

USING THE RF SPOT GLUER

SPECIFICATIONS:

Power supply:	220v/240 v single-phase 16A
Output power:	1.5 kW
Frequency:	27.12 MHz
Oscillating tube:	TB4/1250
Rectification:	solid state rectifiers
Curing area:	±70 x 70 x 50mm – 60mm deep glue line
Total weight:	47kg
Handgun weight:	1.3kg
Overall dimensions:	650 high x 500 x 500mm

BACKGROUND

The RF Spot Gluer is a tool to used to speed up production and lower production cost. It is designed to free up clamping jigs and significantly shorten glue-curing time.

All traditional glues including API's may be used with the RF Spot Gluer.

OPERATION

- Apply glue to the required surfaces,
- Clamp the piece and apply RF with the application gun to the glue line. The RF induces heat into the glue line and curing takes place immediately. Depending on the application, RF is applied for 2- 6seconds depending on area of the glue line to be cured.
- After applying RF, the piece must be left for 15 –25 seconds to cool under pressure. The clamps can be removed and the piece left for post curing in the areas where the RF was not applied.

MACHINE SETUP

- Plug the Spot Gluer 240V into a wall socket.
- Switch the circuit breaker on the spot gluer to the "on" position.
- A Ready indicator will light up on the control panel
- If the amber indicator is lit, then set the machine to "weld"; press the red Reset button on the control panel.
- The output RF power of the machine is determined by the position of adjustable lever on handgun.
- On the control panel is an ammeter, which is labeled "power". Operating power usually set to be between 250 mA – 450 mA depending on the depth of the glue line to be cured

- To apply RF to a glue line:
 - Place the hand-gun electrodes across the glue line as shown below
 - Depress the trigger on the handgun to apply RF. The cure time is set via a timer on front panel of the unit.
 - When the RF is active, the "RF on" indicator will be lit.
 - Continue spot gluing along the glue line at regular intervals of 150 or 200mm
- Supplied with the machine are two sets of electrodes for internal and external corners curing

MAINTENANCE

- Clean electrodes regularly with warm water.
- Blowout air filter out daily
- The pins on the electrode must be kept clean, as these are contact points.
- If there is arcing on the gun, clean the area of carbon using thinners, if necessary fine sand paper.

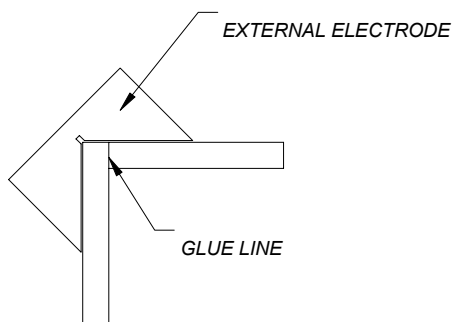
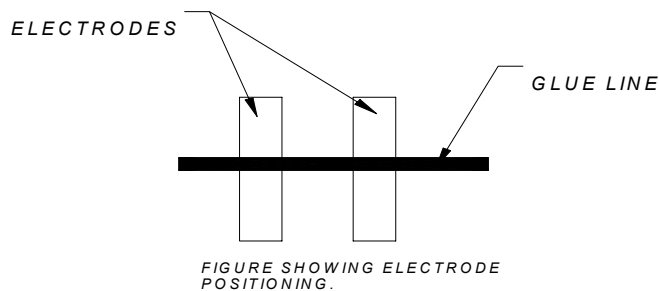


FIGURE SHOWING
EXTERNAL CORNER CURING

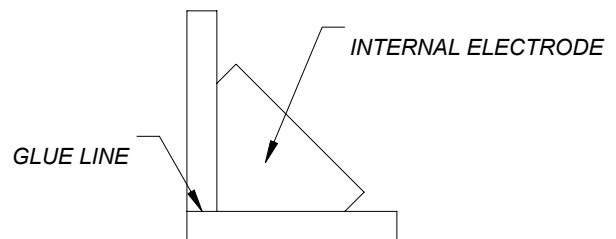


FIGURE SHOWING
INTERNAL CORNER CURING