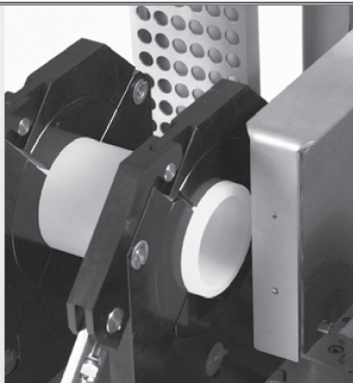


# HÜRNER



## HÜRNER

SCHWEISSTECHNIK

User's Manual

# Manual 1000

*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.*



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## HÜRNER

SCHWEISSTECHNIK

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**The success of the jointing operation depends on the proper pressures, times, and temperatures of the welding as given in the welding value tables in the appendix. The correct pressure value depends on the section of the cylinder of the welding machine. Prior to using the tables in the appendix, verify carefully that the section quoted in the technical specifications of this manual is the same as the section given on the name plate affixed to your machine.**

## 1 Introduction

Dear Customer:

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

The development, manufacture, and check of the heating element butt-welding machine **HÜRNER Manual 1000** has been performed with a view to superior operation safety and user-friendliness. The machine was manufactured and checked according to state-of-the-art technology and widely recognized safety regulations.

To ensure maximum operation safety, please conform to the appropriate messages in this booklet and the regulations for the prevention of accidents.

Thank you.

## 2 Safety Messages

This User's Manual contains important instructions for the intended and safe operation of the product. Every person who operates the product has to conform to the instructions of this manual.

### 2.1 The User's Manual

The User's Manual is presented according to sections which explain the different functions of the product. All rights, in particular the right to copy or reproduce (in print or electronic form) and distribute as well as to translate, are reserved and subject to prior written consent.

### 2.2 Explaining Icons

The following expressions and icons are used in this User's Manual to refer to safety-related issues:



Caution

This icon indicates that non-compliance may result in a hazardous situation that possibly causes bodily injury or material damage.



Important

This icon indicates important messages related to the correct use of the product. Non-compliance may cause problems of operation and damage to the product.



Info

This icon indicates tips and useful information for using the product more efficiently and more economically.

### 2.3 Operating the Product Safely

For your own safety, comply with the following instructions

- Protect the power supply cord and the hydraulic pressure lines from cutting edges. Have an authorized service shop replace damaged cables or lines immediately.
- The product may be operated and serviced exclusively by authorized staff who were briefed on it.
- The product may be operated only when observed.
- Before operating the product, always check for damaged parts and have them repaired or replaced by an authorized service shop as needed.

- The cover caps of the hydraulic lines have to be closed during transport in order to prevent contaminants and humidity from entering the hydraulic and control unit.
- Mains power suppliers' wiring regulations, VDE provisions, DIN/CE regulations, and applicable national legislation have to be respected.
- Without prior authorization by the manufacturer, modifications to the product are unacceptable.



Caution

**Parts Under Power**

After opening the machine or removing the cover, parts of it are accessible that may be under power. The machine may be opened exclusively by an authorized service shop.



Caution

**Pipe Facing Tool**

Start the pipe facing tool only after it was inserted into the machine and carry it only by the handle, never by the disk enclosure.

It is unacceptable to remove shavings from the machine while the facing process is in progress. Make sure nobody is present in this danger zone.



Caution

**Heating Element**

When working with the machine, be extremely cautious while the heating element is used. Since the heating element presents a temperature of more than 200°C during the welding process, it is absolutely indispensable that operators wear suitable protective gloves. Bear in mind that the heating element will remain hot for a while after it was turned off.



Caution

**Danger of Bruises and Injury**

Do not remain in the danger zone while the machine carriage moves apart or closes in, and be sure not to have your arms or legs between the moving and the fixed carriage of the machine.



Caution

**Acceptable Work Conditions**

The work zone has to be clean and has to have proper lighting. It is dangerous to operate while it is raining, in a humid environment, or close to flammable liquids. In regard of this, acceptable work conditions have to be ensured (tent, heating, etc.).



Info

**User's Manual**

The User's Manual has to be available at any time on the site where the machine is used. If the User's Manual becomes incomplete or unreadable, replace it without delay. Feel free to contact us for assistance.

**2.4 Owner and Operator Obligations**

- The machine may be operated exclusively by persons who are familiar with the applicable regulations, the guidelines for the prevention of accidents, and the User's Manual. The owner/manager shall provide the worker operating the machine with the User's Manual and shall make sure that the operator reads and understands it.
- The machine may be operated only when observed. Welders must have been briefed properly on the operation of the machine or must have participated in a dedicated training. The operating/

owning organization engages to check at reasonable intervals if the machine is operated by the welders as intended and under proper guidelines of occupational safety.

- The machine must be operated only when in proper state of repair and for one of the intended uses. Before welding, the welder is required to make sure that the state of the machine is in order.



Important

During transport, the facing tool and the heating element have to be placed into the provided carrying rack at all times.

## 2.5 Intended Use

The Butt-Welding Machine is intended exclusively for joining plastic pipes and fittings according to the butt-welding process with heating element. See Section 3 for a detailed overview of the welding process enabled by this machine.

The notion of intended use also includes:

- Compliance with the instructions in the User's Manual
- Observation of all service and maintenance intervals



Important

All uses other than those mentioned above are not allowed and will cancel any and all liability or warranty by the manufacturer. Unintended use may cause considerable hazards and material damage.

## 2.6 Warranty

Warranty claims may be raised only if the conditions for warranty given in the General Terms and Conditions of Sale and Delivery obtain.

## 2.7 Transport and Storage

When the product is transported or stored, the hydraulic tubing should **not be detached or squeezed**. For transporting the pipe facing tool and the heating element, use the provided carrying rack at all times and **never connect them to, or disconnect them from, the hydraulic unit unless the hydraulic unit is switched off**.

## 2.8 Identifying the Product

Every product is identified by a name plate. It shows the model ("Typ"), the serial number ("Maschinennr."), and the manufacturer. The first two digits of the serial number represent the year of manufacture.

Butt Fusion Welding Device  
Type: Manual Mega Hydraulic  
Ser. No.: 16856614  
Input: 400V 3Ph+N 50/60 Hz IP54 21,2kW  
Hyd.-Oil Type: HF-E 15 Shell naturelle  
Manufacturer: HÜRNER Schweißtechnik GmbH  
Nieder-Ohmener Str. 26  
35325 Mücke (Germany)  
Ph.: +49 6401 9127-0 Fx: -39

## 3 Understanding the Machine

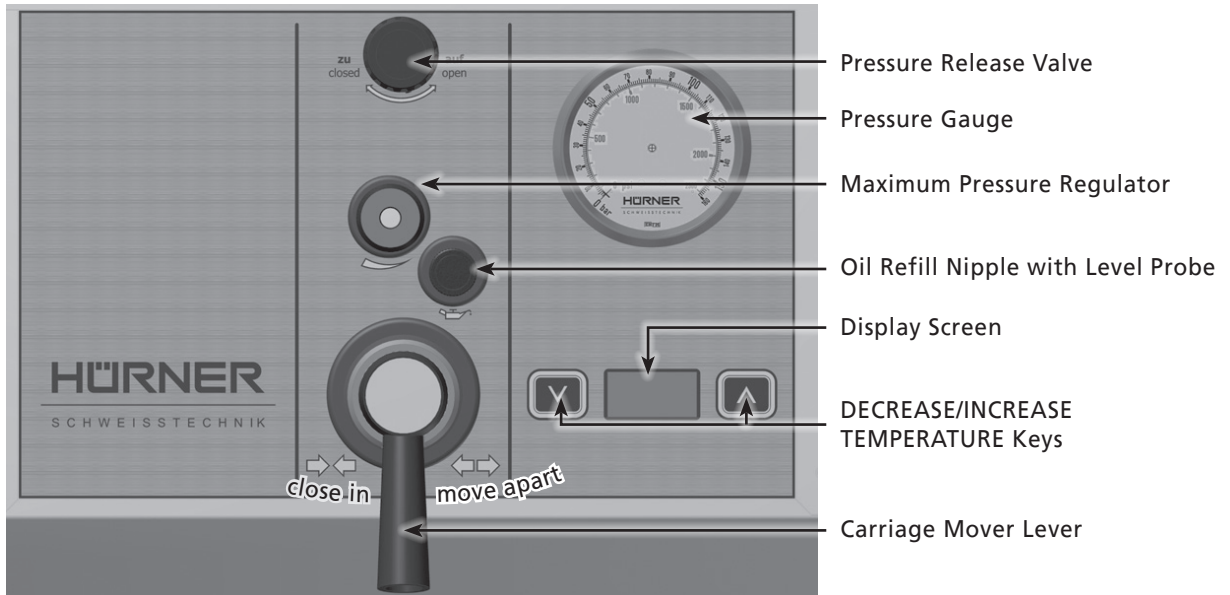
This butt-welding machine for plastics can be used both as an on-site and as a workshop installation, for jointing operations pipe-to-pipe, but also for processing tees and elbows (see also the first paragraphs of Sect. 4.3 for more detailed information on this).

## 3.1 Included Components

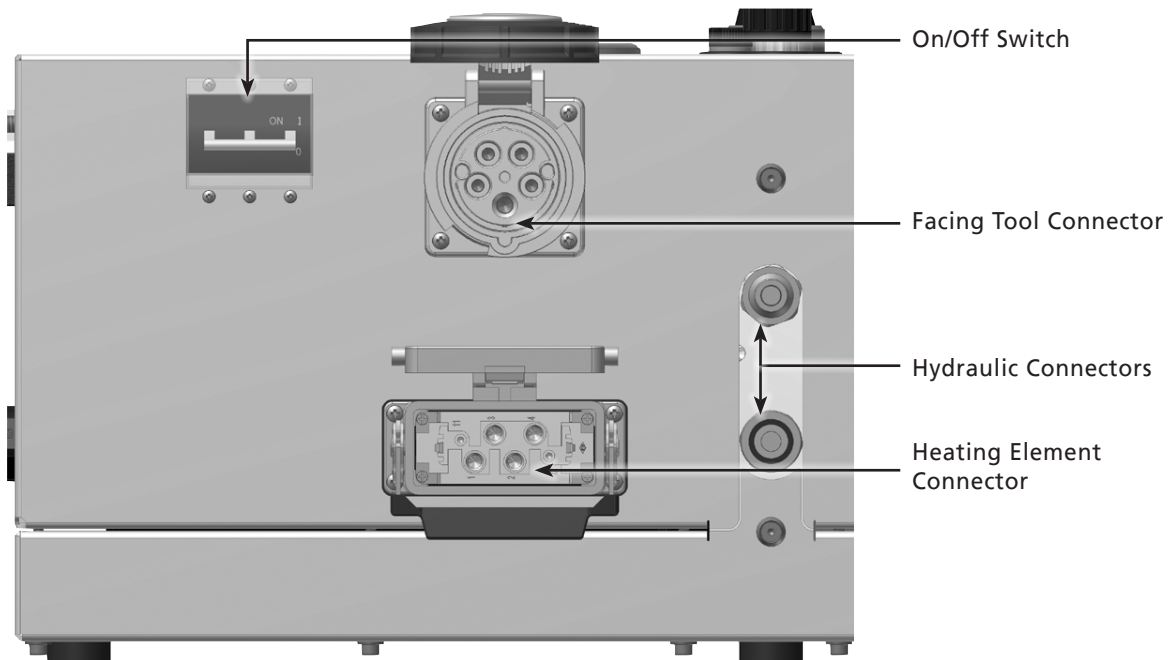
The product ships with the following components:

- Machine chassis ("basic machine") to secure the parts to be welded
- Electrical heating element with anti-stick coating
- Electrical facing tool
- Carrying and storage rack for heating element and facing tool
- Hydraulic and control unit with control panel
- Reducer inserts for clamps of machine chassis for the following nominal pipe sizes: O.D. 630, 710, 800, 900 mm

## 3.2 Control Panel



## 3.3 Connectors



In the Manual with SPG model version, the hydraulic and control unit ships with a rack on which a SPG 2.0 or SPG 2000 Data Logging/ Report Generation Unit can be fitted in just a few moments and with power supply and communication ports for the data logger.



### 3.4 Technical Specifications

<b>HÜRNER Manual 1000</b>	
<b>Power Specifications</b>	
Voltage	400 V 3 Ph * N
Frequency	50 / 60 Hz
Total Rated Powe	20.20 kW
Heating Element	15.00 kW
Facing Tool	2.20 kW
Hydraulic & Control Unit	3.00 kW
<b>Hydraulic Specifications</b>	
Operating Pressure max.	250 bar
Cylinder	45.92 cm <sup>2</sup>
Ambient Temperature Range	-5°C to +50°C
Hydraulic Oil	HF-E 15
Operating Range	630 through 1000 mm
<b>Dimensions</b>	
Basic Machine Chassis	2020 x 1560 x 1560 mm
Facing Tool	1200 x 1450 x 300 mm
Heating Element	1200 x 1500 x 70 mm
Hydraulic & Control Unit	850 x 380 x 300 mm
<b>Weights</b>	
Basic Machine Chassis	710 kg
Facing Tool	277 kg
Heating Element	100 kg
Hydraulic & Control Unit	48 kg

### 3.5 Overview of the Welding Process

The welder performs the welding process in the following manner:

- Applicable welding times and pressures are looked up in the overview tables in the appendix.
- Pipes are clamped into the frame.  
If pipes with an outside diameter smaller than the maximum dimension of the machine are welded, select the reducer set needed. The 8 individual inserts of the set that matches the outside diameter of the pipe to be welded have to be attached to the clamps of the machine chassis using the provided bolts.
- Pipe butts are worked using the pipe facing tool.
- Pipe alignment is checked.
- The drag pressure, i.e. the minimum pressure to set the carriage in motion and "drag" it along, is recorded at the machine.
- The pressures relevant to the welding operation are set.
- The heating element is inserted after cleaning it and checking its temperature.
- The welding process proper is performed (see section 4), and the operator waits for the jointed pipes to cool down.
- After the cooling time is over, pressure can be shutt off from the pipes and the joint can be taken out of the chassis.

## 4 Operation

### 4.1 Start of Operation, Switching the Machine on



Important

Before the control unit is turned on, check the oil level of the hydraulic and control unit and top up with HF-E 15 hydraulic oil as needed.



Important

The surfaces of the heating element have to be free of grease and clean, or they have to be cleaned.



Important

Make sure all connectors are tight in their sockets and note that operation on a worksite is only acceptable if the power supply has earth-leakage circuit breakers.

After connecting the power supply cord to the mains power supply or a generator, turn the machine on at the On/Off switch.



Caution

It has to be ensured that the voltage of the power source the machine is connected to corresponds to the rated voltage of the machine. Also the following has to be respected when using extension cables:

For 400 V power: wire section 4.0 mm<sup>2</sup> = max. 75 m long  
wire section 10.0 mm<sup>2</sup> = max. 100 m long

### Using the Integrated Heating Element Temperature Control

When the machine was connected to the power supply, the control electronics runs an auto-test of the three-digit 7-segment display screen. This is indicated by three short flashes of all segments. After the test, the software switches to control mode, which is recognizable from the display now showing a number. This number corresponds to the currently set nominal temperature of the heating element.

As long as the actual temperature of the heating element is not equal to the required nominal temperature (lower or higher), the display screen flashes. This indicates in most cases that the heating element is heating up. When the nominal temperature is reached, providing it is reached within the specified tolerances and time delays, the display screen stops flashing and the heating element can be used.

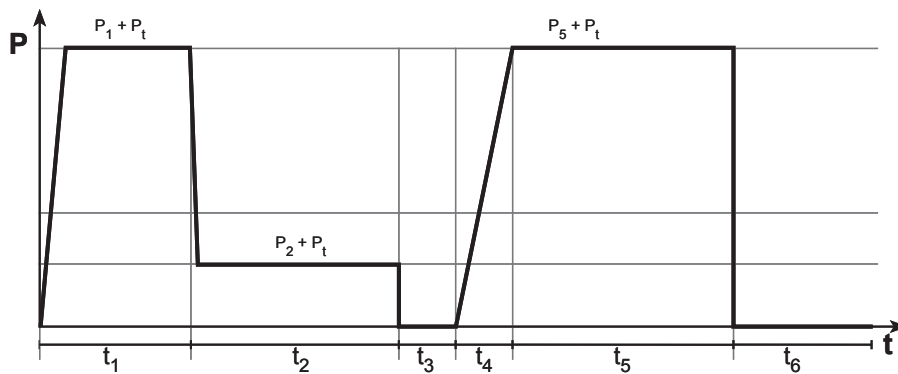
The value of the nominal temperature can be changed using the DECREASE/INCREASE TEMPERATURE keys, either by pressing them repeatedly or by holding them down. The settable temperatures range from 190°C through 250°C. When this setting was changed, the screen starts flashing again, until the heating element has reached the new nominal temperature. The new value is saved to memory and can be used again after the machine is switched on again. To see the current actual temperature of the heating element, hold down both temperature keys. A dot in the lower right-hand corner of the display indicates that the actual temperature is showing.

### 4.2 Welding Process Overview

The welding process proper, after pipe butt facing and pipe alignment check, has the following four stages, or phases, which are also illustrated by the time-and-pressure diagram below.

- **Bead Build-up Stage** – In this stage,  $t_1$  in the diagram, the pipes are pressed against the heating element and heated to the temperature of it; to ensure consistent bead formation, do this at drag pressure ( $P_d$ ) plus  $P_1$  from the welding value tables in the Appendix.

- **Heating Stage** – In this stage,  $t_2$  in the diagram, the pipes remain in contact with the heating element, soaking heat from it; the pressure is reduced to drag pressure ( $P_t$ ) plus  $P_2$  from the welding value tables in the Appendix.
- **Change-over Stage** – In this stage,  $t_3$  in the diagram, pressure is shut off from the pipes, the carriage moves apart to the far end to allow taking the heating element out from in-between the pipes.
- **Joining and Cooling Stage** – This stage is characterized by a succession of events. First, after change-over, the pipe butts are put together and pressure increases as a linear ramp to drag pressure ( $P_t$ ) plus  $P_5$  from the welding value table in the Appendix ( $t_4$  in the diagram). Then, the joint cools down at  $P_t + P_5$ , either until pressure is completely removed from the pipes ( $t_5$  in the diagram) or until pressure is reduced to one-third of  $P_5$  (10 seconds into  $t_5$  in the diagram); in the second case, cooling is completed at the reduced pressure.  
Pipe and fitting manufacturers may include data on how long the new joint should not be exposed to external strain. Also, the applicable welding standard may require a minimum cool-on time after pressure shut-off ( $t_6$  in the diagram). In most cases, however,  $t_6$  is not relevant to the welder.



### 4.3 Performing the Welding Process

To start welding, clamp the pipes into the machine chassis. Use the appropriate reducers if the component size is smaller than the basic machine chassis. When the third clamp of the machine is fastened to its movable carriage, to move with the first and second pipe clamp, tees and elbows can be clamped for processing into the fourth pipe clamp of the machine.

#### 4.3.1 Facing the Pipe Butts

To ensure that the pipe butts are level, insert the pipe facing tool between the machine carriages and turn it on. Using the carriage mover lever on the hydraulic unit, have the movable carriage close in toward the center in order to bring the pipes into contact with the facing tool. Use the pressure regulator to adjust the pressure manually while the facing tool is trimming the pipes.



The farther the carriage mover lever is pushed to the left, the faster the carriage closes in and the faster pressure increases. The farther it is pushed to the right, the faster the carriage of the machine moves apart, and the faster pressure decreases.

Pipe facing should continue until shaving forms a continuous blade that rolls twice or three times around the pipe ends, so the butts are level. Facing is stopped by moving the carriage apart with the carriage mover lever.

If you discover after the facing process that the butts are still not level,

start over, insert the facing tool and repeat the process. When facing is properly done, pipe alignment has to be checked.

#### 4.3.2 Checking Pipe Alignment and Determining Drag Pressure

When the pipes are properly faced, close in the movable carriage completely to check whether a potential vertical and horizontal pipe misalignment is within the tolerance allowed by the applicable welding standard. If pipe alignment is in order, the welding proper can start. If the misalignment is outside tolerance, the pipes must be readjusted in the clamps and, if needed, facing has to be repeated.

When pipe alignment is appropriate, move the carriage apart using the carriage mover lever; make sure the movable carriage is as far apart as possible before continuing. Turn the maximum pressure regulator counter-clockwise as far as it will go to have zero pressure in the hydraulic circuit. Then set the carriage mover lever to its close-in position while simultaneously turning the maximum pressure regulator gradually clockwise. Watch the pressure gauge closely to observe at which pressure level the carriage is "dragged" to start moving. Take note of this value, preferably on paper, as the drag pressure  $P_t$  for this welding operation.



Important

The exact drag pressure depends on various conditions (pipe size and material, position/altitude of the machine, etc.) and has to be determined for every welding individually. The value  $P_t$  is needed to compute the bead build-up, the heating, and the joining pressures needed for jointing (stages  $t_1$ ,  $t_2$ , and  $t_5$  in the welding diagram respectively).

#### 4.3.3 Bead Build-up Stage

Use the welding value tables in the Appendix to look up the joining pressure (maximum pressure to be applied during bead build-up and joining) appropriate for your situation. Then set the maximum pressure regulator to joining pressure plus drag pressure (see Sect. 4.3.2) while observing the actual pressure shown on the gauge, and move apart the carriage of the machine. Using the welding value tables, check that the heating element (heating plate) has the correct temperature and insert it between the butts, move the carriage in on the heating plate and press the pipe butts to it at a pressure of  $P_1 + P_t$  for the bead build-up duration given in the welding value tables in the Appendix ( $t_1$  in the diagram above) until the weld bead has properly formed.

#### 4.3.4 Heating Stage

After the bead build-up stage ( $t_1$  in the diagram) was completed, the pressure must be decreased to below or equal to the level of  $P_2 + P_t$ . The decreased pressure will then be applied for the entire duration of the heating stage ( $t_2$  in the diagram), in which the pipe butts continue to soak heat from the plate. Use the welding value tables in the Appendix to determine the heat-soaking time ( $t_2$ ) and the heat-soaking pressure ( $P_2 + P_t$ ) applicable to your welding situation. To reduce the pressure applied to the pipe, use the pressure release valve and observe the pressure level on the gauge.



Important

Full contact has to be continuously established between the heating plate and the bead, even with lower pressure. While heating, if contact between them is lost somewhere along the circumference, welding has to be aborted and repeated.

#### **4.3.5 Change-over Stage**

After the end of the heating, or heat-soaking, stage, set the carriage mover lever on the hydraulic unit to its move-apart position in order to move the carriage to the far end. Then remove the heating element from in-between the pipes.

The change-over has to be followed immediately by the joining stage. The change-over time given for your welding situation in the tables in the Appendix ( $t_3$ ) must not be exceeded. If it is, welding has to be aborted and repeated.

#### **4.3.6 Joining and Cooling Phase**

Set the carriage mover lever to its close-in position again in order to move the pipe butts in on each other and to build the joining pressure ( $P_5 + P_r$ ) according to a consistent increase. Watch the reading of the gauge. Building the joining pressure must correspond to a linearly increasing ramp and its duration must neither be longer nor shorter than indicated for your welding situation in the welding value tables in the Appendix at  $t_4$ .

Once the joining pressure is reached and has stabilized at  $P_5 + P_r$ , depending on the applicable welding standard, the pressure will either be kept at this level until the end of the joining stage is reached ( $t_5$ ), or pressure will be reduced after 10 seconds to one-third of  $P_5$  and the reduced pressure will be kept until the end of the stage  $t_5$  is reached. Towards the end of the joining stage, the new joint also starts cooling down. If the pressure has to be reduced in the course of the joining stage (under the WIS standard or the UNI standard for PE100 with walls thicker than 20 mm), reducing the pressure is done with the pressure release valve on the hydraulic unit.

Pipe and fitting manufacturers may include data on how long the new joint should not be exposed to external strain. Also, the applicable welding standard may require a minimum cool-on time ( $t_6$  in the diagram). In most cases, however,  $t_6$  is not relevant to the welder.

#### **4.3.7 End of Welding**

The welding is finished at the end of a successful joining and cooling stage. The welder has to shut the pressure off from the pipes using the pressure release valve.

### **4.4 Data Logging/Welding Report Generation (optional)**

As an option, the butt-welding machines of the Manual series offer the possibility to log welding and traceability data of every joint and to save them to a welding report.

All it takes is the connection of a HÜRNER Data Logging/Report Generation Unit of the SPG series to the machine. A model version with a support bracket and connection ports for the data logger is available upon request.

## **5 Indication of Errors Related to the Heating Element**

Error indications that may appear on the 7-segment display are composed of the letter "E" and a code number. When an error is cleared while the machine is still running and provided the cleared error was the only one that occurred, the machine changes back to control mode. No machine re-start is needed. As soon as an error condition is

detected, the heating element is switched off. The control unit supports the following error messages:

Error 'E01' Temperature sensor not connected or ohm value too high

Error 'E02' Heating element temperature exceeds maximum (> 280°C)

Error 'E03' Short-circuit at the temperature sensor input

## 6 Service and Repair

As the product is used in applications sensitive to safety considerations, it may be serviced and repaired only on our premises or by partners who were specifically trained and authorized by us. Thus, constantly high standards of operation quality and safety are maintained.



Non-compliance with this provision will dispense the manufacturer from any warranty and liability claims for the product and any consequential damage.

Important

## 7 Service and Repair Contact

HÜRNER Schweißtechnik

Nieder-Ohmener Str. 26

35325 Mücke, Germany

Tel.: +49 (0)6401 9127 0

Fax: +49 (0)6401 9127 39

Web: [www.huerner.de](http://www.huerner.de)

E-mail: [info@huerner.de](mailto:info@huerner.de)



Info

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

## 8 Accessories/Parts for the Product

Facing Tool Blade for HÜRNER Manual 1000



Info

Only genuine spare parts are acceptable. The use of non-genuine parts voids any and all liability and warranty on the part of the manufacturer.

For consultation and ordering spare parts, refer to the seller or manufacturer of the product.

## Anhang

Die Phasen des Schweißprozesses, für die die folgenden Tabellen die einzuhaltenden Drücke und Dauern angeben, sind im Schweißprozessdiagramm auf Seite 11 erläutert.


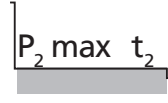
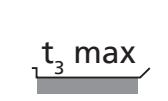
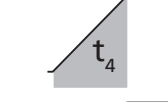
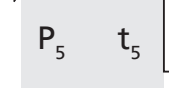
## Appendix

The stages of the welding process, for which the tables below provide applicable time and pressure values, are represented in detail in the welding diagram on page 11.

## Annexe

Les phases de la procédure de soudage, dont les tableaux ci-dessous donnent les pressions et durées à observer, sont expliquées par le diagramme de soudage page 11.

	Zylinderquerschnitt der Grundmaschine Section of cylinder of machine chassis Section du vérin du châssis de la machine
	Durchmesser der Werkstücke Diameter of components to be welded Diamètre des pièces à souder
	Wandstärke der Werkstücke Wall thickness of components Épaisseur de paroi des pièces à souder
$\frac{D}{s}$	Druckstufe als Ø/Wand Standard Dimension Ratio as Ø/Wand Niveau de pression exprimé pour Ø/paroi
	Höchstzulässiger Versatz vor Schweißung Maximum alignment gap before welding Écart maxi. du parallélisme avant soudage
	Heizelementtemp. während Schweißung Heating element temp. while welding Temp° de l'élément chauffant en soudage
	Wulststärke zum Ende des Angleichens Bead thickness to end bead build-up stage Épaisseur du bourrelet en fin d'égalisation

	Druck während der Angleichphase Pressure in bead build-up stage Pression en phase d'égalisation
	Höchstdruck und Dauer der Anwärmphase Max. pressure and time of heating stage Pression maxi. et durée de phase de chauffe
	Höchstdauer der Umstellphase Max. time of change-over Durée maxi. de la mise en contact
	Dauer der Fügerampe zum Fügedruck Time of linear increase to joining pressure Durée de l'évolution vers pression de fusion
	Fügedruck und Dauer der Abkühlphase Joining pressure and time of cooling Pression de fusion et durée du refroidissement

**Allen Druckwerten in den Tabellen ( $P_1$ ,  $P_2$  max.,  $P_5$ ) ist für die Schweißung noch der Bewegungsdruck  $P_t$  (vgl. Seite 12) hinzu-zuaddieren ( $P_1 + P_t$ ,  $P_2$  max. +  $P_t$ ,  $P_5 + P_t$ ).**

**To all pressure values in the tables ( $P_1$ ,  $P_2$  max.,  $P_5$ ), add the drag-into-movement pressure  $P_t$  (refer to page 12) to perform the welding operation ( $P_1 + P_t$ ,  $P_2$  max. +  $P_t$ ,  $P_5 + P_t$ ).**

**À toutes les pressions citées ci-après ( $P_1$ ,  $P_2$  max.,  $P_5$ ), il faut ajouter la pression minimale de mise en contact  $P_t$  (cf. page 12) en vue du soudage ( $P_1 + P_t$ ,  $P_2$  max. +  $P_t$ ,  $P_5 + P_t$ ).**

Die **Dauer des Abkühlens** ist umgebungstemperaturabhängig. Die angegebene Abkühlzeit gilt für Außentemperatur > 25 °C. Wird die angegebene Dauer eingehalten, ist die Schweißung nach DVS jedenfalls ordnungsgemäß. Bei niedrigerer Umgebungstemperatur kann die Abkühlzeit verkürzt werden:

- ist sie < 25 °C, aber > 15 °C  
**bei PE** um 25 %  
**bei PP** um 20 %
- ist sie < 15 °C  
**bei PE** um 40 %  
**bei PP** um 30 %

Bei Werkstattschweißungen kann die Abkühlzeit verkürzt werden:

- **bei PE** um 50 %  
**bei PP** um 40 %

sofern beim und nach dem Herausnehmen aus der Grundmaschine auf die neue Verbindung nur geringe mechanische Kräfte wirken.

The **time for cooling** depends on the ambient temperature. The cooling time given in the tables is applicable to outside temperatures > 25 °C. If this time is observed, the welded joint will be standard-compliant under DVS in all events. If the ambient temperature is lower, the cooling time can be reduced:

- if it is < 25 °C, but > 15 °C  
**for PE** by 25 %  
**for PP** by 20 %
- if it is < 15 °C  
**for PE** by 40 %  
**for PP** by 30 %

For joints made in the workshop, the cooling time can be reduced:

- **for PE** by 50 %  
**for PP** by 40 %

provided only minor mechanical stress is exercised on the new joint while and after it is removed from the basic machine chassis.

La **durée du refroidissement** est fonction de la température ambiante. La valeur donnée ci-après vaut pour une température extérieure > 25 °C. Si cette durée est observée, l'assemblage remplira les exigences de la norme DVS dans tous les cas. À température ambiante inférieure à cela, le refroidissement peut être réduit :

- si elle est < 25 °C, mais > 15 °C  
**pour le PE**, de 25 %  
**pour le PP**, de 20 %
- si elle est < 15 °C  
**pour le PE**, de 40 %  
**pour le PP**, de 30 %

Si le soudage est réalisé en atelier, le refroidissement peut être réduit :

- **pour le PE**, de 50 %  
**pour le PP**, de 40 %

à condition que les forces mécaniques subies par le nouvel assemblage lors de et après son retrait du châssis de la machine soient négligeables.



**Schweißtabellen**  
**Welding Value Tables**  
**Paramètres de soudage**








## HÜRNER Manual 1000



Technische Änderungen an der Maschine bleiben vorbehalten.

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









Nous nous réservons le droit d'apporter des modifications techniques sans préavis.

<b>PE 80 / PE 100</b> DVS 2207-1 (12/2016)		<b>HÜRNER Manual 1000</b>											
 mm	 mm	$\frac{D}{s}$ SDR	 mm	 °C (PE 80)	 °C (PE 100)	$P_1$ bar	 mm	$P_{2\max.}$ bar	$t_2$ sec	$t_{3\max.}$ sec	$t_4$ sec	$P_5$ bar	$t_6$ min
630	15,4	41	1,6	209	220	9,5	1,5	1,5	154	9	10	9,5	19,5
630	19,3	33	2,0	206	220	12,0	2,0	1,5	193	10	11	12,0	24,5
630	24,1	26	2,4	204	220	15,0	2,5	2,0	241	11	13	15,0	30,0
630	30,0	21	3,0	202	220	18,5	2,5	2,5	300	13	16	18,5	36,5
630	35,7	17,6	3,6	201	220	22,0	3,0	3,0	357	16	19	22,0	43,5
630	37,1	17	3,7	201	220	22,5	3,0	3,0	371	16	19	22,5	45,0
630	46,3	13,6	4,7	200	220	27,5	3,5	3,5	463	19	24	27,5	56,5
630	57,3	11	5,8	200	220	33,5	3,5	4,5	573	22	29	33,5	70,0
710	17,4	41	1,8	207	220	12,5	2,0	1,5	174	10	11	12,5	22,0
710	21,7	33	2,2	205	220	15,5	2,0	2,0	217	11	12	15,5	27,0
710	27,2	26	2,8	203	220	19,0	2,5	2,5	272	12	15	19,0	33,5
710	33,9	21	3,4	201	220	23,5	3,0	3,0	339	15	18	23,5	41,5
710	40,2	17,6	4,1	200	220	27,5	3,0	3,5	402	17	21	27,5	49,0
710	41,8	17	4,2	200	220	28,5	3,0	4,0	418	17	21	28,5	51,0
710	52,2	13,6	5,3	200	220	35,0	3,5	4,5	522	21	26	35,0	63,5
710	64,5	11	6,5	200	220	42,5	4,0	5,5	645	24	33	42,5	78,5
800	19,6	41	2,0	206	220	15,5	2,0	2,0	196	10	12	15,5	24,5
800	24,4	33	2,5	204	220	19,5	2,5	2,5	244	12	14	19,5	30,0
800	30,7	26	3,1	202	220	24,0	2,5	3,0	307	14	16	24,0	37,5
800	38,1	21	3,9	200	220	30,0	3,0	4,0	381	16	20	30,0	46,5
800	45,4	17,6	4,6	200	220	35,0	3,5	4,5	454	19	23	35,0	55,5
800	47,1	17	4,7	200	220	36,5	3,5	5,0	471	19	24	36,5	57,5
800	58,8	13,6	5,9	200	220	44,5	3,5	6,0	588	22	30	44,5	71,5
800	72,7	11	7,3	200	220	54,5	4,0	7,0	727	26	35	54,5	79,5
900	22,0	41	2,2	205	220	20,0	2,0	2,5	220	11	13	20,0	27,5
900	27,4	33	2,8	203	220	24,5	2,5	3,5	274	13	15	24,5	33,5
900	34,5	26	3,5	201	220	30,5	3,0	4,0	345	15	18	30,5	42,0
900	42,9	21	4,3	200	220	37,5	3,0	5,0	429	18	22	37,5	52,5
900	51,0	17,6	5,1	200	220	44,5	3,5	6,0	510	20	26	44,5	62,0
900	52,9	17	5,3	200	220	46,0	3,5	6,0	529	21	27	46,0	64,5
900	66,2	13,6	6,7	200	220	56,5	4,0	7,5	662	24	33	56,5	80,5
900	81,8	11	8,2	200	220	68,5	4,5	9,0	818	28	35	68,5	61,5










See important info on interpretation of tables on page 15.



<b>PE 80 / PE 100</b> DVS 2207-1 (12/2016)		<b>HÜRNER Manual 1000</b>  45,92 cm²											
 mm	 mm	$\frac{D}{s}$ SDR	 mm	 °C (PE 80)	 °C (PE 100)	$P_1$ bar	 mm	$P_2$ max. bar	$t_2$ sec	$t_3$ max. sec	$t_4$ sec	$P_5$ bar	$t_6$ min








1000	24,5	41	2,5	204	220	24,5	2,5	3,5	245	12	14	24,5	30,5
1000	30,5	33	3,1	202	220	30,5	2,5	4,0	305	14	16	30,5	37,5
1000	38,4	26	3,9	200	220	38,0	3,0	5,0	384	16	20	38,0	46,5
1000	47,7	21	4,8	200	220	46,5	3,5	6,0	477	19	24	46,5	58,0
1000	56,7	17,6	5,7	200	220	55,0	3,5	7,5	567	22	29	55,0	69,0
1000	58,8	17	5,9	200	220	57,0	3,5	7,5	588	22	30	57,0	71,5
1000	73,5	13,6	7,4	200	220	70,0	4,0	9,5	735	26	35	70,0	89,0
1000	90,9	11	9,1	200	220	85,0	4,5	11,5	909	30	35	85,0	110,0

<div>PP</div> <div>DVS 2207-11</div> <div>(02/2017)</div>		<div>HÜRNER Manual 1000</div> <div></div> <div>45,92 cm²</div>										
 <div>mm</div>	 <div>mm</div>	<div><math>\frac{D}{s}</math></div> <div>SDR</div>	 <div>mm</div>	 <div>°C</div>	<div><math>P_1</math></div> <div>bar</div>	 <div>mm</div>	<div><math>P_2^{max.}</math></div> <div>bar</div>	<div><math>t_2</math></div> <div>sec</div>	<div><math>t_3^{max.}</math></div> <div>sec</div>	<div><math>t_4</math></div> <div>sec</div>	<div><math>P_5</math></div> <div>bar</div>	<div><math>t_6</math></div> <div>min</div>

630	15,4	41	1,6	210	6,5	1,0	0,5	170	8	14	6,5	19,5
630	19,2	33	2,0	210	8,0	1,0	1,0	208	9	17	8,0	24,0
630	24,1	26	2,4	210	10,0	1,5	1,0	254	10	21	10,0	30,0
630	35,8	17,6	3,6	210	14,5	2,0	1,5	352	14	31	14,5	43,5
630	46,3	13,6	4,7	210	18,5	2,5	2,0	425	16	40	18,5	56,5
630	57,3	11	5,8	210	22,5	2,5	2,0	485	19	43	22,5	70,0
710	17,4	41	1,8	210	8,0	1,0	1,0	190	9	16	8,0	22,0
710	21,6	33	2,2	210	10,0	1,0	1,0	230	10	19	10,0	27,0
710	27,2	26	2,8	210	12,5	1,5	1,5	281	11	23	12,5	33,5
710	40,2	17,6	4,1	210	18,5	2,0	2,0	384	15	35	18,5	49,0
710	52,2	13,6	5,3	210	23,5	2,5	2,5	461	18	43	23,5	63,5
710	64,5	11	6,5	210	28,5	3,0	3,0	520	21	43	28,5	78,5
800	19,6	41	2,0	210	10,5	1,0	1,0	212	9	18	10,5	24,5
800	24,3	33	2,5	210	13,0	1,5	1,5	255	11	21	13,0	30,0
800	30,7	26	3,1	210	16,0	1,5	1,5	310	12	27	16,0	37,5
800	45,3	17,6	4,6	210	23,5	2,5	2,5	418	16	39	23,5	55,0
800	58,8	13,6	5,9	210	30,0	2,5	3,0	492	19	43	30,0	71,5
800	72,7	11	7,3	210	36,0	3,0	3,5	561	22	43	36,0	89,5
900	22,0	41	2,2	210	13,0	1,0	1,5	234	10	19	13,0	27,5
900	27,5	33	2,8	210	16,5	1,5	1,5	284	11	24	16,5	34,0
900	34,5	26	3,5	210	20,5	2,0	2,0	342	13	30	20,5	42,0
900	51,1	17,6	5,1	210	29,5	2,5	3,0	456	17	43	29,5	62,5
900	66,2	13,6	6,7	210	38,0	3,0	4,0	528	21	43	38,0	80,5



See important info on interpretation of tables on page 15.

<b>PP</b> DVS 2207-11 (02/2017)		<b>HÜRNER Manual 1000</b>  <b>45,92 cm²</b>										
 mm	 mm	$\frac{D}{s}$ SDR	 mm	 °C	$P_1$ bar	 mm	$P_{2\text{ max.}}$ bar	$t_2$ sec	$t_{3\text{ max.}}$ sec	$t_4$ sec	$P_5$ bar	$t_6$ min

1000	24,5	41	2,5	210	16,5	1,5	1,5	257	11	21	16,5	30,5
1000	30,4	33	3,1	210	20,0	1,5	2,0	308	12	26	20,0	37,0
1000	38,4	26	3,9	210	25,5	2,0	2,5	372	14	33	25,5	46,5
1000	56,8	17,6	5,7	210	36,5	2,5	3,5	483	19	43	36,5	69,0
1000	73,5	13,6	7,4	210	46,5	3,0	4,5	570	22	43	46,5	91,0



See important info on interpretation of tables on page 15.

# KONFORMITÄTSERKLÄRUNG

Declaration of Conformity

Declaração de conformidade

Wir / We / Nós

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

erklären in alleiniger Verantwortung, dass das Produkt  
declare under our sole responsibility that the product  
declaramos sob nossa exclusiva responsabilidade que o produto

## HÜRNER Manual 1000

Heizelement-Stumpschweißmaschine zur Verschweißung von Kunststoffrohren und -formteilen  
Heating Element Butt-Welding Machine for Welding Plastic Pipes and Fittings  
Máquina de solda por termofusão para solda de tubos e conexões plásticos

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

para o qual essa declaração se refere, está em conformidade com as normas ou documentos  
normativos abaixo citados

### CE-Konformität / CE Conformity / Conformidade CE

Directive 2012/19/EU

Directive 2014/30/EU

Directive 2014/35/EU

Directive 2006/42/EG (soweit anwendbar / insofar as applicable / tal que aplicável)

Directive 2011/65/EU

### Andere Normen / Other Standards / Outras normas

EN 61000-6-1

EN 61000-6-2

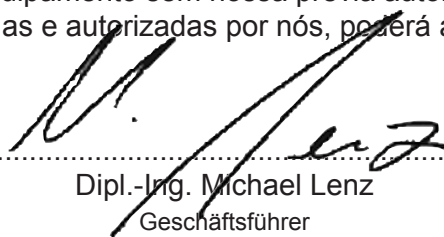
EN 60335-1

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.

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 03.01.2018

  
Dipl.-Ing. Michael Lenz  
Geschäftsführer  
General Manager  
Direitor geral