



SKC-S,SKC-SA Series

**Poly Fusion Machine
For Plastic Pipes**

Operation Manual

Thanks for choosing our machine.

Please read the operation manual carefully before using it.

LEADER SAEMIN INTERNATIONAL CORP.,LTD

CATALOG

1. Brief Introduction
2. Notice and Correct Operation
3. Notice and Correct Operation of SKC-S,SKC-SA Series
4. Parameters
5. After-service

Brief Introduction

There're two series of poly fusion machines, SKC-S and SKC-SA, for different requirements of customers. It composes quality electrical heating, electrical temperature control, plastic handle, Head Adapter, tooling box and accessories. RJQ series is electrical stimulate control. It's quick heating, high temperature precision, easy operation and reliable, suitable for connecting PP-R pipes. SKC-S series is computer control with function like digital temperature set, automatic temperature adjustment, temperature display and over-heating alarm, suitable for connecting pipes PP-R, HDPE or PB, etc. It's reliable, high precision, safe and easy operation.

Notice and Correct Operation

1. Read it carefully before using the machine.
2. The pin connects earth at poles. Don't change it randomly. Put pin into plug with earth connection when using the machine.
3. Avoid scold by high temperature.
4. Put it orderly when using it to avoid breaking the shell.
5. It's forbidden to use it outside in rain.
6. Keep Head Adapter carefully for long working life.
7. Install Head Adapter carefully. Don't screw it tightly to avoid breaking screw thread.
8. Put the machine on a support. It's easy and firm.
9. Disconnect power to stop machine. Put it into box after it's cool down.
10. Don't open the machine if not professional to avoid short circuit.
11. Connect electrify. It's heating with red light on. It stops heating with green light on and red light off. The red light turns to on again after some minutes to hold temperature. Then you work on the machine.

Notice and Correct Operation of SKC-S,SKC-SA Series

1. Temperature suggested for pipes

PP-R	260° C
PB	240° C
HDPE	220° C

2. How to set temperature?
Press set button (●) and number digit shines. Change it pressing increasing button (▲) or decreasing button (▼). Press switch button (◀▶) and tens digit shines. Change it in the same way. There're separately controlled. Press switch button to change the numbers repeat. It's limit for set, max. 279° C and min.200° C. Then press set button (●).
3. Over-heating alarm
The alarm makes noise when it's over 295° C. Disconnect electrify. Solve problem then use the machine.
4. Replace fuse
Fuse inside protects the machine when short circuit. Professional person replaces it when it's melt broken.
5. Automatic temperature adjustment
The machine automatically sets temperature 10 ° C higher when environment temperature is below 7 ° C. And 8 ° C lower when it over 30 ° C. Set temperature by manual when big difference of environment temperature.
6. Factory-set temperature
It's 260° C.

Parameters

Table One

Model	Rating voltage, V~	Rating frequency, Hz	Rating power, W	Set temperature ° C	Alarm temperature ° C	Display Temperature ° C	Heating Time, < min
SKC-SA32	220/110	50/60	600	260			10
SKC-SA63	220/110	50/60	800	260			10
SKC-SA110	220/110	50/60	1200	260			10
SKC-S32	220/110	50/60	600	200~279	295	0~295	10
SKC-S63	220/110	50/60	800	200~279	295	0~295	10
SKC-S110	220/110	50/60	1200	200~279	295	0~295	10

Table Two Head Adapter

Specification, mm

Pipe size	Female inner diameter,(Φ)	Male inner diameter, (Φ)	Melt length
20	19.8 ± 0.30	19.3 ± 0.30	14
25	24.8 ± 0.30	24.4 ± 0.30	15
32	31.7 ± 0.30	31.3 ± 0.30	16.5
40	39.7 ± 0.30	39.3 ± 0.30	18
50	49.6 ± 0.40	49.2 ± 0.30	20
63	62.6 ± 0.40	62.1 ± 0.40	24
75	74.5 ± 0.40	73.9 ± 0.40	26
90	89.4 ± 0.40	88.8 ± 0.40	29
110	109 ± 0.40	108.7 ± 0.40	32.5

Remark: Exact size of Head Adapter is according to pipes. See real products.

Table Three Proposal of connecting pipes

Diameter(mm)	Melt length(mm)	Heating time(s)	Process time(s)	Cooling time(mm)
20	14	5	4	3
25	16	7	4	3
32	20	8	4	4
40	21	12	6	4
50	22.5	18	6	5
63	24	24	6	6
75	26	30	8	8
90	29	40	8	8
110	32.5	50	10	8

Remark : Extend 5% more heating time when environment temperature is below 5° C.

After-service

Two years guarantee to keep the machine in good repair from purchase date.

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