

# TB0250 Fault Finding Welding Issues

Welding Issues - particularly with Y notches - can have a number of root causes outside the Stuga Machine. This checklist identifies a number of potential root causes that have been regularly known to occur

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## Technical Bulletin

<b>TB Number:</b>	250
<b>Originator:</b>	Gareth Green
<b>Machine:</b>	All
<b>Date:</b>	03/04/14
<b>Circulate to:</b>	Service
<b>Title:</b>	Welding Issues

## Symptoms

Code	Description
	Windows incorrect size / bowed / not parallel
	Weld not consistent top to bottom
	Poor finish on ovolo
	Dog leg on reverse butt weld
	V notches too deep
	Q-Cuts incorrect
	Incorrect parts / profile
	Coloured on White orientation incorrect
	Scrapes / damage to profile surface
	Weak welds
	Windows Ok from one welder, no good from another

## Actions / Checks

Code	Description	Tick
	Profile storage - temperature	
	Bowed profile	
	Profile width within tolerance	
	Saw blade blunt / damaged	
	V notch blade blunt / damaged	

	Cutter blunt	
	Check clamping / accuracy / alignment	
	Check office link has correct codes	
	Heater plate temperatures	
	Profile have concave / convex face	
	Setting plates out of square	
	Setting blocks	
	Welding pressure	
	Inexperienced operator on welder	
	General Welder setup - has it been serviced	
	Profile not square / twisted / not parallel / symmetrical	
	Burn off on reverse butt	
	Timing on reverse butt welder	
	Profile slipping in weld cycle	
	Backfence on welder not square	
	Teflon on heater plates not changed	
	Pulling pressure on corner cleaner	
	Check same window on all different welders, especially butt welders	