



# Welding Machine Set

# KAS®



## KAS WELDING MACHINE SET - 94.00.001

<b>Body</b>	Aluminium Body
<b>Heat Element</b>	Double heating elements with thermostat. Heating elements are made of non-corrosive material
<b>Power (W)</b>	1500 watt
<b>Temperature Range</b>	50 - 300 °C
<b>Welding Diameter</b>	16 - 63 mm
<b>Voltage</b>	220 - 240 - Volt 50 - 60 Hz
<b>Foot</b>	Aluminium Foot
<b>Warranty</b>	1 Year
<b>Set Weight</b>	5.15 kg
<b>Set Dimensions</b>	440 mm x 270 mm x 100 mm
<b>Set Include</b>	Welding Machine, Aluminium Yoke Foot, Cutter, Allen Key Steel Tape, Swiss Teflon Coated Die Plates (20 mm, 25 mm, 32 mm, 40 mm)

## PPR PIPE WELDING MANUAL

1. Get welding machines and suitable welding sockets ready. Sockets should be cleaned before assembly.
2. Turn on the welding machine by setting it to 260°C. The thermostat light turns off when it reaches 260°C, at which point you can start welding.
3. Be careful to have the welding surfaces of pipes and fittings clean. If needed, the surfaces should be cleaned with alcohol and dried with a clean cloth.
4. Pipes should be cut to appropriate measurement and vertical to the pipes axis.
5. The height of the pipe's welding area should be equal to the depth of the welding and should be marked. Longer length can cause smaller radius accumulation, shorter length can cause space and less welding area.
6. The pipe and fittings inserted into the welding socket should not turn.
7. The heating time should be calculated according to the table at the bottom.
8. Pipe and fittings should be heated at the same time. At the end of heating process, they should be rapidly removed from the socket at the same time and connected along the same axis pushing into each other without turning.
9. After connecting wait for the assembly to cool.

## WELDING TIMES

External Diameter (mm)	Depth Grafting (mm)	Time of Heating (sec.)	Time of Assembly (sec.)	Time of Cooling (min.)
20	14	5	4	2
25	15	7	4	2
32	16,5	8	5	3
40	18	12	6	4
50	20	18	7	4
63	24	24	8	6
75	28	30	8	6
90	29	40	8	8
110	32,5	50	10	8
125	40	70	10	8
160	48	100	10	10