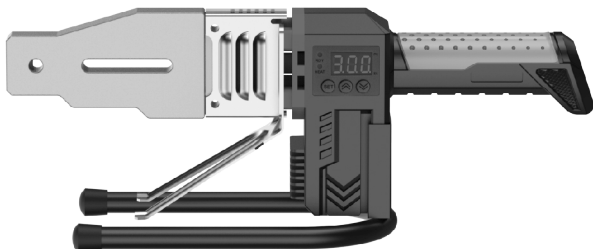


# **WIPCOOL®**

**IDEAL PRODUCTS FOR HVAC**



## **PWM-40**

### **Pipe Welding Machine**

-Operation Manual-

# 1. Operating instructions

This product is an intelligent temperature control digital display type pipe welding machine, suitable for welding thermoplastic pipes, such as PP-R, PE, PP-C, etc.

This product has precise temperature control, intuitive temperature display function, high reliability, good safety. Easy for operation.

## 2. Technical data

Voltage	220-240V~/50-60Hz
Usage conditions:	Altitude not exceeding 1000 meters
Working temperature:	-20 °C ~ 50 °C
Relative humidity:	45% rh ~ 95% rh
Heating head temperature:	factory set at $260 \pm 5$ °C adjustable temperature range 100-320 °C/340 °C, warning temperature 320 °C
Safety index:	Insulation resistance not less than 1MΩ
Leakage current:	$\leq 5$ mA (AC effective value)
Pipe size	20 25 32 40mm(external diameter)

## 3. Usage method

### (1).Fix the welding machine and install the melt die head.

Place the welding machine on the rack, install the corresponding melt die head on the heating plate with screws according to the required pipeline specifications, and tighten it with an Allen wrench .

### (2).Plug in

After connecting the power supply (note that the power supply must have a grounding protection wire), press or to adjust the temperature up or down, short press or , the temperature number will rise or fall once, long press or the temperature will continue to rise or fall, and then press SET to confirm the setting is complete.

After setting the temperature, wait for 3-5 seconds for automatic heating. The red light indicates heating up, and the green light indicates reaching the setting temperature.

### (3).Welding pipe

Cut the pipe vertically with a pipe cutter, and simultaneously push the pipe and fittings into the melt die head without rotation.

The heating time is subject to the following table.

**Note: If the operating environment temperature is below 5 °C, the heating time should be extended by 50%.**

Outside diameter(mm)	Heat length (mm)	Heat time(s)	Operate time (s)	Cooling time (min)
20	14	5	4	3
25	16	7	4	3
32	18.1	8	4	4
40	20.5	12	6	4

## 4. Attention

(1). The handle shell of the product is strong and reliable, the electric wire is standard with grounding safety plug.

Please insert the plug into the safe outlet when using the machine. The plug shouldn't be changed arbitrarily.

(2). In order to protect the safety of persons and property, make sure to place the machine safe when it works normally.

(3). Warning! When the machine is not used but it is heating or cooling, you should put it on the supporting stand.

(4). Be careful of high temperature when the fusing machine works normally. In order to avoid hurt the skin, you must wear gloves when operating or changing welding socket.

(5). Don't open the handle shell of the fusing machine to avoid electric shock or the damage of machine structure.

(6). The fusing machine cannot be used in the rain at outdoors. Escape from water and other kinds of liquid go into the internal part.

(7). If the electric wire is broken, it should be changed in the appointed maintenance store or distributor because it needs special tools.

(8). When you finished the fusing work, you must pulled out the plug first, and after the machine becomes cool, put it back to the box.

- (9). Fix the welding sockets: according to specifications, fix welding sockets with M8×45 hex key screws. Do not screw too firmly when the machine is cool, as the screw tread will be damaged when disassembled at work. Be carefully when changing the welding sockets under work. The disassembled welding sockets should be stored appropriately. Do not damage the surface coat of welding socket, as it will cause stick the plastic on and influence working quality and reduce the lifetime of welding sockets.
- (10). Fix the fusing machine: The fusing machine is equipped with special supporting stand that can be fixed handle shell with both slots. It can be fixed firmly. The operator stepped on the supporting stand when using the machine and it makes operating easily and steadily. Switch on the power and heat: Switch on the power (Warning: the power should have the grounding wire!!!),
- (11). then the red indicator lamp will be on. That means the fusing machine is being heated. When the red lamp is off and the green indicator lamp is on, it means the fusing machine stops heating. After a while, the red lamp will be on again and the fusing machine is in a state of keeping temperature and ready to work.(the process is often less than ten minutes.)
- (12). Fusing and connecting pipes: Use pipe cutter to cut pipes vertically. Push the pipes and fittings into the welding socket and heat for several seconds. Pull it out quickly and then push the heated pipes to heated pipe fitting exactly. Do not press extremely, in order to avoid bending pipes head.