

Electro fusion machine



DH-II Electro Fusion Machine Operation Mannual

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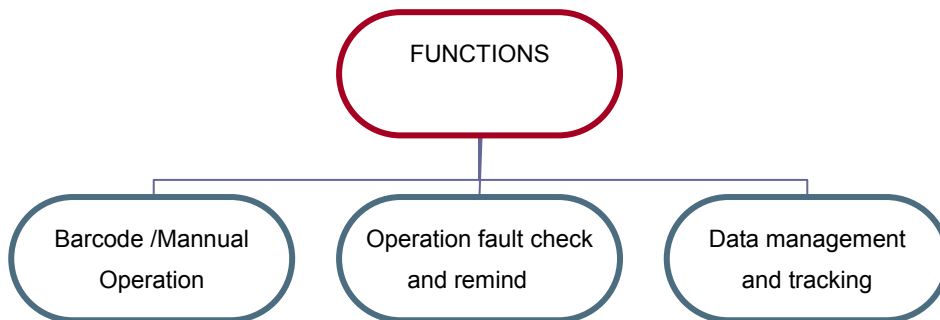
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1. Introduction

DH-II Electro-fusion machine adopts scm (single chip) as the main controller, controlled by voltage adjustment which can output precise voltage. It adopts Chinese and English two languages panel. Matched with laser scanning tool to read the barcode information, and execute the fusion according to the barcode. It can check the operation fault and reminds the operator by itself. 1000 pcs data memory capacity, quick data download and printing easy for management and tracking after welding.



DH-II Electro-fusion machine can be used on water-supply, gas ,irrigation and other pipeline installation. The machine will output the welding power by adjusting the welding voltage and welding time by itself after barcode recognition or receive the data by manual input.



2.Main Operation

ITEM NO.	DH-II
INPUT VOLTAGE	220v ± 15%
OUTPUT VOLTAGE	10~50v
ISO BARCODE	24 digits: Standard Electro-fusion
WELDING RANGE	20mm-400mm
PIN DIAMETER	4.0 mm 4.7mm
POWER SUPPLY	3200w-90A
WORKING TEM.	-10°C ~ +45°C
IP GRADE	IP54
MEMERORY	1000PCS
DATA DOWNLOAD	USB
PRINTER INTERFACE	Serial interface DB9P
SIZE (L×W×H)	295×212×416mm
WEIGHT	21kg
WARRANTY	1 YEAR

3.Key Description



Parameter Positive Number Selection Key



Parameter Negative Number Selection Key



Backward key



Forward key



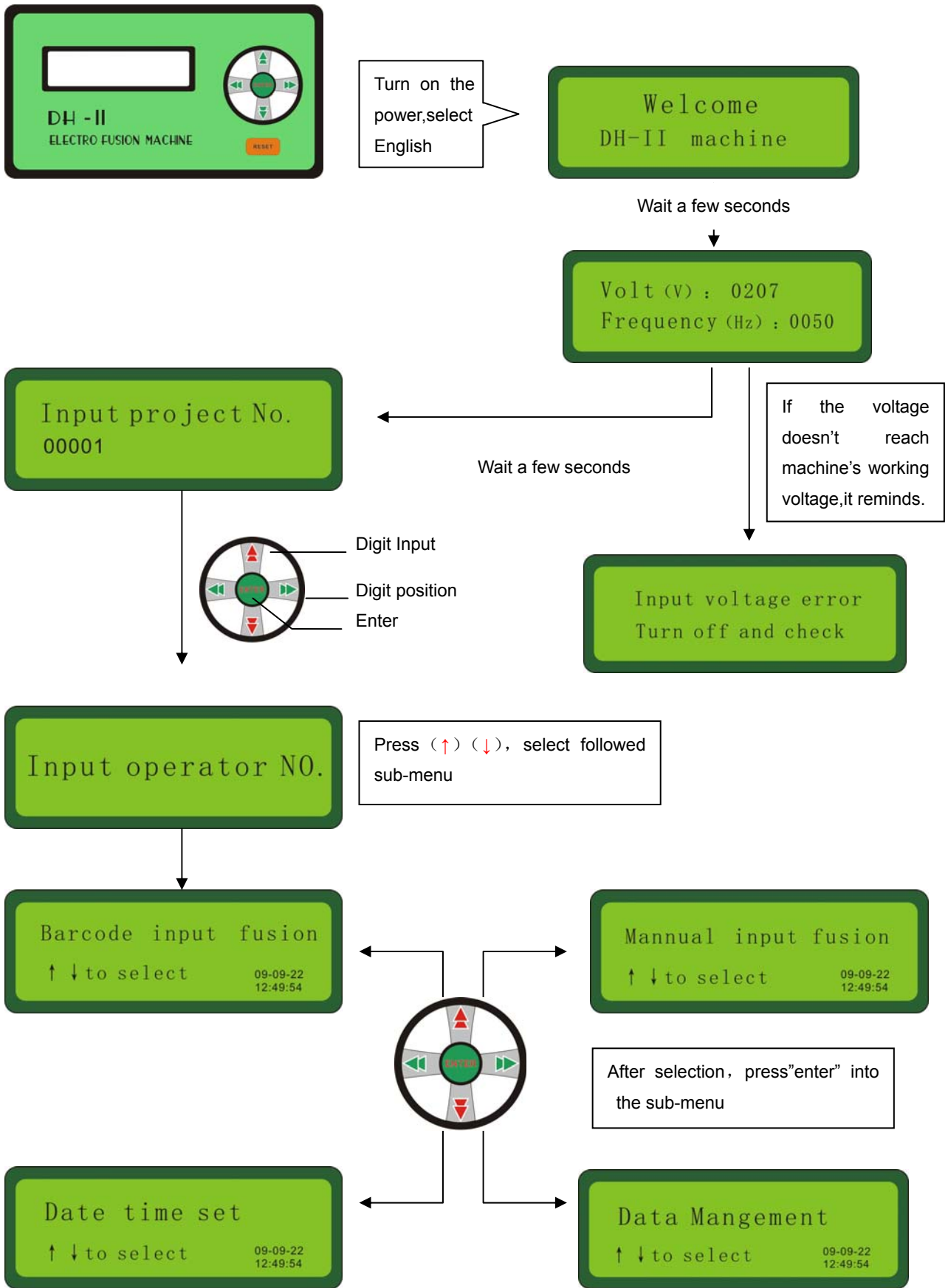
Reset key

4.Operation Preparation

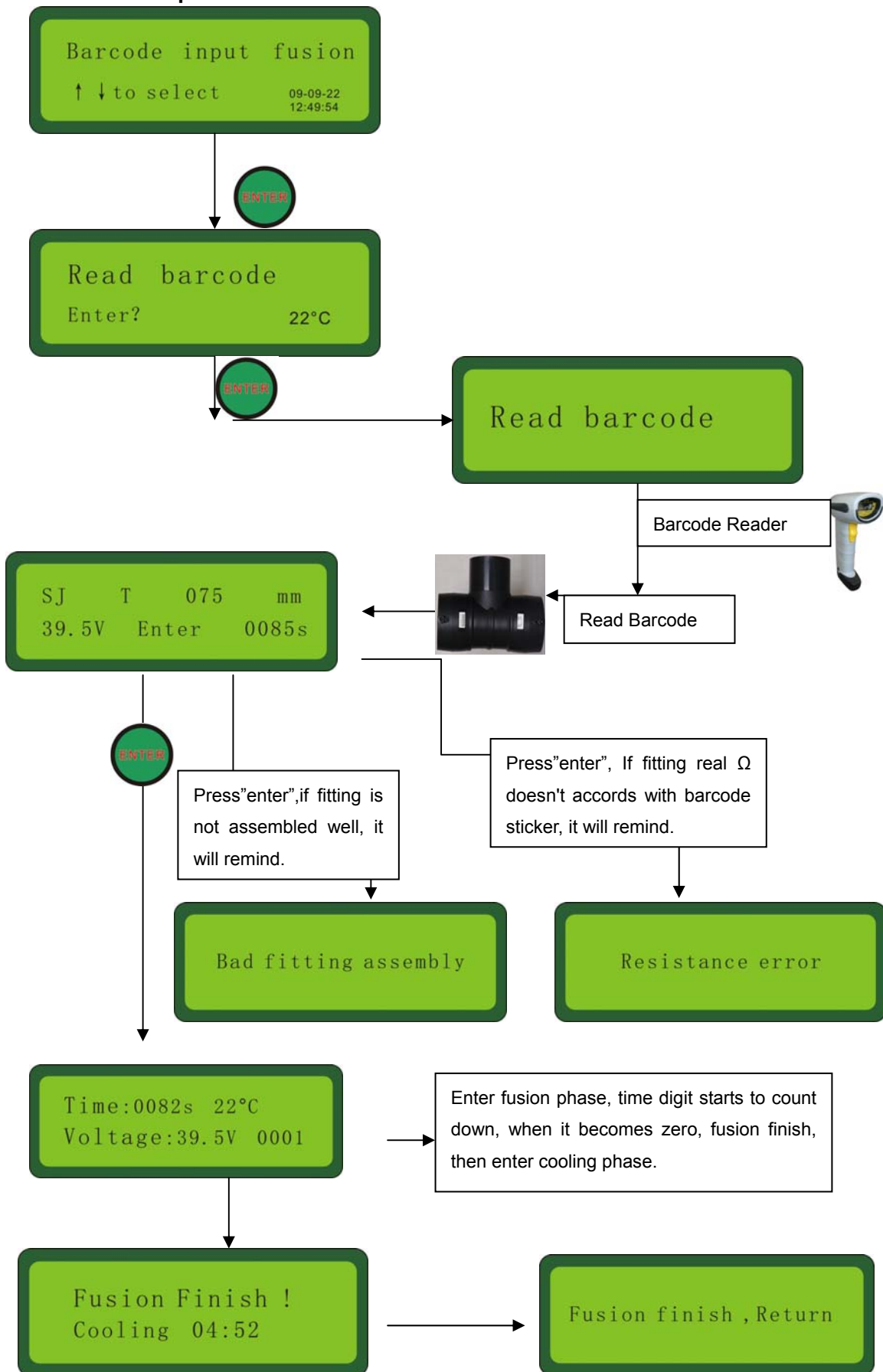
- ◆ Before connect the power supply, make sure the power switch is on “off” position.
- ◆ Check if wire and socket is in good condition.
- ◆ Assemble the electrofusion fitting with pipe according to related requirement, scrapping the surface and clean, then assemble and clamp.
- ◆ Connect the machine with the power supply and connect the output wire of machine with electro-fusion fittings.

Notice: When power comes from power generator, before the operation, make sure the generator is supplying the power stably.

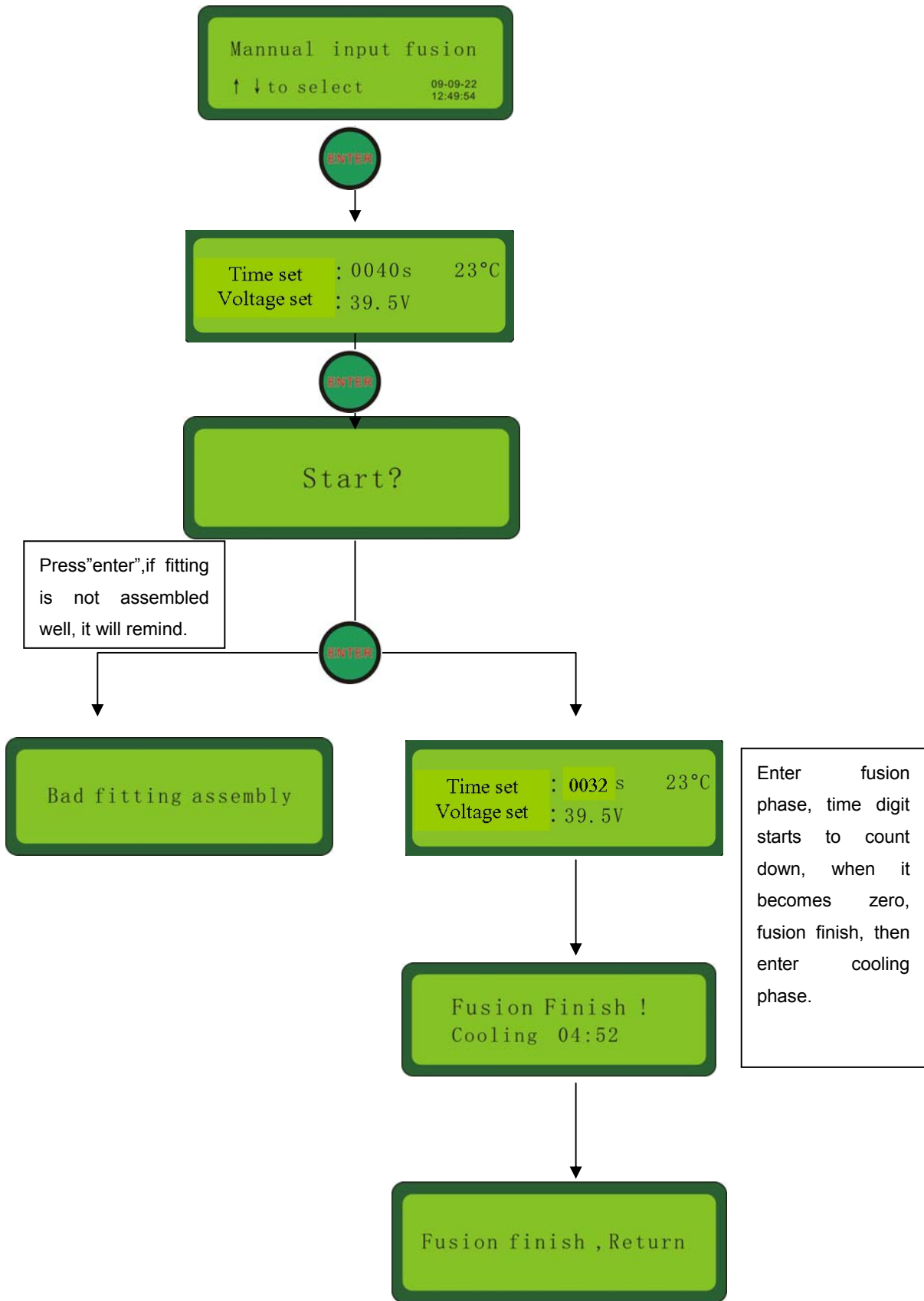
5: Machine Operation



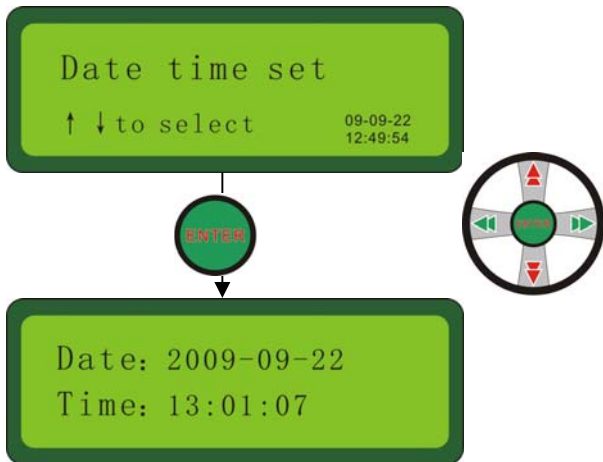
5.1 Barcode Fusion Operation



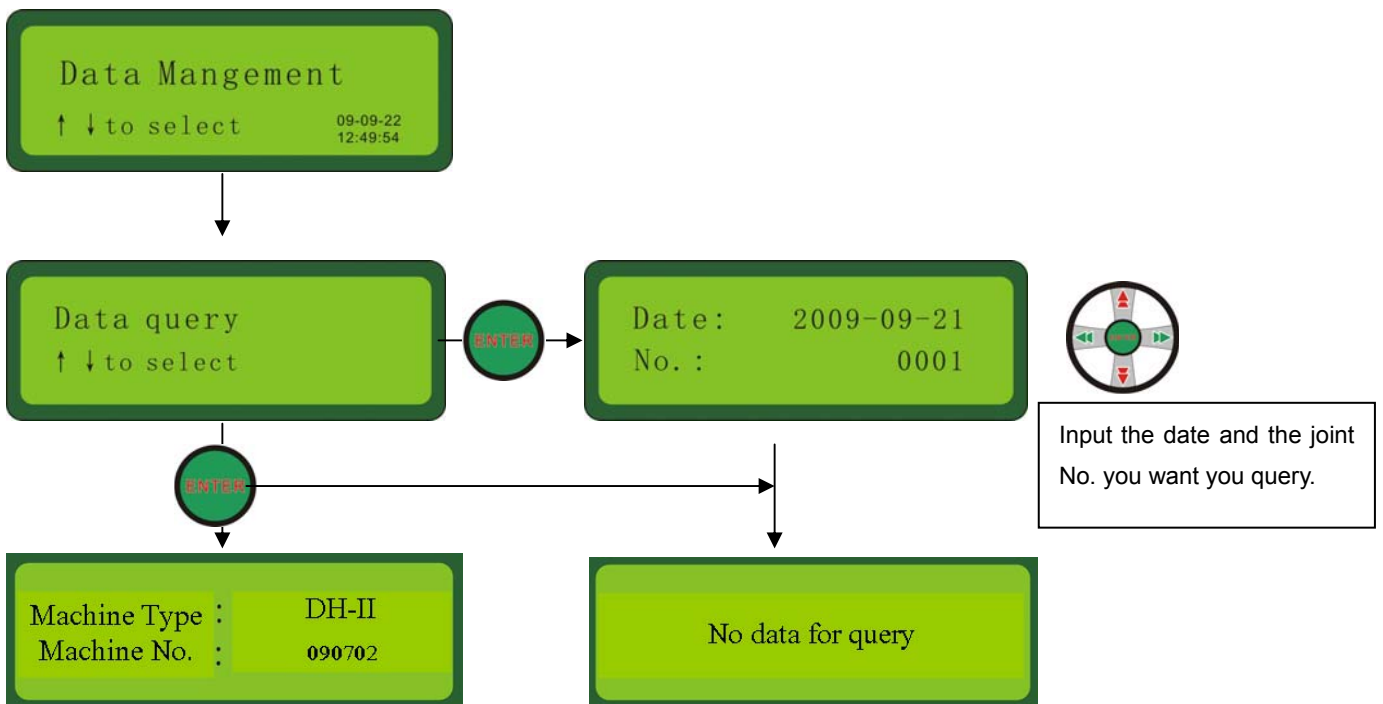
5.2 Manual fusion operation



5.3 Date and time set

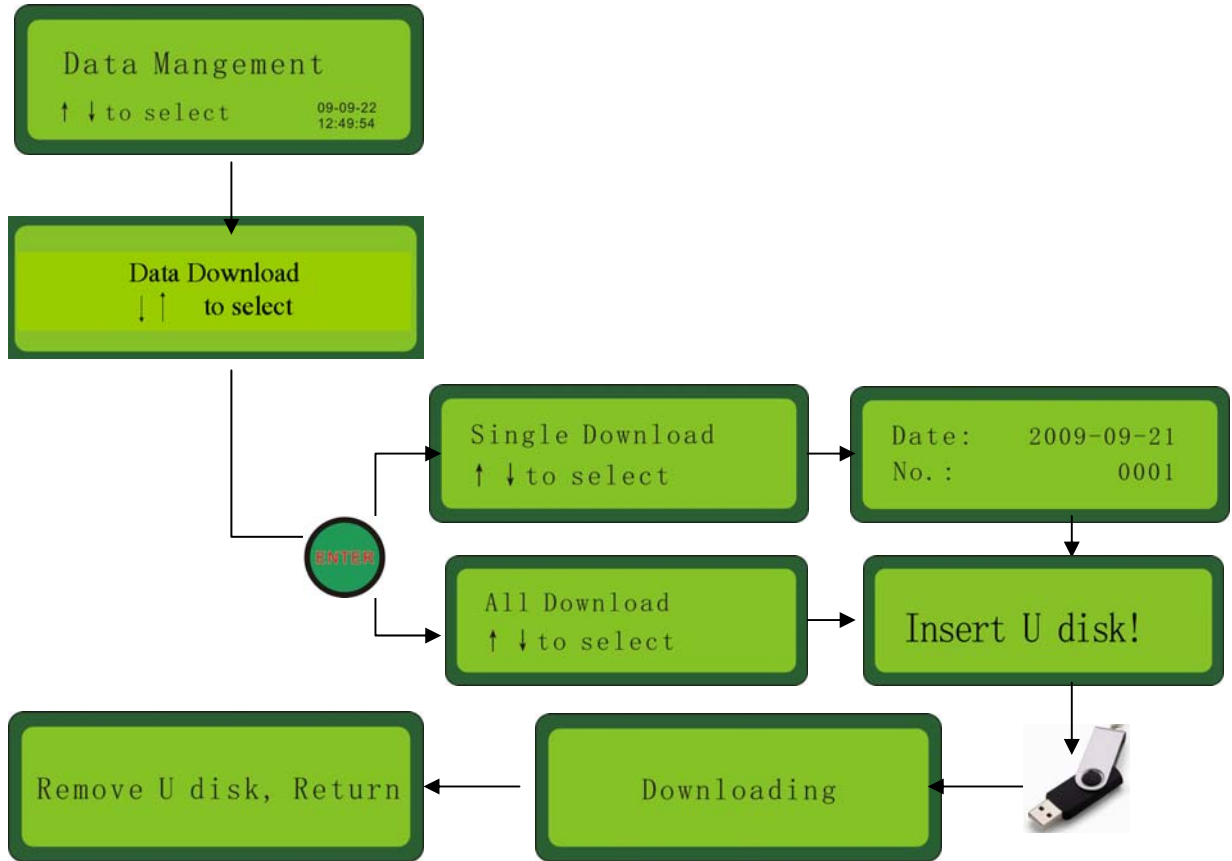


5.3 Data query



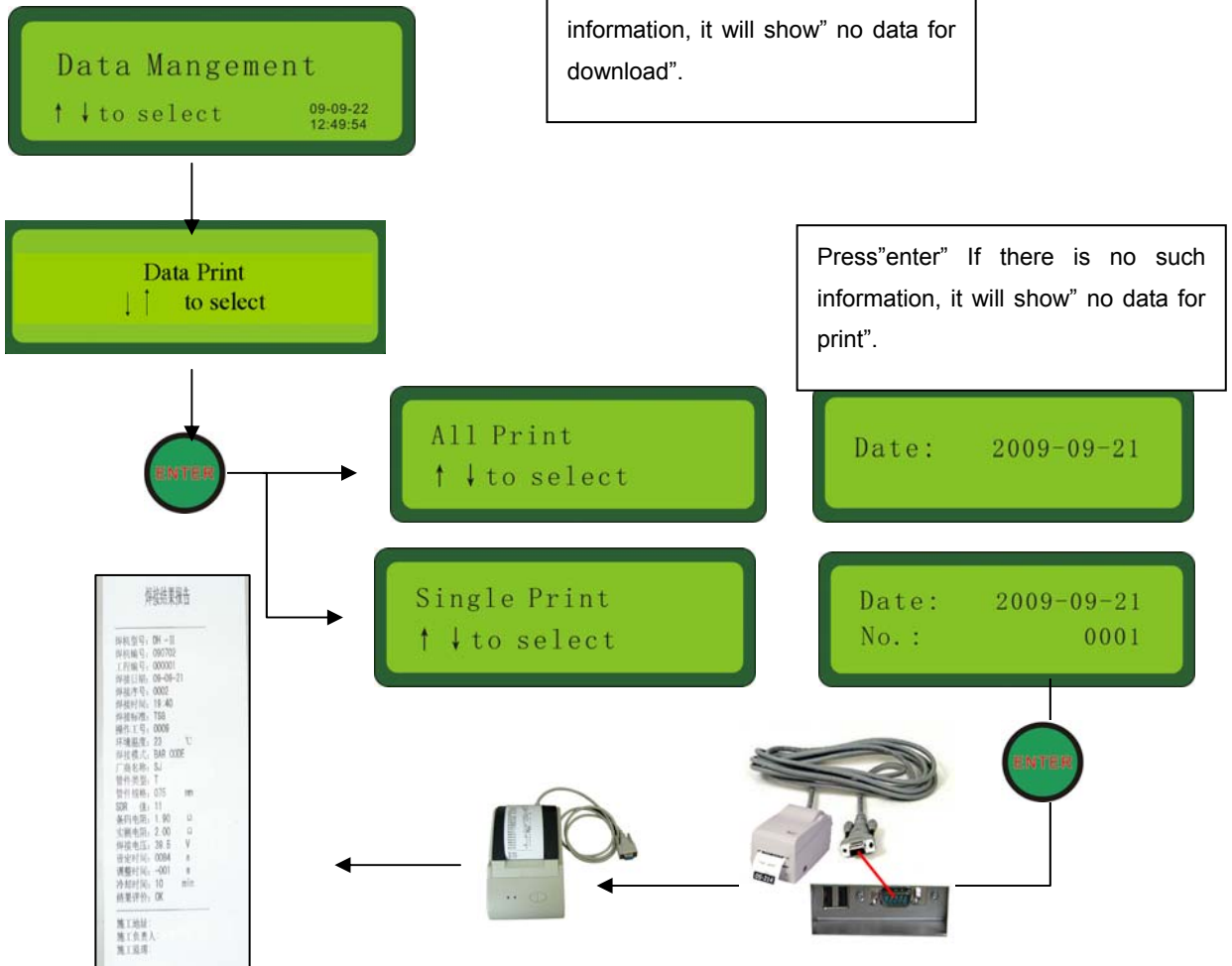
Press "enter" it will show the detailed information you query, press (↑)(↓) to check the information line by line. If there is no such information, it will show "no data for query".

5.3 Data download



Press "enter" If there is no such information, it will show "no data for download".

5.4 Data print



Press "enter" If there is no such information, it will show "no data for print".

焊接结果报告

焊机型号: DM-10
焊机编号: 090702
工厂编号: 000001
焊接日期: 09-09-21
焊接序号: 0002
焊接时间: 13:40
焊接标准: T68
焊工工号: 0009
环境温度: 23 °C
焊接模式: BAR CODE
厂商名称: SJ
零件类型: T
零件规格: 035 mm
罐号: 11
条码电压: 1.90 u
空载电压: 2.00 G
焊接电压: 38 F V
焊接时间: 0004 s
罐号时间: -001 s
冷却时间: 10 min
结果评价: OK

施工站号:
施工负责人:
施工日期:

6.Operation Fault

6.1 Barcode reading fault

When reading barcode, there is no audio-frequency confirmation signal, please check if there is physical damage or wire connection problem. If there is a problem in barcode reader, you can change to manual fusion.

6.2 Fusion break

For operation fault, the fusion break in the middle, if the fitting manufacturer demonstrate that fitting can be fused again, fusion should be conducted after it cools down.

6.3 Error reminds

No.	Error Code	Error	Remark	Result	Reminds
1	01	Input volage error	Input voltage doesn't arccords 220V±15% range.	Cann't enter next step	Input voltage error ! turn off and check ! (Buzzer reminds turning off the power.)
2	02	Barcode error	Barcode sticker damage	Cann't enter barcode reading	Barcode error! (Buzzer reminding returing back)
3	03	Beyond working Temp.	Environ.Temp. beyond -10~+45°C range.	Cann't enter fusion	Enviro.Temp. Error! (Buzzer reminds turning off the power)
4	04	Output break	Pin problem Resistance too big Output wire damage	Cann't enter fusion	Bad fitting assembly! (Buzzer reminding returing back)
5	05	Resistance error	Fitting damage Output wire damage Real resistance doesn't accord with sticker information	Cann't enter fusion	Resistance Error! (Buzzer reminding returing back)
6	06	Fusion phase voltage too low or output voltage break	Fusion phase voltage too low or output voltage break	Fusion terminate	Low voltage ! (Buzzer reminding returing back)
7	07	Memorizer full,	Capacity reach 1000pcs	Warning	Capacity full, download!