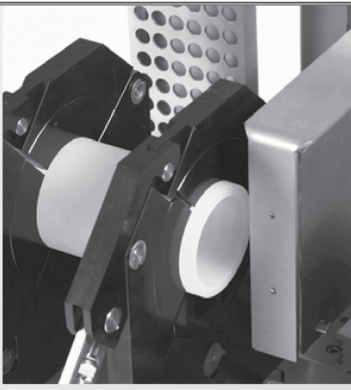


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SCHWEISSTECHNIK

User's Manual

HST 300 Manual USB 2.0

Inliegende deutsche Fassung der Anleitung ist der Urtext, welchen inliegende Übersetzungen wiedergeben.

The German version of the manual enclosed herein is the original copy, reflected in the translations herein.

La version allemande ci-après représente le texte original du manuel, rendu par les traductions ci-joint.

La versión alemana adjunta está el texto original de las instrucciones, que también representan las traducciones de esta.

Приложенная немецкая версия руководства является оригинальным текстом, с которого сделаны включенные переводы.

A versão em alemão desse manual anexo é a versão original, e foi a base para as traduções para as outras línguas.

Vejledningens tyske version er originalteksten, som de foreliggende oversættelser gengiver.



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HÜRNER

SCHWEISSTECHNIK

Version April 2019

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1 Introduction

Dear Customer:

Thank you very much for purchasing our product. We are confident that it will meet your expectations.

The HST 300 Manual USB 2.0 Welding Unit is designed exclusively for welding plastic pipe fittings according to the electrofusion process. It represents the next generation of the tried and tested HST 300 series, featuring a broader range of functions.

The product was manufactured and checked according to state-of-the-art technology and widely recognized safety regulations and is equipped with the appropriate safety features.

Before shipment, it was checked for operation reliability and safety. In the event of errors of handling or misuse, however, the following may be exposed to hazards:

- the operator's health,
- the product and other hardware of the operator,
- the efficient work of the product.

All persons involved in the installation, operation, maintenance, and service of the product have to

- be properly qualified,
- operate the product only when observed,
- read carefully and conform to the User's Manual before working with the product.

Thank you.

2 Safety Messages

2.1 Using the Correct Connection Terminal

Use the appropriate connection terminal that is compatible with the fitting type used. Be sure the contact is firmly established and do not use connection terminals or terminal adapters that are burnt or not designed for the intended use.

2.2 Improper Use of the Welding and Power Supply Cables

Do not carry the product by its cables and do not pull the

power cord to unplug the unit from the socket. Protect the cables against heat, oil, and cutting edges.

2.3 Securing the Fitting and the Joint

Use positioner clamps or a vice to secure the fitting and the joint to be made before welding. The fitting manufacturer's installation instructions, local and national regulations have to be respected in all cases.

A welding process must never be repeated with the same fitting, since this may cause parts under power to be accessible to the touch.

2.4 Cleaning the Product

The product must not be sprayed with or immersed in water.

2.5 Opening the Unit



The cover of the product may be removed only by specialized staff of the manufacturer or of a service shop properly trained and approved by it.

2.6 Extension Cables on the Worksite

To extend power cord length, use exclusively properly approved extension cables that are labeled as such and have the following conductor sections:

up to 20 m: 1.5 mm² (2.5 mm² recommended); Type H07RN-F
over 20 m: 2.5 mm² (4.0 mm² recommended); Type H07RN-F



When using the extension cable, it has always to be rolled off completely and lie fully extended.

2.7 Checking the Product for Damage

Before every use of the product, check safety features and possibly existing parts with minor damage for proper function. Make sure that the push-on connection terminals work properly, that contact is fully established, and that the contact surfaces are clean. All parts have to be installed correctly and properly conform to all conditions in order for the product to function as intended. Damaged safety features or functional parts should be properly repaired or replaced by an approved service shop.

2.8 General Remark

Comply with the indications and instructions about product maintenance to ensure proper and safe work. Use

only accessories and spare parts that are recommended or approved by the manufacturer. Using other parts or accessories may put yourself in danger of bodily injury or cause the device to malfunction.

2.9 Power Supply Specifications

2.9.1 Mains Power Supply

Utility suppliers' wiring requirements, occupational safety rules, applicable standards, and national codes have to be respected.



Caution

When using power distributions on the worksite, rules for the installation of earth-leakage circuit breakers (RCD) have to be respected, and operation requires an installed breaker.

Generator or mains power fuse protection should be 16 A (slow blow). The product has to be protected against rain and humidity.

2.9.2 Generator Power Supply

The required nominal generator capacity as determined by the power supply requirement of the largest fitting to be welded depends on the power supply specifications, the environment conditions, and the generator type itself including its control/regulation characteristics.

Nominal output power of a generator 1-phase, 220 - 240 V, 50/60 Hz:

d 20.....d 160	3.2 kW
d 160.....d 450	4 kW mechanically regulated
	5 kW electronically regulated

Start the generator first, then connect the welding unit. The idle voltage should be set to approx. 240 volts. When turning the generator off, disconnect the welding unit first.



Important

The working output power of the generator decreases by about 10% per 1,000 m of altitude. During the welding process no other device connected to the same generator should be operated.

3 Service and Repair

3.1 General

As the product is used in applications that are sensitive to safety considerations, it may be serviced and repaired only by the manufacturer or its duly authorized and trained partners. Thus, constantly high standards of operation quality and safety are maintained.

Failure to comply with this provision will dispense the manufacturer from any warranty and liability claims for the product, including any consequential damage.

When serviced, the unit is upgraded automatically to the technical specifications of the product at the moment it is serviced, and we grant a three-month functional warranty on the serviced unit.

We recommend having the product serviced at least every twelve months.

Any provisions in the law pertaining to an electrical safety inspection have to be complied with.

3.2 Transport, Storage, Shipment

The product ships in a transport box. The product should be stored in this box, protects the product from humidity and environmental agents.

When sending the product, it should be placed into the transport box at all times.

4 Principles of Operation

The HST 300 Manual USB 2.0 allows welding electrofusion fittings that require of welding voltage from 8 V to 48 V. Every fitting has its own, specific welding voltage and welding time. For a proper welding operation, these data have to be entered manually.

The microprocessor-controlled HST 300 Manual USB 2.0 Welding Unit controls and monitors the welding process in a fully automated fashion. While doing so, the sensor on the welding cable cycles to measure to ambient temperature and to adjust the welding time based on it.

All data that are relevant for the weld or for traceability are saved to the internal memory and can be sent to a USB stick.

The unit monitors the characteristics of its power supply continuously. If one of these is out of tolerance, welding is aborted or cannot be started.

5 Check-out and Operation

- To operate the welding unit, be sure that it is set on a proper, level surface.
- Be sure that power supply/generator protection is 16 A (slow blow).
- Plug the power supply cord into the mains power supply or the generator.
- Read and comply with the User's Manual of the generator, if applicable.

5.1 Turning the Welding Unit on

After connecting the power supply cable to mains power or a generator, turn the welding unit on using the On/Off switch. This causes Display 1 to show.

Then the screen changes to Display 2.

```
*****  
HUERNER  
HST300 ManualUSB 2.0  
*****
```

Display 1

```
Connect fitting  
14:32:11 21.10.12  
Inp.Volt. 230V 50Hz  
No Contact
```

Display 2



Caution

CAUTION in case of System Errors!

If during the auto-test that the unit performs at start-up, an error is detected, a "System Error" message shows on the display. When this happens, the welding unit has to be disconnected immediately from the power supply and the fitting, and it has to be shipped to the manufacturer for repair.



Important

The dust cap for the interface has to cover the port during operation, in order to keep humidity and contaminations away.

5.2 Connecting the Fitting

Connect the connection terminals to the fitting and check for proper contact. Use terminal adapters if needed. The contact surfaces of the cable connection terminals or adapters and the fitting have to be clean. Dirty terminals may lead to improper welding and also to overheated and fused connection terminals. Protect the cable connectors against getting dirty at all times. Terminals and push-on adapters should be considered consumables and, therefore, have to be checked before every welding operation and replaced if damaged or dirty.

When the fitting is connected, the "No Contact" message (see Display 2) disappears.

5.3 Entering Welding Voltage and Time

After the fitting was connected to the welder, Display 3 shows on the screen.

```
Voltage/Time  
U= 40 V t= 1000 s
```

Display 3

Use the arrow keys \leftarrow , \rightarrow , \uparrow , \downarrow to set the welding voltage and the welding time, according to the fitting manufacturer's instructions, then press the START/SET key to confirm your input. The "Start ?" message then displayed indicates that the unit is ready for welding.

5.4 Starting the Welding Process

After entering the parameters for the welding operation, the welding process can be started using the START/SET key, when the "Start ?" message is displayed and there is no indication of a problem.

```
Start ?  
Temp.: 20°C  
HST 315mm 58s  
SAT 40.00V 0.80Ω
```

Display 4

Pressing the START/SET key will trigger a confirmation message "Pipe treated?," which in turn requires a confirmation with the START/SET key to start the welding proper.

5.5 Welding Process

The welding process is monitored for its entire duration applying the welding parameters contained in the fitting code. The welding voltage, the resistance, and the welding current are displayed in the lower line of the screen.

```
Act. Time: 56sec  
Nom. Time: 90sec  
35.00V 1.57Ω 22.29A
```

Display 5

5.6 End of Welding

The welding process ends successfully if the actual welding time corresponds to the nominal welding time and the buzzer can be heard twice.

5.7 Aborted Welding Process

The welding process has failed if a plain-text error is displayed on the screen and the audible signal buzzes by intervals, yet continuously. An error has to be acknowledged by pressing the STOP/RESET key.

5.8 Cooling Time

The cooling time as given in the fitting manufacturer's instructions has to be respected. Note that for that time the pipe fitting joint which is still warm must not be subjected to an external force.

6 Downloading the Reports

Interface

USB A Interface Port

for connecting USB mass storage media (such as a memory stick)

The interface port complies with the USB version 2.0 specification (i.e., maximum data rate of 480 megabits per second).



Important

Before transferring data, it is highly recommended to switch the welding unit off and on again. If this fails to happen, there is a risk of data transfer failure, or reports in the welding unit may be corrupted.



Important

When transferring welding reports to a USB stick, always be sure to wait until the display shows the "Download finished" message before you disconnect the USB stick from the product. If you disconnect it too early, the unit may ask you whether you want to delete the reports in memory, although they were not properly transferred. In this case, if you delete the contents of the report memory, the welding reports would be irrevocably lost and would not be available elsewhere either.

6.1 Selecting the File Format

Connecting the storage media causes the the screen to appear in which the format of the output file with the welding reports can be selected: a PDF file with an abstracted or extended version of the report, the format of the welding data management application DataWork or a CSV file. Using the \uparrow and \downarrow arrow keys, select the file type you need and confirm your selection by pressing the START/SET key.

```
* Select File Type *  
DataWork File  
>PDF Abstract  
PDF Ext'd Report
```

Display 6

The CSV format enables import of the report data into a database or spreadsheet application, provided this application can read the format; this is the case, e.g., with Microsoft Excel.

The Service Report option is not important for normal operation. In the scope of computer-assisted unit service, this report lists the events related to the maintenance of the welding unit.

6.2 Downloading All Reports

After the file type was selected, the next screen offers a "Print All Reports" option. Selecting it will download all welding reports currently in system memory in the previously selected file format.

6.3 Downloading by Commission Number, Date or Report Range

After the file type was selected, the next screen offers a "By Commission Number," a "By Date Range," and a "By Report Range" options. Depending on the selection, the ↑ and ↓ arrow keys can be used to select from the commissions currently in system memory the desired one, of which the reports should be downloaded, or the alphanumeric keypad can be used (see Info in Sect. 5.2) to enter a start date and an end date, or the first and the last report, that define a range of dates or a range of reports of which the reports should be downloaded. When you press the START/SET key, you cause the selected reports to be transferred to the storage media.

6.4 Understanding the Report Download Process

The download starts automatically after a selection was made among the options. Wait for all the selected reports to transfer and the "Download completed" message to appear on the screen.

If a problem occurs while the download is in progress, a "Not ready" message shows. After the problem condition is cleared, the download resumes automatically.



If the welding unit recognizes a problem that cannot be cleared while the data transfer is in progress, it does not resume the process and displays a "Download cancelled" error message. To acknowledge this error, press the START/SET key.

6.5 Deleting Data from Memory

The report data in memory can be deleted only after all welding reports were transferred, which is indicated by the "Download completed" message. When the storage media is unplugged, a "Delete Memory" message appears. If the START/SET key is pressed at this point, a further confirmation message "Delete Memory, sure?" is shown, which has to be confirmed by pressing the START/SET key once again. Then, the report data in memory are deleted.

6.6 Keeping Data in Memory

When the cable or storage media is unplugged, a “Delete Memory” message is displayed. Press the STOP/RESET key to keep the current report data in memory. They can then be printed off once again.



Important Make a habit of handling the internal storage as described at the beginning of Sect. 6, to maintain data integrity and avoid any inadvertent deletion of the reports in memory.

7 Dedicated Welding Unit Information

7.1 Displaying Characteristics of the Welding Unit

The key technical information on the welding unit itself is displayed by pressing the ⇨ key at the “Enter Fitting Code” screen. They are the software version, the serial number of the unit, the date of the next scheduled maintenance, and the number of currently available, unused reports. To quit this screen, press the STOP/RESET key.

If the scheduled service is overdue, a service due message appears on the screen as soon as the unit is plugged into the mains or generator power supply. This message has to be acknowledged by pressing START/SET.

7.2 Measuring Resistance

When the START/SET key was pressed to initiate a welding process, the resistance value of the fitting is measured. If the value is obviously incorrect, the welding unit aborts welding and displays a “Resistance Error” message. It also displays the actual resistance value measured for the connected fitting.

The reason for a resistance error may be poorly contacting and/or worn connection terminals. Therefore, if this error occurs, check them for proper fit and, if worn, replace them with new ones.

7.3 Overheating Switch

The welding process aborts if the temperature of the transformer of the welding unit is too high. The overheating circuit breaker for the welder stops the welding process if the temperature reading is too high and the remaining welding time is longer than 800 seconds. The display and the welding report will show an “Overheated” message.

7.4 Indication of Power Supply Failure at the Last Welding

The message "Power Supply Failure Last Welding" indicates that the previous welding aborted because of a power supply failure. The reason may be too weak a generator or too long or too thin an extension cable, or a tripped cut-out in the mounting box. The next welding operation is still possible after acknowledging the message by pressing the STOP/RESET key.

8 Configuring the Welding Unit

With the MENU key, the welding unit can be reconfigured. When it is pressed, a "Settings – M – " screen appears from which the settings screen proper (Display17) is accessed by pressing MENU key once more. (Under "Recording," there is only a sub-menu for starting to print (a) label(s) with reference to a given welding operation, with the optional label tag printer.)

Use the \uparrow and \downarrow arrow keys to select the desired set-up option.

If a " – M – " is shown at a set-up option, this indicates that a sub-menu is accessible here by pressing the MENU key.

Press the START/SET key to confirm the set-up and save it to memory.

Understanding the settings:

"Language – M – " means that by pressing the MENU key, the user can access a sub-menu for selecting the display and report language (see Sect. 8.1).

"Date/Time – M – " means that by pressing the MENU key, the user can access a sub-menu for setting the clock (see Sect. 8.2).

"Buzzer Volume – M – " means that by pressing the MENU key, the user can access a sub-menu for setting the volume of the status buzzer (see Sect. 8.3).

```
*** SET-UP MENU ***
>Language           -M-
Date/Time           -M-
Buzzer Volume       -M-
```

Display 7

8.1 Selecting the Display Language

When the "Select Language" sub-menu was selected, the screen changes and the display reproduced in Display 22 appears.

```
***** LANGUAGE *****
>Deutsch
English
Français
```

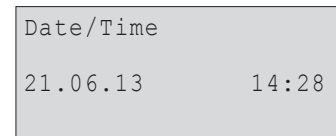
Display 8

Use the arrow keys \uparrow and \downarrow to select one of the options, "Deutsch," "English," and "Français" and confirm by pressing the START/SET key.

8.2 Setting the Clock

When the "Set Clock" sub-menu was selected, the screen changes and the display reproduced in Display 9 appears.

The time of day and the date can be set using the keypad. The portions "Hour," "Minute," "Day," "Month," and "Year" are set separately. Press the START/SET key to confirm your settings.

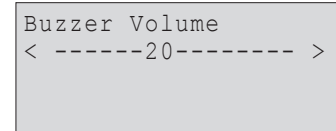


Date/Time
21.06.13 14:28

Display 9

8.3 Setting the Buzzer Volume

When the "Set Volume" sub-menu was selected, the screen changes and the display reproduced in Display 10 appears. The buzzer can also be heard. Turn the buzzer volume up or down to the desired value using the ←, → arrow keys (from 0 to 100) and confirm your setting by pressing the START/SET key.



Buzzer Volume
< -----20----- >

Display 10

9 Self-Monitoring Functions Overview

9.1 Errors During Data Input

9.1.1 No Contact

There is no properly established electric contact between the welding unit and the fitting (check push-on terminal on fitting), or the heater coil is defective.

9.1.2 Low Voltage

The input voltage is below 175 volts. Adjust generator output voltage.

9.1.3 Overvoltage

The input voltage is over 290 volts. Decrease generator output voltage.

9.1.4 Overheated

The transformer temperature is too hot. Let the welding unit cool down for about 1 hour.

9.1.5 System Error

CAUTION!

The welding unit has to be disconnected immediately from both the power supply and the fitting. The auto-test has detected an error in the system. The unit must no longer

be operated and has to be sent to an approved shop for check and repair.

9.1.6 Clock Error

The internal system clock works improperly or is defective. Reset it, or send the welding unit to the manufacturer for check and service.

9.1.7 Input Error

At manual welding parameter input, no welding time was entered. An incorrect value was selected in the date setting.

9.2 Errors During Welding

All errors that occur while welding is in progress are also indicated by an audible alarm.

9.2.1 Low Voltage

The input voltage is below 175 volts. If the error condition persists for longer than 15 seconds, the welding process will be aborted. If the voltage goes down below 170 volts, the welding process will abort immediately.

9.2.2 Overvoltage

The input voltage is over 290 volts. If the error condition persists for longer than 15 seconds, the welding process will be aborted.

9.2.3 Frequency Error

The frequency of the input voltage is out of tolerance (42 Hz - 69 Hz).

9.2.4 Voltage Error

Check generator voltage and current. The output voltage does not correspond to the value previously read; the welding unit has to be sent to the manufacturer for check-up.

9.2.5 Low Current

The message is displayed if there is a momentary current failure or if the current decreases by more than 15% per second for 3 seconds.

9.2.6 High Current

The output current value is in excess; possible causes: short-circuit in the heater coil or the welding cable. During the start stage the upper abort threshold equals 1.18 times the

value at start, in any other case the upper limit depends on the load value and is calculated as the current at start plus 15%.

9.2.7 Emergency Off

The welding process has been interrupted by pressing the STOP/RESET key.

9.2.8 Power Supply Failure at Last Welding

The last welding is incomplete. The welding unit was disconnected from the power supply voltage while it was in progress. To go on using the unit, this error has to be acknowledged by pressing the STOP/RESET key (see also Sect. 9.4).

10 Technical Specifications

Nominal Voltage	230 V
Frequency	50 Hz / 60 Hz
Power	2800 VA, 80% duty cy.
Ingress Protection	IP 54
Primary Current	max. 16 A
Ambient Temperature	-20°C to +60 °C (-4°F to +140°F)
Output Voltage	8 V - 48 V
Max. Output Current	110 A

Tolerances:

Temperature	± 5 %
Voltage	± 2 %
Current	± 2 %
Resistance	± 5 %

11 Service and Repair Contact

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We reserve the right to change technical specs of the product without prior notice.

12 Accessories/Parts for the Product

Connection Terminal 4.0 threaded (fitting connector of welding cable)	217 - 010 - 061
Push-on Elbow Adapter 4.0 - 4.7	216 - 010 - 630
Adapter Bag	216 - 030 - 310

KONFORMITÄTSERKLÄRUNG
Déclaration de conformité
Declaração de conformidade

Wir / We / Nós

HÜRNER Schweisstechnik GmbH
Nieder-Ohmener Str. 26
D-35325 Mücke-Atzenhain

erklären in alleiniger Verantwortung, dass das Produkt
déclarons sous notre seule responsabilité que le produit
declaramos sob nossa exclusiva responsabilidade que o produto

HÜRNER HST 300 Manual USB 2.0

Schweißautomat zur Verarbeitung von Elektroschweiß-Fittings
Appareil pour l'électrosoudage par fusion des raccords de tuyauterie,
Máquina de solda por eletrofusão,

auf die sich diese Erklärung bezieht, mit den folgenden Normen oder normativen Dokumenten
übereinstimmen
auquel se réfère cette déclaration, est conforme aux normes et documents de normalisation suiv-
ants
para o qual essa declaração se refere, está em conformidade com as normas ou documentos
normativos abaixo citados

CE-Konformität / Conformité CE / Conformidade CE

Directive 2014/30/EU

Directive 2012/19/EU

Directive 2014/35/EU

Directive 2011/65/EU

Andere Normen / Autres normes / Outras normas

EN 60335-1

EN 61000-3-2

EN 60335-2-45

EN 61000-3-3

EN 60529

EN 62135-2:2008

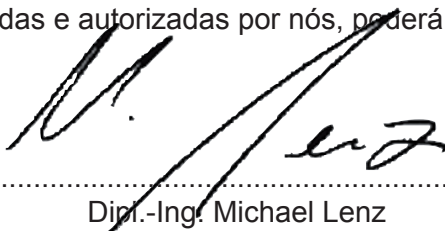
ISO 12176-2

Bei einer nicht mit uns abgestimmten Änderung der Maschine oder einer Reparatur von Personen,
die nicht von uns im Hause geschult und autorisiert wurden, verliert diese Erklärung ihre Gültigkeit.
En cas de modification apportée à l'appareil sans notre accord préalable ainsi que de réparation
effectuée par des personnes non formées et agréées par nos soins, cette déclaration deviendra
caduque.

Toda e qualquer modificação do equipamento sem nossa prévia autorização, e qualquer reparo
por pessoas que não sejam treinadas e autorizadas por nós, poderá anular essa declaração.

Mücke-Atzenhain

CE Marking Date 19.01.2018



Dipl.-Ing. Michael Lenz

Geschäftsführer
Directeur général
Diretor geral

DECLARATION OF CONFORMITY

Declaración de conformidad

Декларация о соответствии

Overensstemmelseserklæring

We / Nosotros / Мы / Vi

HÜRNER Schweisstechnik GmbH
Nieder-Ohmener Str. 26
D-35325 Mücke-Atzenhain

declare under our sole responsibility that the product
decōlaramos bajo la propia responsabilidad que el producto
заявляем с полной ответственностью, что изделие
erklærer som eneste ansvarlige, at produktet

HÜRNER HST 300 Manual USB 2.0

Welding Device for Processing Electrofusion Fittings
Máquina de soldar para los accesorios de electrofusión
аппарат для электромужфтовой сварки,
Svejsesautomat til bearbejdning af elektrosvajningsfittings

to which this declaration relates, are in conformity with the following standards or standardizing documents
al cual se refiere esta declaración es conforme a las siguientes normativas o documentos de normalización
на который распространяется настоящая декларация, соответствует следующим стандартам
или нормативным документам
som denne erklæring relaterer sig til, stemmer overens med følgende standarder og normative dokumenter

CE Conformity / Conformidad CE / Соответствие CE / CE-overensstemmelse

Directive 2014/30/EU

Directive 2012/19/EU

Directive 2014/35/EU

Directive 2011/65/EU

Other Standards / Otras normativas / Прочие стандарты / Andre standarder

EN 60335-1

EN 61000-3-2

EN 60335-2-45

EN 61000-3-3

EN 60529

EN 62135-2:2008

ISO 12176-2

Any and all modifications of the device without our prior approval, and any repairs by persons who were not trained and authorized by us, shall cause this declaration to become void.

En el caso de modificaciones del producto realizadas sin nuestra previa aprobación y también de reparos por personas no formadas y autorizadas por nosotros, esta declaración será considerada nulla.

Настоящая декларация утрачивает силу в случаях внесения изменений в конструкцию изделия без нашего предварительного согласия, а также осуществления ремонта лицами, которые не были обучены и авторизованы нами.

Denne erklæring mister sin gyldighed, såfremt maskinen ændres uden vores samtykke, eller hvis den repareres af personer, som ikke er blevet uddannet og autoriseret i vores firma.

Mücke-Atzenhain

CE Marking Date 19.04.2019

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Dipl.-Ing. Michael Lenz

General Manager
Director gerente

Исполнительный директор
Adm. direktor