

*Socket fusion kits*



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# Socket Fusion Kits Operation Mannual

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### SF63 SF110 Socket Fusion Kits

These tools are of best quality of the kind from China, and the product is CE approved.

Feature:

Manual operated

Electronic control for temperature adjustment

Digital display

Suitable for pipe material of PE, PP, PPR, PVDF and PB

## 1. Product Description

Product components:

SF socket fusion kits mainly include parts as followed:

- High-quality electric tube heater;
- Electronic temperature controller;
- Plastic handle;
- Welding head;
- Good quality plastic tool box.

SF socket fusion kits adopt the analog electronic control circuit, and micro- computer controlling circuit.

Product feature:

- Quick temperature rising;
- High temperature accuracy;
- Easy and reliable operation;
- Digital temperature set;
- Auto environmental temperature correction;
- Real temperature display;
- Self-alarmed when temperature exceeds the set temperature.

## 2. Notice and Rules

- (1) Please read this manual carefully before operation.
- (2) Power supply adopts bipolar with grounding plug. Don't change the plug without authorization; the plug must be earthed.
- (3) Be careful about the high temperature, protect yourself from being hurt.
- (4) Please place the socket kits well to protect the shell.
- (5) Avoid using it outdoor when it rains to protect the kits from being wet.
- (6) Protect the welding head well.
- (7) Be careful when install the welding head, don't tighten screws too tightly.
- (8) The welding machine is placed by the fixed broad. It's easy and firm.
- (9) Unplug after using, put it into the box after cooling.
- (10) Don't open the shell without qualified electrician to prevent the anti-electric shock device.
- (11) Power on, when red light means welding device is heating, when red light is off, green light means welding device stop heating. After a moment, red light is on again. It means kits enter the temperature maintaining state, and then start to work.

## 3. Operation

(1) Recommend the welding temperature of the pipe

PP-R	260℃
PB	240℃
HDPE	220℃

(2) Temperature setting

Press the setting key(●),you can see temperature setting digits flashing, then if you press the increasing key(▲)or the decreasing key(▼),the digit can be changed. If you need change the tenth digit, please press the L/R key(◀▶),then press the increasing or decreasing key to change it. The maximum temperature setting is 279℃, the minimum is 200℃, after setting,

please press the setting key (SET) to finish the setting.

(3)Temperature overheat alarm

When the temperature is over 295℃, the buzz rings, please cut off the electricity.

(4)Change the fuse

There is the fuse that can protect the machine from the short-cut. The fuse need be changed by qualified electrician when it burns.

(5) Environmental temperature self compensation

The kits has the environmental temperature self compensation function. When environ. temp. is lower than 7 degree, the kits will automatically increase 10 degrees based on the setting temperature. When environ.temp. is over 30 degree, he kits will automatically decrease 8 degrees based on the setting temperature.

(6) Factory setting temperature

The temperature of the machine is 260℃ when it is manufactured.

#### 4. Technical Parameter

Type	Rated voltage V~	Rated frequency Hz	Rated power W	Setting temperature ℃	Alarm temperature ℃	Show temperature ℃	Heating time <min
SF-32	220	60	600	260			10
SF-63	220	60	800	260			10
SF-110	220	60	1200	260			10
ZRJQ	220	60	800	200~279	295	0~295	10
ZRJQ	220	60	1200	200~279	295	0~295	10

#### 5. Welding Parameter

Dn (mm)	Melt depth (mm)	Heating time (s)	Working time (s)	Cooling time (min)
20	14	5	4	3
25	16	7	4	3
32	20	8	4	4
40	21	12	6	4
50	22.5	18	6	5
63	24	24	6	6
75	26	30	8	8
90	29	40	8	8
110	32.5	50	10	8

When temperature is lower than 5 degree, please extend the heating time 5%.