



WELDING MACHINE

- POLYPROPYLENE DISTRIBUTION SYSTEM -

PIPE TECH Italia

tecnologia della plastica

PIPETECH ITALIA S.R.L.

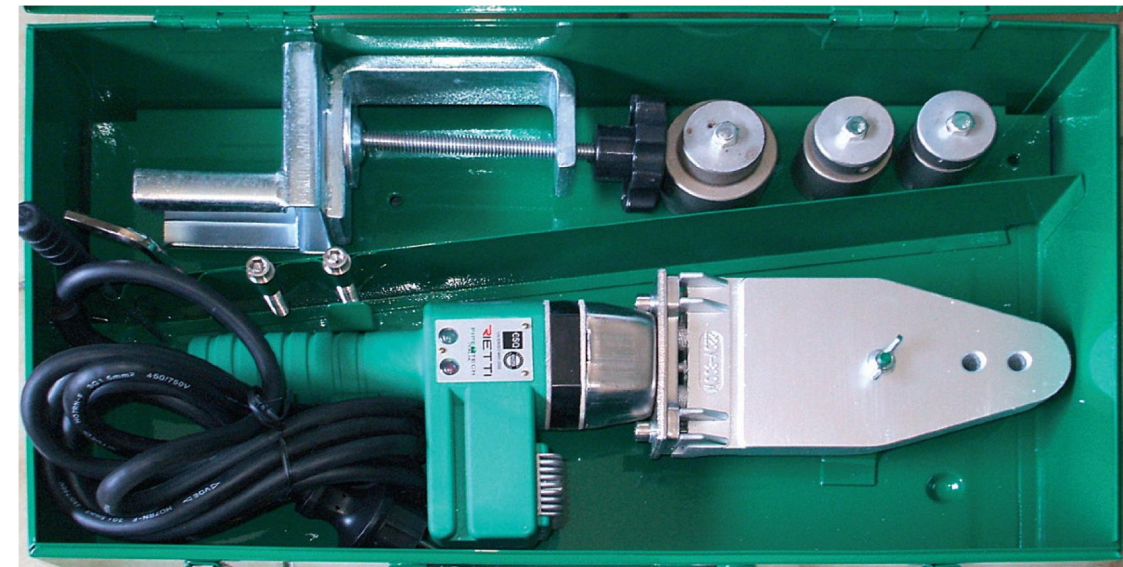
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RT-63 - RTE-63

1. Brief introduction

These series of plastic pipe socket fusion machines are new types of hand electro thermal tools for fusing and connecting plastic pipes including PPR,PB and HDPE. The machine is composed of quality electric heating plate, electric controller, comfortable nylon plastic handle shell and high quality welding sockets. There are 2 series with different size and operation for meeting different customer’s requirement .RJQ series is based on the standard and regular hand welder with the new controller added for overheat protection and easy operation. This provides an excellent fusion result.

Digital series of ZRJQ and ZRJQ-T models add a digital controller and screen for improving the accuracy of the temperature to fusion . The temperature range can set as different material pipes demand, required fusing temperature can fix and display on the screen, environment temperature will be adjusted and updated automatically, over-temperature will be alarmed automatically and etc. This provides a more excellent fusion result.

❖ Please read this instruction carefully to ensure safe operation of the machine.

The welding machine series comply with the following specification:

2. Technical data

Table 1 – Technical data

Specifications	Specified volt	Specified frequency	Specified watt	Surface temperature of heating tool	Time <min
	V~	Hz	W	C°	
RT-63	(110)220/230	(60) 50	800/900	260	10
RTE-63	(110)220/230	(60) 50	800/900	200-279	10

Table 2 – Heating tool

Specification of pipes Ø	Internal diameter of concave head Ø	Internal diameter of convex head Ø	Heat-fusing depth
20	19.78±0.04	19.38±0.04	14
25	24.77±0.04	24.32±0.04	16
32	31.75±0.04	31.26±0.04	18
40	39.76±0.04	49.20±0.04	20
50	49.68±0.06	49.19±0.06	23
63	62.60±0.06	62.10±0.06	27
75	74.59±0.06	74.00±0.06	31
90	89.57±0.06	88.93±0.06	35
110	109.49±0.06	108.80±0.06	41

Guarantee receipt of welding machines

Customer’s name:

Address:

Phone

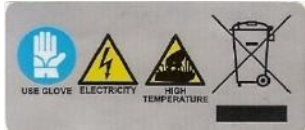
E-mail:

Purchase date:

Purchase place:

Identification number:

1. Environment temperature compensate automatically:
This machine has a environment temperature automatically compensate function, when the environment temperature is lower than 7°C, the machine will increase the set temperature 10°C more, when the environment temperature is higher than 30°C, the machine will decrease the set temperature 8°C less. When the environment temperature has big deviation, the worker can set the temperature by himself to get the requested temperature.
2. Defaulted temperature
The set temperature of this machine is 260°C.
3. Other points of attention are same as RT type.



RT-63 TYPE

Product structure

- Handle shell
- LED
- Heat insulation cover
- Heating plate
- Supporting stand
- Electrical wire

Points of attention

1. The handle shell of the product is strong and reliable, the electric wire is standard with grounding safty plug. Please insert the plug into the safe outlet when using the machine. The plug shouldn't be changed arbitrarily.
2. In order to protect the safety of persons and property, make sure to place the machine safe when it works normally
3. Warning! When the machine is not used but it is heating or cooling, you should put it on the supporting stand
4. Be careful of high temperature when the fusing machine works normally. In order to avoid hurt the skin, you must wear gloves when operating or changing welding socket.
5. Don't open the handle shell of the fusing machine to avoid electric shock or the damage of machine structure.
6. The fusing machine cannot be used in the rain at outdoors. Escape from water and other kinds of liquid go into the internal part.
7. If the electric wire is broken, it should be changed in the appointed maintenance store or distributor because it needs special tools.
8. When you finished the fusing work, you must pulled out the plug first, and after the machine becomes cool, put it back to the box.
9. Fix the welding sockets: according to specifications,fix welding sockets with M8×45 hex key screws. Do not screw too firmly when the machine is cool, as the screw tread will be damaged when disassembled at work. Be carefully when changing the welding sockets under work. The disassembled welding sockets should be stored appropriately. Do not damage the surface coat of welding socket, as it will cause stick the plastic on and influence working quality and reduce the lifetime of welding sockets.
10. Fix the fusing machine: The fusing machine is equipped with special supporting stand that can be fixed handle shell with both slots. It can be fixed firmly. The operator stepped on the supporting stand when using the machine and it makes operating easily and steadily.

Switch on the power and heat: Switch on the power (Warning: the power should have the grounding wire!!!),

Technical assistance

- All types of welding machines are safe, convenient, practical and reliable. It is guaranteed for one year. So the users should store the instructions well to make it as maintenance voucher.
- a) The factory will change any parts for free charge which the machine is proved to be poor quality in six months from the user buys the machine.
- b) After six months, any broken parts can be changed with cost price.
- c) The plastics pipe fusing machine has the factory mark on it. Any broken parts can be changed new with cost price.
- d) If you want to have further service, you can contact local agent or manufacturing factory.
- e) The users who without any agent in the locality can post the broken parts to the factory. The factory will bear all the charges in six months and collect cost fee and postage after six months. (The local users should bring the original invoice and the out of province's users should post and enclose the duplicating invoice.)

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11. then the red indicator lamp will be on. That means the fusing machine is being heated. When the red lamp is off and the green indicator lamp is on, it means the fusing machine stops heating. After a while, the red lamp will be on again and the fusing machine is in a state of keeping temperature and ready to work.(the process is often less than ten minutes.)
12. Fusing and connecting pipes: Use pipe cutter to cut pipes vertically. Push the pipes and fittings into the welding socket and heat for several seconds (Briefly in the Table3). Pull it out quickly and then push the heated pipes to heated pipe fitting exactly.Do not press extremely, in order to avoid bending pipes head.

Table 3 Fusing standards of pipes

External diameter (mm)	Fusing depth (mm)	Heating time (s)	Processing time (s)	Cooling time (min)
20	14	5	4	3
25	16	7	4	3
32	18	8	4	4
40	20	12	6	4
50	23	18	6	5
63	27	24	6	6
75	31	30	8	8
90	35	40	8	8
110	41	50	10	8

Note: If the surrounding is lower than 5°C, the heating time should be delayed 5%.

RTE-63 TYPE

Product structure

- Handle shell
- Digital controller with temperature display screen including following keys:
RDY and HEAT Indicator lamp, Down key , Up key , Alt Key ,Set Key
- Heat insulation cover
- Heating plate
- Supporting Stand
- Electrical wire

Points of attention

4. The suggestion temperature for below pipe:
PP-R 260℃
PB 240℃
HDPE 220℃
5. Set the temperature:
First press the key “SET” , it will display the original set temperature and with flickering on the unit, and if you press “Up key” or “Down key” , you can adjust the unit figures, if need adjust the data on the decimal figures (00-digit), you need to press the “Alt” key , and at the same time, decimal figures will be flicker, and press “Up” or “Down” key to adjust. The adjustment for the unit and decimal data is independent. Press the “Alt” key can repeat to adjust the unit and decimal figures. Temperature range is fixed, Maximum. is 279℃, Minimum is 200℃, after finish the temperature setting, please press the “SET” key once again, then the machine is ready to work.
6. Over-heating alarm:
When the machine make the buzz , it warns the temperature over 295℃, and you must switch off the power. After trouble shootings, the machine can work again.
7. Change the fuse:
The machine is equipped with fuse, when short circuit happens, the fuse can protect the machine. Please check the fuse is good or not when the machine have no display, if you find that the fuse is broken, please eliminate the fault then change the fuse.