

ASSEMBLY INSTRUCTIONS

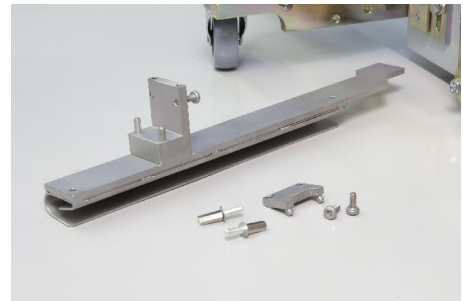
HEM WELDING KIT 20 mm / 30 mm and 40/45 mm

Extent of delivery:

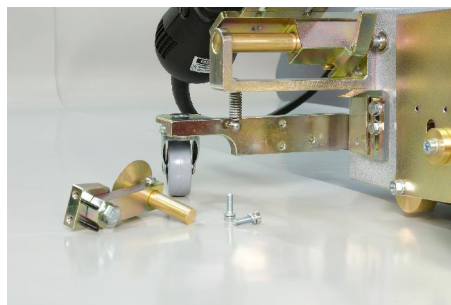
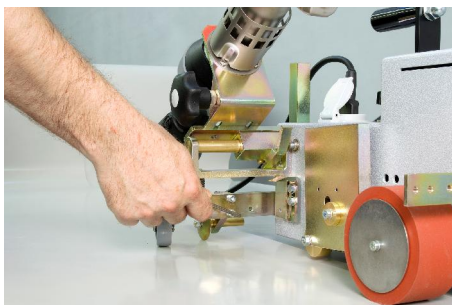
Seam guide with screws, fixation strap, 2 additional screws, pins for 20 mm and 40 mm hems

Note: 20 mm and 40 mm hems are welded by mounting pins on guide, 30 mm and 45 mm hems without pins.

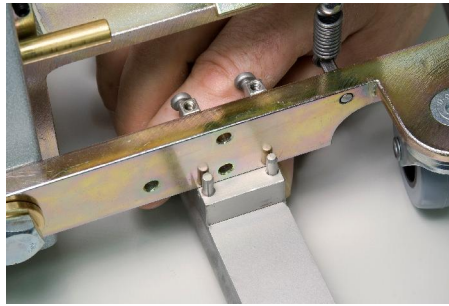
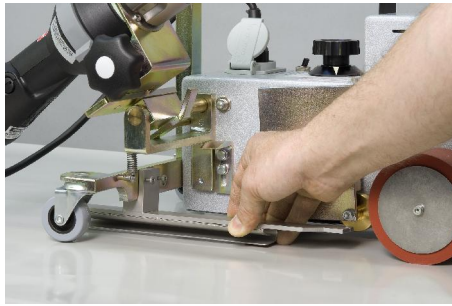
The pins are narrowing the guide of the welding material.



1.) Remove the guide role of your automatic welding machine.



2.) Mount the seam guide onto the holder of the caster wheels.

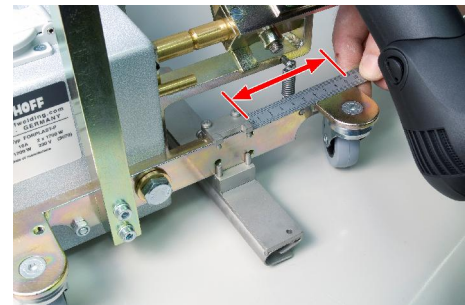


3.) Before you mount the fixation strap, please measure the distance to the caster wheel which is located besides the blower:

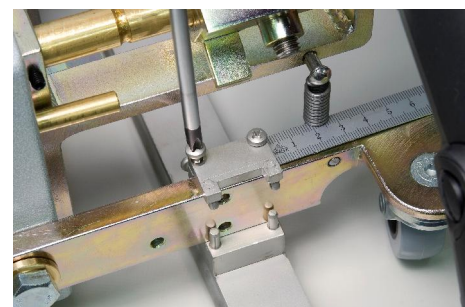
For the welding of 20 mm hems the distance should be 75 mm;

For the welding of 30 mm hems the distance should be 100 mm.

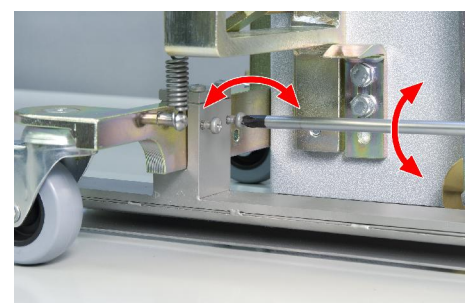
For the welding of 40 mm and 45 mm hems the distance should be 103 mm.



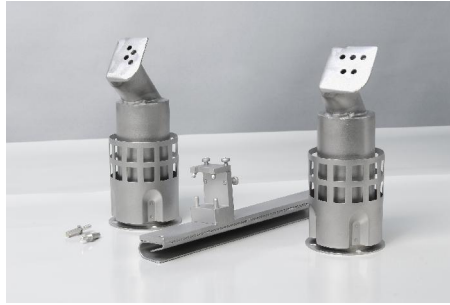
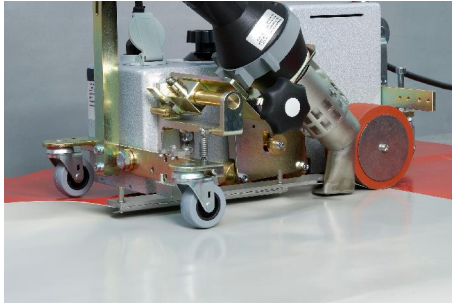
4.) After the distance is determined, both screws can be tightened at the fixation strip.



5.) By the help of tightening the backward screws of the hem guide, you can adjust the vertical and horizontal position of the hem welding kit.

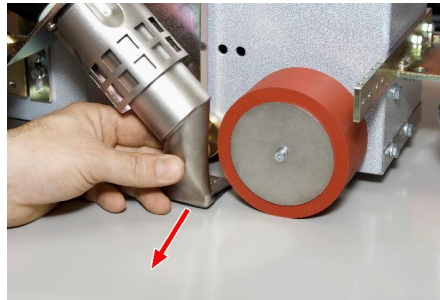
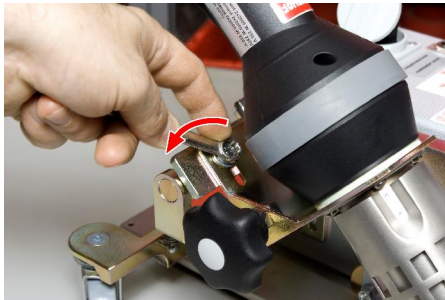


Please take care that 20 mm and 40 mm hems can only be produced if the 2 pins are placed into the hem guide.

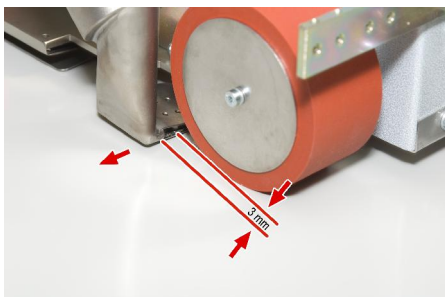


Additional change of nozzle position is required when welding 45 mm hems:

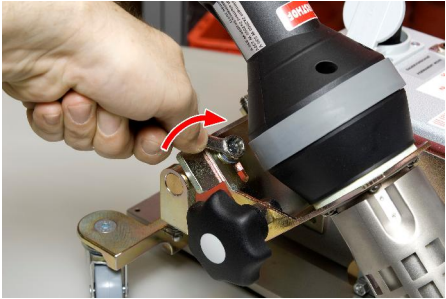
When the hem welding kit is mounted for welding 45 mm hems, the nozzle must be slightly placed out of trace. Loosen both screws on the back side of the blower angle and pull the nozzle slightly out of trace.



The distance from the beginning of the nozzle slot to the silicone rubber must be 3 mm.



Finally re-tighten both screws of the blower angle.



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