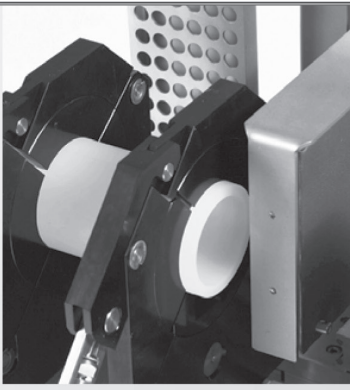


HÜRNER



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SCHWEISSTECHNIK

User's Manual

HST 300 Junior + 2.0

HST 300 Junior 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 both translations herein.
La version allemande ci-après représente le texte original du manuel, rendu par les deux traductions ci-joint.*



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SCHWEISSTECHNIK

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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 Welding Unit, in the model version HST 300 Junior+ 2.0 and HST 300 Junior 2.0, 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



Caution

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



Caution

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 max. 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.

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

4 Principles of Operation

The HST 300 Junior+ 2.0 and the HST 300 Junior 2.0 allow welding electrofusion fittings that feature a bar code. Every fitting is provided with a tag with one or two bar codes on it. The structure of this code is internationally standardized. The first code, encoding the data on proper welding, complies with ISO TR 13950 and can be processed with the welding unit.

The model version HST 300 Junior+ 2.0 allows additionally the manual input of the welding parameters. The microprocessor-controlled welding unit:-

- controls and monitors the welding process in a fully automated fashion,

- determines welding duration depending on ambient temperature.

The latter is done by the temperature sensor located on the welding cable, which checks the ambient temperature at regular intervals.

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.

```
*****  
                HUERNER  
HST 300 Junior+ 2.0  
*****
```

Display 1

Then the screen changes to 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.

```
Enter Fitting Code  
14:32:11      21.10.12  
Inp.Volt. 230V 50Hz  
No Contact
```

Display 2

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 Reading the Fitting Code with a Handheld Scanner

Only the bar code on the tag sticking on the fitting to be welded may be used. It is not acceptable to read the fitting code tag of a fitting of a different kind if the intended one is damaged or unreadable.

Read the fitting code by holding the scanner in front of the bar code at a distance of 5 to 10 cm (2 to 4 inches), where the red line indicates the reading area. Then push the reading button. If the data are correctly read, the welding unit confirms this by an audible signal and displays the decoded data on the screen (see Display 3).

Start ?		
Temp.:	20°C	
HST	315mm	58s
MON	35.00V	1.57Ω

Display 3



Info

The displayed values are the nominal welding parameters contained in the fitting bar code or computed based on these data. They are displayed before the actual resistance of the electrofusion fitting is measured. This means that even when the showing ohm value is o.k., a resistance error may still be detected (see Sect. 7.2). Only when the welding process starts, the display shows the actual, measured welding parameters.

The “Start ?” message means that the unit is ready to start the welding process. Check the read data and if you see that they are erroneous, delete them by pressing the STOP/RESET key. The read data are also deleted if the welding unit is disconnected from the fitting.

5.4 Starting the Welding Process

After reading or entering the fitting code, 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.

Act. Time:	56sec	
Nom. Time:	90sec	
35.00V	1.57Ω	15.94A

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.

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 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. If the bar code provided by the fitting manufacturer contains cooling time data, it will be displayed at the end of the welding process and will be counted down to zero. This countdown can be acknowledged and canceled at any time by the STOP/RESET key. However, note that for that time the pipe fitting joint which is still warm must not be subjected to an external force. No cooling time is displayed if the fitting code does not contain any such information.

5.9 Returning to the Start of Parameter Input

After welding is finished, disconnecting the welded fitting from the unit or pressing the STOP/RESET key will reset the unit back to the start of entering the welding parameters.

5.10 Using ViewWeld to View Welding Reports

The ViewWeld feature offers viewing an abstracted version of the welding report recorded during the last welding process. The ViewWeld abstract shows the report number, the date and time of the welding and the welding parameters along with an evaluation of the quality of the joint/welding operation (see Display 5).

```
0015 24.02.13 09:33  
M/B MON HST 315  
0058s 025.0V 1.57Ω  
Welding OK
```

Display 5

To call the ViewWeld abstract of a welding report, press the \uparrow key in the bar code input screen (see Display 2).

6 Entering Welding Parameters Manually (only for model version HST 300 Junior+ 2.0)

To be able to enter the welding parameters manually, you have first to connect the fitting to the welding unit with the welding cable. The manual input of the parameters can then be accessed by pressing the \downarrow arrow key. The screen

```
** MANUAL INPUT **  
  
>Enter Voltage/Time  
Enter Fitting Code
```

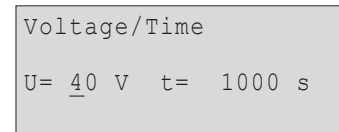
Display 6

will show a menu as reproduced in Display 6, provided manual input is enabled in the configuration menu (see Sect. 8.1). In other words, the manual parameter input replaces reading the bar code of the fitting with a scanner.

Using the arrow keys \uparrow and \downarrow you can select "Enter Voltage/Time" or "Enter Fitting Code" (i.e., the numbers that represents the code of the fitting to be used). Confirm your selection by pressing the START/SET key.

6.1 Manually Entering Welding Voltage and Time

If this option was chosen in the manual parameter input menu, a display like the one to the right appears on the screen. 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 displayed after the confirmation by START/SET indicates that the unit is ready for welding.



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

Display 7

6.2 Entering the String of Numbers

If this option was chosen in the manual parameter input menu, the "Enter Fitting Code" display shows. The 24 characters of the fitting code to be entered display as asterisks (*). Use the arrow keys \leftarrow , \rightarrow , \uparrow , \downarrow to enter the code and press START/SET to confirm your input and have it decoded. If the code entered is not correct, an "Input Error" message appears; check the string of numbers and correct as needed. If the code is correct, the decoded data is displayed, and the "Start ?" message indicates that the unit is ready to start welding.

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 \Rightarrow key at the "Enter Fitting Code" screen. They are the software version, the serial number of the unit, and the date of the next scheduled maintenance. 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 and compared to the value entered as part of the read fitting code. If the gap between the two values is smaller than the acceptable tolerance given in the code, the welding process starts. If the gap is greater than the preset tolerance, the welding unit aborts welding and displays a "Resistance Error" message. Furthermore, it 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 in the welding unit is too high. The overheating circuit breaker for the transformer stops the welding 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 operator identity card, the welding unit can be reconfigured. When the MENU key is pressed, the "Enter Menu Code" message appears on the screen. After the code was read from the operator card, a screen reading "Settings – M – " is displayed, in which the settings menu proper (Display 8) can be opened by pressing the MENU key again.

In the configuration menu, use the \uparrow and \downarrow arrow keys to select the desired set-up option. Use the \Rightarrow arrow key to toggle between "on" and "off" for that set-up option.

If a "M" is shown next to 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:

"Manual Input on" means that the manual input of welding parameters (see Sect. 6) is possible, "off," that the manual input is not allowed (option available only with HST 300 Junior+ 2.0 model version).

"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. 10.1.1).

"Date/Time – M – " means that by pressing the MENU key, the user can access a sub-menu for setting the clock (see Sect. 10.1.2).

"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. 10.1.3).

"Temperature Unit – M – " means that by pressing the MENU key, the user can access a sub-menu for selecting centigrade or Fahrenheit as the unit for the temperature.

"Inventory Number – M – " means that by pressing the MENU key, the user can access a sub-menu for entering the number under which the unit is inventorized with the operating company.

```
***  SET-UP MENU  ***
Manual Input      on
Language          -M-
>Date/Time       -M-
```

Display 8

8.1 Selecting the Display Language

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

```
***** LANGUAGE *****
>Deutsch
English
Francais
```

Display 9

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 10 appears.

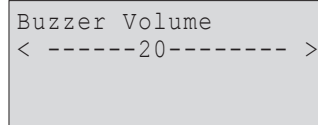
```
Date/Time
21.06.2013      14:28
```

Display 10

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.

8.3 Setting the Buzzer Volume

When the "Set Volume" sub-menu was selected, the screen changes and the display reproduced in Display 11 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 11

8.4 Selecting the Temperature Unit and Entering the Inventory Number

The unit of temperature values (Centigrade or Fahrenheit) can be selected in a sub-menu similar to the language selection (see Sect. 10.1.1). The internal identifier of the welding unit in its owner's inventory, a maximum of 8 characters, can be entered using the ←, →, ↑, ↓ arrow keys; it has then to be confirmed by pressing the START/SET key.

9 Self-Monitoring Functions Overview

9.1 Errors During Data Input

9.1.1 Code Error

An erroneous input has occurred, a code tag is poor or has an error in code symbology or code reading was improper.

9.1.2 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.

9.1.3 Low Voltage

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

9.1.4 Overvoltage

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

9.1.5 Overheated

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

9.1.6 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.

9.1.7 Temperature Error

The ambient temperature measured is outside the operating range of the welding unit, i.e., below -20°C (-4°F) or over $+60^{\circ}\text{C}$ ($+140^{\circ}\text{F}$).

9.1.8 Temperatur Sensor Defective

The ambient temperature sensor on the welding cable is damaged or defective.

9.1.9 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.

9.1.10 Unit to Service

The recommended next service date for the welding unit is overdue. The service due message has to be acknowledged by pressing the START/SET key. Send the welding unit to the manufacturer or an approved service point for service and check-up.

9.1.11 Input Error

A code that was entered is incorrect. 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 Resistance Error

The resistance value of the connected fitting is out of the read tolerance.

9.2.4 Frequency Error

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

9.2.5 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.

9.2.6 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.

9.2.7 Excess 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%.

9.2.8 Emergency Off

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

9.2.9 Heater Coil Error

The dynamic current value during welding differs by more than 15% from the required value, indicating a short-circuit in the heater coil.

9.2.10 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. 7.4).

10 Technical Specifications

Nominal Voltage	230 V
Frequency	50 Hz / 60 Hz
Output 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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Web: <http://www.huerner.de> Mail: info@huerner.de



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

12 Accessories/Parts for the Product

Connection Terminal 4.7 threaded (fitting connector of welding cable), compatible with Uponor, DURA-Pipe, Simona, Strenghweld, Plasson	216 - 023 - 430
Push-on Adapter FF flat compatible with Friatec	216 - 010 - 070
Push-on Adapter FF round 4.0 compat. w/ Friatec, GF, agru, Wavin, Euro Standard	216 - 010 - 080
Push-on Adapter FF pin compatible with Friatec FriaFit (waste water)	216 - 010 - 400
Push-on Adapter GF compatible w/ GF, agru, Wavin, with free wires	216 - 010 - 090
Push-on Elbow Adapter 4.7 - 4.7 90°	216 - 010 - 580
Adapter Bag	216 - 030 - 310
Welder/Operator ID Card	216 - 080 - 031

KONFORMITÄTSERKLÄRUNG
Declaration of Conformity
Déclaration de conformité

Wir / We / Nous

HÜRNER Schweißtechnik
Nieder-Ohmener Str. 26
D-35325 Mücke-Atzenhain

erklären in alleiniger Verantwortung, dass das Produkt
declare under our sole responsibility that the product
déclarons sous notre seule responsabilité que le produit

HÜRNER HST 300 Junior (+) 2.0

Schweißautomat zur Verarbeitung von Elektroschweiß-Fittings
Welding Device for Processing Electrofusion Fittings
Appareil pour l'électrosoudage par fusion des raccords de tuyauterie,

auf die sich diese Erklärung bezieht, mit den folgenden Normen oder normativen Dokumenten
übereinstimmen
to which this declaration relates, are in conformity with the following standards or standardizing
documents
auxquels se réfère cette déclaration, sont conformes aux normes et documents de normalisation
suivants

CE-Konformität / CE Conformity / Conformité CE

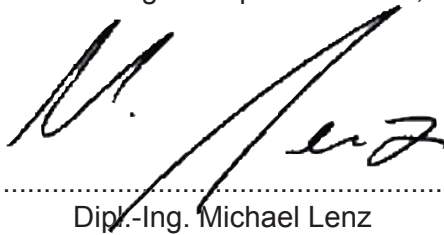
EMC Directive 2004/108/EG (==> 2014/30/EU)
Low Voltage Directive 2006/95/EG (==> 2014/35/EU)

Andere Normen / Other Standards / Autres normes

EN 60335-1:2012/A11:2014	EN 61000-3-3:2013
EN 60335-2-45:2002/A2:2011	EN 62135-2:2008
EN 60529:2014	ISO 12176-2
EN 61000-3-2:2014	WEE 2012/19/EU

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.
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 cas de modification apportée à l'appareil sans notre accord préalable ainsi que de réparation
effectuée par des personnes non formées et agréées par non soins, cette déclaration deviendra
caduque.



Mücke-Atzenhain
CE Marking Date 19.04.2016

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Dipl.-Ing. Michael Lenz
Geschäftsführer
General Manager
Directeur général