

User's manual

Plastic pipeline meeting

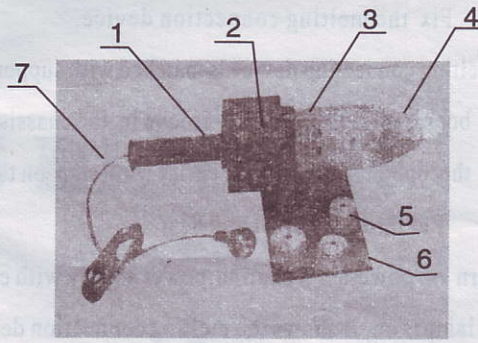
Connection device:

Caution

- 1) Please check the outer cover and cables of the meeting connection device first. Don't use it if it is damaged
- 2) Meeting Connection device adopts the single-phase tertiary safety flat plug, user can't change the plug at will, the power should with earth connection.
- 3) Meeting Connection device is prohibited to use outside when it is raining, and prevent water & various kinds of liquid form entering into meeting connection device.
- 4) Operator must operate and change bonding tool with wearing gloves while the device is in working normally.
- 5) The device should be paid attention to laying, prevent personnel and property from damaging.
- 6) Chassis of meeting connection device can't be opened willly, so as not to get an electric shock and destroy the safety performance of the machine
- 7) If indicator lamp are not changed for a long time, it shows the device is in non-normal working state, it should be quit work immediately and cut off the power.
- 8) Check insulating ability regularly in the course of using, the device should be stopped working as soon as basic insulating is destroyed.
- 9) The device should be sent to manufacturer to repair if it is out of order.

Product Structure

1. Chassis
2. indicator
3. heat insulation cover
4. heated board
5. bonding tool
6. support board
7. cable



三. Technological data

Surface temperature of the bonding tool: 0°C~300°C

temperature rising time: <15min

rated power: 800W

Voltage: 220V A.C

Frequency: 50HZ

Size of bonding tool: see table 1

unit: mm

Pipeline specification	Internal diameter of concave head	Internal diameter of Protruding heat	Heat melting depth
20	14	5	4
25	16	7	4
32	20	8	4
40	21	12	6
50	22.5	18	6
63	24	24	6

1. installation & heaten the bonding tool.

According to specification needed, to install the corresponding bonding tool with inside hex screw, screw can't be twisted too tight while cooling, otherwise, the thread of bonding tool will be damaged easily. Generally, the small is in front of the big while installing.

In working state, be careful while changing the bonding tool.

2. Fix the melting connection device.

Melting connection device is matched with support board special-purposly,the board is fixde by the fix-groove in the chassis, simple & convenient. Make the operator operate be.easier with step on the support board.

3. Put throuth power and heat

Turn on power(caution:power supply with earth wire),the red indicator lamp is on, it shows the melting connection device is heatenig, if the green indicator is on, it shows the device stop heatening. After a while, the red indicator lamp is on again,it shows melting connection device enterinto the state of control & keep temperature, it can begin to work.

4. Melting pipeline

Cutting off the pipeline with cut device,advance the pipeling & pipe fitting in the bonding tool in same time and heaten for several seconds(see table 2) and then,pull out them rapidly to move forward perpendiculary.It is not too big to exert while moving forward in order to prevent the head being crooked.

Note:within fixed processing time,the connect can be corrected,however,it is prohibited to rotate. Melting connection request.

Unit:mm

external diamter	heat melting depth	hheat time	process time	ccool time
20	14	5	4	3
25	16	7	4	3
32	20	8	4	4
40	21	12	6	4
50	22.5	18	6	5
63	24	24	6	6