TEXTILES COATED
TCI
INTERNATIONAL

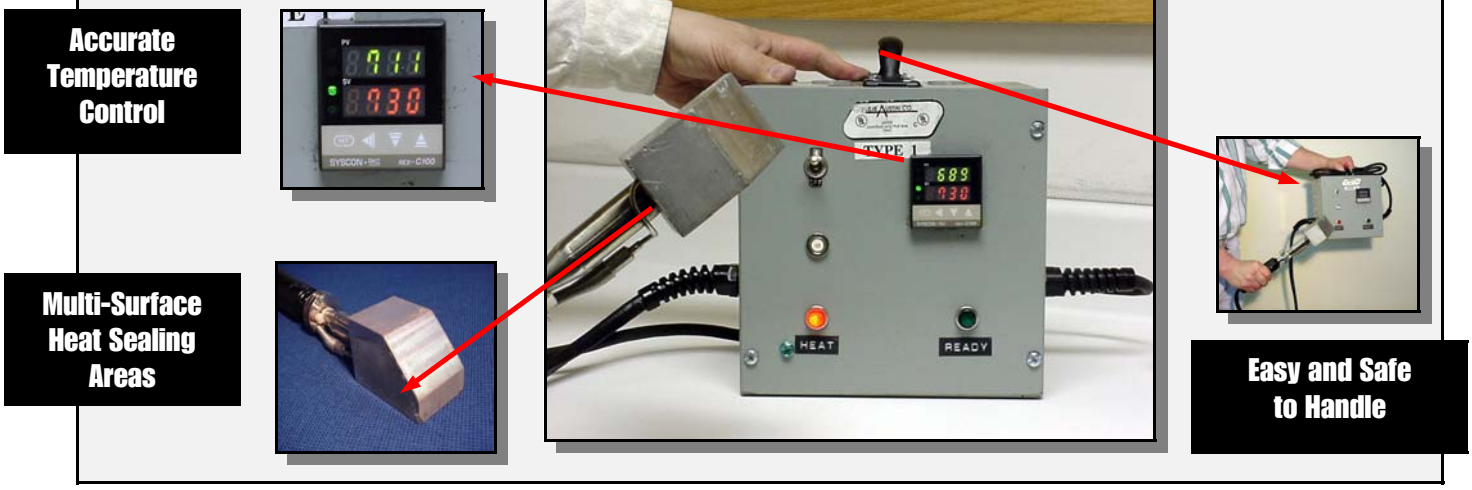
HEAT SEALER EQUIPMENT

PO Box 532/105 Rt. 101A Amherst, NH 03031 (603) 883-9932 FAX (603) 883-9956 www.textilescoated.com

Company Profile **TCI** manufactures high-performance PTFE materials for industrial applications. These materials often require thermal-welding (heat sealing) in field service. Cost effective and easy-to-use heatsealers are manufactured by **TCI** for use with **TCI** materials.

Product Description The main function of a heat sealer is to introduce enough heat to allow a proper bond between PTFE surfaces of **TCI** material. The melting point of PTFE is around 621°F (327°C). However, the setting of a heat sealing iron is determined by factors like ambient temperature, thickness of bonding materials, and the surface upon which you heat seal. Applying pressure can help facilitate a good bond, but in order to achieve a correct bond, the melting point of the **TCI** materials must be reached.

HEAT SEALER FEATURES



Heat Sealer Operation To operate the Heat Sealer, proceed with the following directions:

* Plug the unit into an electrical outlet.
* Push the toggle switch up to the "on" position.
* Set the temperature by turning the dial to the desired temperature. A temperature range of 700°-740ºF (370-385ºC) is typical for **TCI** materials.

The unit contains two lights, a "**heat up**" light and a "**ready**" light. The "**heat up**" light will remain lit until the unit reaches the set temperature, at which point the "**ready**" light will go on.

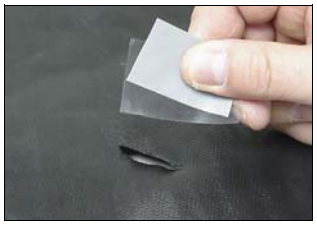
SAFETY PRECAUTIONS Experience has shown fluoropolymers can be processed and used at elevated temperatures without hazard if proper ventilation is used. Make certain all heat sealing is performed in well ventilated areas. Make certain the heat sealer is safely handled during use. The heat sealer temperature will reach 725°F in normal operation. Special care must be taken with the heat sealer during handling due to the high temperature.

INSTRUCTIONS CONTINUE ON REVERSE

STEP No. 1

Prepare a surface that will not CONDUCT AWAY the heat. The needled fiberglass shown in this picture is ideal for this purpose.

STEP No. 2

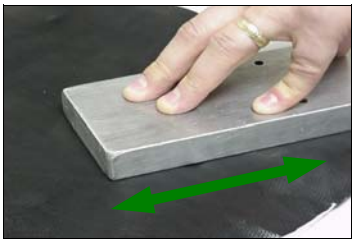


A PFA adhesive is recommended for best sealing performance with **TCI** materials. Place the PFA between the two surfaces to be sealed. PFA thicknesses of 0.005" or 0.010" are typically used.

STEP No. 3

Bring the heat sealer in contact with the splice area. Make sure the heat sealer has reached the set point temperature of 700°-740°F (371°-385°C) before using.

STEP No. 4



Once the sealer is removed it is recommended that the heated area is cooled and smoothed with a flat aluminum block.

STEP No. 5

When the heat seal has been completed, remove the sealer. Allow the patch to cool to room temperature before handling. A gray patch is being used to show contrast.

IMPORTANT

Inspect both sides of the cover to ensure that the repair has been done properly. The repair is complete and the cover is ready for service.

Product Specifications

TCI		
Product	***3 X 6 Heat Sealer***	***Block Head***
Platen Dimensions	**3" x 6" (76 x 152 mm)**	**2" x 2"x 3" (50.8 x 50.8 x 76.2 mm)**
Supply Voltage	**120 Volts or 240 Volts**	**120 Volts or 240 Volts**
Current	**7.1 Amps @ 120 Volts 3-1/2 Amps @ 240 Volts**	**2 Amps @ 120 Volts 1 Amps @ 240 Volts**
Controller	**Fenwal Series 54-4**	**Fenwal Series 54-4**
Weight	**12.5 lbs (5.7 kg)**	**5.5 lbs (2.5 kg)**
Wattage	**850 Watts**	**200 Watts**
Frequency	**60/50 Hz**	**60/50 Hz**