

Owner's Manual & Safety Instructions

Save This Manual Keep this manual for the safety warnings and precautions, assembly, operating, inspection, maintenance and cleaning procedures. Write the product's Date Code in the back of the manual near the assembly diagram (or month and year of purchase if product has no number). Keep this manual and the receipt in a safe and dry place for future reference.

25d

**CHICAGO
ELECTRIC™**

WELDING

1600 WATT

PLASTIC WELDING KIT

WITH AIR MOTOR AND TEMPERATURE ADJUSTMENT



Visit our website at: <https://www.harborfreight.com>
Email our technical support at: productsupport@harborfreight.com

59646

When unpacking, make sure that the product is intact and undamaged. If any parts are missing or broken, please call 1-800-444-3353 as soon as possible.

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No portion of this manual or any artwork contained herein may be reproduced in any shape or form without the express written consent of Harbor Freight Tools. Diagrams within this manual may not be drawn proportionally. Due to continuing improvements, actual product may differ slightly from the product described herein. Tools required for assembly and service may not be included.

⚠ WARNING

**Read this material before using this product.
Failure to do so can result in serious injury.
SAVE THIS MANUAL.**

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WARNING SYMBOLS AND DEFINITIONS

	This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.
	Indicates a hazardous situation which, if not avoided, will result in death or serious injury.
	Indicates a hazardous situation which, if not avoided, could result in death or serious injury.
	Indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.
	Addresses practices not related to personal injury.

IMPORTANT SAFETY INFORMATION

General Power Tool Safety Warnings

WARNING

Read all safety warnings and all instructions.

Failure to follow the warnings and instructions may result in electric shock, fire and/or serious injury.

Save all warnings and instructions for future reference.

The term "power tool" in the warnings refers to your mains-operated (corded) power tool.

Work Area Safety

- 1. Keep work area clean and well lit.**
Cluttered or dark areas invite accidents.
- 2. Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.** *Power tools create sparks which may ignite the dust or fumes.*
- 3. Keep children and bystanders away while operating a power tool.**
Distractions can cause you to lose control.

Electrical Safety

1. **Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with grounded power tools.** *Unmodified plugs and matching outlets will reduce risk of electric shock.*
2. **Avoid body contact with grounded surfaces such as pipes, radiators, ranges and refrigerators.** *There is an increased risk of electric shock if your body is grounded.*
3. **Do not expose power tools to rain or wet conditions.** *Water entering a power tool will increase the risk of electric shock.*
4. **Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts.** *Damaged or entangled cords increase the risk of electric shock.*
5. **When operating a power tool outdoors, use an extension cord suitable for outdoor use.** *Use of a cord suitable for outdoor use reduces the risk of electric shock.*
6. **If operating a power tool in a damp location is unavoidable, use a Ground Fault Circuit Interrupter (GFCI) protected supply.** *Use of a GFCI reduces the risk of electric shock.*

Personal Safety

1. **Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication.** *A moment of inattention while operating power tools may result in serious personal injury.*
2. **Use personal protective equipment. Always wear eye protection.** *Protective equipment such as dust mask, non-skid safety shoes, hard hat, or hearing protection used for appropriate conditions will reduce personal injuries.*
3. **Prevent unintentional starting. Ensure the Power Switch is in the off-position before connecting to power source, picking up or carrying the tool.** *Carrying power tools with your finger on the Power Switch or energizing power tools that have the Power Switch on invites accidents.*
4. **Do not overreach. Keep proper footing and balance at all times.** *This enables better control of the power tool in unexpected situations.*
5. **Dress properly. Do not wear loose clothing or jewelry. Keep your hair, clothing and gloves away from moving parts.** *Loose clothes, jewelry or long hair can be caught in moving parts.*
6. **If devices are provided for the connection of dust extraction and collection facilities, ensure these are connected and properly used.** *Use of dust collection can reduce dust-related hazards.*
7. **Only use safety equipment that has been approved by an appropriate standards agency.** *Unapproved safety equipment may not provide adequate protection. Eye protection must be ANSI-approved and breathing protection must be NIOSH-approved for the specific hazards in the work area.*

Power Tool Use and Care

1. **Do not force the power tool. Use the correct power tool for your application.** *The correct power tool will do the job better and safer at the rate for which it was designed.*
2. **Do not use the power tool if the Power Switch does not turn it on and off.** *Any power tool that cannot be controlled with the Power Switch is dangerous and must be repaired.*
3. **Disconnect the plug from the power source before making any adjustments, changing accessories, or storing power tools.** *Such preventive safety measures reduce the risk of starting the power tool accidentally.*
4. **Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool. Power tools are dangerous in the hands of untrained users.**
5. **Maintain power tools. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tool's operation. If damaged, have the power tool repaired before use.** *Many accidents are caused by poorly maintained power tools.*
6. **Keep cutting tools sharp and clean.** *Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.*
7. **Use the power tool, accessories and tool bits etc. in accordance with these instructions, taking into account the working conditions and the work to be performed. Use of the power tool for operations different from those intended could result in a hazardous situation.**

Service

Have your power tool serviced by a qualified repair person using only identical replacement parts.

This will ensure that the safety of the power tool is maintained.

Welder Safety Warnings

1. Do not use near flammable materials.
2. Do not touch barrel or tip when using. Do not touch any metal parts on Welder until they have completely cooled.
3. Do not place the Welder in a vise to change heating elements.
4. Always use pliers to change the tip on the Welder.
5. Avoid electrical shock. Do not use in a damp or wet environment.
6. Do not rest Welder on flammable surface.
7. This product is designed for use only for plastic welding. This product is designed to be used only to weld plastic items.
8. Maintain labels and nameplates on the tool. These carry important safety information. If unreadable or missing, contact Harbor Freight Tools for a replacement.
9. Avoid unintentional starting. Prepare to begin work before turning on the tool.
10. Do not leave the tool unattended when it is plugged into an electrical outlet. Turn off the tool, and unplug it from its electrical outlet before leaving.
11. Use clamps (not included) or other practical ways to secure and support the workpiece to a stable platform. Holding the work by hand or against your body is unstable and may lead to loss of control.
12. This product is not a toy. Keep it out of reach of children.
13. For household use only.
14. People with pacemakers should consult their physician(s) before use. Electromagnetic fields in close proximity to heart pacemaker could cause pacemaker interference or pacemaker failure. In addition, people with pacemakers should:
 - Avoid operating alone.
 - Do not use with Power Switch locked on.
 - Properly maintain and inspect to avoid electrical shock.
 - Properly ground power cord. Ground Fault Circuit Interrupter (GFCI) should also be implemented – it prevents sustained electrical shock.
15. The warnings, precautions, and instructions discussed in this instruction manual cannot cover all possible conditions and situations that may occur. It must be understood by the operator that common sense and caution are factors which cannot be built into this product, but must be supplied by the operator.



SAVE THESE INSTRUCTIONS.

SAFETY

SETUP

OPERATION

MAINTENANCE

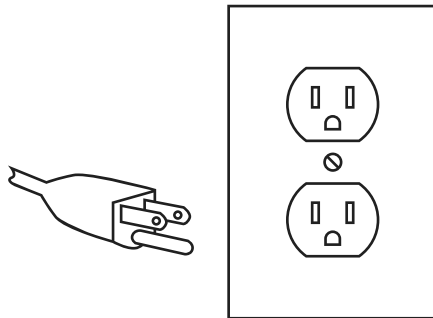
!WARNING



TO PREVENT ELECTRIC SHOCK AND DEATH FROM INCORRECT GROUNDING WIRE CONNECTION:

Check with a qualified electrician if you are in doubt as to whether the outlet is properly grounded. Do not modify the power cord plug provided with the tool. Never remove the grounding prong from the plug. Do not use the tool if the power cord or plug is damaged. If damaged, have it repaired by a service facility before use. If the plug will not fit the outlet, have a proper outlet installed by a qualified electrician.

Grounded Tools: Tools with Three Prong Plugs

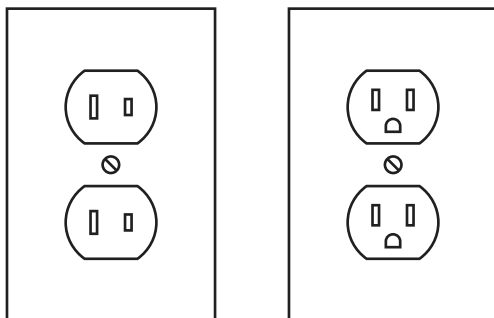


3-Prong Plug and Outlet

1. Tools marked with "Grounding Required" have a three wire cord and three prong grounding plug. The plug must be connected to a properly grounded outlet. If the tool should electrically malfunction or break down, grounding provides a low resistance path to carry electricity away from the user, reducing the risk of electric shock. (See 3-Prong Plug and Outlet.)

2. The grounding prong in the plug is connected through the green wire inside the cord to the grounding system in the tool. The green wire in the cord must be the only wire connected to the tool's grounding system and must never be attached to an electrically "live" terminal. (See 3-Prong Plug and Outlet.)
3. The tool must be plugged into an appropriate outlet, properly installed and grounded in accordance with all codes and ordinances. The plug and outlet should look like those in the preceding illustration. (See 3-Prong Plug and Outlet.)

Double Insulated Tools: Tools with Two Prong Plugs



Outlets for 2-Prong Plug

1. Tools marked "Double Insulated" do not require grounding. They have a special double insulation system which satisfies OSHA requirements and complies with the applicable standards of Underwriters Laboratories, Inc., the Canadian Standard Association, and the National Electrical Code.
2. Double insulated tools may be used in either of the 120 volt outlets shown in the preceding illustration. (See Outlets for 2-Prong Plug.)

Extension Cords

SAFETY

1. ***Grounded*** tools require a three wire extension cord. ***Double Insulated*** tools can use either a two or three wire extension cord.
2. As the distance from the supply outlet increases, you must use a heavier gauge extension cord. Using extension cords with inadequately sized wire causes a serious drop in voltage, resulting in loss of power and possible tool damage. **(See Table A.)**
3. The smaller the gauge number of the wire, the greater the capacity of the cord. For example, a 14 gauge cord can carry a higher current than a 16 gauge cord. **(See Table A.)**
4. When using more than one extension cord to make up the total length, make sure each cord contains at least the minimum wire size required. **(See Table A.)**
5. If you are using one extension cord for more than one tool, add the nameplate amperes and use the sum to determine the required minimum cord size. **(See Table A.)**
6. If you are using an extension cord outdoors, make sure it is marked with the suffix "W-A" ("W" in Canada) to indicate it is acceptable for outdoor use.
7. Make sure the extension cord is properly wired and in good electrical condition. Always replace a damaged extension cord or have it repaired by a qualified electrician before using it.
8. Protect the extension cords from sharp objects, excessive heat, and damp or wet areas.

TABLE A: RECOMMENDED MINIMUM WIRE GAUGE FOR EXTENSION CORDS* (120/240 VOLT)

NAMEPLATE AMPERES (at full load)	EXTENSION CORD LENGTH				
	25'	50'	75'	100'	150'
0 – 2.0	18	18	18	18	16
2.1 – 3.4	18	18	18	16	14
3.5 – 5.0	18	18	16	14	12
5.1 – 7.0	18	16	14	12	12
7.1 – 12.0	18	14	12	10	-
12.1 – 16.0	14	12	10	-	-
16.1 – 20.0	12	10	-	-	-

* Based on limiting the line voltage drop to five volts at 150% of the rated amperes.

SETUP

Symbology

	Double Insulated
	Volts
	Alternating Current
	Amperes
	No Load Revolutions per Minute (RPM)

	WARNING marking concerning Risk of Eye Injury. Wear ANSI-approved safety goggles with side shields.
	Read the manual before set-up and/or use.
	WARNING marking concerning Risk of Fire. Do not cover ventilation ducts. Keep flammable objects away.
	WARNING marking concerning Risk of Electric Shock. Properly connect power cord to appropriate outlet.

OPERATION

MAINTENANCE

Specifications

Electrical Rating	120VAC / 60Hz / 1600W
Air Requirement	6.3 CFM
Temperature Range	120° to 1080°
Maximum Material Thickness	1/2"
Nozzle Sizes	A. Bent Tip (1-1/2" L) B. Angle Tip (1-3/4"L) C. Curved/Rounded Tip (2-1/8" L) D Speed Welding Tip

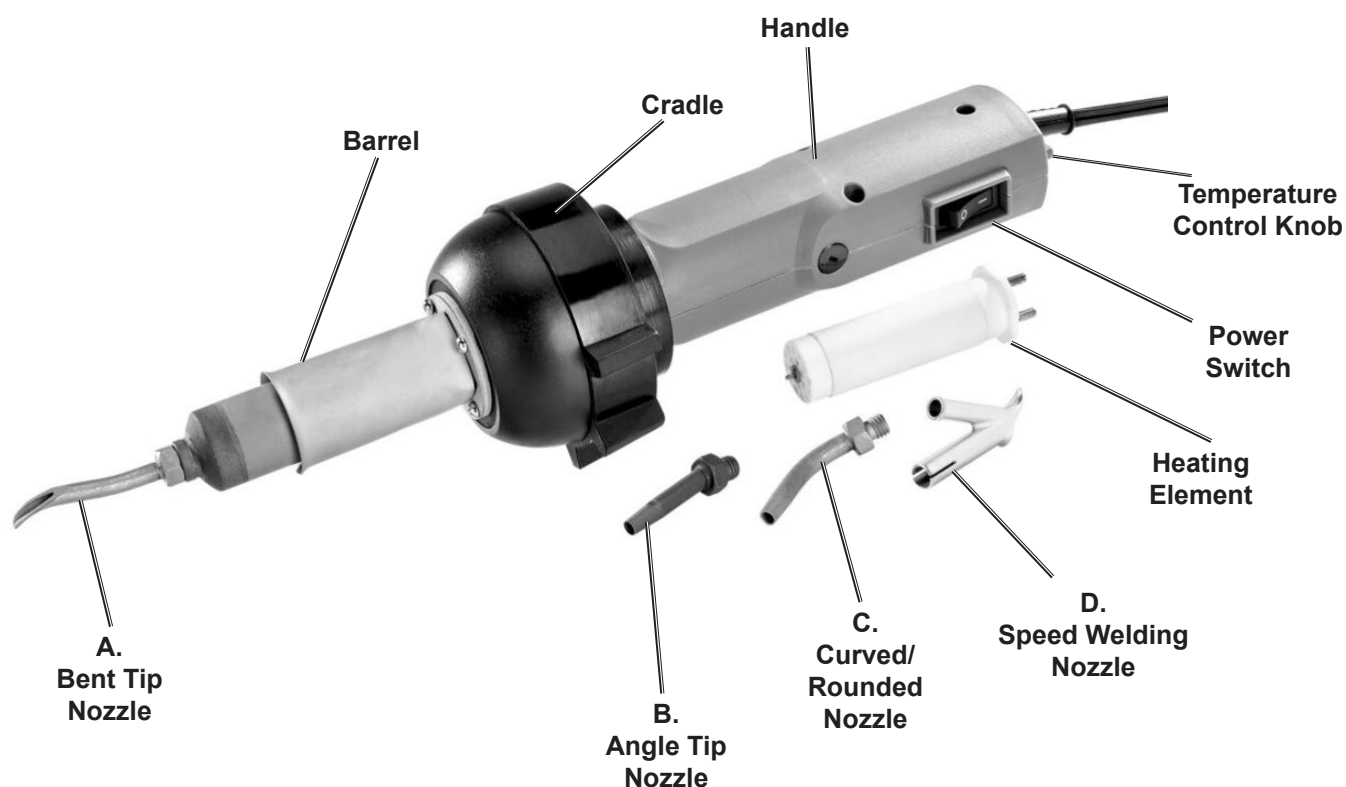
Setup - Before Use:



Read the **ENTIRE IMPORTANT SAFETY INFORMATION** section at the beginning of this manual including all text under subheadings therein before set up or use of this product.

Note: For additional information regarding the parts listed in the following pages, refer to *Parts List and Diagram* on page 11.

Functions



Operating Instructions



Read the **ENTIRE IMPORTANT SAFETY INFORMATION** section at the beginning of this manual including all text under subheadings therein before set up or use of this product.

Set Up

⚠ WARNING

TO PREVENT SERIOUS INJURY FROM ACCIDENTAL OPERATION:

Make sure that the Power Switch is in the off-position and unplug the tool from its electrical outlet before performing any procedure in this section.

1. If workpieces require beveled edge, cut edges to a 60° angle.
2. Clean workpieces with acetone (not included).

CAUTION! TO PREVENT INJURY: Follow acetone manufacturer's instructions.

3. Thread Nozzle onto tool, tighten using a wrench (sold separately).

NOTE: When welding two plastic sheets together at 90°, use Bent Nozzle for the tack weld first. Then use Angled Nozzle or Curved Nozzle for the line weld.

Nozzle Type	Heat Setting	Output
Angled Nozzle 	1	170°F
	2	440°F
	3	690°F
	4	800°F
	5	880°F
	6	920°F
	7	980°F
	8	1030°F
	9	1040°F
	10	1080°F
Curved Nozzle 	1	190°F
	2	300°F
	3	480°F
	4	600°F
	5	680°F
	6	780°F
	7	860°F
	8	910°F
	9	950°F
	10	980°F
Bent Nozzle 	1	170°F
	2	200°F
	3	490°F
	4	730°F
	5	780°F
	6	800°F
	7	860°F
	8	900°F
	9	910°F
	10	920°F
Speed Welding Nozzle		

Workpiece and Work Area Set Up

1. Designate a work area that is clean and well lit. The work area must not allow access by children or pets to prevent distraction and injury.
2. Route the power cord along a safe route to reach the work area without creating a tripping hazard or exposing the power cord to possible damage. The power cord must reach the work area with enough extra length to allow free movement while working.
3. Secure loose workpieces using a vise or clamps (not included) to prevent movement while working.
4. There must not be objects, such as utility lines, nearby that will present a hazard while working.

General Operating Instructions

WARNING!: TO PREVENT SERIOUS

INJURY FROM BURNS: Inspect tool before each use. Do not use if damaged.

WARNING!: The heat generated by the Plastic Welding Kit can cause serious burns. Observe all Safety Warnings and Precautions. Inspect the Plastic Welder for signs of damage prior to each use.

1. Set the Temperature Control Knob to "0". Make sure the Power Switch is in the off-position then plug the Power Cord into a 120 volt, grounded, electrical outlet.
2. Turn on the Power Switch. Adjust the Temperature Control Knob to reach the desired temperature. Allow the Plastic Welder to warm up for several minutes before starting to weld.
3. Allow air to run through the Nozzle to heat it up.
4. Carefully apply the Nozzle to the area to be joined.
5. With small pieces, weld them just enough to hold the pieces together. If the pieces are large, you may need to weld along the entire seam or connection point.
6. Avoid overheating tack points as doing so will cause the plastic to warp, burn, or discolor. Grind the tack points down to take off the edges.
7. When finished welding, set the Temperature Control Knob to "0". Rest the Plastic Welder on its Cradle to keep the hot Nozzle from touching any surfaces.
8. **IMPORTANT!** Keep the air flowing for several minutes to allow the Welder to cool.
9. To prevent accidents, turn off the tool and unplug it after use. Clean, then store the tool indoors out of children's reach.

Using Welding Rods

NOTE: Use the same type of welding rod as the material being joined.

CAUTION! Never place a welding rod inside the Nozzle.

1. Material up to 1/2" thick can be welded. As different types of plastic material will melt at different temperatures, the Temperature Control must be properly adjusted.
2. Hold the Welder with one hand. With the other hand, hold the welding rod. Hold the welding rod close to the Nozzle (1/4" to 3/8" away).
3. Proceed with welding operation.
4. When finished welding, set the Temperature Control Knob to "0". Rest the Plastic Welder on its Cradle to keep the hot Nozzle from touching any surfaces.
5. **IMPORTANT!** Keep the air flowing for several minutes to allow the Welder to cool.
6. To prevent accidents, turn off the tool and unplug it after use. Clean, then store the tool indoors out of children's reach.

Maintenance and Servicing



Procedures not specifically explained in this manual must be performed only by a qualified technician.

!WARNING

TO PREVENT SERIOUS INJURY FROM ACCIDENTAL OPERATION:

Make sure that the Power Switch is in the off-position and unplug the tool from its electrical outlet before performing any procedure in this section.

TO PREVENT SERIOUS INJURY FROM TOOL FAILURE:

Do not use damaged equipment. If abnormal noise or vibration occurs, have the problem corrected before further use.

Cleaning, Maintenance, and Lubrication

1. **BEFORE EACH USE**, inspect the general condition of the tool. Check for:
 - loose hardware,
 - misalignment or binding of moving parts,
 - damaged cord/electrical wiring,
 - cracked or broken parts, and
 - any other condition that may affect its safe operation.
2. **AFTER USE**, wipe external surfaces of the tool with clean cloth.

3. Always store the tool in a clean, dry, safe location out of reach of children and other unauthorized people.

CAUTION! All maintenance, service, and repairs not mentioned in this manual must only be performed by a qualified service technician.

4. **⚠ WARNING! TO PREVENT SERIOUS INJURY:** If power cord is damaged, it must be replaced only by a qualified service technician.

Troubleshooting

Problem	Possible Causes	Likely Solutions
Tool will not start.	1. Cord not connected. 2. No power at outlet. 3. Tool's thermal reset breaker tripped (if equipped). 4. Internal damage or wear. (Carbon brushes or Power Switch, for example.)	1. Check that cord is plugged in. 2. Check power at outlet. If outlet is unpowered, turn off tool and check circuit breaker. If breaker is tripped, make sure circuit is right capacity for tool and circuit has no other loads. 3. Turn off tool and allow to cool. Press reset button on tool. 4. Have technician service tool.
Tool operates slowly.	1. Forcing tool to work too fast. 2. Extension cord too long or cord diameter too small.	1. Allow tool to work at its own rate. 2. Eliminate use of extension cord. If an extension cord is needed, use one with the proper diameter for its length and load. See <i>Extension Cords</i> in <i>Grounding</i> section on page 5.
Performance decreases over time.	Carbon brushes worn or damaged.	Have qualified technician replace brushes.
Excessive noise or rattling.	Internal damage or wear. (Carbon brushes or bearings, for example.)	Have technician service tool.
Overheating.	1. Forcing tool to work too fast. 2. Blocked motor housing vents. 3. Motor being strained by long or small diameter extension cord.	1. Allow tool to work at its own rate. 2. Wear ANSI-approved safety goggles and NIOSH-approved dust mask/respirator while blowing dust out of motor using compressed air. 3. Eliminate use of extension cord. If an extension cord is needed, use one with the proper diameter for its length and load. See <i>Extension Cords</i> in <i>Grounding</i> section on page 5.
Weld does not penetrate joint.	1. Insufficient weld heat. 2. Incorrect fill material.	1. Increase potentiometer setting slightly. 2. Make sure that fill material is appropriate for material being welded.
Plastic starts to break down, smoke, or burn.	Too much weld heat.	Make sure to have adequate ventilation. Decrease potentiometer setting slightly.
Unsatisfactory weld.	Potentiometer not properly adjusted.	Refer to the plastic material manufacturer's manual to determine the proper heat required. Then set the Potentiometer to the proper heat setting.



Follow all safety precautions whenever diagnosing or servicing the tool. Disconnect power supply before service.

PLEASE READ THE FOLLOWING CAREFULLY

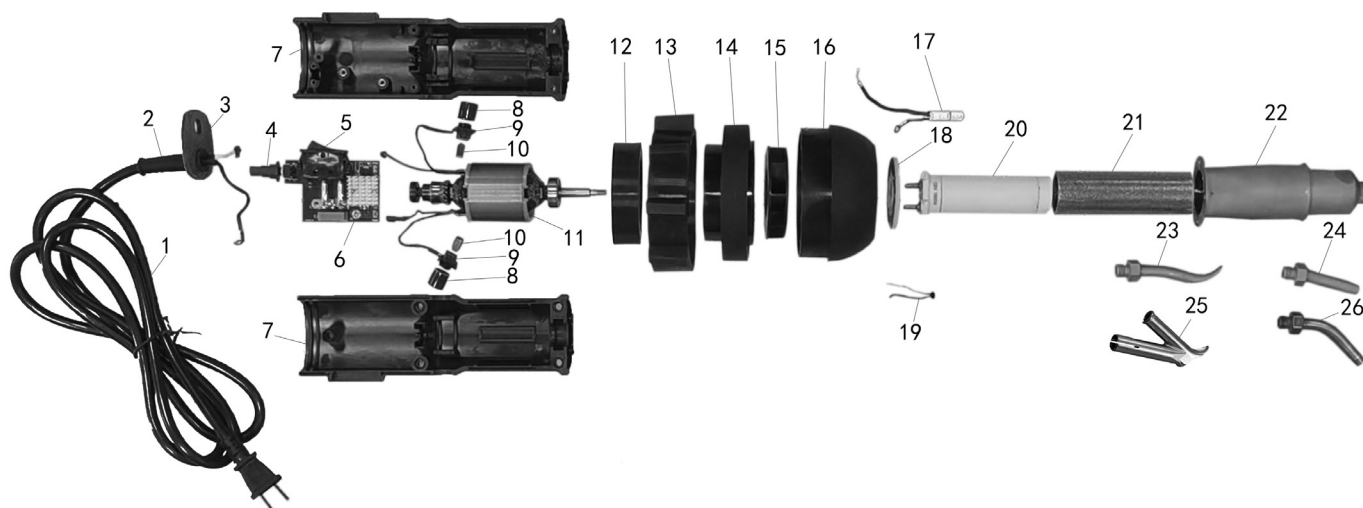
THE MANUFACTURER AND/OR DISTRIBUTOR HAS PROVIDED THE PARTS LIST AND ASSEMBLY DIAGRAM IN THIS MANUAL AS A REFERENCE TOOL ONLY. NEITHER THE MANUFACTURER OR DISTRIBUTOR MAKES ANY REPRESENTATION OR WARRANTY OF ANY KIND TO THE BUYER THAT HE OR SHE IS QUALIFIED TO MAKE ANY REPAIRS TO THE PRODUCT, OR THAT HE OR SHE IS QUALIFIED TO REPLACE ANY PARTS OF THE PRODUCT. IN FACT, THE MANUFACTURER AND/OR DISTRIBUTOR EXPRESSLY STATES THAT ALL REPAIRS AND PARTS REPLACEMENTS SHOULD BE UNDERTAKEN BY CERTIFIED AND LICENSED TECHNICIANS, AND NOT BY THE BUYER. THE BUYER ASSUMES ALL RISK AND LIABILITY ARISING OUT OF HIS OR HER REPAIRS TO THE ORIGINAL PRODUCT OR REPLACEMENT PARTS THERETO, OR ARISING OUT OF HIS OR HER INSTALLATION OF REPLACEMENT PARTS THERETO.

Parts List

Part	Description	Qty
1	Power Cord	1
2	Power Cord Sheath	1
3	Mesh Sheet	1
4	Temperature Control Knob	1
5	Power Switch/Cover Assembly	1
6	Control Circuit Board	1
7	Motor Housing	2
8	Carbon Brush Cap	1
9	Carbon Brush holder	1
10	Carbon Brush	1
11	Motor Assembly	1
12	Rubber Ring	1
13	Cradle	1

Part	Description	Qty
14	Fan Volute	1
15	Fan Cover	2
16	Fan Head Housing	1
17	Heat Protector	1
18	Insulation Washer	2
19	Temperature Sensor	1
20	Heating Element	2
21	Insulating Tube	1
22	Barrel	1
23	Bent Nozzle	1
24	Angled Nozzle	1
25	Speed Welding Nozzle	1
26	Curved Nozzle	1

Assembly Diagram



Record Product's Date Code Here: _____

Note: If product has no Date Code, record month and year of purchase instead.

Note: Some parts are listed and shown for illustration purposes only, and are not available individually as replacement parts. Specify UPC 193175477682 when ordering parts.

Limited 90 Day Warranty

Harbor Freight Tools Co. makes every effort to assure that its products meet high quality and durability standards, and warrants to the original purchaser that this product is free from defects in materials and workmanship for the period of 90 days from the date of purchase. This warranty does not apply to damage due directly or indirectly, to misuse, abuse, negligence or accidents, repairs or alterations outside our facilities, criminal activity, improper installation, normal wear and tear, or to lack of maintenance. We shall in no event be liable for death, injuries to persons or property, or for incidental, contingent, special or consequential damages arising from the use of our product. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation of exclusion may not apply to you. THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

To take advantage of this warranty, the product or part must be returned to us with transportation charges prepaid. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection verifies the defect, we will either repair or replace the product at our election or we may elect to refund the purchase price if we cannot readily and quickly provide you with a replacement. We will return repaired products at our expense, but if we determine there is no defect, or that the defect resulted from causes not within the scope of our warranty, then you must bear the cost of returning the product.

This warranty gives you specific legal rights and you may also have other rights which vary from state to state.



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