



TECHSPAN CE/Handextruder

- D** EG – Konformitätserklärung
- F** Déclaration CE de conformité
- I** Dichiarazione CE di conformità
- GB** EC Declaration of conformity
- E** Declaración CE de conformidad

D EG – Konformitätserklärung

DOHLE Extrusionstechnik, D-53809 Ruppichterorth/BRD

Bestätigt, dass das nachfolgend bezeichnete Gerät in der von uns in Verkehr gebrachten Ausführung die Anforderungen der folgenden EG-Richtlinie(n) erfüllt.

Bezeichnung des Gerätes : Handschweissextruder
Typ : Mini CS
EG – Richtlinie : Elektromagnetische Verträglichkeit
89/336/EWG Niederspannungsrichtlinie 73/23/EWG
Harmonisierte Normen : EN55014-1, EN55014-2, EN61000-3-2,
EN61000-3-3, EN60335-2-45

Peter Chr. Dohle

Ruppichterorth, 1.04.2003
Peter Christian Dohle, Geschäftsführer

F Déclaration CE de conformité

DOHLE Extrusionstechnik, D-53809 Ruppichterorth/BRD

déclare qu'à la sortie de ses usines l'appareil désigné ci-dessous était conforme aux dispositions de(s) la directive(s) CEE suivante(s).

Description de l'appareil : Handschweissextruder
Modèle : Mini CS
Directive(s) CEE : 89/336/CEE, 73/23/CEE
Normes harmonisées : EN55014-1, EN55014-2, EN61000-3-2,
EN61000-3-3, EN60335-2-45

Peter Chr. Dohle

Ruppichterorth, 1.04.2003
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I Dichiarazione CE di conformità

DOHLE Extrusionstechnik, D-53809 Ruppichterorth/BRD

dichiara che l'apparecchio qui di seguito descritto nei modelli commercializzati risulta conforme alle direttive di armonizzazione comunitarie impartite dalla CEE.

Descrizione dell'apparecchio : Handschweissextruder
Modello : Mini CS
Direttive CEE : 89/336/CEE, 73/23/CEE
Norme armonizzate : EN55014-1, EN55014-2, EN61000-3-2,
EN61000-3-3, EN60335-2-45

Peter Chr. Dohle

Ruppichterorth, 1.04.2003
Peter Christian Dohle, Geschäftsführer

GB Declaration of conformity

DOHLE Extrusionstechnik, D-53809 Ruppichterorth/BRD

declares that the tool described below, released by us. Fulfits the provisions of the follwings EC directive(s).

Description of tool : Handschweissextruder
Type : Mini CS
EC directives : 89/336/CEE, 73/23/CEE
Harmonized standards : EN55014-1, EN55014-2, EN61000-3-2,
EN61000-3-3, EN60335-2-45

Peter Chr. Dohle

Ruppichterorth, 1.04.2003
Peter Christian Dohle, Geschäftsführer

E Declaración CE de conformidad

DOHLE Extrusionstechnik, D-53809 Ruppichterorth/BRD

certifica que el aparato que a continuación se describe cumple con la ejecución que hemos puesto en circulación, con las exigencias de las directrices armonizadas de la CE.

Denominación del aparato : Handschweissextruder
Modelo : Mini CS
Directrice(s) de la CE : 89/336/CEE, 73/23/CEE
Normas armonizadas : EN55014-1, EN55014-2, EN61000-3-2,
EN61000-3-3, EN60335-2-45

Peter Chr. Dohle

Ruppichterorth, 1.04.2003
Peter Christian Dohle, Geschäftsführer

Type of machine	:	Mini CS
Machine No.	:
Required voltage	:	230 V / 50 - 60 Hz
Unit total	:	2400W/10,5A

We retain all copyrights of all descriptions, drawings and schedules contained in these operating instructions which may not be reproduced nor be made accessible by third parties or by competitors, neither in whole nor in part, unless we have expressly consented thereto.

Before start-up these operating instructions must be examined carefully because we will not assume any liability for any failures resulting from improper use. No warranty claims will be accepted if the hand-held welding and extruding machine has been modified unless this has been done in consultation with the manufacturer/ supplier.

The extruder shall be used for extrusion weld works only !

These operating instructions should always be accessible by the operator.

For after-sales service and orders please contact:

TECHSPANGROUP
Australia & New Zealand -
Ph Australia - 1-800 148 791
Ph New Zealand - 0800 603 603
Email - info@techspanonline.com
Website - www.techspanonline.com

Safety:

Pursuant to section 55 of VDE 0 100 (Regulations of the Association of German Electrotechnical Engineers), the extruder must be operated using a protective switch or an isolation transformer. Always keep extruder dry!

Operating hand-held welding and extruding machines is subject to applicable national regulations. Observe applicable regulations for the prevention of accidents as well as technical rules for safe and professional operation.

Directive 92/ 57/ EWG dated June 24, 1992, shall be applicable by analogy.

Utilisation:

Hand-held welding and extruding machines are manufactured according to the latest state of the art and in compliance with safety requirements.

Any improper use may result in dangers for the operator or third parties or may adversely affect machines and assets.

Only use hand-held welding and extruding machines if in technically perfect condition and for the purposes for which they are intended while observing the operating instructions.

The manufacturer / supplier will not accept any liability for any failure to comply with the above or for damages resulting there from.

Any utilisation of the hand-held welding and extruding machine for other purposes than those for which it is intended is subject to the consent of the manufacturer / supplier.

Work on electrical parts of the hand-held welding and extruding machines may only be performed by an electrical engineer in compliance with electro-technical rules.

Special risks:

All hand-held welding and extruding machines may only be held and operated using the handles provided for this purpose.

A risk of burning exists on all **uncovered metal parts**. Avoid contact with these parts because they may achieve temperatures of up to 350 °C.

Caution: Heat can reach combustible materials!

Safety area:

The hot air stream of the hand-held welding and extruding machine may not be directed to temperature-sensitive objects or living things. Ensure that a safety distance of 2m is observed in all directions.

Don't concentrate the heat stream long time on the same area.

Operation:

Never use hand-held welding and extruding machines without air supply.

In case of external air supply ensure that the feed line is of sufficient size.

The pressurised air that is supplied **must be free of oil and water**.

Overhead work:

When working overhead always wear appropriate safety devices (such as hard hat, goggles etc.).

Safety:

Check for correct nominal voltage before connecting the hand-held welding and extruding machine to the mains voltage.

Mains voltage must be identical to the nominal voltage shown on the type plate of the hand-held welding and extruding machine.

Pursuant to sec. 55 of VDE 0 100 the hand-held welding and extruding machine must be operated using a protective switch or an isolation transformer.

Extension cords:

When using extension cords the minimum diameter of cables must be observed.

Length up to 18 m: diameter 2.5 mm²

Length up to 50 m: diameter 4.0 mm²

Extension cords must be approved and marked for their place of utilisation.

Stop operating the hand-held welding and extruding machine if:

- connecting line or plug have been damaged
- safety installations have been damaged
- foreign objects or liquids have entered the hand-held welding and extruding machine
- changes occur in the operating state

Never spray water on hand-held welding and extruding machines

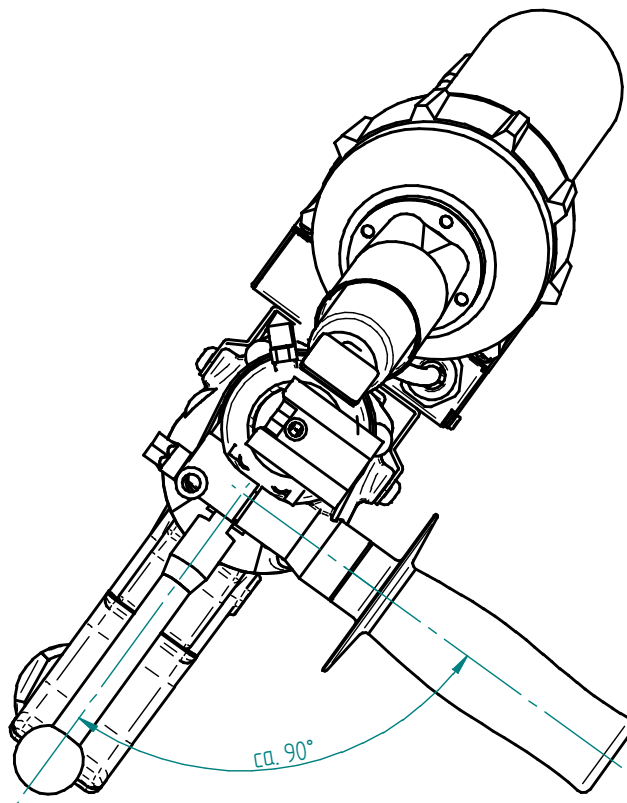
(risk of short circuit)

Never use hand-held welding and extruding machines in hazardous or inflammable areas.

To park the tool:

To save the stand, click the machine base out and put the tool on the three points (machine base – handle drive unit – pivoted handle).

Make sure that the machine base to the pivoted handle is in angle of 90°.



Start-up

General:

Observe the notes on safety contained in these operating instructions. In addition, the regulations on the prevention of accidents and the national regulations shall apply.

Assembling the hand-held welding and extruding machine

When dispatched, our hand-held welding and extruding machines are almost completely assembled.

What remains to be done is to screw the enclosed handle to the machine.

For machines with external air supply the air supply hose must be connected.

Ensure sufficient supply with air which is free of oil and water (min. 300 l/min).

We recommend our air compressor, item no. DX 011.

Weld fitting

The machine is supplied with two blanks for weld fittings which can be machined to suit your requirements.

Note: please observe guideline DVS 2207 part 4.

If you indicate your required form of seam and thickness of plates we will supply two weld fittings machined ready for use.

Start-up of hand-held welding extruder

Observe the section concerning safety of these operating instructions.

Hand-held welding and extruding machines may not be used without air supply.

This would inevitably result in damages of the extruder.

Before connecting the extruder to the mains supply please check that:

- air supply is connected correctly
- the driving machine has not been put to permanent operation
- now switch on air supply
- and put plug into socket.

If you give now the power supply plug to a suitable plug socket (230V, 16A), press that On-off switch on the air heater on position ON and place on position 4 the potentiometer.

The machine heats now up.

Make sure by each switching on of the machine, that the on-off switch of the drive engine is switched off.

After a heating-up time of approx. 15 minutes, start the machine using the welding material wished by you and examine the air and welding material temperature with a suitable temperature measurement. By changing the temperature of the air heater consider the reaction response time of the system .

Change of the welding shoe

In order to be sure that no more old welding rod is in the hand welding extrusion, heat up the machine on operating temperature, remove the welding shoe and change the nozzle (note: left hand thread!).

Note: with work on heated machine burn danger.

When the nozzle is changed drive for approx. 1 min. the new welding rod in the hand welding extrusion.

Interruption of the welding

Do not leave the hand welding extruder unsupervised.
The air supply must remain maintained

Switch off the hand welding extruder

Bring the potentiometer of the air heater in position 0 and pull after ca.2 minutes the power supply plug.

Note: Also after 15 minutes still exists on bright metal parts burn danger.

No water or other materials for accelerating the cooling procedure must be used. .

Maintenance

Before maintenance work on the equipment, pull power supply plug!
Maintenance work may be accomplished only by electrical specialists.

Consider the security chapter!

After approximately 500 operation hours the hand welding extruder, including the drive unit must be cleaned, greased and controlled. These work may be implemented only by electrical specialists.

Drive

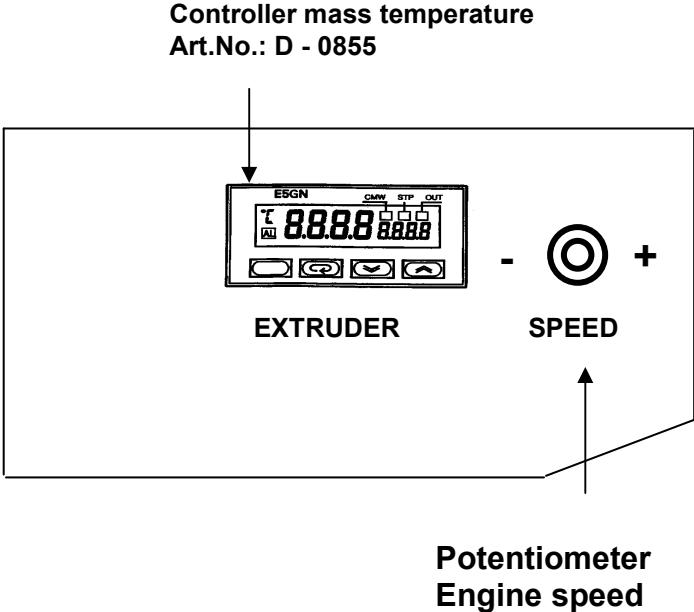
The carbon brushes conductors of the drive must be examined approx. every 200 operation hours and renewed if necessary.

Deep groove ball thrust bearing /barrel extruder

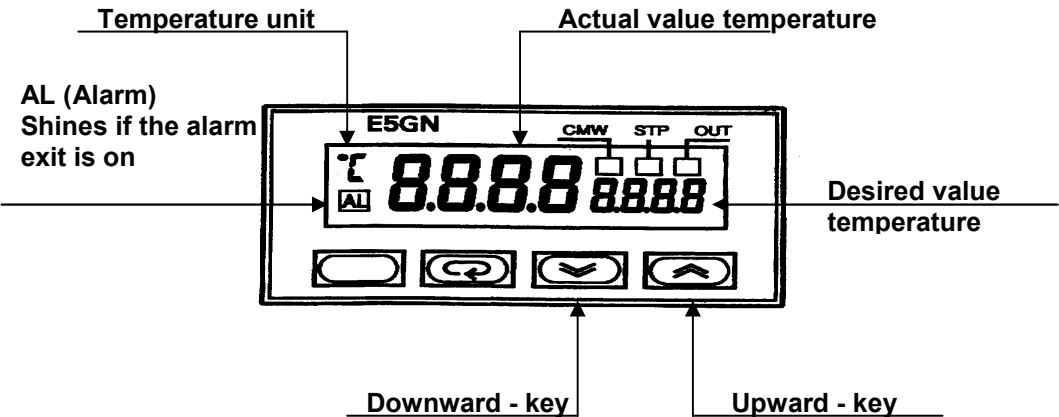
The deep groove thrust bearing and the barrel extruder should be cleaned approx. every 200 operation hours and again be greased

Note: Only high temperature grease can be used. Our art. no.: D-0581

View - controller front - steering box



Display and control elements of the controller front



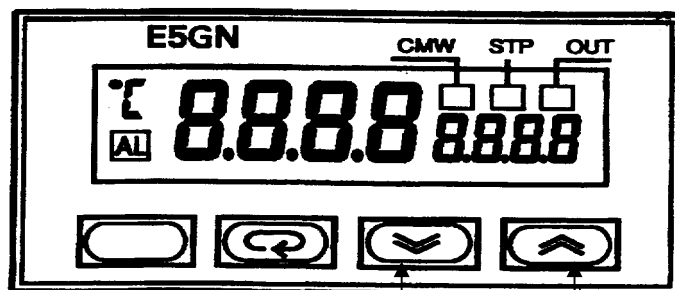
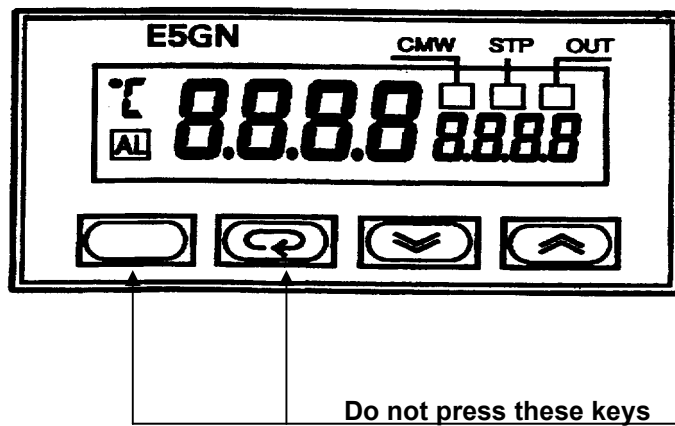
Controller – desired value setting

All controllers can be changed only in the desired value and are electronically locked against wrong inputs.

Change the desired value

The controller indicates actual and desired value temperature at the same time.

To change the desired value temperature proceed as follows:



Downward- key

By every press of this key, the value becomes smaller, which is indicated on the desired value display. If this key is kept constantly pressed, then the value sequentially becomes smaller.

Upward – key

By every press of this key, the value increases, which is indicated on the desired value display. If this key is kept constantly pressed, then the value sequentially becomes higher.

Error tracing

Malfunctioning

Error- Nr.

Driving motor does not start 01,02,08,09,10,11,12

Driving motor switches off 03, 08,09,10

Extruder remains cold 09,

Hot air remains cold 08,09,12

Hot air temperature is under 13

desired value

Extrusion temperature is under 11

desired value

Error- Nr.	possible cause	Elimination of error
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01	no current supply	provide current supply
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02	wrong rated voltage	leave examine from specialist/expert
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03	extension cord becomes hot	examine line cross section unroll completely cable drum
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08	On/off switch on OFF	Switch on ON
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09	defect on cable connection	leave examine from specialist/expert
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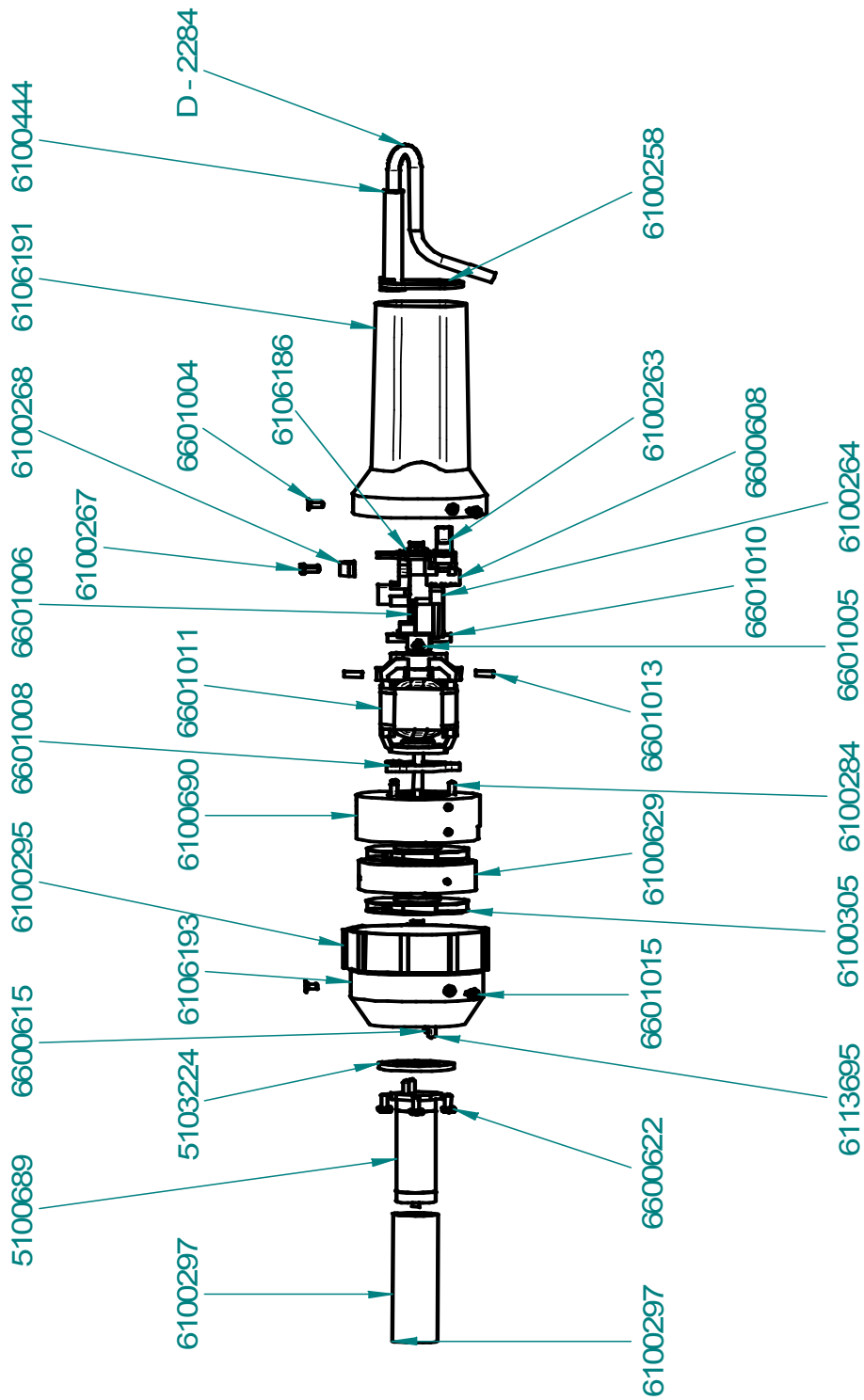
10	Carbon brushes of drive motor worn	Replace the carbon brushes
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11	pre-heating time too short	Heat up the extruder
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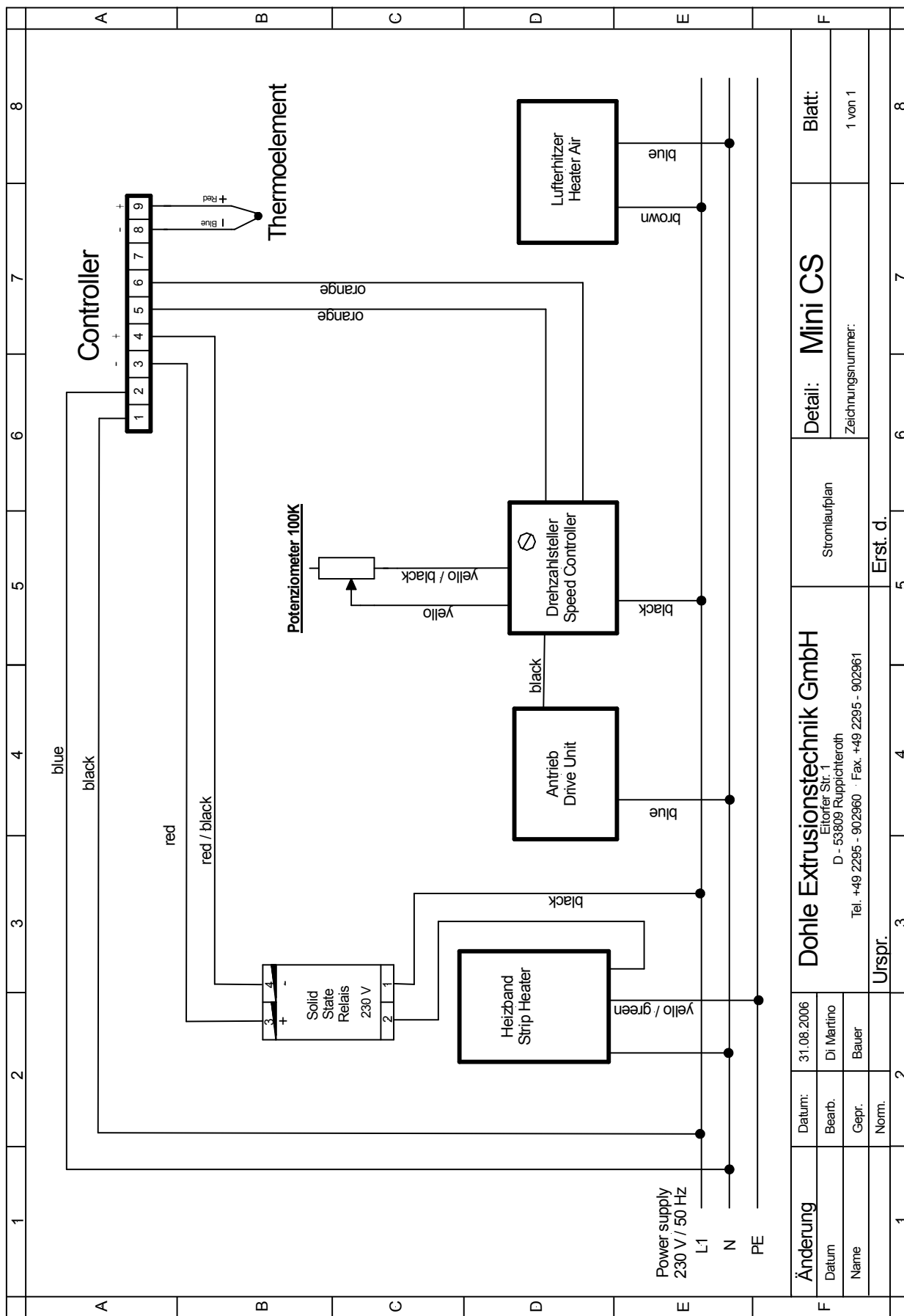
12	external air supply not connected	Connect external air supply
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13	Air flow too high when using	reduce to prescribed quantity
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article-no	description	qty
D - 0164	deep groove ball thrust bearing	1
D - 0283	screw M5x40	4
D - 0567	cylinder pin 3x8	1
D - 0652	screw M4x6	1
D - 0680	compression spring handle	1
D - 0687	link	1
D - 0688	link joint 1502-3002	1
D - 0690	ball button 1502 - 6002	1
D - 0691	axis	1
D - 0707	ULS screw M6x10	2
D - 0726	ball	1
D - 0727	press sleeve 3x16	1
D - 0789	speed regulator	1
D - 0792	cylinder draft Mini	1
D - 0793	disc Mini	1
D - 0794	output shaft	1
D - 0801	worm Mini	1
D - 0806	strip heater Mini 230V/320W	1
D - 0815	burner pipe Mini	1
D - 0816	die Mini	1
D - 0823	thermoelement	1
D - 0846	control box Mini	1
D - 0847	head control box Mini	1
D - 0849	front paneel Mini D	1
D - 0854	handle	1
D - 0855	temperature controler Mini	1
D - 0858	drive unit Mini, 230V	1
D - 0860	sealing ring CU	1
D - 0861	hinge pin for hose clamp	1
D - 0863	ULS screw M5x20	1
D - 0864	screw 2,9x6,5	11
D - 0905	air die Mini PVC	1
D - 1074	RION 230V/1600W	1
D - 1076	cylinder Mini	1
D - 2002	screwed cable PG9	2
D - 2004	pa hexagon nut PG9	1
D - 2010	screwed cable PG7	1
D - 2011	pa hexagon nut PG7	1
D - 2014	potentiometer 100k	1
D - 2050	screwed cable buckelproofed PG11	1
D - 2063	main cable 8m	1
D - 2134	widening PG9-PG11	1
D - 2177	solid state relais	1
D - 2260	hexagon nut Ms PG9	2
D - 2261	connecting clamp	1



article-no	description	qty
5100689	heating element 230V-1550W	1
5103224	gasket 30/50x4	1
6100258	air filter	1
6100263	potentiometer knob red	1
6100264	connecting piece complete	1
6100267	pt-screw KL30x10	2
6100268	strain relief	1
6100284	countersunk screw M4x12 TX	3
6100287	hexagon nut M5	1
6100295	rubber ring	1
6100297	mica tube	1
6100305	turbine	2
6100444	cord guard 9,6x75	1
6100629	stripper	1
6100690	turbine housing	1
6106186	rocker switch	1
6106191	handle	1
6106193	connecting head	1
6113695	temperatur limit switch 135°C	1
6600608	potentiometer 10KOhm	1
6600615	phototransistor	1
6600622	fillister head screw M4x10 TX	4
6601004	screw M4x10 TX	3
6601005	pt-screw KL40x10 TX	2
6601006	electronic circuit board 230V	1
6601008	flange turbine housing	1
6601010	flange connecting piece	1
6601011	motor RION, 230V	1
6601013	carbon brush 230/120V	2
6601015	screw M4x8 TX	3
D - 2284	power supply cord H07 2x1	1

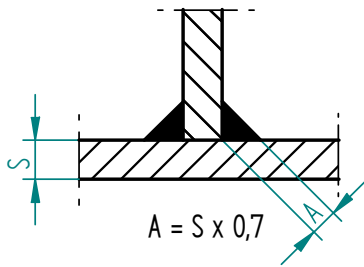


Änderung	Datum:	31.08.2006	Dohle Extrusionstechnik GmbH		Stromtauplan	Detail:	Mini CS	Blatt:	1 von 1
	Bearb.:	Di Martino	Eitorfer Str. 1 D - 53809 Ruppichteroth				Zeichnungsnummer:		
	Name:	Bauer	Tel. +49 2295 - 902960 · Fax. +49 2295 - 902961		Erst. d.				
1	Norm.:		Urspr.						

Schweißschuhprogramm Mini

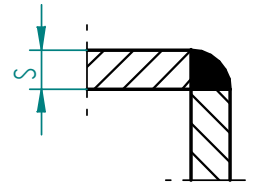
S = Plattendicke

Kehlnaht



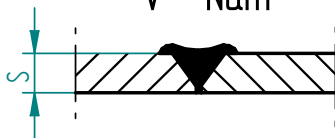
Plattendicke	Artikel-Nr.
5-6	D-0827
8	D-0828
10	D-0829
12	D-0830

Eck - Naht



Plattendicke	Artikel-Nr.
5-8	D-0837
8-12	D-0838

V - Naht

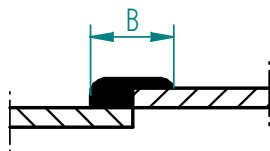


Plattendicke	Artikel-Nr.
5-6	D-0831
8	D-0832
10	D-0833
12	D-0834

Sonderschweißschuh rund

	Artikel-Nr.
ϕ 10	D-0839
ϕ 15	D-0840
ϕ 20	D-0841

Folien - Naht



Nahtbreite B	Artikel-Nr.
20	D-0835
25	D-0836

Schweißschuh - Rohling

Größe	Artikel-Nr.
30 x 40 x 30	D-0842
ϕ 30	D-0843

Sonderabmessung nach Anfrage