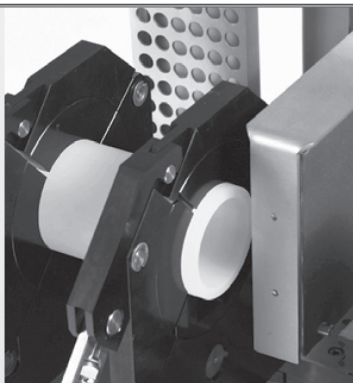


HÜRNER



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SCHWEISSTECHNIK

User's Manual

Manual 800

*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

Version Januar 2018

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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 800** 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

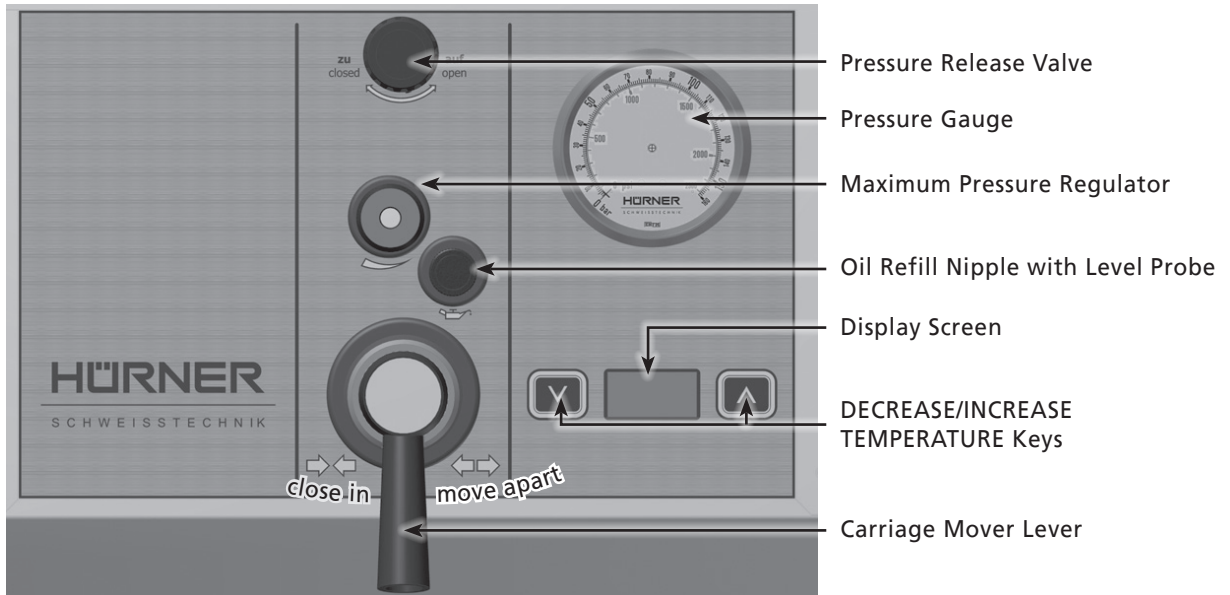
This butt-welding machine for plastics can be used both as an on-site and as a workshop installation, for jointing operations pipe-to-pipe, but also for processing tees and elbows (see also the first paragraphs of Sect. 4.3 for more detailed information on this).

3.1 Included Components

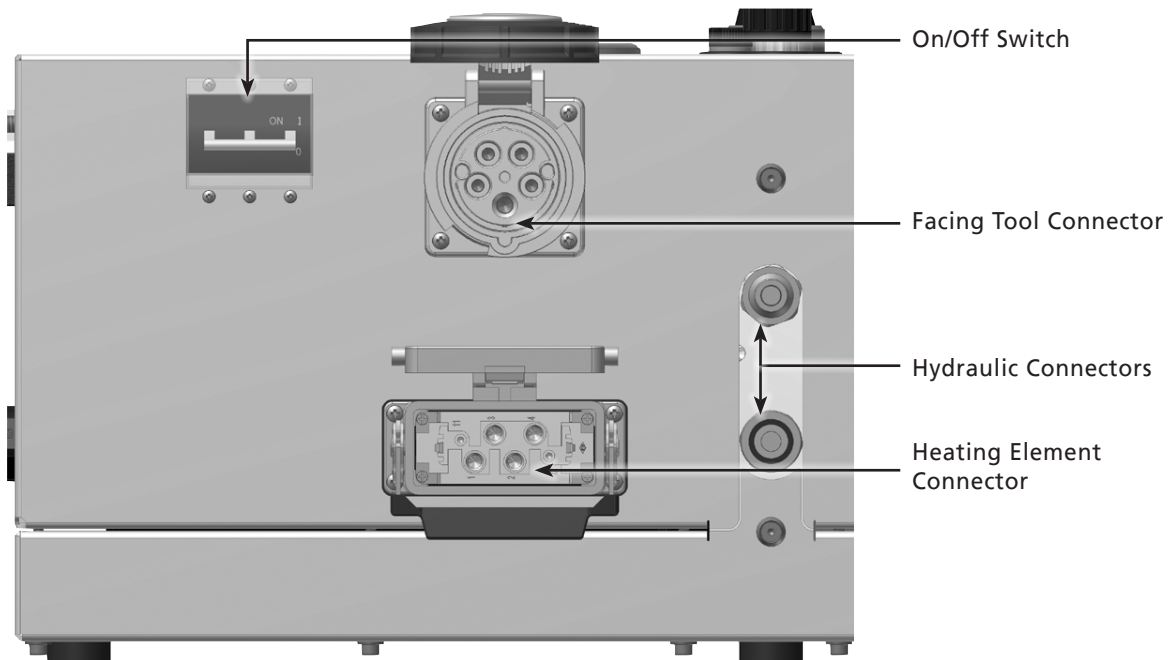
The product ships with the following components:

- 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. 500, 560, 630, 710 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

HÜRNER Manual 800	
Power Specifications	
Voltage	400 V 3 Ph * N
Frequency	50 / 60 Hz
Total Rated Powe	16.80 kW
Heating Element	12.00 kW
Facing Tool	1.80 kW
Hydraulic & Control Unit	3.00 kW
Hydraulic Specifications	
Operating Pressure max.	250 bar
Cylinder	36.50 cm ²
Ambient Temperature Range	-5°C to +50°C
Hydraulic Oil	HF-E 15
Operating Range	500 through 800 mm
Dimensions	
Basic Machine Chassis	1700 x 1200 x 1200 mm
Facing Tool	1270 x 1000 x 350 mm
Heating Element	1270 x 1150 x 100 mm
Hydraulic & Control Unit	850 x 380 x 300 mm
Weights	
Basic Machine Chassis	490 kg
Facing Tool	160 kg
Heating Element	73 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 mm² = max. 75 m long
wire section 10.0 mm² = 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.

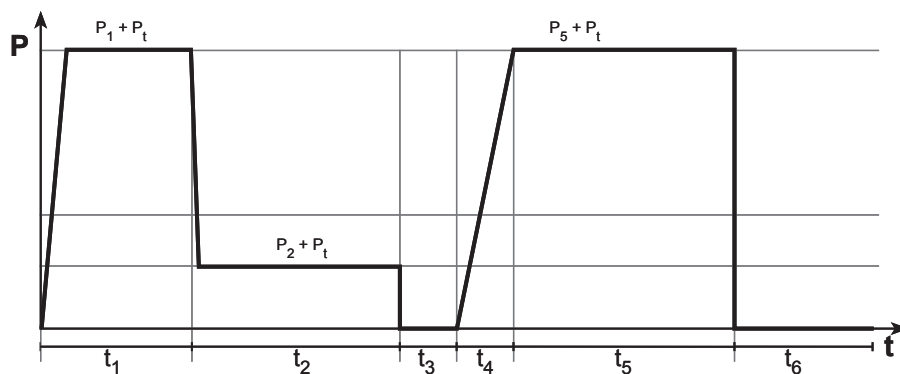
The value of the nominal temperature can be changed using the DECREASE/INCREASE TEMPERATURE keys, either by pressing them repeatedly or by holding them down. The settable temperatures range from 190°C through 250°C. When this setting was changed, the screen starts flashing again, until the heating element 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

E-mail: info@huerner.de



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

Info

8 Accessories/Parts for the Product

Facing Tool Blade for HÜRNER Manual 800



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.

Info

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



Druckstufe als \emptyset / Wand
Standard Dimension Ratio as \emptyset / Wand
Niveau de pression exprimé pour \emptyset / paroi



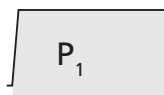
Höchstzulässiger Versatz vor Schweißung
Maximum alignment gap before welding
Écart maxi. du parallélisme avant soudage



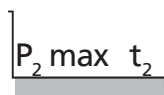
Heizelementtemp. während Schweißung
Heating element temp. while welding
Temp° de l'élément chauffant en soudage



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



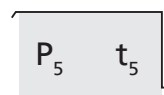
Höchstdruck und Dauer der Anwärmphase
Max. pressure and time of heating stage
Pression maxi. et durée de phase de chauffe



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 $> 25^\circ\text{C}$. Wird die angegebene Dauer eingehalten, ist die Schweißung nach DVS jedenfalls ordnungsgemäß. Bei niedrigerer Umgebungstemperatur kann die Abkühlzeit verkürzt werden:

- ist sie $< 25^\circ\text{C}$, aber $> 15^\circ\text{C}$
bei PE um 25 %
bei PP um 20 %
- ist sie $< 15^\circ\text{C}$
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 $> 25^\circ\text{C}$. 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 $< 25^\circ\text{C}$, but $> 15^\circ\text{C}$
for PE by 25 %
for PP by 20 %
- if it is $< 15^\circ\text{C}$
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 $> 25^\circ\text{C}$. 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 $< 25^\circ\text{C}$, mais $> 15^\circ\text{C}$
pour le PE, de 25 %
pour le PP, de 20 %
- si elle est $< 15^\circ\text{C}$
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.

Schweißstabellen
Welding Value Tables
Paramètres de soudage








HÜRNER Manual 800



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.








PE 80 / PE 100 DVS 2207-1 (12/2016)		HÜRNER Manual 800											
 D	 s	$\frac{D}{s}$	 max	 °C (PE 80)	 °C (PE 100)	P_1		P_2 max.	t_2	$t_{3\text{max.}}$	t_4	P_5	t_6
mm	mm	SDR	mm	°C (PE 80)	°C (PE 100)	bar	mm	bar	sec	sec	sec	bar	min
500	12,3	41	1,3	211	220	7,5	1,5	1,0	123	8	8	7,5	16,0
500	15,3	33	1,6	209	220	9,5	1,5	1,5	153	9	10	9,5	19,5
500	19,1	26	1,9	206	220	12,0	2,0	1,5	191	10	11	12,0	24,0
500	23,9	21	2,4	204	220	14,5	2,5	2,0	239	11	13	14,5	29,5
500	28,3	17,6	2,9	203	220	17,0	2,5	2,5	283	13	15	17,0	34,5
500	29,4	17	3,0	202	220	18,0	2,5	2,5	294	13	16	18,0	36,0
500	36,8	13,6	3,7	201	220	34,0	3,0	4,5	368	16	19	34,0	45,0
500	45,4	11	4,6	200	220	41,5	3,5	5,5	454	19	23	41,5	55,5
560	13,7	41	1,4	210	220	9,5	1,5	1,5	137	8	9	9,5	17,5
560	17,0	33	1,7	208	220	12,0	2,0	1,5	170	9	10	12,0	21,5
560	21,4	26	2,2	205	220	15,0	2,0	2,0	214	11	12	15,0	26,5
560	26,7	21	2,7	203	220	18,5	2,5	2,5	267	12	15	18,5	33,0
560	31,7	17,6	3,2	202	220	21,5	3,0	3,0	317	14	17	21,5	38,5
560	32,9	17	3,3	201	220	22,5	3,0	3,0	329	15	17	22,5	40,0
560	41,2	13,6	4,1	200	220	43,0	3,0	5,5	412	17	21	43,0	50,0
560	50,8	11	5,1	200	220	52,0	3,5	7,0	508	20	26	52,0	62,0
630	15,4	41	1,6	209	220	12,0	1,5	1,5	154	9	10	12,0	19,5
630	19,2	33	2,0	206	220	15,0	2,0	2,0	192	10	11	15,0	24,0
630	24,1	26	2,4	204	220	19,0	2,5	2,5	241	11	13	19,0	30,0
630	30,0	21	3,0	202	220	23,0	2,5	3,0	300	13	16	23,0	36,5
630	35,7	17,6	3,6	201	220	27,5	3,0	3,5	357	16	19	27,5	43,5
630	37,1	17	3,7	201	220	28,5	3,0	4,0	371	16	19	28,5	45,0
630	46,3	13,6	4,7	200	220	54,0	3,5	7,0	463	19	24	54,0	56,5
630	57,2	11	5,8	200	220	65,5	3,5	8,5	572	22	29	65,5	69,5
710	17,3	41	1,8	207	220	15,5	2,0	2,0	173	10	11	15,5	22,0
710	21,5	33	2,2	205	220	19,0	2,0	2,5	215	11	12	19,0	27,0
710	27,2	26	2,8	203	220	24,0	2,5	3,0	272	12	15	24,0	33,5
710	33,9	21	3,4	201	220	29,5	3,0	4,0	339	15	18	29,5	41,5
710	40,2	17,6	4,1	200	220	35,0	3,0	4,5	402	17	21	35,0	49,0
710	41,8	17	4,2	200	220	36,0	3,0	5,0	418	17	21	36,0	51,0
710	52,2	13,6	5,3	200	220	68,5	3,5	9,0	522	21	26	68,5	63,5
710	64,5	11	6,5	200	220	83,5	4,0	11,0	645	24	33	83,5	78,5



See important info on interpretation of tables on page 15.

PE 80 / PE 100 DVS 2207-1 (12/2016)		HÜRNER Manual 800  36,50 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

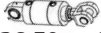






800	19,6	41	2,0	206	220	30,5	2,0	4,0	196	10	12	30,5	24,5
800	24,4	33	2,5	204	220	37,5	2,5	5,0	244	12	14	37,5	30,0
800	30,7	26	3,1	202	220	47,0	2,5	6,0	307	14	16	47,0	37,5
800	38,1	21	3,8	200	220	58,0	3,0	7,5	381	16	20	58,0	46,5
800	45,4	17,6	4,6	200	220	68,5	3,5	9,0	454	19	23	68,5	55,5
800	47,1	17	4,7	200	220	70,5	3,5	9,0	471	19	24	70,5	57,5
800	58,8	13,6	5,9	200	220	87,0	3,5	11,5	588	22	30	87,0	71,5
800	72,7	11	7,3	200	220	105,5	4,0	14,0	727	26	35	105,5	88,0

<div>PP</div> <div>DVS 2207-11</div> <div>(02/2017)</div>		<div>HÜRNER Manual 800</div> <div></div> <div>36,50 cm²</div>										
 <div>mm</div>	 <div>mm</div>	<div>$\frac{D}{s}$</div> <div>SDR</div>	 <div>mm</div>	 <div>°C</div>	<div>P_1</div> <div>bar</div>	 <div>mm</div>	<div>P_2 max.</div> <div>bar</div>	<div>t_2</div> <div>sec</div>	<div>t_3 max.</div> <div>sec</div>	<div>t_4</div> <div>sec</div>	<div>P_5</div> <div>bar</div>	<div>t_6</div> <div>min</div>

500	12,3	41	1,3	210	5,0	1,0	0,5	138	7	12	5,0	16,0
500	15,3	33	1,6	210	6,5	1,0	0,5	169	8	14	6,5	19,5
500	19,1	26	1,9	210	8,0	1,0	1,0	207	9	17	8,0	24,0
500	28,4	17,6	2,9	210	11,5	1,5	1,0	291	12	24	11,5	35,0
500	36,8	13,6	3,7	210	14,5	2,0	1,5	361	14	32	14,5	45,0
500	45,5	11	4,6	210	18,0	2,5	2,0	420	16	39	18,0	55,5
560	13,7	41	1,4	210	6,5	1,0	0,5	152	7	13	6,5	17,5
560	17,0	33	1,7	210	8,0	1,0	1,0	186	8	16	8,0	21,5
560	21,5	26	2,2	210	10,0	1,0	1,0	229	10	19	10,0	27,0
560	31,8	17,6	3,2	210	14,5	2,0	1,5	319	13	28	14,5	39,0
560	41,2	13,6	4,2	210	18,5	2,0	2,0	391	15	36	18,5	50,0
560	50,9	11	5,1	210	22,5	2,5	2,0	455	17	43	22,5	62,0
630	15,4	41	1,6	210	8,0	1,0	1,0	170	8	14	8,0	19,5
630	19,1	33	1,9	210	10,0	1,0	1,0	207	9	17	10,0	24,0
630	24,2	26	2,5	210	12,5	1,5	1,5	255	10	21	12,5	30,0
630	35,8	17,6	3,6	210	18,5	2,0	2,0	352	14	31	18,5	43,5
630	46,3	13,6	4,7	210	23,5	2,5	2,5	425	16	40	23,5	56,5
630	57,3	11	5,8	210	28,0	2,5	3,0	485	19	43	28,0	70,0
710	17,4	41	1,8	210	10,5	1,0	1,0	190	9	16	10,5	22,0
710	21,6	33	2,2	210	13,0	1,0	1,5	230	10	19	13,0	27,0
710	27,2	26	2,8	210	16,0	1,5	1,5	281	11	23	16,0	33,5
710	40,2	17,6	4,1	210	23,0	2,0	2,5	384	15	35	23,0	49,0
710	52,2	13,6	5,3	210	29,5	2,5	3,0	461	18	43	29,5	63,5
710	64,5	11	6,5	210	36,0	3,0	3,5	520	21	43	36,0	78,5



See important info on interpretation of tables on page 15.

PP DVS 2207-11 (02/2017)		HÜRNER Manual 800  36,50 cm²										
 mm	 mm	$\frac{D}{s}$ SDR	 mm	 °C	P₁ bar	 mm	P₂ max. bar	t₂ sec	t₃ max. sec	t₄ sec	P₅ bar	t₆ min

800	19,6	41	2,0	210	13,0	1,0	1,5	212	9	18	13,0	24,5
800	24,3	33	2,5	210	16,0	1,5	1,5	255	11	21	16,0	30,0
800	30,7	26	3,1	210	20,5	1,5	2,0	310	12	27	20,5	37,5
800	45,4	17,6	4,6	210	29,5	2,5	3,0	419	16	39	29,5	55,5
800	58,8	13,6	5,9	210	37,5	2,5	4,0	492	19	43	37,5	71,5
800	72,7	11	7,3	210	45,5	3,0	4,5	561	22	43	45,5	89,5



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 800

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

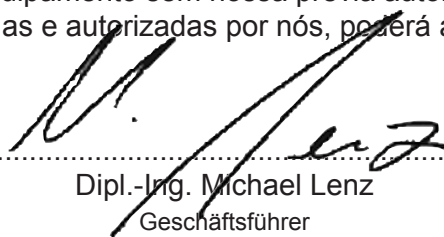
EN 60335-1

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