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Basic Guide to Welding PVC-U

P.V.C. is a little tricky to weld. If the material overheats it starts burning.

Try the following steps and you should be welding trouble free.

You should check the temperature with an external insertion temperature probe to make sure that the correct temperature has been achieved.

Please follow these steps:

1. Select in the program P.V.C. Material
2. At the beginning raise the Melt Temperature from 190°C; manually to 215°C
3. Start the drive after reaching the temperature of 215°C
4. When the drive is running, reduce the temperature to approximately 190°C and start to weld
5. If you stop welding change to the PP Program and purge the P.V.C.-U out of the extruder
6. Run PP into the unit after you stop welding.

Please Note:-

**When P.V.C. is welded it emits a chlorine gas.
Therefore it is advisable to weld in a well-ventilated area and use a mask.**



Welding mask (Example)

Important:-

If the above guidelines are not strictly adhered to, the result may be serious damage to your welder due to the corrosive nature of the PVC welding rod.

Barnes Plastic Welding Equipment Limited will not be held responsible for any damage incurred.