



**Technical Data Typ W 2500 Special**

**Welding Equipment operating at 400 V / 50 – 60 HZ / 16 Ampere**

(Planer operating at 400 V/ 50 Hz/ 4,6 Amp with 550 Watt at 140 Rpm)

(Welding Mirror operating at 230 V/50 Hz/ 4,5 Amp with 1000 Watt)

**Remark: The welding equipment needs exhaustive Power Supply of 6 KVA or full 16 Ampere directly at equipment.**

1. **Never move or open planer without power 'on' !!!!!**  
Fix Handle with 13 mm screw-wrench.  
Insert pipe clamps according pipe size.  
Insert planer inserts according pipe size.  
Fix welding mirror according pipe size.



2. **Connect welding equipment to power supply.**  
**Switch Main Power on.**  
**Check power on with red light from planer position switch.**



3. **Switch both welding mirror on.**  
**Check temperature to be minimum 210°C.**  
**Green light is on during heat up period.**



4. **Fix pipe ends by clamps with about 4 cm projecting ends**



5. **Read all planer instructions carefully before use to prevent from damages.**  
**Planer must be connected to power supply 'on' always before any operation !!!**  
**Planer is equipped with electromagnetics to hold the planner halves. Never open planer halves during red lamp at control board.**

6. **Fix planer in park position exactly between pipe ends. Hand gear is in position 'left'.**  
**Light at control board is off.**

7. **Unlock planer by turning hand gear 60° right in position 'pick up'.**



<p>8. Pull left handle towards yourself and pull hand gear simultaneous for opening. Open in one motion but not abruptly. Swing planer halves over the stay cable.</p>	
<p>9. Planer pre-closing position.</p>	
<p>10. Lock planer by turning hand gear 90° left and push in position 'lock'.</p>	
<p>11. Light at control board shows 'green'. Press green button permanent during planning process. Move the support until both pipe ends are in contact with the planer. Best planer force is 8 Kp. Pipe ends are plane when circular shavings on both pipe ends are built up. Move support back unless planer is in free motion. Release green button now. Planer will stop in 'opening position' automatically. Pull hand gear, turn 90° right and move planer back and close it in position 'park'.</p>	
<p>12. In case of unexpected planer stop during planning light at control board shows 'red'.</p>	
<p>13. Push the emergency button to continue the planning process. Move support back unless planer is in free motion.</p>	

14. Press green button until position switch light of the planer shows 'red-on'.  
Move planer back in 'park position' as described before.

15. Remove the pipe end shavings without touching the pipe ends.  
Check pipe parallelism (gap max 0,5 mm) by closing the pipe ends using the support and check alignment (max. 1.0 mm)



16. Check welding temperature (minimum 210°C + 10°C).  
Control light is 'green' during heating up.

17. Control light is 'out' if temperature is reached.



18. Place welding mirror in central position between the pipe ends, swing over the stay cable and fix it.



19. Move the support forward and set up adjusting pressure.



20. After minimum circumferential adjusting bead is achieved, release the pressure to the warm up pressure indicated in the list.



21. Remove welding mirror after warm up time end by not exceeding the change over time.

22. Apply welding pressure from 0 to full pressure smoothly in between the given time.  
Check the welding time.

23. Keep pressure up during cooling time.



24. After end of cooling time release the pressure.  
Unclamp welded pipe

