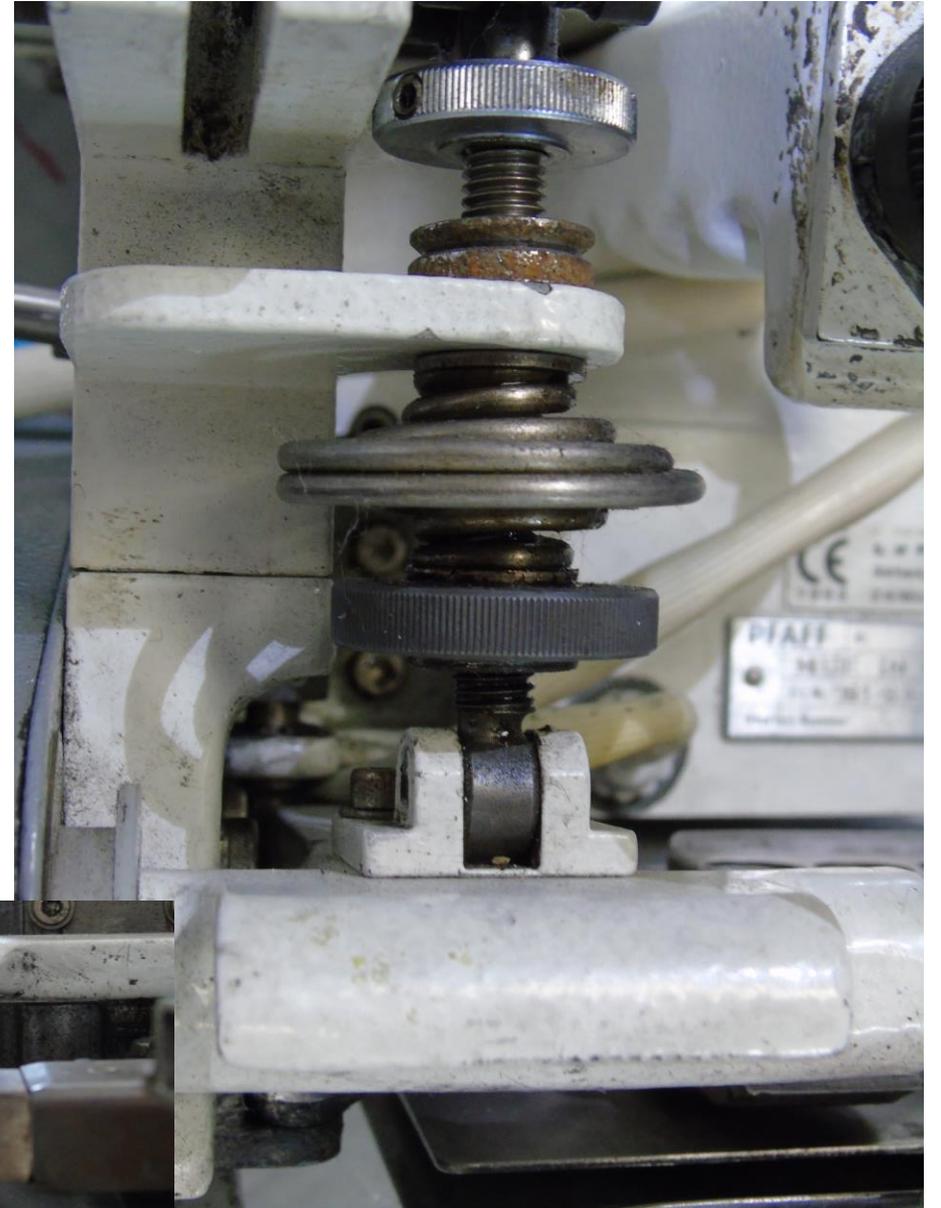
Drive roller (silicon)

2nd roller (steel)

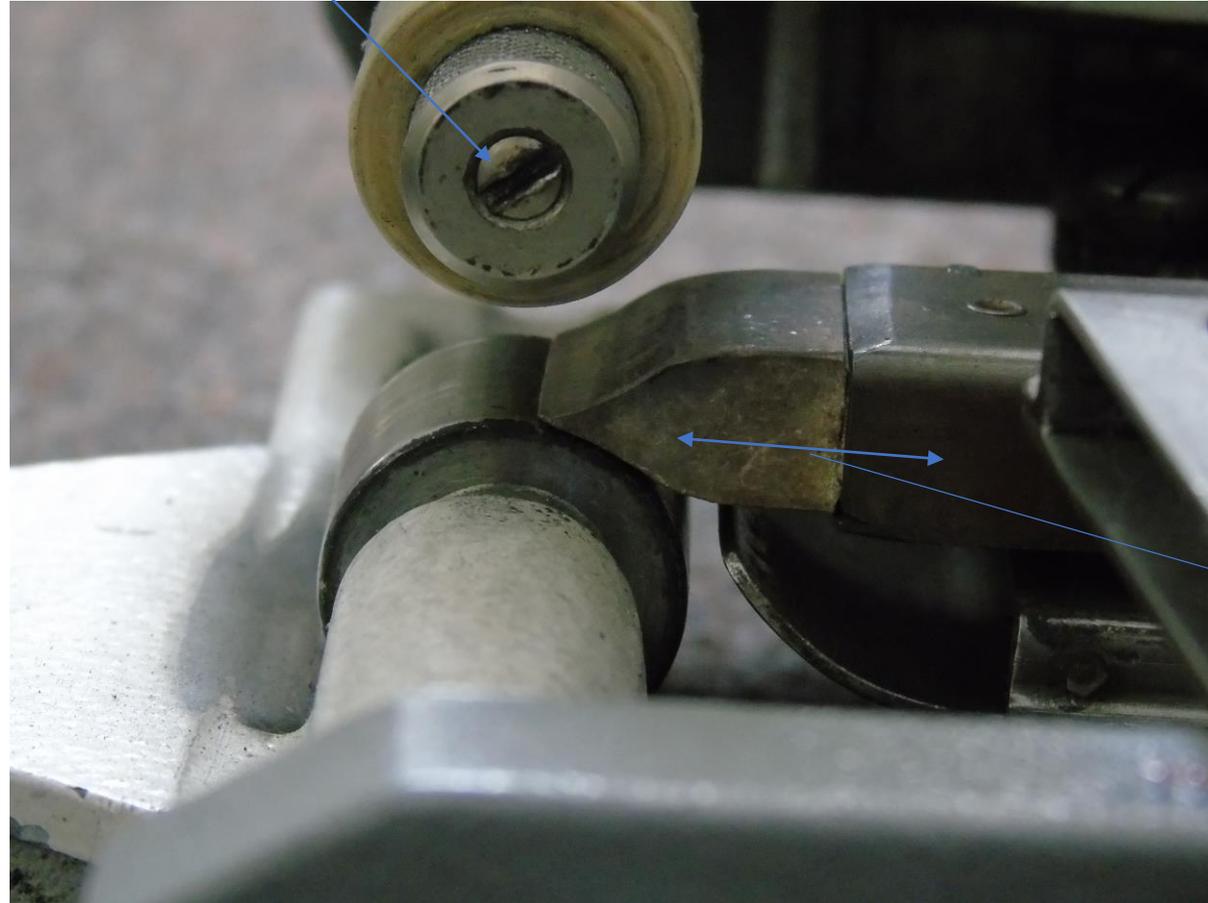


Pinch Settings

- The pinch adjustment should allow enough pressures for a piece of paper to be able to be pulled between the rollers without ripping but enough pressure to allow for a piece of paper to be held securely between the rollers.



This screw controls the tension of the drive roller if this is too tight it produces drag that effect as it works as a potential

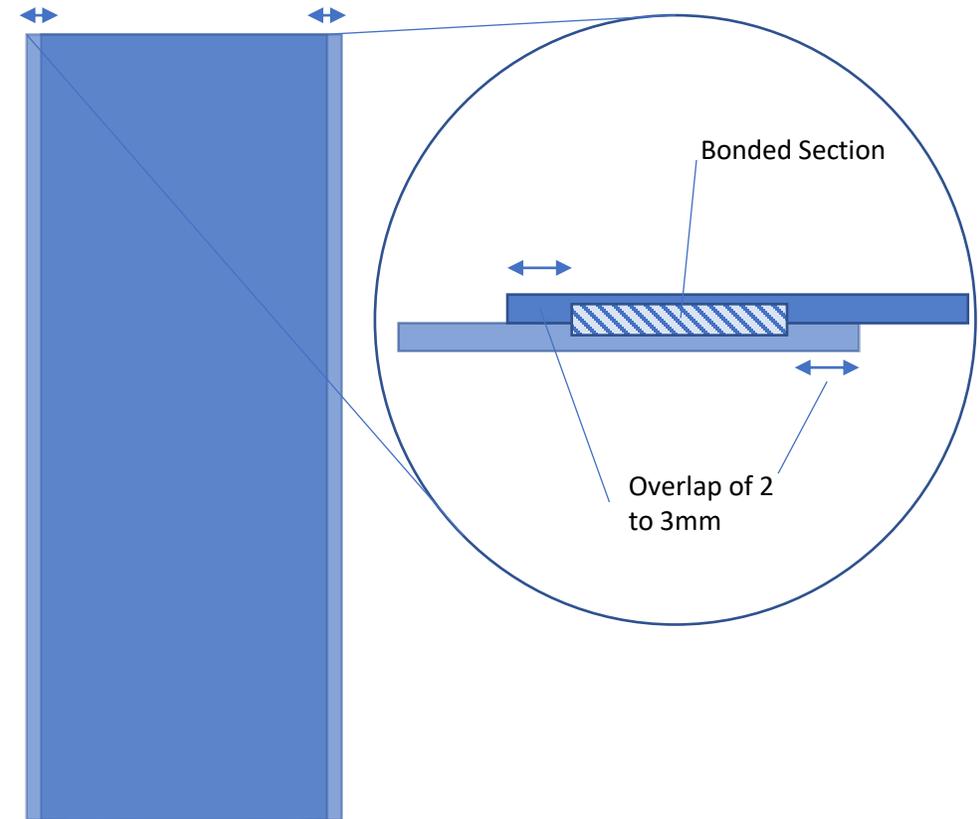


The wedge can move forward and back to allow for readjustment as it wears. To far forward and it will work as a brake. To far back and it will impact the bonding of the material. As the wedge is used it will require occasional cleaning and reshaping.



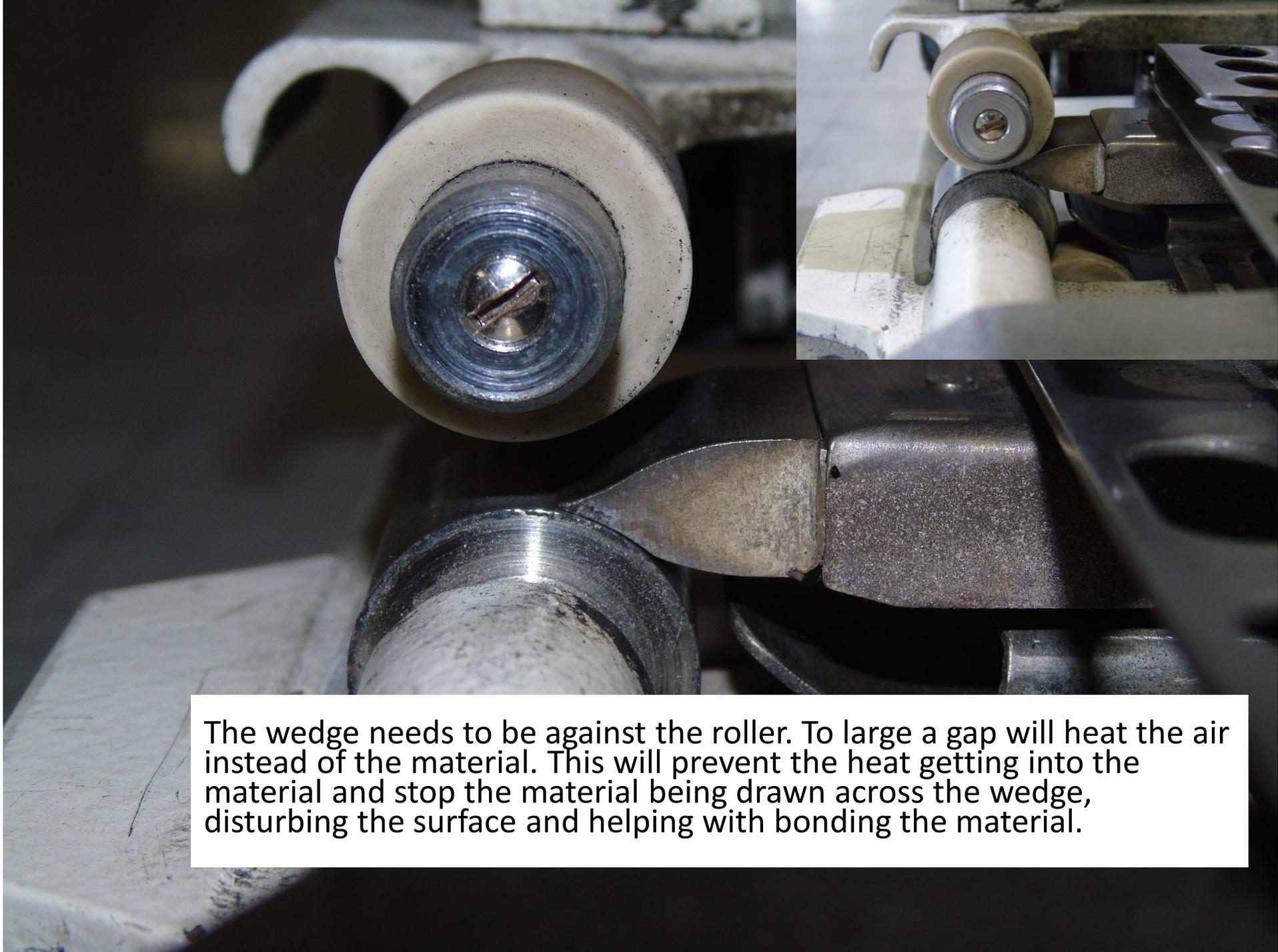
Upper Guide adjustment

Lower Guide adjustment



Bonded Section

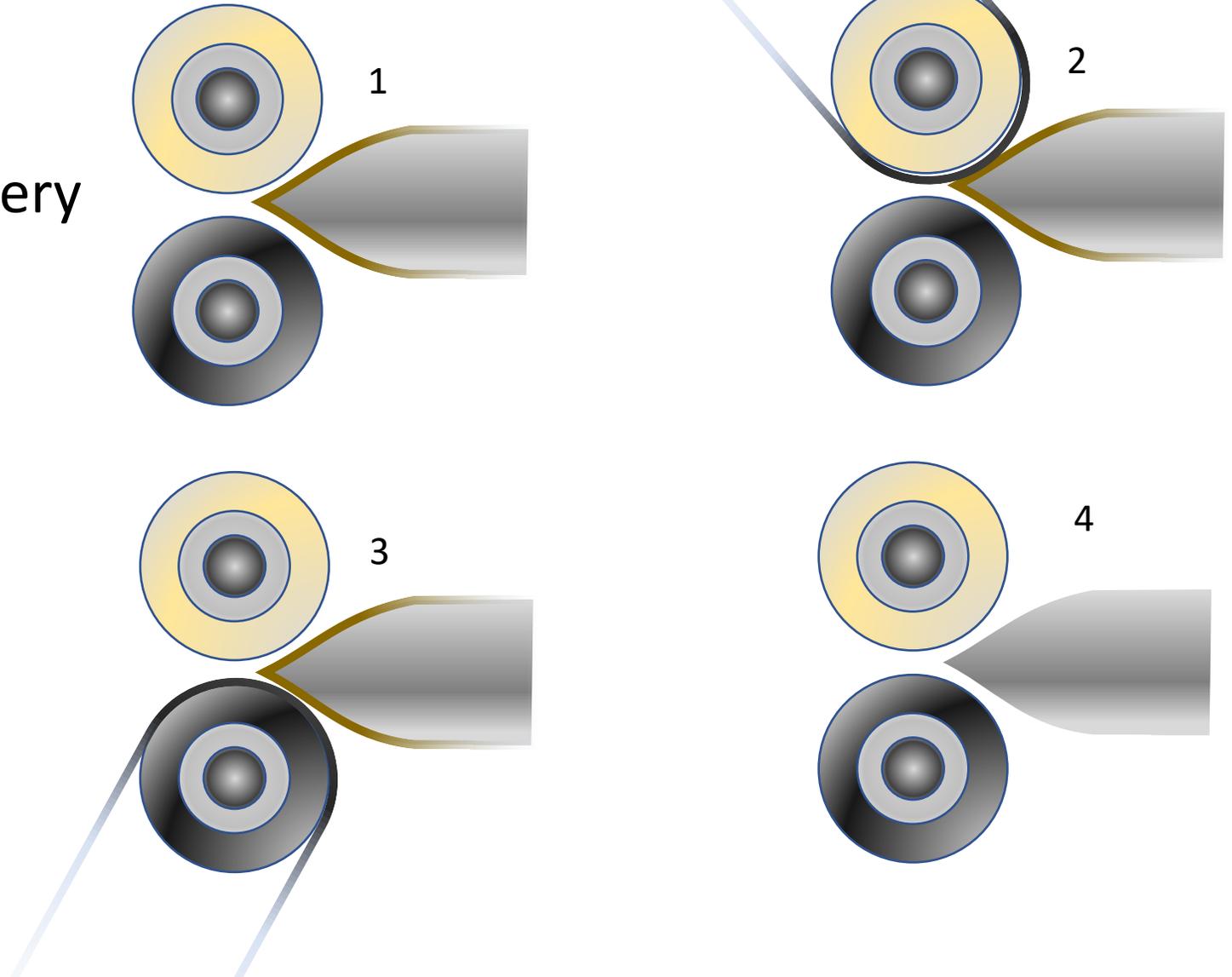
Overlap of 2 to 3mm



The wedge needs to be against the roller. To large a gap will heat the air instead of the material. This will prevent the heat getting into the material and stop the material being drawn across the wedge, disturbing the surface and helping with bonding the material.

Pfaff cleaning and shaping the wedge

- When the Pfaff requires shaping. Create a loop of emery tape around each roller with the wedge engaged.
- This will clean and shape the wedge ready to continue welding.

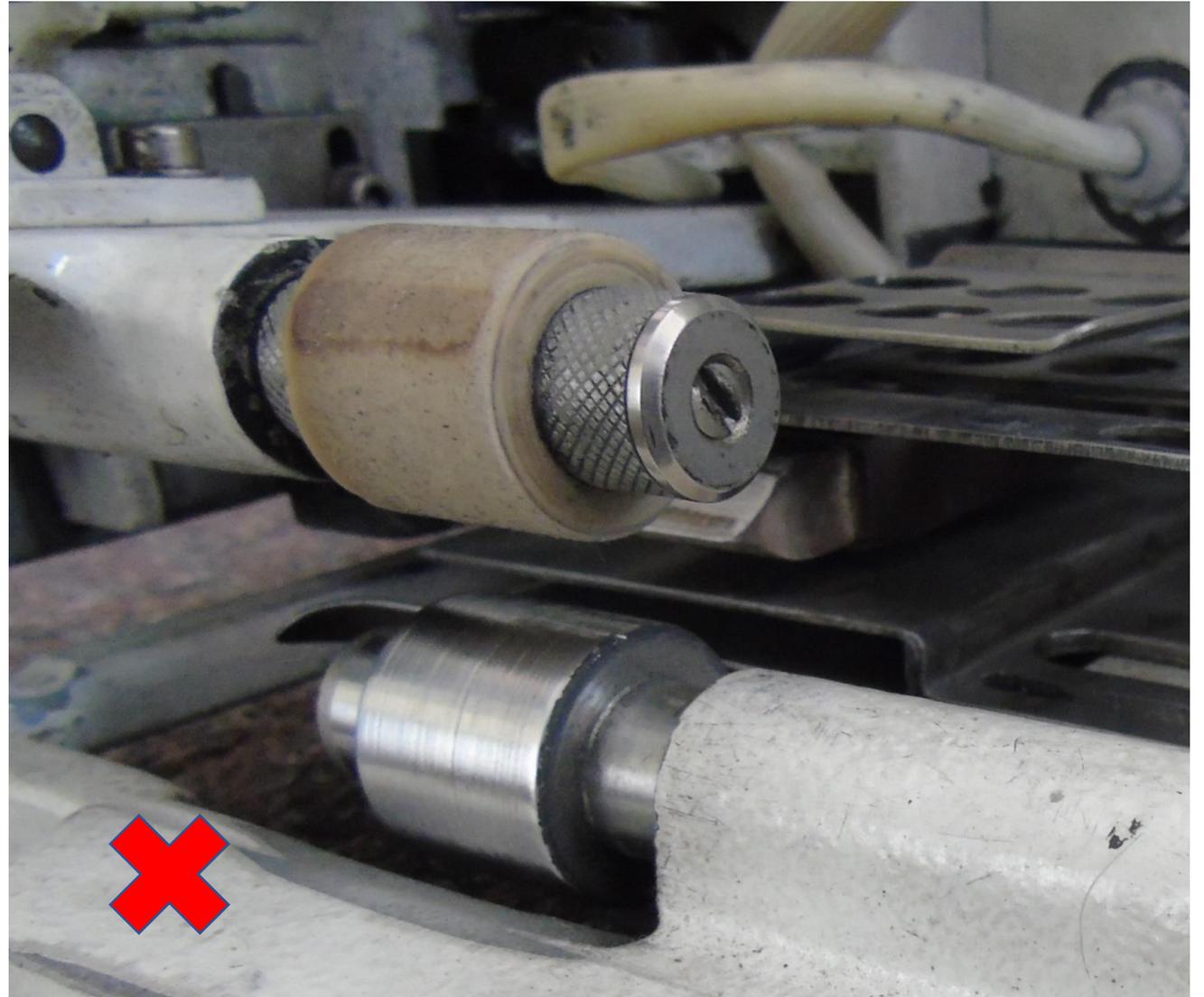


Always disengage the roller and the wedge.

This prevents the wedge from burning the silicone roller and prevents excess build up on the wedge

When the machine is not in use the pinch must be disengaged to prevent the silicone roller from being compressed.

Marks or a compressed roller will cause an intermittent mark across the weld.



Plastipack Suggested Pfaff Welding Settings

Grade	Temperature °C	Line Speed	Rollers Top/bottom
200	470	90	Rubber / metal
300	470	100	Rubber / metal
400	480	100	Rubber / metal
500	480	100	Rubber / metal
600	490	90	Rubber / metal
VapourGuard	440	50	Rubber / metal
Weave	490	90	Gripping / metal

It is recommend when welding materials with a laminated weave to replace the silicon roller with a textured metal roller to provide extra grip on the material.

<https://www.youtube.com/watch?v=jEFRDPZCIsM> PFAFF welding video

Useful Accessories

Festoon system:

For large cover production festoon systems are a neat solution for cable management. A festoon system consists simply of mobile hangers on a suspended trackway that can move the welder's power supply cable as the welder moves below during welding.

This has the added advantage of preventing the wire from producing drag on the floor that may slow it down while welding long lengths of material.

[Festoon system link](#)



Eyelets:

When using eyelets metal can often rust and pit while on the pool. A good solution can be the use of clear plastic eyelets. It is important to ensure that the eyelet neck will be tall enough to provide a secure permanent fitting even through the bubble. Eyelets are secured with the use of a hand press that applies pressure to the two eyelet sections to permanently connect the two sections.

[Link for eyelets and hand presses](#)



Clip attachment:

If eyelets are not desirable or you wish remove or relocate the clips when needed. There is a kind of clip known as a "holdon clip" that is a removable reusable solution that provides a strong attachment without piercing the material.

[Holdon clip link](#)





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Thank you

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