

## MANUAL FOR USING PLASTIC PIPE WELDING MACHINE

- 1- a- Before mounting, socket and assembly parts are to be wiped with a clean piece of cloth  
 b- The pipes should be cut vertically by Plastic Pipe Cutter.  
 c- Take out the welding machine from the bag and set it on the floor base.  
 d- According to the pipe and fitting size, mount the female and male part of the socket to the heating plate.  
 e- Adjust the temperature indicator of the thermostat to 260°C
- 2- Try the first use of the newly purchased machine outdoors. The reason of that is the special material used for the isolation between the iron part of the machine and the body. It causes smoke and smell for a short period of time.
- 3- Do not let children and animals (pets) to come close to machine.
- 4- When the machine starts to operate, the iron plate is heated. Therefore do not touch the heating iron in any way with your hands or arms, etc.
- 5- If tool is not used, it should be placed at its special stand.
- 6- Connect the machine to a grounded socket of 220-240 Volts.
- 7- a- The machine is equipped with an on/off button and green lamps are lighted at the first start.  
 When the set temperature is reached, green lights turn into red signals. (CM-01, CM-02, CM-04, CM-05 Model)  
 b- The machine is equipped with an on/off button and RED SIGNAL lamps are lighted at the first start. When the set temperature is reached, these lamps go off. (CM-03, CM-06 Model)
- 8- Except CM-02 model, all other machines in the product range are equipped with double resistance. You can put on and use both switch keys for fast heating. After the machine is heated, you may put off one of the keys.
- 9- When the heating temperature of the iron plate reaches the adjusted by thermostat degrees, replace the pipe to the female part of the socket and accordingly the pipe fitting to the male part firmly. According to the pipe diameter, wait during the time value shown in the table below. After this time period, get the pipe and the fitting out of the sockets and connect them quickly to each other. After connecting two parts, please wait as long as the cooling time value shown in the table below.
- 10- Do not let the heating plate to get contact with the electric cable and plug.
- 11- The machine is not to be subjected to strokes in any way.
- 12- Cooling of the machine is to be by itself using air. Avoid using water for cooling.
- 13- Do not let the machine touch water.
- 14- Use battery connection scale and fitting element for installing the faucet.
- 15- After welding operation is finished, apply water under pressure by using the "Test Pressure Pump" in order to check if any leakages.
- 16- Do not use the Welding Machine and the cutter for any other purpose than plastic pipes.
- 17- After welding operation is finished, keep the machine on its foot base to get cooled and then pack it into the case.
- 18- In case of any damages or faults don't repair the machine. It should be taken only to authorized service.
- 19- When the machine is used not in accordance with the operating instructions, responsibility fully belongs to the customer.
- 20- Socket with worn Teflon is not to be used in welding operation.
- 21- Socket is to be cleaned using a clean piece of cloth soaked with water-alcohol mixture.
- 22- This device is not intended for use by people with lack of physical, sensory or mental capabilities (including children) or experience and lack of information, unless the supervision and management is not provided in respect of the use of the device by a person responsible for the device's security.
- 23- Children should be kept under surveillance to assure they do not play with the device.
- 24- The welding process should not be repeated on connection element (fitting).
- 25- If the supply cord is damaged, this cord must be replaced by the manufacturer or its service agent or equally qualified personnel to avoid a dangerous situation.
- 26- Do not use the ungrounded outlet.
- 27- Our machine do not include asbestos, mercury and Polychlorurbiphenyl (PCB).

### WELDING TIME TABLE OF PP-R PIPES

PIPE SIZE		HEATING TIMES	OPERATING TIMES	COOLING TIMES
mm	inch	(Sec.)	(Sec.)	(Min.)
16	3/8	5	4	2
20	1/2	5		
25	3/4	7		
32	1	8	6	4
40	1 1/4	12		
50	1 1/2	18		
63	2	24	8	6
75	2 1/2	30	8	8
90	3	40	8	8
110	3 1/2	50	10	8
125	4	60	10	8
Saddles – All Sizes		30	15	10

**TABLE:** DVS 2207 PART 11

**NOTICE:** Pipes with aluminum folio are to be peeled with special shaver before welding operation.



## INSTRUCTIUNI DE UTILIZARE PENTRU SETUL DE SUDURA PPR

- 1- A - Inainte de montaj, matritile si partile care se asambleaza trebuie bine curatate cu o carpa, iar teava trebuie taiata drept.
  - B – Scoateti aparatul de sudura din ambalaj si asezati-l pe suport.
  - C – Montati pe aparat matrita cu diametrul corespunzator tevii si fitingului de sudat.
  - D – Setati indicatorul de temperatura al aparatului la 270°C.
- 2- Inainte de a utiliza prima data aparatul, efectuati un test in aer liber. Testul se executa in aer liber deoarece se utilizeaza un material special ca izolatia intre placa incalzitoare si corpul aparatului. La prima utilizare a aparatului, datorita incalzirii materialului izolan, se produce fum si se degaja un miros neplacut. Dupa o scurta perioada aceste efecte neplacute dispar, functionarea aparatului revenind la normal.
- 3- Este interzis accesul copiilor si animalelor domestice in zona de utilizare a aparatului de sudura.
- 4- Cand aparatul porneste, placa metalica se incalzeste. Este interzisa atingerea partii metalice!
- 5- Legati aparatul la o priza de 220 V, cu impamantare.
- 6- Aparatul este echipat cu un buton on/off, iar ledul ROSU se aprinde la punerea in functiune. Cand se atinge temperatura de lucru, acest led se stinge.
- 7- Aparatul este echipat cu o rezistenta dubla. Pentru o incalzire mai rapida, se pot folosi ambele butoane. Dupa incalzirea aparatului, poate ramane apasat numai unul din acestea.
- 8- Cand se atinge temperatura setata, se apropie usor capatul tevii de matrita mama, respectand unghiul corect, fitingul fiind pozitionat de cealalta parte, in matrita tata.
- 9- Evitati contactul dintre partile incalzite ale aparatului si stecherul sau cablul electric!
- 10- Evitati socurile datorate lovirii aparatului!
- 11- Aparatul este cu autoracire, utilizand aerul din ambient. Evitati racirea cu apa!
- 12- Nu permiteti contactul aparatului cu apa!
- 13- Folositi sablonul din dotare pentru a efectua legarea bateriilor.
- 14- Dupa ce ati efectuat sudura, executati testul de etanseitate, introducand apa sub presiune in tevile sudate.
- 15- Nu folositi aparatul de sudura pentru alt tip de tevi decat cele din material plastic!
- 16- Dupa ce ati utilizat aparatul, asteptati sa se raceasca si apoi puneti-l la loc in trusa.
- 17- Nu demontati aparatul pentru reparatii!
- 18- Clientul isi asuma intreaga responsabilitate in cazul in care nu se respecta instructiunile de utilizare.
- 19- Este interzisa utilizarea matritelor uzate din teflon in procesul de sudura.
- 20- Matritile se curata cu o carpa curata, imbibata cu apa si alcool.

### TABEL TIMPI DE SUDURA

DIAMETRUL INTERIOR AL TEVII		TIMP DE INCALZIRE (Sec)	TIMP DE LUCRU (Sec)	TIMP DE RACIRE (Min)
mm	inch	(Sec.)	(Sec.)	(Min.)
16	3/8	5	4	2
20	1/2	5		
25	3/4	7		
32	1	8	6	4
40	1 1/4	12		
50	1 1/2	18		
63	2	24	8	6
75	2 1/2	30	8	8
90	3	40	8	8
110	3 1/2	50	10	8
125	4	60	10	8

**NOTA:** Pentru a efectua imbinarea “palstic-plastic”, la tevile cu folie din aluminiu se razuieste insertia metalica inainte de a efectua sudura.