



112EX Key Settings Cheat Sheet

- The three factors necessary to achieve a good weld are heat, speed, and pressure.
- When the above factors kept consistent, the easier it is to adjust.
 - For example, if you consider that typical weld pressure with a silicone roller will be 10psi and set the temp at the max (730c), the only variable to adjust will be the speed.
- Heat and speed play directly off of each other. If you want to run faster, you need to run hotter. If you want to run slower, you need to run cooler. If you are seeing excessive waving or glazing, there is too much heat and you may need to run cooler or faster.

Weld Pressure is the force being applied by the roller against the weld track. If we are seeing appearance issues on a good weld, such as pinching or material being “bulldozed” out of position, our weld pressure may be too high. The goal for weld pressure is to have it as low as possible while still achieving a good weld.

Clutch Pressure is the rate at which the roller is turning relative to the speed of the head carriage. When joining two pieces in an overlap, the clutch ensures that the pieces will remain the same length. If you are welding two same-length pieces and the top piece finishes longer than the bottom, the clutch is too low. If the top piece finished shorter than the bottom, the clutch is too high. Turn the clutch up higher when running hems to keep the material properly in the guide.

Drive Delay is the amount of time that the head carriage is delayed from moving which allows the heat system to move in.

IMPORTANT: Nozzle position consistency is necessary to maintain the integrity of recipes. If the nozzle is not always set in the same position, recipes will yield different results. The nozzle should be 1/8” above the weld track, 1/8” from the weld roller, parallel to the weld track, and square to the roller.