



# **THERMOPLASTIC WELDING EQUIPMENT**

## **SWT-B500/200H BUTT FUSION WELDING MACHINE OPERATION MANUAL**



**HEBEI MINGMAI TECHNOLOGY CO.,LTD**

# CONTENTS

1. Brief.....	3
2. Special Description.....	3
3. Safety.....	4
4. Applicable range and Technical parameter.....	6
5. Descriptions.....	7
6. Instruction for Use.....	8
7. Timer and Temperature Controller.....	10
8. Reference of Welding Standard (DVS2207-1-1995) .....	12
Total section of cylinders.....	13
9. Malfunctions Analyzing and Solutions.....	13
10. Circuit & Hydraulic Unit Diagram.....	18
11. Packing List.....	18
12. Guarantee Clauses.....	19
13. Space Occupation Chart.....	20

## 1. Brief

Along with the property of PE material continuous perfecting and raising, PE pipes are extensively used in gas and water supply, sewage disposal, chemical industry, mine and so on.

For more than ten years, our factory has been researching and developing SWT series plastics pipe butt fusion machine that is suit for PE, PP, and PVDF. We have fulfilled the techniques requirements of ISO12176-1. Our products have outstanding features in convenience, reliability, safety and lower price.

Today, our products include eight kinds and over than 20 types that can be applied to plastics pipe construction and make fittings in workshop as follow:

- |   |   |
|---|---|
|  ZRJQ series socket welder               |  SWT-C series band saw                     |
|  SWT-M series manual butt fusion machine |  SWT-G series workshop butt fusion machine |
|  SWT-H series butt fusion machine        |  SWT-D Series special tools                |
|  SWT-A series Auto-butt fusion machine   |  SWT-L series saddle fusion machine        |

This manual is suit for SWT-B500/200H plastic pipe butt fusion welding machine. It's suggested to read and follow carefully the following safety rules and maintenance rules before operating the machine.

## 2. Special Description

Before operating the machine, everyone should read this description carefully and keep it well to ensure the equipment and operator's safety, as well as others' safety.

2.1 The machine is used to weld pipes made from PE, PP, PVDF and can not be used to weld material without description, otherwise the machine may be damaged or some accident may be resulted in.

2.2 Don't use the machine in a place with potential hazard of explosion

2.3 The machine should be operated by responsible, qualified and trained personnel.

2.4 The machine should be operated on a dry area. The protective measures should be adopted when it is used in rain or on wet ground.

2.5 The input power is  $380V \pm 10\%$ , 50 Hz. If extended input line is used, it should have enough lead section.

2.6 Before using the machine, fill 46# hydraulic oil. Make sure the hydraulic oil is enough for working; the oil level should be 2/3 of the tank. Replace the iron oil tank cap by the red plastic air bleed cap or the pressure can not be hold.



### 3. Safety

#### 3.1 Safety marks

The following marks are stuck to the machine:

Hot ! Keep distance from parts with this sign, for they are very hot!



Danger, Electrical shock  
Parts with this sign have a danger of electricity leak. Be careful when working here.



No approaching! Moving parts can crush. Keep fingers, feet, arms, legs, and head out of the jaw area between the moving tables.



Caution, injure hand



Caution, hanging



Caution, heavy



#### 3.2 Precautions for Safety

**When operating the machine, instruction and safety rules should be abided carefully.**

3.2.1 The operator should be responsible and trained personnel.

3.2.2 Completely inspect and maintain the machine per year for the safety and machine's reliability.

3.2.3 Power: the electricity distribution box should have leakage switch with relevant electricity safety standard.

**All safety protection devices are indicated by easily understandable words or marks.**

3.2.4 Connection of machine to power

The cable connecting machine to power should be mechanical concussion and chemical corrosion resistance.

If the extended wire is used, it must have enough lead section according to its length.

3.2.5 Earthing: The whole site should share the same ground wire and the ground connection system should

be finished and tested by professional people.

#### 3.2.6 Storage of electrical equipment

For the min. dangers, all equipment must be used and stored correctly as follows:

- ※ Avoid using temporary wire not complying with standard
- ※ Do not touch electrophorus parts
- ※ Forbid hauling off the cable to disconnect
- ※ Forbid hauling cables for lifting equipment
- ※ Do not put heavy or sharp object on the cables, and control the temperature of cable within limiting temperature (70℃)
- ※ Do not work in the wet environment. Check if the groove and shoes is dry.
- ※ Do not splash the machine

#### 3.2.7 Check insulation condition of machine periodically

- ※ Check the insulation of cables specially the points extruded
- ※ Do not operate the machine under extreme condition.
- ※ Check if the leakage switch works well at least per week.
- ※ Check the earthing of the machine by qualified personnel

#### 3.2.8 Clean the machine carefully

- ※ Do not use materials damaging the insulation easily (like gas, abrasive, and other solvents) when clean the machine.
- ※ Make sure the power is disconnected when finishing job.
- ※ Make sure there is no any damage in the machine before reusing.

**If only following above mentioned, the precaution can work well.**

#### 3.2.9 Operation after an accident:

Make sure the switch of the machine is closed before powering it on.

#### 3.2.10 Tightness of parts

Make sure the pipes are fixed correctly. Ensure that it can move well and prevent it from sliding down.

#### 3.2.11 Work in environment with hazards

When work in a ditch, check if there is fender which stop the earth or stones from falling down to the machine, and also check if it has a water or other fluid leaking, if there be, the operator may get an electric shock.

When lift the machine to ditch, the weight of the machine should be within the rated lifting weight, and person is forbidden staying under the lifting arm.

Avoid using the machine in the environment full of paint, gas, smoke and deoil, since the infection of eyes and respiratory tract would be caused.

**Do not put the machine in a dirty place.**

#### 3.2.12 Personnel safety while working

Remove jewelry and rings, and does not wear loose-fitting clothing avoid wearing shoe lace, long mustache or long hair that may be hooked into the machine.

The following is the operation rules:

---Wear safety glove



---Wear safety shoe



---Dress work clothes



---Wear safety glasses



---Wear earmuffs



### 3.2.13 Keep the site clean and tidy

Crowd, dirty and messy site is not favourable to working, so it is important to keep the site clean and tidy.

3.2.14 Untrained person is not allowed to operate the machine anytime.

### 3.3. Potential Dangers

#### 3.3.1 Butt fusion machine controlled by hydraulic unit:

This machine is only operated by professional person or others with a certificate for operation, otherwise unwanted accident may be caused.

#### 3.3.2 Heating Plate

The max temperature can reach 270°C, so the following things should be noticed:

-----Wear safety glove



-----Never touch the surface of the heating plate



#### 3.3.3 Planing tool

Before shaving the pipes, ends of pipes should be cleaned, especially clean the sand or other draft crowd around the ends. By doing this, the lifetime of edge can be prolonged, and also prevent the shavings are thrown out to danger people.

#### 3.3.4 Basic Frame:

Make sure the pipes or fittings are fixed correctly to get the right alignment. When joining pipes, the operator should keep a certain space to the machine for personnel safety.

Before transporting, make sure all the clamps are fixed well and can not fall down during transportation.

#### 3.3.5 Lift (if lift provided)

Check every parts of the lift to avoid any unwanted danger.

**Follow all the safety marks in the machine.**

## 4. Applicable range and Technical parameter

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Type	SWT-B500H	
Materials	PE, PP, PVDF	
Max. range of diameter	500 mm	
Environment Temperature	- 5~45℃	
Power Supply	~380 V±10%	
Frequency	50 Hz	
Total current	17A	
Total power	10 kW	
Include : Heating Plate	7kW	
Facing tool Motor	1.5 kW IP54	
Hydraulic Unit Motor	1.5 kW IP54	
Crane	/	
Dielectric resistance	>1MΩ	
Undesired sound	<70 dB	
Max. Pressure	8 MPa	
Total section of cylinders	23.06cm <sup>2</sup>	
Volume of oil box	3L	
Hydraulic oil	40~50 (kinematic viscosity) mm <sup>2</sup> /s, 40℃)	
Undesired sound	<70 dB	
Max. Temp. of Heating Plate	270℃	
Difference in surface temperature of heating plate	±5℃	
Basic frame	Size , mm	1650×1050×950
	Weight , kg	550
Hydraulic unit	Size , mm	780×420×470
	Weight , kg	45
Planing tool and heating plate	Size , mm	1080×750×1300
	Weight , kg	102
Total weight , kg		697

## 5. Descriptions

The machine is formed of basic frame, hydraulic unit, heating plate, facing tool, the recorder, support, lifter and recorder.

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## 5.1 The machine



Figure .1  
1. Hydraulic unit    2. Basic frame    3. Support    4. Facing tool    5. Heating plate    6. Crane

## 5.2 Hydraulic Unit



Figure .2  
1. Direction valve    2. Pressure regulation valve    3. Pressure gauge  
4. Swing check valve    5. Oil tank    6. Power supply socket

## 6. Instruction for Use

6.1 The whole equipment should be placed on a stable and dry plane to operate.

6.2 Before operation make sure the following things:

- a) The power supply should fit the requirements according to the butt fusion machine
- b) Power line is not broken or worn
- c) The blades of planning tool are sharp
- d) All instruments are normal
- e) All necessary parts and tools are available

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f) The machine is in good conditions

### 6.3 Connection and preparation

6.3.1 Connect the basic frame to hydraulic unit by quick couplers.



6.3.2 Connect the heating plate to the eclectic box with the special cable.



Connection the cable with electrical box

Connection between the cable and heating plate

6.3.3 Install appropriate inserts to frame according to the outside diameter of pipes/fittings.

6.3.4 According to the requirements of fitting and welding process, set the temperature in temperature controller and set time in timer. (See section 7 this manual).

### 6.4 Operation.

6.4.1 Before welding, firstly, check if the material, diameter and wall thickness are the required ones. Secondly check if there are scratches or fissures on the surface of pipes/fittings. If the depth of scratches or fissures exceeds 10% of the wall thickness, cut the section of scratches or fissures.

6.4.2 Clean the inside and outside surface of pipe ends to be welded.

6.4.3 Place the pipes/fittings in inserts of frame. The pipe out of the basic frame should be supported to the same central axial of clamps. Fasten the screws of clamps to fix the pipes/fittings.

6.4.4 Measure the drag pressure: open the pressure regulation valve completely, lock the swing check valve tightly and then push forward the direction valve meanwhile adjust the pressure regulation valve till the cylinder begin to move, at this point the pressure in the system is the drag pressure.

6.4.5 Open the pressure regulation valve completely, lock the swing check valve tightly and then push forward the direction valve meanwhile adjust the pressure regulation valve to set the system pressure equals to drag pressure add butting pressure.

6.4.6 Separate the pipes/fittings ends after turning swing check valve in anti-clockwise direction to relief the pressure to lowest. Put the planning tool between the pipes/fittings ends and switch it on, close the pipes/fittings ends by operating the direction valve of hydraulic unit and slowly turn swing check valve in clockwise direction until there are continuous shavings appearing on both ends , push the direction valve bar on middle position for a few seconds, and then open the frame, switch off the planning tool and remove it out

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of frame, and then turn swing check valve clockwise to the end.

Caution: The shavings thickness should be within 0.2~0.5 mm and it can be adjusted by adjusting the height of the planning tool blades.

6.4.7 Close the pipes/fitting ends and check the alignment of them. The maximal misalignment should not exceed 10% of the wall thickness, and it could be improved by loosening or tightening the screws of clamps. The gap between two pipe ends should not exceed 10% of wall thickness; otherwise the pipes/fittings should be planed again.

6.4.8 Clear the dust or slit on the surface of heating plate.

Caution: Don't damage PTFE layer on the surface of heating plate.

6.4.9 Put the heating plate between the pipe ends after it reaches required temperature. Close the pipes/fittings ends by operating direction valve and raise the pressure to specified pressure by swinging pressure regulation valve till the bead reaches specified height.

6.4.10 Turn swing check valve anti-clockwise to reduce the pressure (not more than drag pressure) and turn swing check valve in clockwise direction to the end.

Press the button "T<sub>2</sub>", the soaking time begins to count and the time will count down to zero by second, then the buzzer will buzz ( see section 7 )

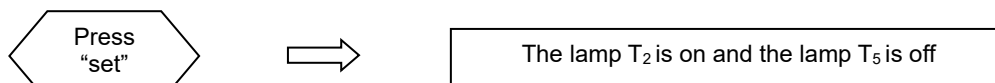
6.4.11 Open the frame and take out the heating plate and close two melting ends as quickly as possible.

6.4.12 Keep the bar of direction valve on the close position for 2 ~ 3 minutes, put the bar of direction valve on middle position and press the button ("T<sub>5</sub>") to count cooling time until it is over. At this point, the machine will give an alarm again. Relief the pressure, loose the screw of clamps and then take out the jointed pipes.

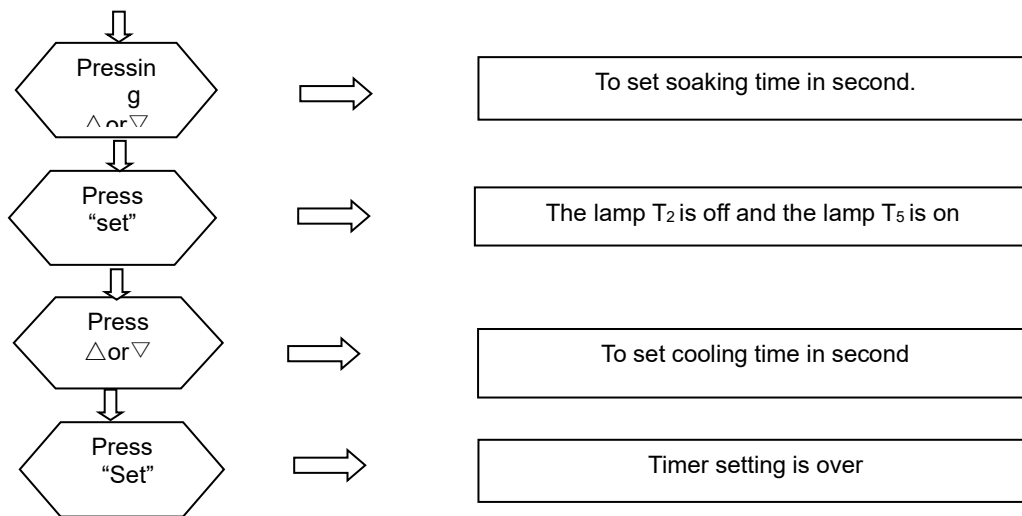
## 7. Timer and Temperature Controller

If one of the parameters is changed, such as outside diameter, SDR or material of pipes, the soaking time and cooling time should be reset according to the welding standard.

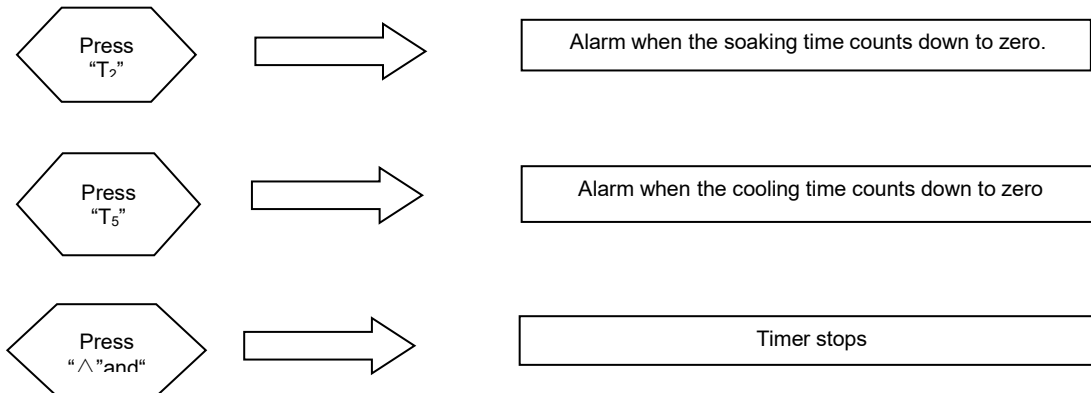
### 7.1 Timer setting



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## 7.2 Instruction for Use



## 7.3 Temperature controller setting

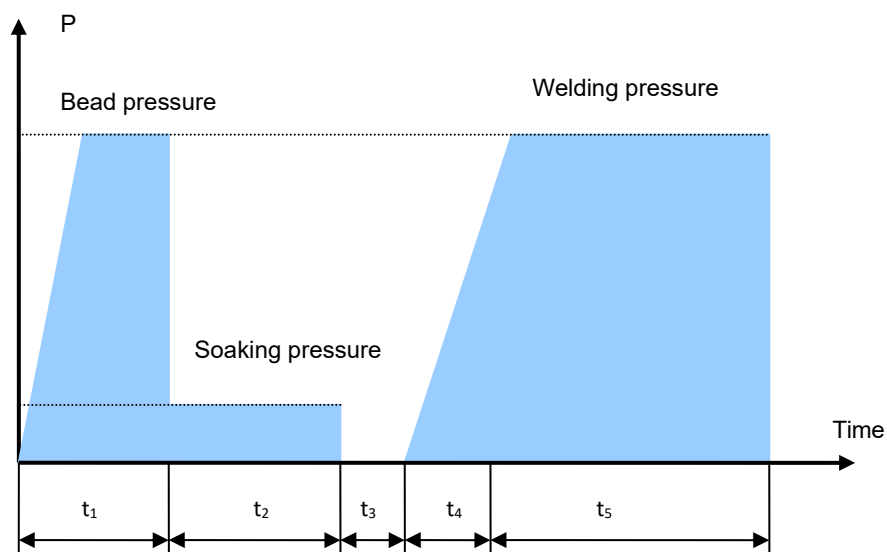
- 1) Press "SET" for more than 3 seconds till "sd" is shown in the upper window
- 2) Press " $\wedge$ " or " $\nabla$ " to change the value to specified (press " $\wedge$ " or " $\nabla$ " continuously, the value will plus or minus automatically )
- 3) After setting, press "SET" to go back to monitoring and controlling interface

## 8. Reference of Welding Standard ( DVS2207-1-1995 )

8.1 Because of difference in welding standard and PE material, the time and pressure vary in different phases of welding. It suggests that the actual welding parameters should be offered by pipes and fittings' manufacturers.

8.2 Given welding temperature of pipes made from PE、PP and PVDF by DVS standard ranges from 180℃ to 270℃. Application temperature of heating plate is within 180~230℃, and its max. surface temperature can reach 270℃.

8.3 Reference standard DVS2207-1-1995



Wall thickness (mm)	Bead height (mm)	Bead build-up pressure (MPa)	Soaking time t <sub>2</sub> (sec)	Soaking pressure (MPa)	Change-over time t <sub>3</sub> (sec)	Pressure build-up time t <sub>4</sub> (sec)	Welding pressure (MPa)	Cooling time t <sub>5</sub> (min)
0~4.5	0.5	0.15	45	≤0.02	5	5	0.15±0.01	6
4.5~7	1.0	0.15	45~70	≤0.02	5~6	5~6	0.15±0.01	6~10
7~12	1.5	0.15	70~120	≤0.02	6~8	6~8	0.15±0.01	10~16
12~19	2.0	0.15	120~190	≤0.02	8~10	8~11	0.15±0.01	16~24
19~26	2.5	0.15	190~260	≤0.02	10~12	11~14	0.15±0.01	24~32
26~37	3.0	0.15	260~370	≤0.02	12~16	14~19	0.15±0.01	32~45
37~50	3.5	0.15	370~500	≤0.02	16~20	19~25	0.15±0.01	45~60
50~70	4.0	0.15	500~700	≤0.02	20~25	25~35	0.15±0.01	60~80

Remark: Bead build-up pressure and welding pressure in the form is the recommended interface pressure, the gauge pressure should be calculated with the following formula.

Expressions:

$$\text{welding pressure} = \frac{\text{Section of welding pipe ends}}{\text{Total section of cylinders}} \times 0.15 + \text{drag pressure (MPa)}$$

## 9. Malfunctions Analyzing and Solutions

The possible malfunctions and solutions are stated as follows:

### 9.1 Joints quality analyzes (Reference)

◆ Correct joint



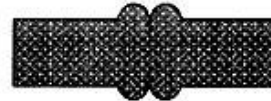
◆ Bead narrow and fall. Too big pressure



◆ Small bead. Not enough pressure



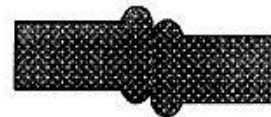
◆ Crack on the center of welding head. Not enough temperature or too long over time



◆ The material have different heating time or heating temperature



◆ Misalignment. Tolerances exceeds 10% of pipe wall thickness



### 9.2 Maintenance and inspection periods

#### 9.2.1 Maintenance

##### ※ Heating plate coating

Please take care on handling the heating plate. Keep a certain distance away from heating plate. Cleaning of its surface must be done with surface still warm by using a soft cloth or paper, avoid abrasive materials in that might damage the coating.

At regular intervals check as follows

1. Clean the surface by using a quick evaporation detergent (alcohol)
2. check the tightening of the screws and the cable and plug condition
3. Verify its surface temperature by using infrared-ray scanning

##### ※ Planing tool

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It is strongly suggested to keep always clean the blades and wash the pulleys by using a detergent. At regular intervals, carry out a complete cleaning operation.

※ hydraulic unit

Maintain it as follows

- 1) check periodically the oil level
- 2) replace totally the oil every 6 months

Keep tank and oil circuit clean

## 9.2.2 Maintenance & Inspection

Ordinary inspection

Item	Description	Inspect before use	First month	Every 6 months	Every year
Planning tool	Mill or replace the blade Replace the cable if it is broken Retighten mechanical connections	• •	•		• •
Heating plate	Rejoined the cable and socket Clean surface of heating plate, recoat PTFE layer again if necessary Retighten mechanical connections	• • •	•		•
Temp. control system	Checkout the temperature indicator Replace the cable if it is broken	•			• •
Hydraulic system	Checkout pressure gauge Replace seals if the hydraulic unit is leak Clean the filter Make sure the oil is enough for operation Change the hydraulic oil Replace if the oil hose is breakage	• • • •		•	• • • •
Basic Frame	Retighten screws in the end of frame axis Spray antirust paint again if necessary	•	•	•	•
Power Supply	Press the testing button of circuit protector to make sure it can working normally Replace the cable if it is broken	• •		•	

“•”..... maintenance period

### 9.2.3 How to adjust the deviation between heating plate and temperature controller

1. When temperature controller is stable, it reads 220 degrees



2. Test the heating plate, and the average temperature is 196 degrees



3. At this time, we should have temperature controller deviation rectified. (deviation rectified degree is -24 degree,  $196 - 220 = -24$ ), the method of deviation rectification is as follows:

a. press keys "set" and "▲" at the same time for three seconds





b. press key “set” twice, display is as the following picture  
If the temperature controller’s original rectification value is five degree, so the correct rectification value is:  $5 + (-24) = (-19)$  degree



c. Press “↓” until it displays “-19”





d. Press "set", return to original show, and complete the temperature controller setting.



4. When temperature displays 220 degrees stably, retest the surface temperature of heating plate. If there is still deviation, please repeat the above deviation rectified operation.



### 9.3 Frequent malfunction analyses and solution

During the using, hydraulic unit and electrical units may appear some problems. Frequent malfunction is listed as follows:

Please use tools attached, spare parts or other tools with a safety certificate while maintain or replace parts.

Tools and spare parts without safety certificate are forbidden to be used.

Malfunctions of hydraulic unit			
No	malfunction	malfunction analyzes	Solutions
1	The pump motor does not work	<ol style="list-style-type: none"> <li>1. Switch is fault.</li> <li>2. Power source is not connected well.</li> <li>3. The socket inside connection is loosen</li> <li>4. The machine is not grounded correctly</li> </ol>	<ul style="list-style-type: none"> <li>◆ Check the switch</li> <li>◆ Connect the power well</li> <li>◆ Check the connection</li> <li>◆ Check the earthing connection</li> </ul>
2	The pump motor rotate too slowly with abnormality noise	<ol style="list-style-type: none"> <li>1. The motor is overloaded</li> <li>2. The motor is fault</li> <li>3. The oil filter is blocked</li> <li>4. The working voltage is instable</li> </ol>	<ul style="list-style-type: none"> <li>◆ Make sure the motor load is less that 3 MPa</li> <li>◆ Repair or replace the pump</li> <li>◆ Clean the filter</li> <li>◆ Check the instability of power</li> </ul>
3	The cylinder works abnormally	<ul style="list-style-type: none"> <li>● The direction valve is damaged</li> <li>● There is air in system</li> <li>● The system pressure is too low</li> <li>● The quick coupler is blocked</li> </ul>	<ol style="list-style-type: none"> <li>1. Replace the direction valve.</li> <li>2. Move the cylinder several times to outgo the air.</li> <li>3. Adjust the system pressure</li> </ol>

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		<ul style="list-style-type: none"> <li>The pressure relief valve is not locked</li> </ul>	4. Replace the quick coupler 5. Lock the valve
4	Cylinder leak	1. The oil ring is fault 2. The cylinder or piston is damaged badly	1. Replace the oil ring 2. Replace the cylinder
5	The pressure can not be increased or the fluctuation is too big	1. The core of overflow valve is blocked. 2. The pump is leak. 3. The joint slack of pump is loosened or key groove is skid. 4. The pressure relief valve is not locked	1. Clean or replace the core of over-flow valve 2. Replace the pump 3. Replace the joint slack 4. Lock the valve
Malfunctions of electrical units			
1	The machine does not work	1. The power cable is damaged 2. Source power is abnormal 3. The ground fault switch is closed	1. Check the power cable 2. Check the working power 3. Open the ground fault interrupter
2	Ground fault switch trips	1. Power cable of heating plate, the motor of pump and planing tool may be damaged 2. Electrical components are t affected with damp 3. The higher-up power has not a ground fault safety device	1. Check the power cables 2. Check the electrical elements. 3. Check the higher-up power safety device
3	Abnormal temperature increasing	1. The temperature controller switch is open 2. The sensor ( pt100 ) is abnormal. The resistance value of 7 and 8 of heating plate socket should be within 100~183Ω 3. The heating stick inside heating plate is abnormal. The resistances between 2, 4and 6 should be within 23Ω. Insulation resistance between head of heating stick and outside shell must be more than 1MΩ 4. Should the temperature controller readings be more than 300℃, which suggest he sensor may be damaged or the connection is loosen. Should the temperature controller indicate LL, which suggests the sensor have a short circuit. Should the temperature controller indicate HH, which suggests the circuit of sensor is open. 5. Correct the temperature by button located on the temperature controller. 6. The temperature fluctuate abnormally	1. Check the connection of contactors 2. Replace the sensor 3. Replace the heating plate 4. Replace the temperature controller 5. Refer to the methods to set the temperature 6. Check and replace the contactors if necessary
4	Lose of control when heating	Check the connector is fault or the joints 7 and 8 can not open when get the required temperature.	Replace the temperature controller
5	Planing tool does not rotate	The limit switch is ineffective or the mechanical parts of planing tool are clipped.	Replace the planning tool limit switch or minor sprocket

## 10. Circuit & Hydraulic Unit Diagram

10.1 Circuit unit diagram (Seen in affix)

10.2 Hydraulic unit diagram (Seen in affix)

## 11. Packing List

Seen in affix

## 12. Guarantee Clauses

1. The guarantee range refers to the whole machine.
2. Maintenance for malfunctions during normal utilization is free of charge within guarantee time that is 24 months
3. The guarantee time starts with the date of delivery.
4. Fees are charged in case of the following condition:
  - 4.1 Malfunction caused by improper operation
  - 4.2 Damages caused by fire, flood, and abnormal voltage
  - 4.3 Working exceeds its normal function
5. Fees are charged as actual expense. A contract about the fees shall be abided if there is one.
6. Please contact us or our agent if any questions.

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### 13. Space Occupation Chart

