HOLO

Cleat Welding Machine

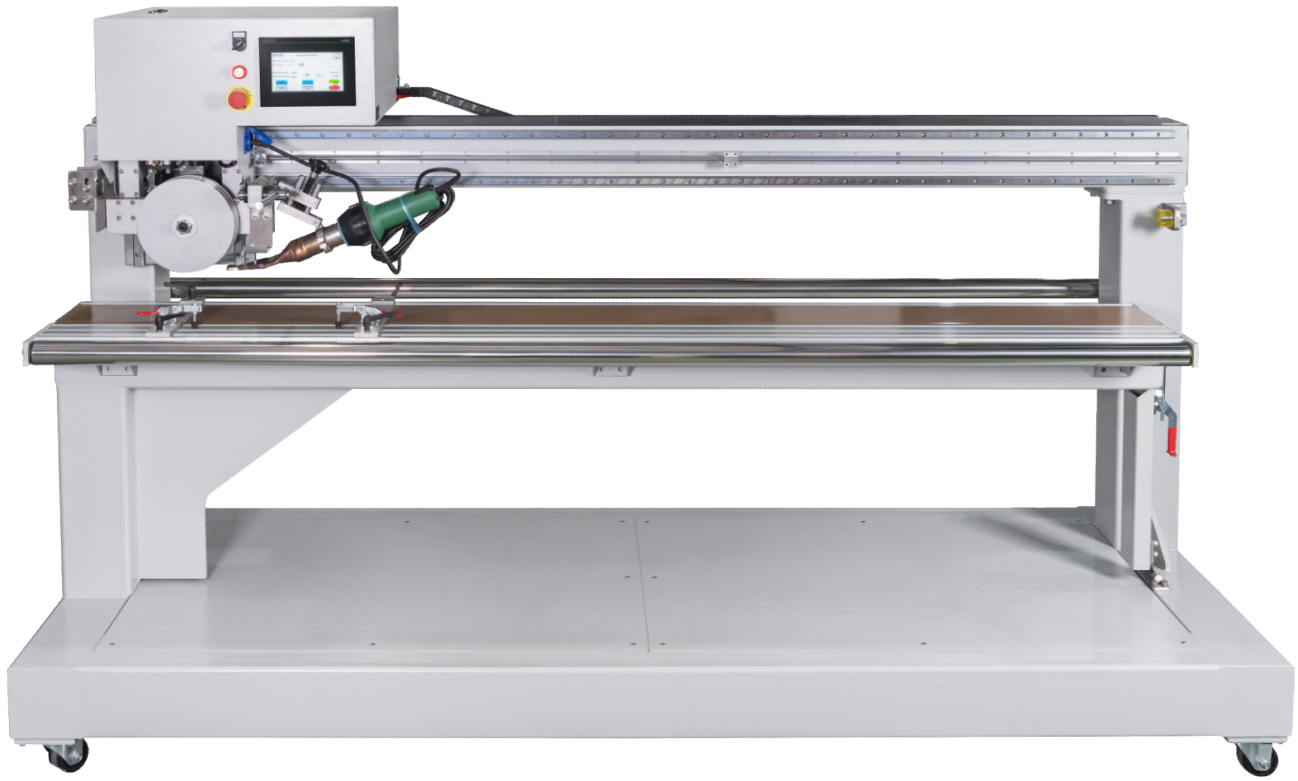
Safety & Operations Manual

Precautions

Improper or unsafe use of this appliance can result in serious bodily injury! This manual contains important information about the functions and safe operation of the product. Any operator or equipment owner should carefully read the methods provided in this manual. Before operating the tool, make sure you have fully understood this manual. Please store this manual, whether in paper or electronic format, in case you can consult it at any time.

Cleat Welding Machine Manuals

Be sure to read and fully understand the components and detailed operation of this device. Make sure that the equipment you use meets your requirements, including length, voltage, specifications, etc.



Precautions:

This equipment uses 1phase 220V electricity and requires an air compressor to supply pressure.

Main Components:

Working Panel, Rack and Pinion Slide Module, Press Unit, Welding Unit, Workbench, Locking Mechanism, Casters

Technical Parameters:

Machine Model	Cleat Welding Machine 2M	Cleat Welding Machine 3M
Power	5.5KW	
Voltage	Single phase 220V	
Belts	PVC，PU belt	
Maximum Welding Speed	2m/min	
Thickness of Belt	2-10mm	
Effective Width	2000mm	3000mm
Air Heating Gun Power Suggest	3.4KW	
Machine Size（mm）	Length 2600 * Width 900 * Height 1600	Length 3600 * Width 900 * Height 1600

Catalogue of instructions

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Primary safety rules

It is important to remember these rules

Safety sign description

"Danger" indicates an imminent danger situation.

If not avoided, it will result in death or serious injury.

This identification is limited to the most extreme cases in which it is marked.

"Warning" identifies a potentially dangerous situation.

"If not avoided, it could result in death or serious injury.

"Attention" identifies a potentially dangerous situation.

If not avoided, it may result in minor or moderate losses.

It can also be used to be alert to unsafe behavior.

In the process of reading, please pay attention to the details, and judge the situation.

Security identification

This is a safety sign recognition system that has attracted international attention Related to the correct use of equipment and personal safety!

Safety information

In order to avoid serious personal injury or property damage, please read and fully understand the following safety measures.

Overall preview of safety rules

Warning

The hot air gun generates intense heat. Never touch the nozzle or direct the airflow towards skin.Always be aware of the gun's orientation and maintain a safe distance during use.

Warning

The operator's hands and other parts of the body should be outside the guide wheel, otherwise it will cause serious personal injury.

Attention

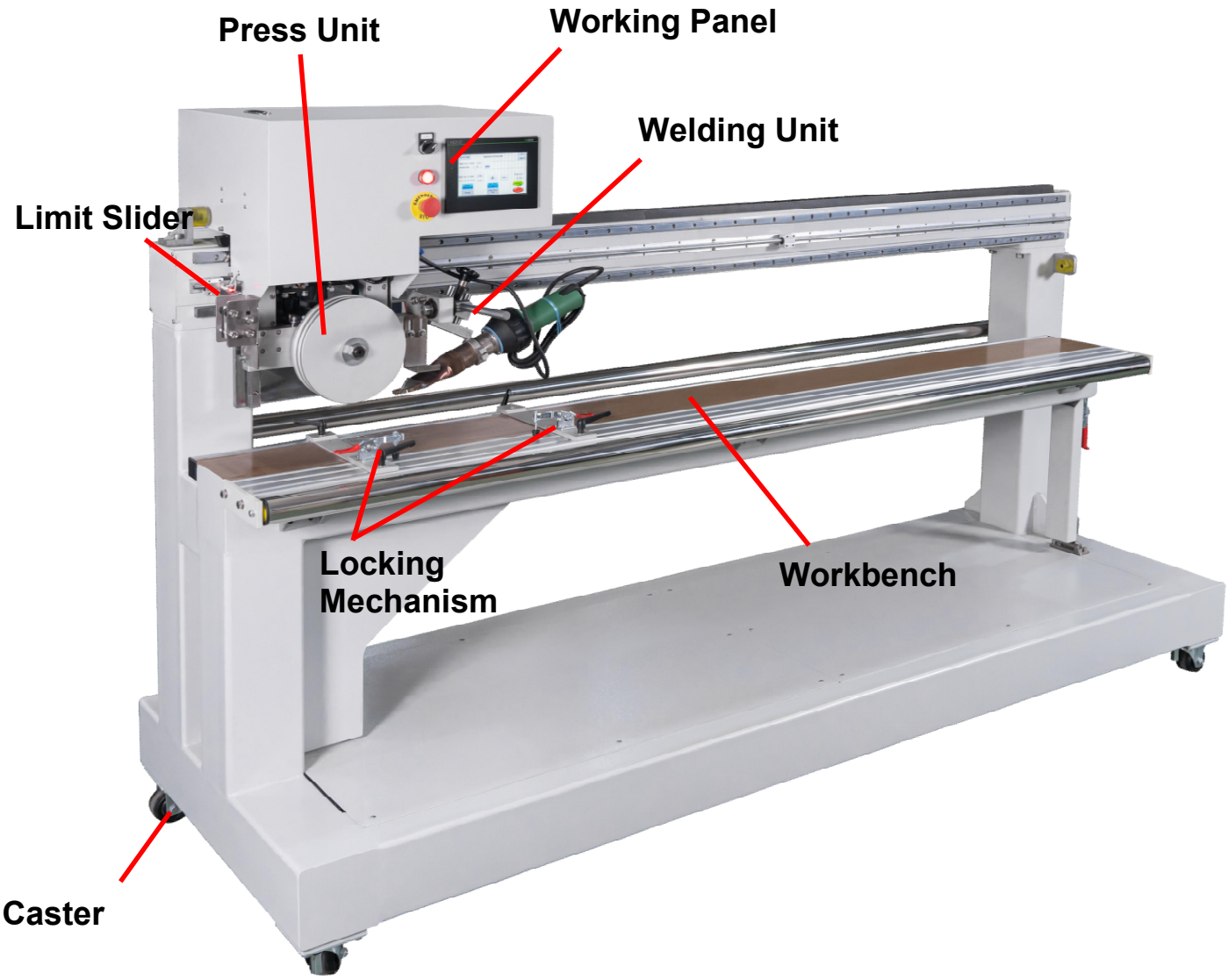
Please keep your work area clean and well-lit. A cluttered and dimly lit workbench can easily lead to accidents.

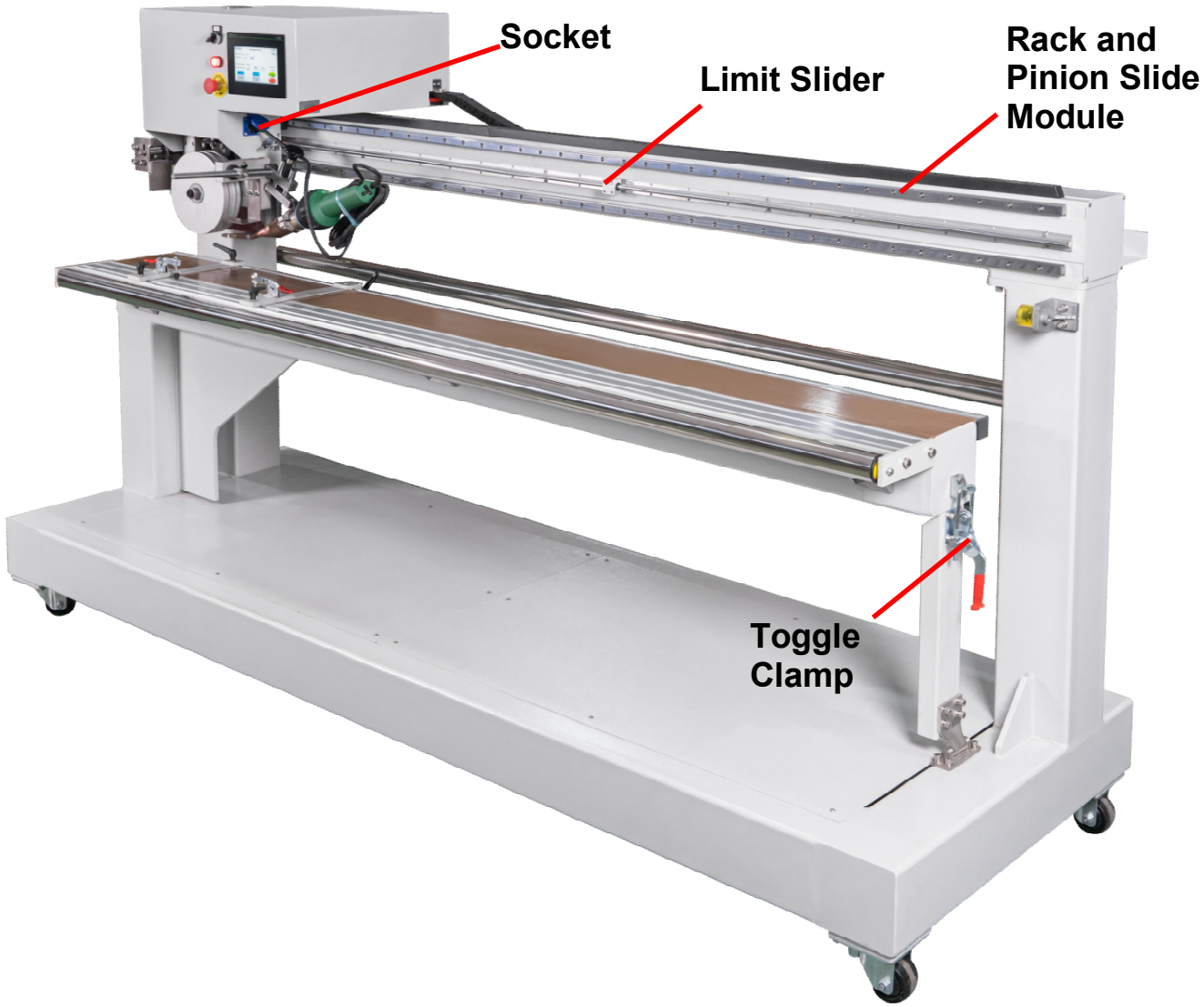
Warning

The high-temperature airflow can cause severe burns and poses a risk of fire or explosion. Maintain a safe distance from all flammable substances.

Main component

This manual will mark the key parts of the equipment in the following Picture in detail. If you do not know the position or the position is not explained in the operation, please refer to the following note Pic for understanding. Familiarity with the parts is helpful for operation.

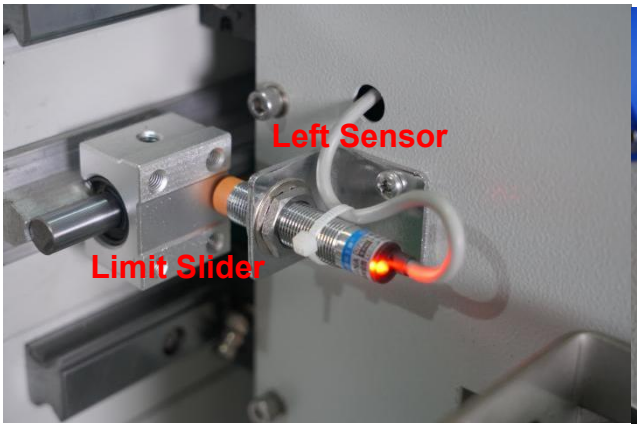


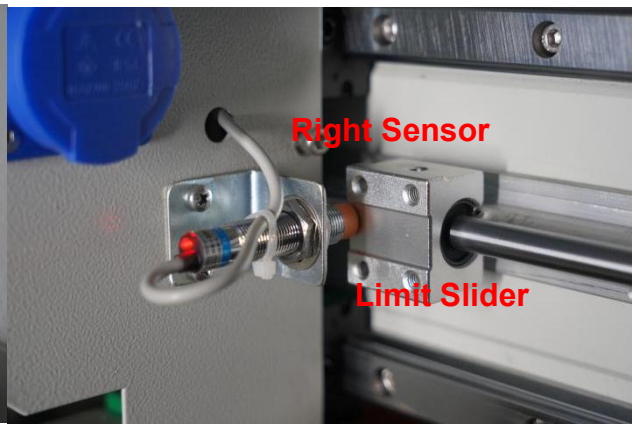

Socket
Limit Slider
Rack and Pinion Slide Module
Toggle Clamp

Safety & Operations Manual

1.Inspection and preparation of the machine

1. Check the position of the limit sliders at both ends of the gear rack sliding module and adjust the slider positions to the required locations.

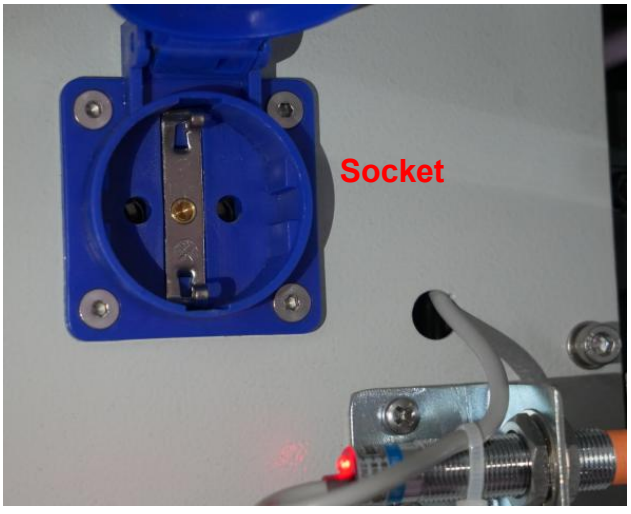




You can use Jog button on the touch screen to move the position of the whole press unit.

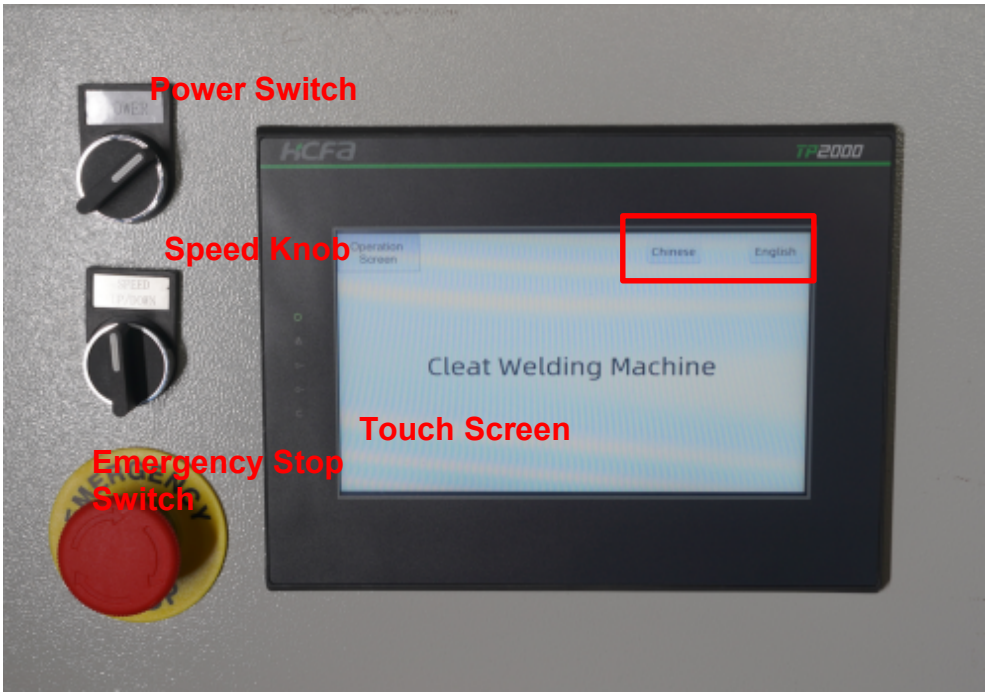
2. Check that the clamp on the machine's right side is secure.If you need to work on the endless belt, first release the toggle clamp. Then, pass the belt through the work area, and lock the clamp.

3. Connect the power and the air pipe and adjust the air pressure to 0.4-0.6 MPa. Connect the air heating gun to the socket on the machine.

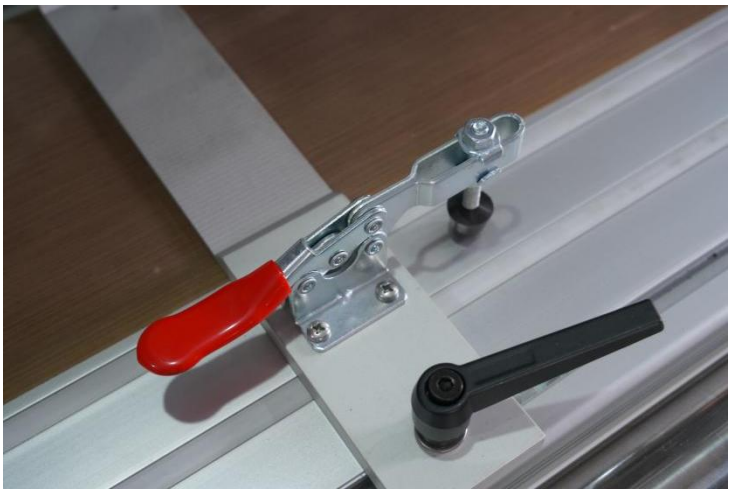


2. Adjustment before operation

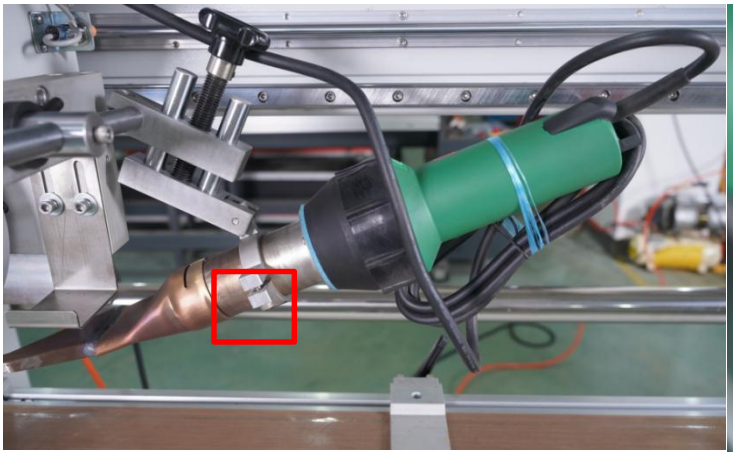
1. Turn on the power switch. Select the operating language on the upper right corner of the touchscreen.



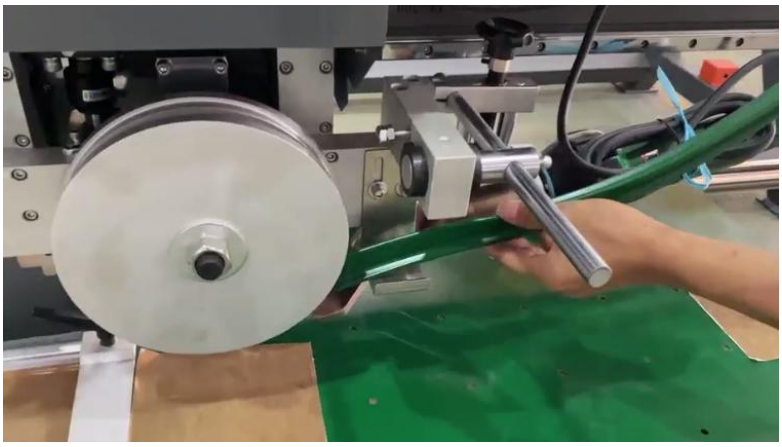
2. Load the belt and align to the calibration edges, use the locking mechanism to fix the belt.



3. Loosen the locking screw of the air heating gun and mount the air gun onto the adjustable stand. Turn on the air heating gun and set it to the lowest level. (The smaller the number on the knob at the back of the heat gun, the lower the temperature of the hot air. The air heating gun produces cold airflow at the lowest level.)



4. Place the cleat under the guide wheel.

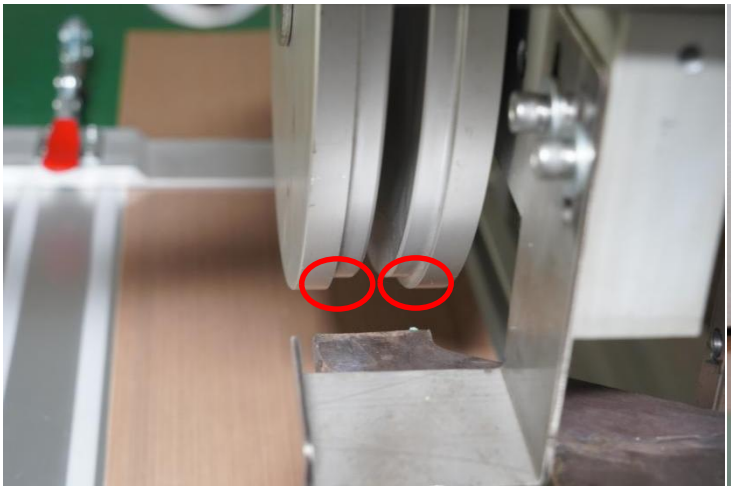
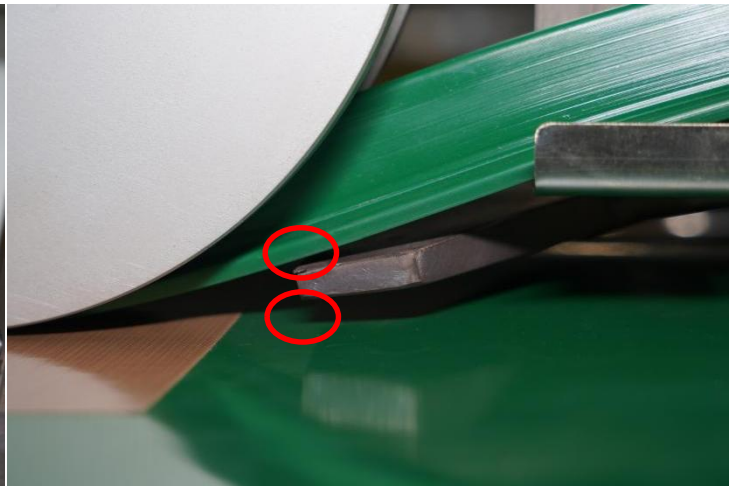


5. When adjusting the position of the air heating gun, please note the following points:

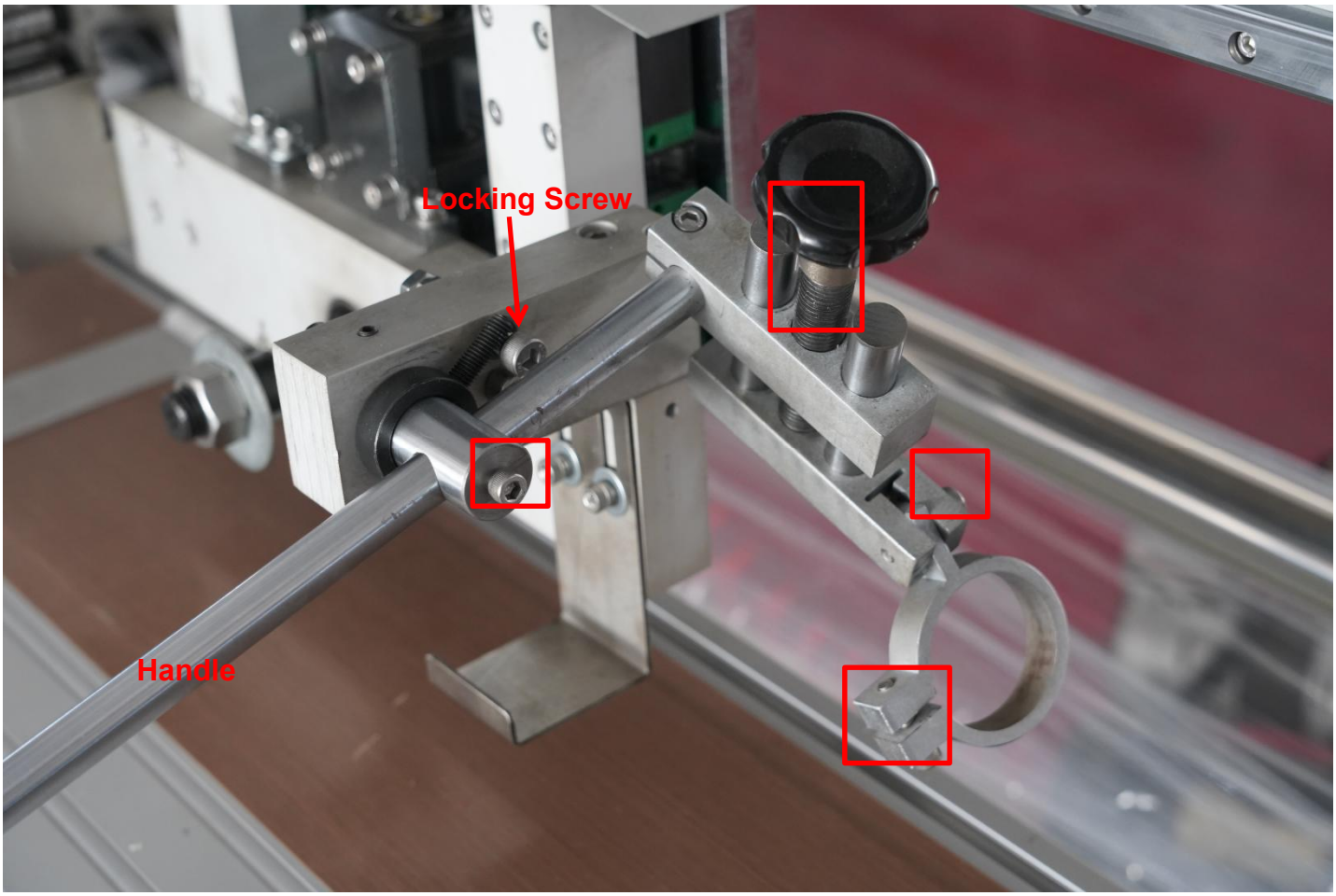
①.The airflow from the air heating gun should be directed at the guide wheel groove, with approximately equal airflow velocity at both ends of the groove.

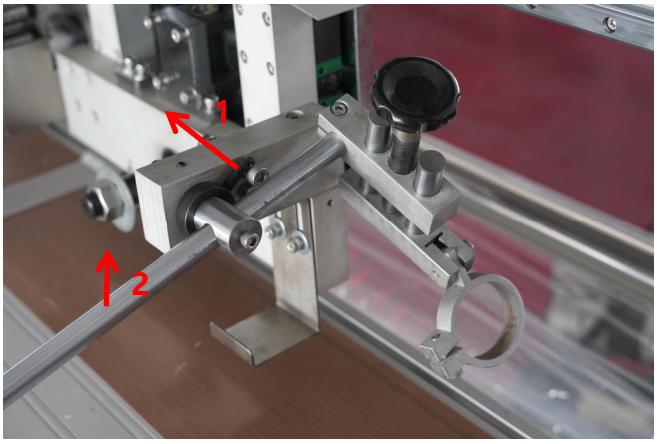
②. The nozzle of the air heating gun should be positioned as close as possible to the middle place between the belt and the cleat without making direct contact with either.

③. When adjusting the front-to-back position of the air heating gun, use the handle and ensure that it does not come into direct contact with any other parts of the machine.

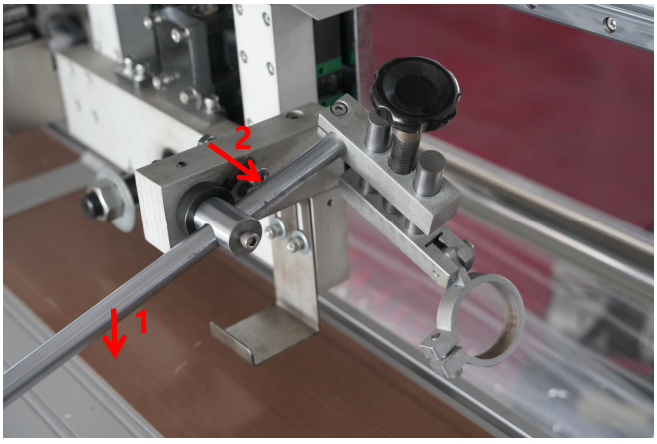



6. The position of the heat gun is adjusted by modifying the bracket position via the screw at the annotated location in the figure below.





Air Heating Gun Forward Adjustment:
Slide the locking screw to the left.
Lift the handle upward.



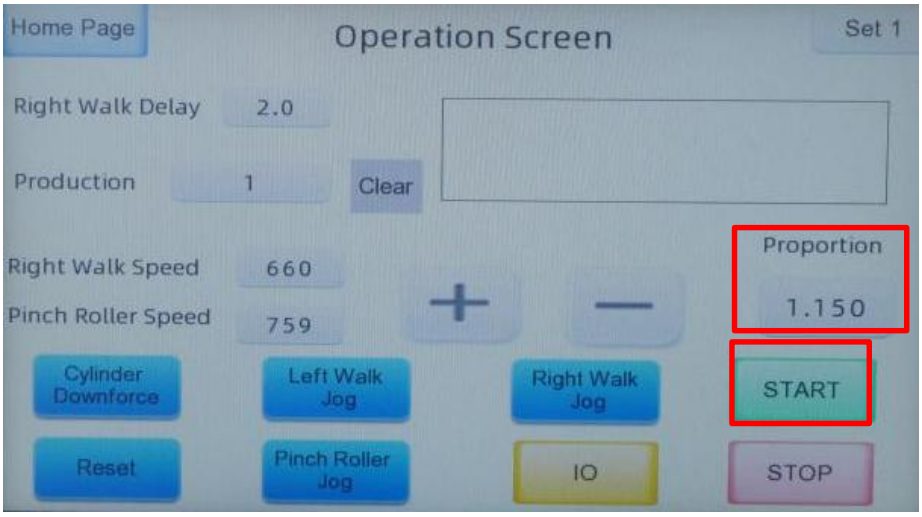
Air Heating Gun Backward Adjustment:
Press the handle down.
Slide the locking screw to the right.

3. Operate the machine

1. Open the air heating gun and set it to higher level. It requires several minutes of preheating after being turned on. After preheating for few minutes, place the cleat in front of the heat gun nozzle. When the cleat melts rapidly, it indicates that preheating is complete, then move the air heating gun forward. If not, set the air heating gun to higher level.

2. Press the "operation screen" button on the upper left corner of the touchscreen.

3. Press the start button on the working panel, and observe the status of both the belt and the cleat during machine operation.



Typically, the machine's parameters are pre-configured at the factory for normal operations. However, adjustments may be needed based on actual working conditions. Normally, set the proportion parameter to 1.1-1.15 and the right walk speed to 300 . The wheel speed does not

need to be set, as it will automatically adjust according to the proportion parameter. Adjust the proportion by ±0.01 for trial.

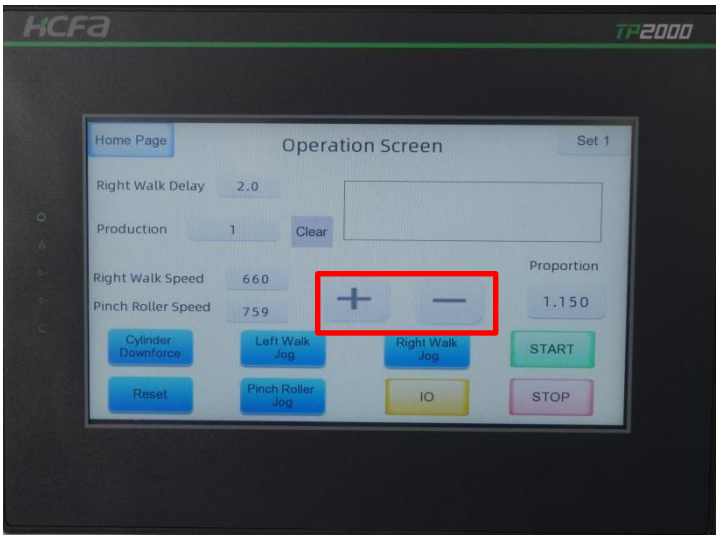
①. If the belt and cleat remain straight after operation, it indicates proper speed synchronization between the guide wheel and machine head, ensuring maintained straightness throughout the subsequent welding process.

②. If the belt arches upward relative to the cleat after operation, decrease the proportion parameter in the touchscreen interface.

③. If the belt lifts away from the cleat after operation, increase the proportion parameter in the touchscreen interface.

Adjust the machine's proportional parameter until the belt and cleat maintain a straight state after operation.

4. At the same time, pay attention to the welding effects:

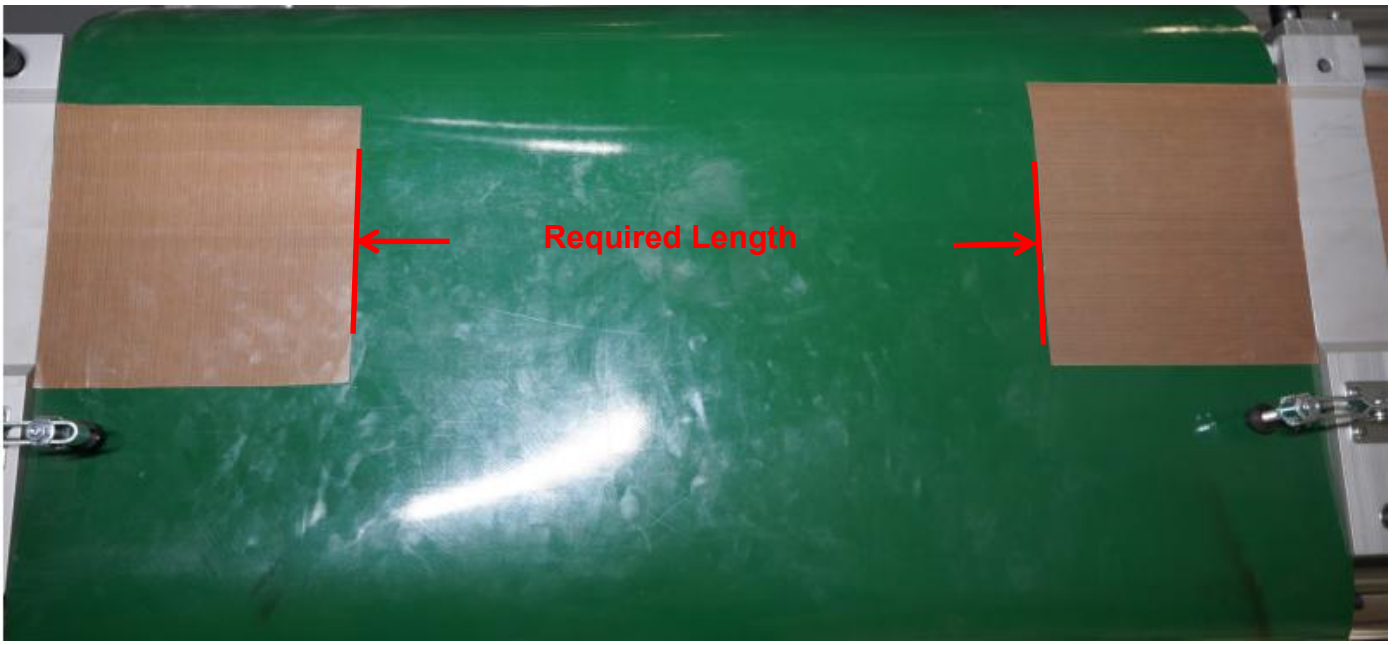


①. If no smoke is generated during welding, it indicates incomplete melting at the bottom of the cleat. Press the minus "-" button or turn the speed knob right to reduce the operating speed.

②. If excessive smoke is produced during welding, it suggests over melting of the cleat, which may cause charring. Press the plus "+" button or turn the speed knob left to increase the operating speed.

Recommendation:

During welding operations, apply Teflon tape to both ends of the belt. The tape prevents sticking between the belt and the cleat. The distance between the inner edges of the tape determines the required length of the welding cleat.



4. After welding operation

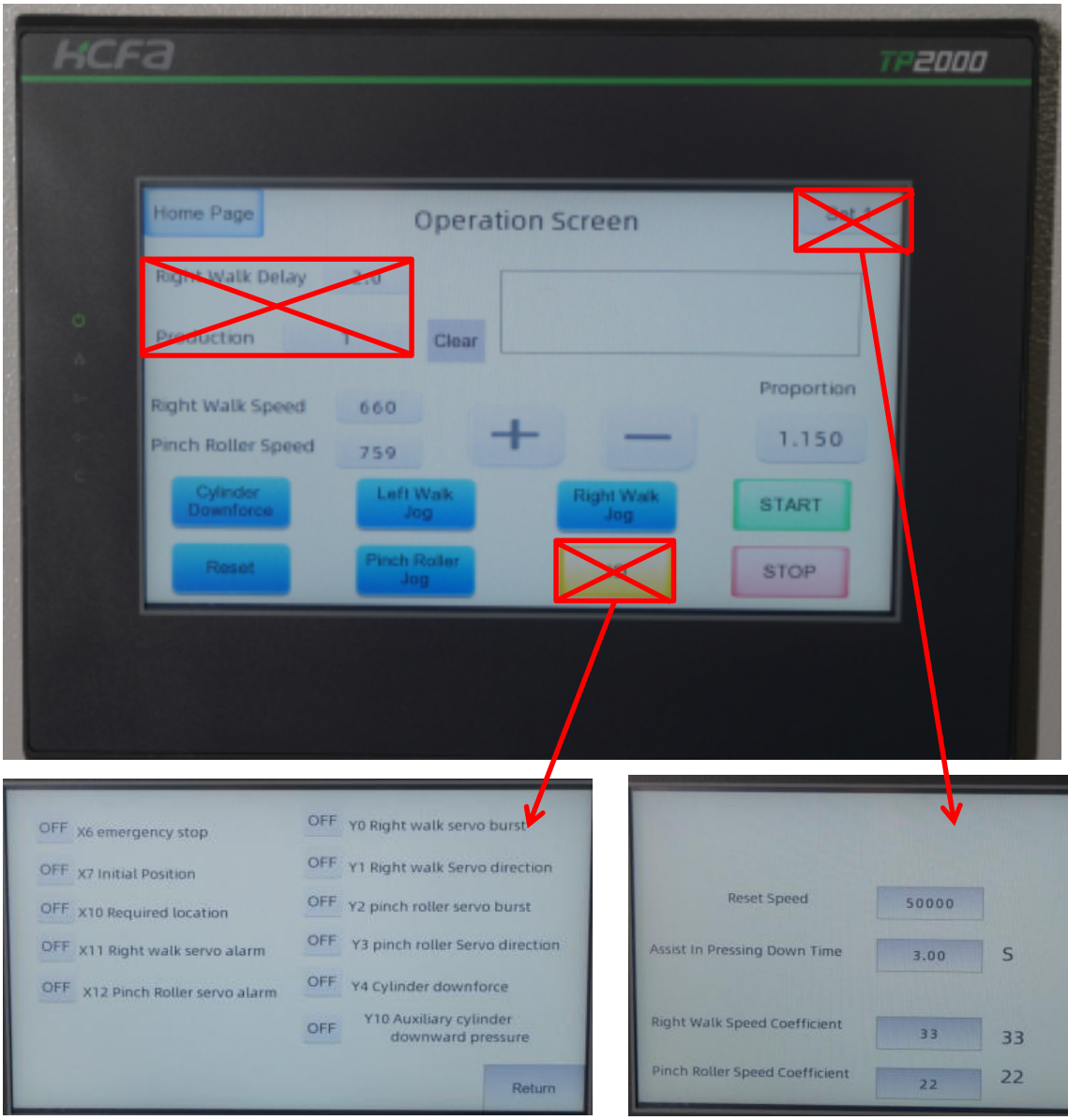
1. When the welding operation is completed, move the air heating gun backward, set it to the lowest level but don' t close it. (**Operating the heat gun at a lowest level instead turning it off can extend its service life.**)

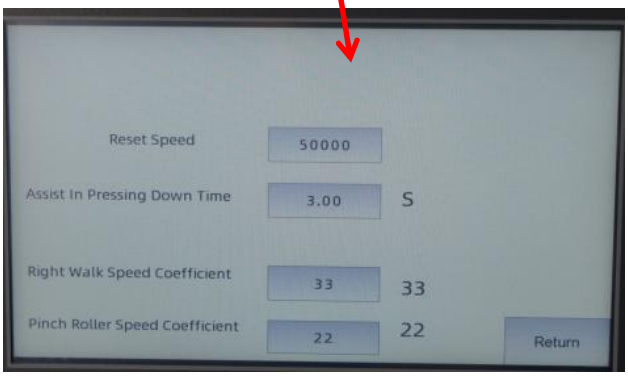
2. Press the "reset" button to rise up the guide wheel, and take the cleat out. When the airflow of the air gun turns cold, then close it.

3. Remove the cleat and cut it to the required length.

The parameters on the touchscreen have been preset at the factory.

Please don’ t make arbitrary changes.





5. Turn off the power

When operation is ended:

1. Set the air gun to the lowest level and close the air heating gun. Move it backward.
2. Turn off the power switch, disconnect the power cord, and disconnect the air pipe.
3. Unplug the power of the air heating gun.

6. Welding results:

After the welding process is completed, there should be no burn marks at the connection between the belt and the cleat. The cooled product must be secure and stable.

Improper use of this equipment can seriously endanger your health!
This manual contains important information about product functions and safe operation.
Please read the instructions provided in this manual carefully.
Please make sure you fully understand this manual before operating the machine. Please keep this manual in a safe place,
either in paper or electronic form, for reference at any time

温州红龙工业设备制造有限公司

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