



# PFAFF 8362i Welding Guide

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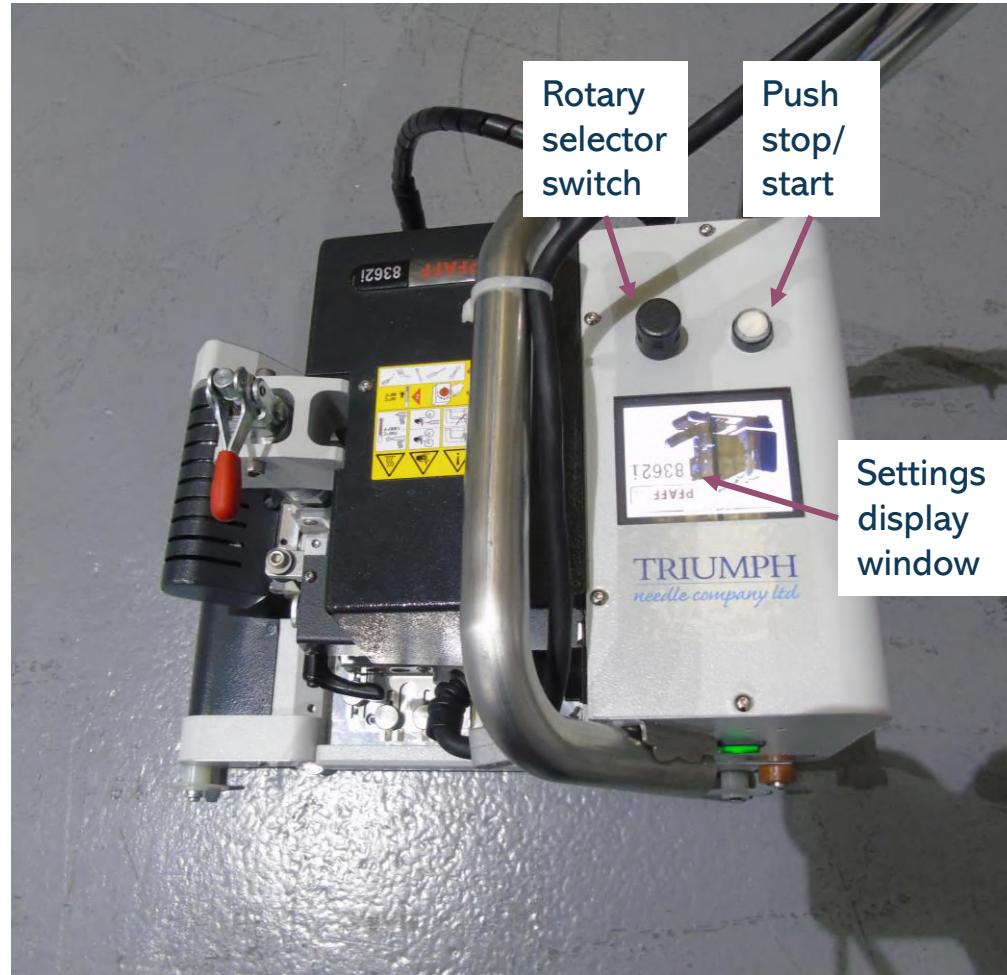
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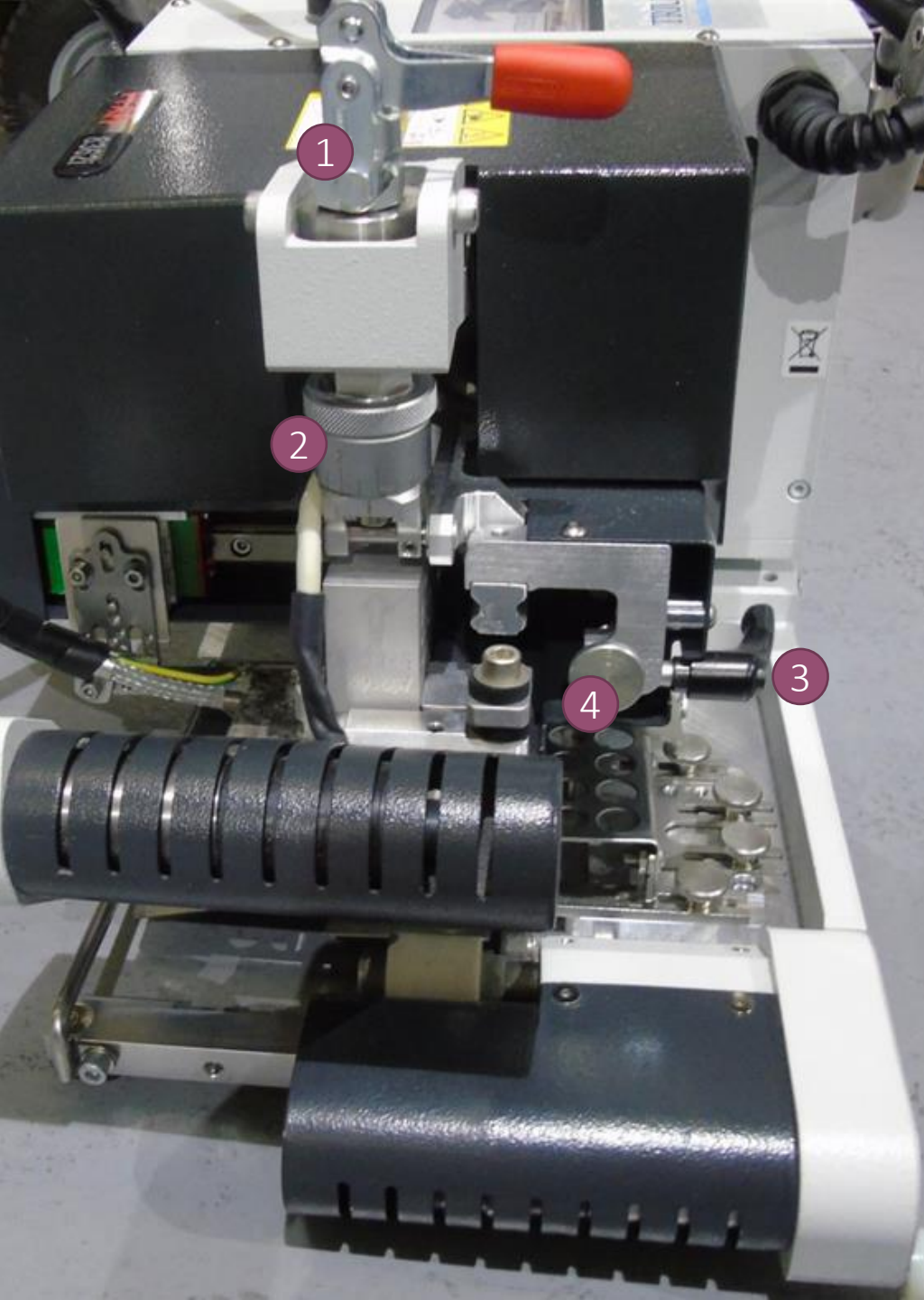


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# PFAFF 8362i

Swimming Pool Cover Edition





## PFAFF 8362i – Swimming Pool Cover Edition

1

Open/ close rollers

2

Pinch pressure fine adjust

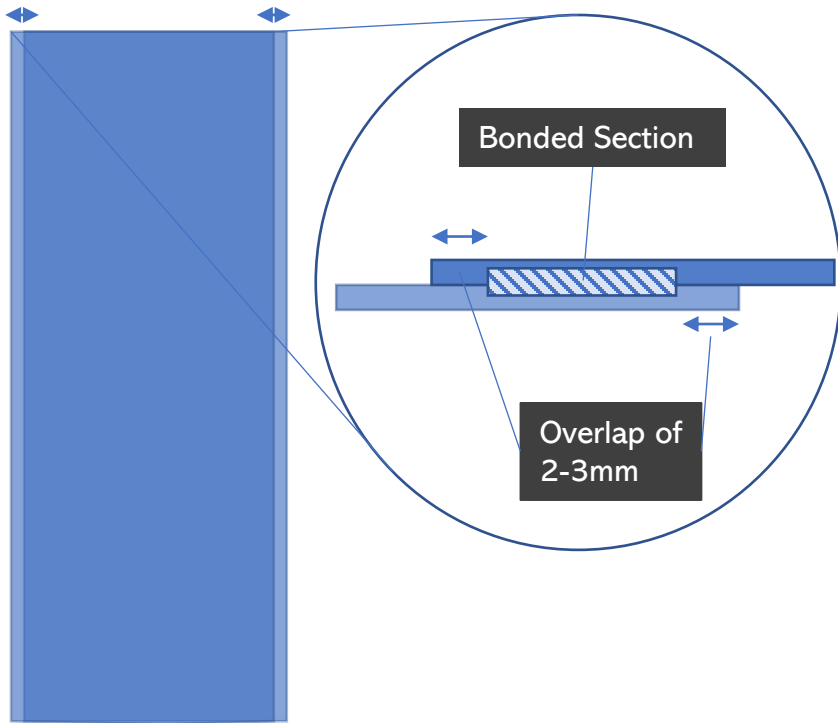
3

Wedge clearance adjust lock

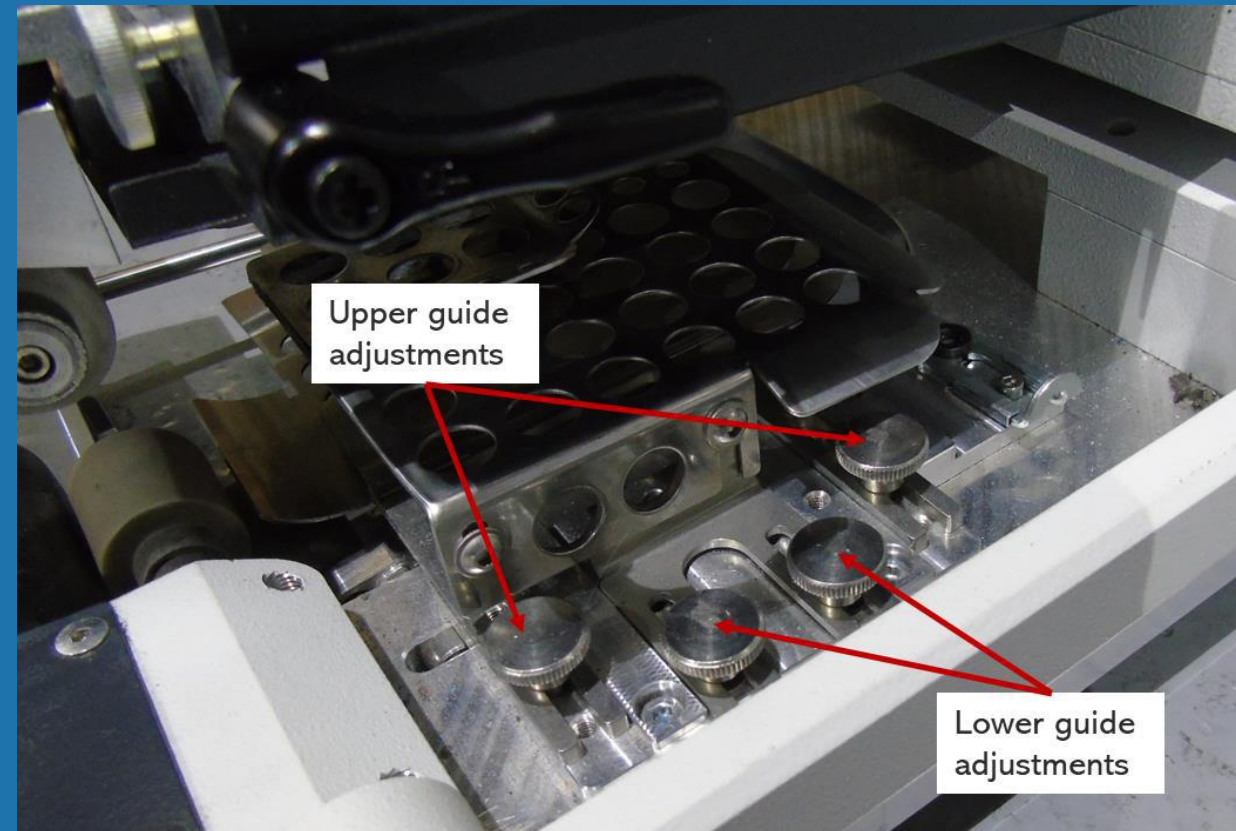
4

Wedge clearance adjust

# PFAFF 8362i – Swimming Pool Cover Edition



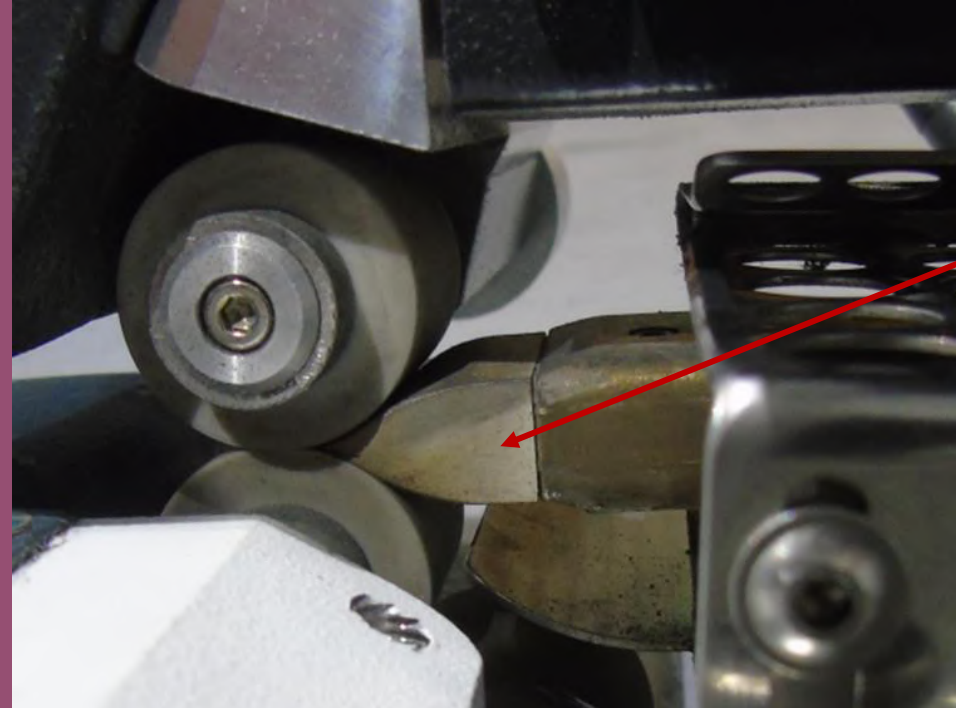
The upper and lower guides should be adjusted such that a 2-3mm overlap exists each side of the welded region.



# PFAFF 8362i – Adjusting Wedge Clearance

The wedge clearance can be adjusted towards/ away from the drive rollers. The position requires altering as the wedge is worn away over time.

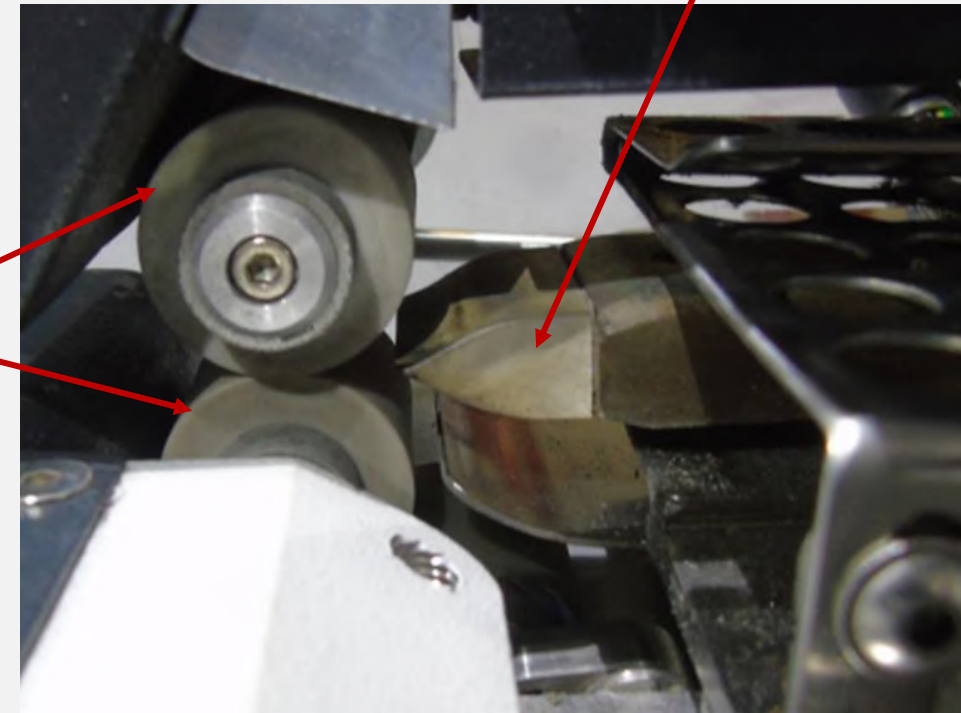
The clearance of the wedge is crucial - Too far forward and it will generate excessive drag. Too far back and the contact with the material will be insufficient for proper bonding during the welding process.



Wedge – Correct position

Wedge – Too far back

Silicone drive rollers



# PFAFF 8362i –

## Wedge Care and Shaping

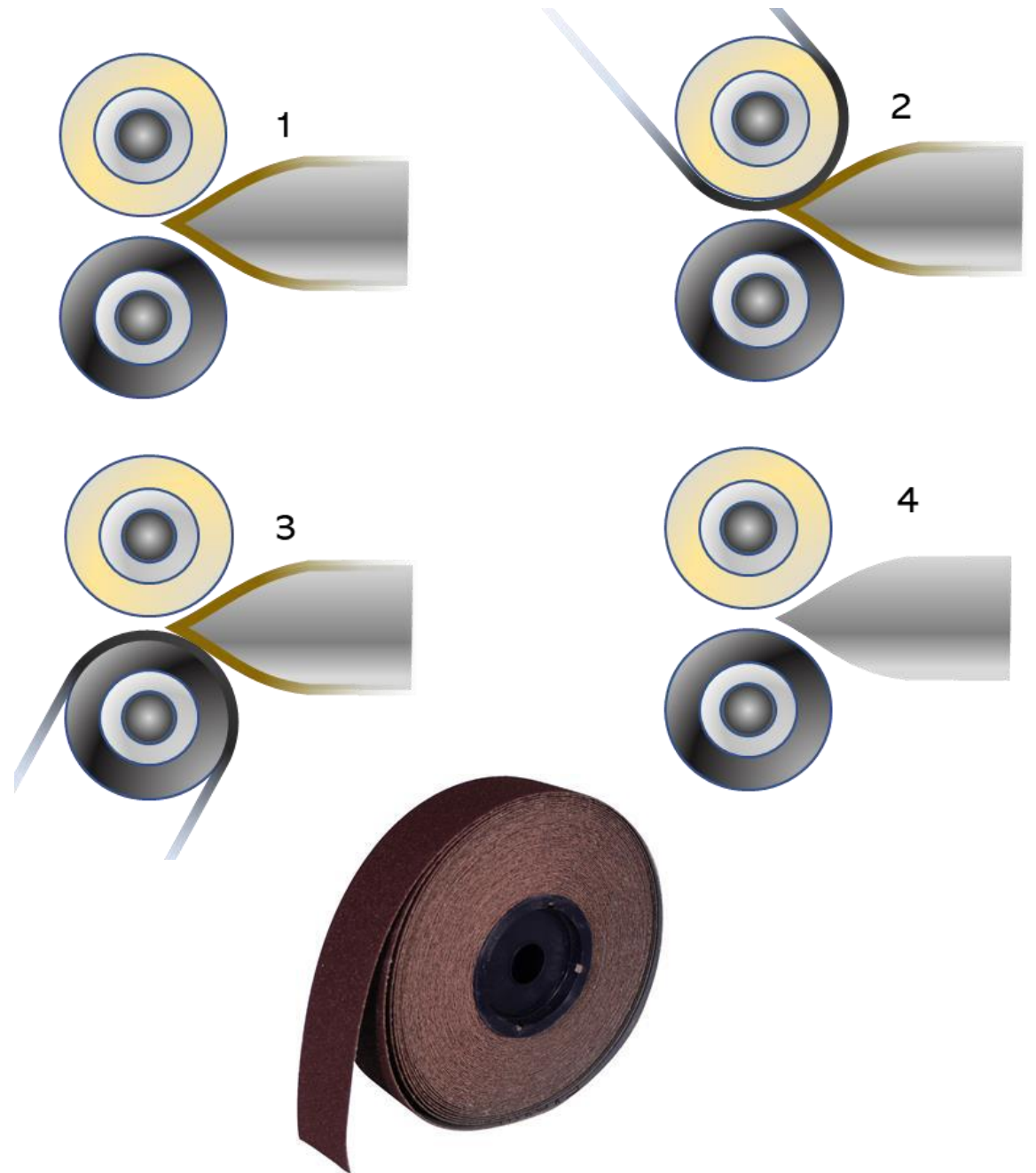
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The wedge should be periodically and gently cleaned using the soft wire brush provided - This is to remove any dirt and debris that can build up on the wedge and potentially damage the material as it is welded.

As the wedge is consumed over time it will become necessary to reshape the wedge - This ensures that good contact between the wedge and the rollers is maintained in order to produce a strong bonded section.

When the wedge requires shaping, first create a loop of emery tape around each roller with the wedge and rollers both engaged.

The rollers are then run in reverse in 'wedge shaping mode' resulting in the wedge being gently abraded until it has regained its tapered shape and fits closely between the silicone rollers once more.



# PFAFF 8362i –

## Adjusting Weld Settings

Welding temperature, welding speed and pinch pressure are all set digitally using via the settings display window.

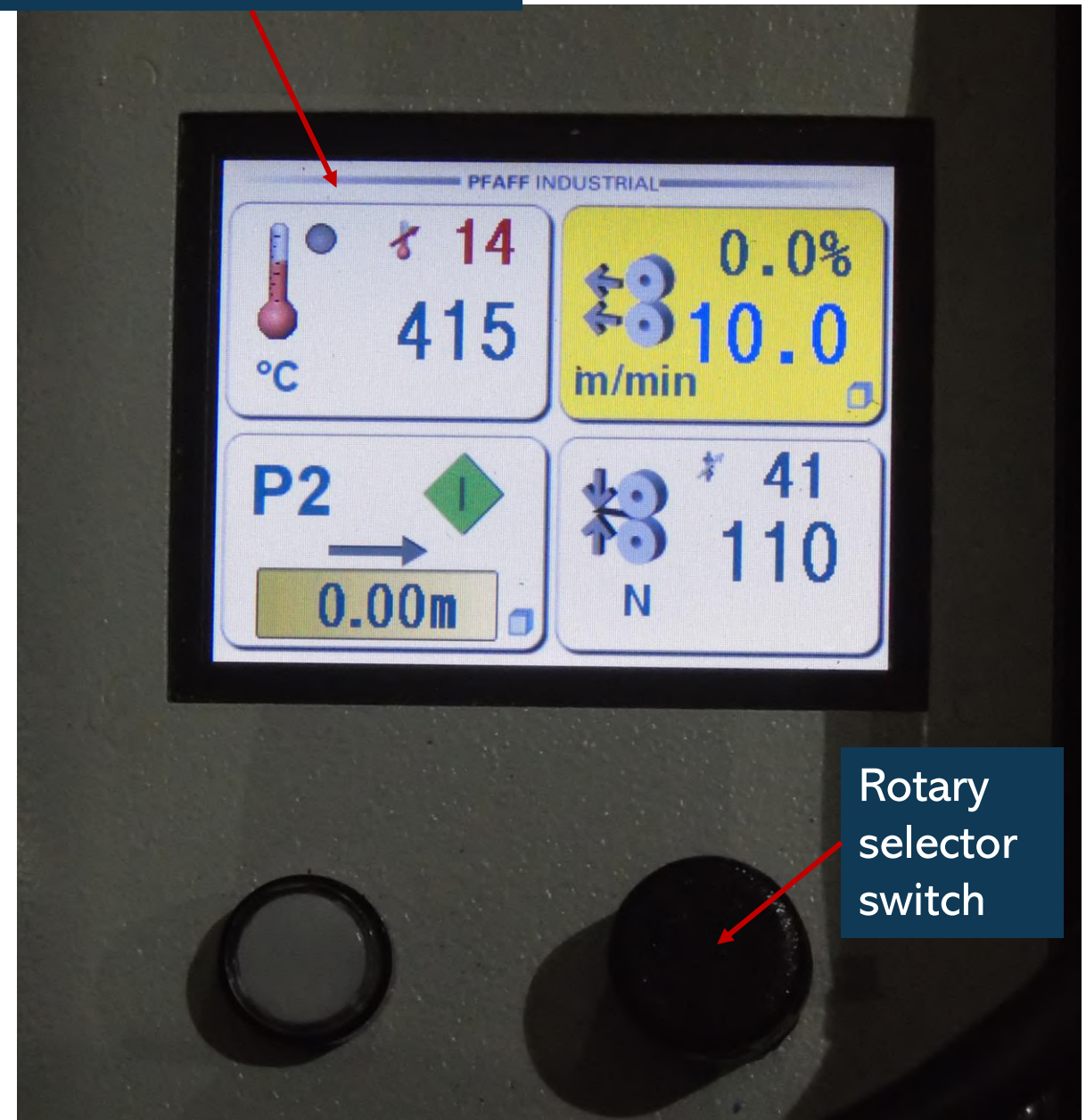
Up to nine welding programmes can be set and saved locally to the machine.

The settings window is navigated using the selector switch. Pressing down on the selector switch when a setting is highlighted will enable it to be altered, pressing it again will confirm the new setting.

The actual wedge temperature is displayed above target temperature set by the operator. The machine will not commence welding until the target temperature has been achieved.

The pinch force is set digitally however can be fine adjusted manually. If the machine detects a drop in pinch pressure it will stop welding.

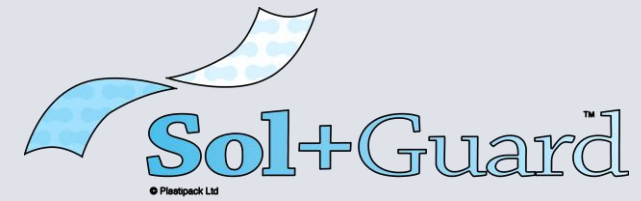
## Settings display window



# PFAFF 8362i –

## Plastipack Welding Settings

Below are welding settings for the 8362i that have been used previously by Plastipack. These should be used as a guide only - all settings should be trialled before being implemented. Welding settings will vary depending on material and age/ condition of the wedge.

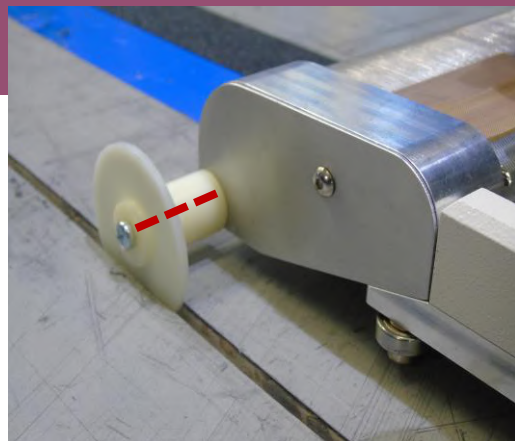
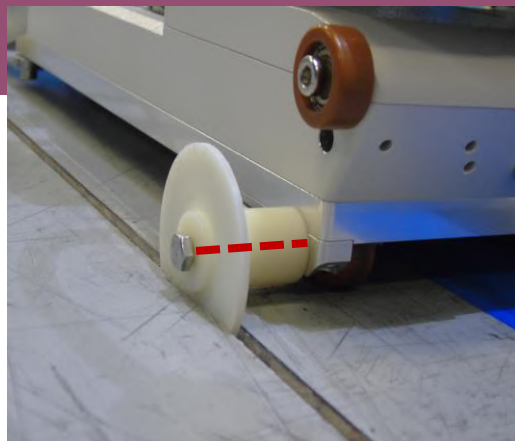


Material	Temperature (°C)	Speed (ms <sup>-1</sup> )	Pinch Pressure (N)
400µm Materials	360-380	10	70-90
500µm Materials	390-420	9	100
Sol+Guard™	415	9.5	90
EnergyGuard™	390-420	9.0-9.5	90-120
Woven Materials	490	6.5	160





# PFAFF 8362i – Plastipack Welding Settings



To ensure a high-quality and straight weld over long distances, Plastipack use a guide track system which spans the full length of the welding lane (50m).

Wheel modifications sit in the guide track and keep the machine straight as it moves.

The guide wheels are attached via screws into the housing of the welding machine at the front and back.



Guide track

Guide wheels

# PFAFF 8362i – Useful Welding Accessories

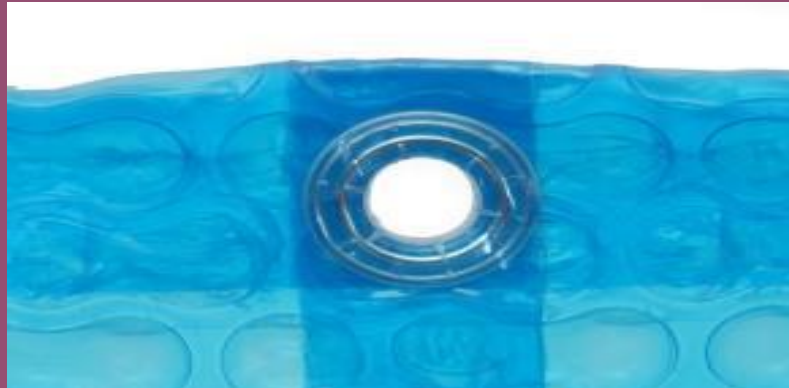


For large cover production festoon systems are a neat solution for cable management. A festoon system consists simply of mobile hangers on a suspended trackway that can move the welder's power supply cable as the welder moves below during welding.

[Festoon system link](#)

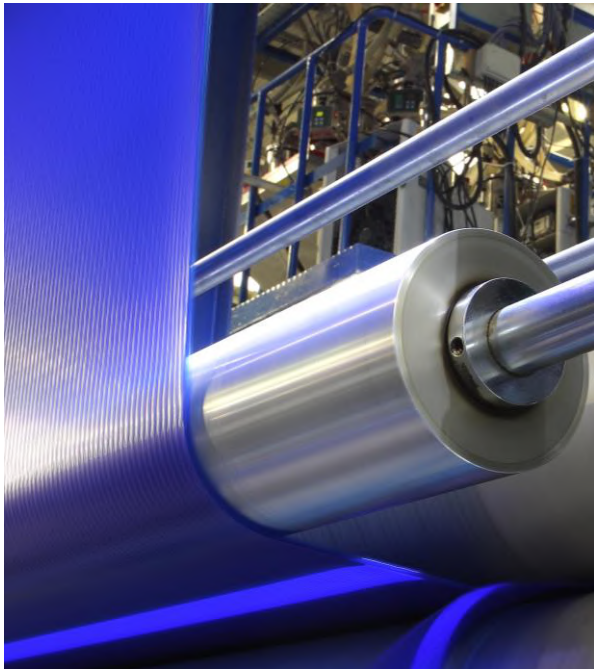
When using eyelets metal can often rust and pit while on the pool. A good solution can be the use of clear plastic eyelets. It is important to ensure that the eyelet neck will be tall enough to provide a secure permanent fitting even through the bubble. Eyelets are secured with the use of a hand press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

[Link for eyelets and hand presses](#)



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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