

Working Instructions Translation

Heating element butt welding machine

WIDOS 6100



Keep for further use!

Model:	Heating element butt welding machine
Type:	WIDOS 6100
Serial number, year of construction:	see type lable

Customer Entries

Inventory-No.:	
Place of working:	

Order of spare parts and after sales service:

Address of manufacturer

WIDOS

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Purpose of the document

These working instructions give you information about all important questions which refer to the construction and the safe working of your machine.

Just as we are, you are obliged to engage in these working instructions, as well.

Not only to run your machine economically but also to avoid damages and injuries.

Should questions arise, contact our service team in the factory or in our subsidiary companies.

We will help you with pleasure.

According to our interest to continuously improve our products and working instructions, we kindly ask you to inform us about problems and defects which occur in exercise.

Thank you.

Structure of the working instructions

This manual is arranged in chapters, which belong to the different using phases of the machine.

Due to this structure, the searched information can be easily found.



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Any changes prior to technical innovations.

1. DESCRIPTION OF THE PRODUCT	6
1.1. Usage and purpose-oriented use	6
1.2. Safety measures.....	6
1.3. Conformity	6
1.4. Designation of the product	6
1.4.1. Technical data	7
1.4.1.1. WIDOS 6100 General data	7
1.4.1.2. Heating element.....	7
1.4.1.3. Planer.....	8
1.4.1.4. Hydraulic aggregate.....	8
1.4.1.5. Basic frame	8
1.4.1.6. Lift-off device (optional).....	8
1.5. Machine overview	9
1.6. Accessories:	9
2. SAFETY RULES	10
2.1. Explanation of the symbols and indications	10
2.2. Obligations of the owner	11
2.3. Obligations of the worker.....	11
2.4. Measures of organisation	11
2.5. Information about safety precautions.....	11
2.6. Instructions for the staff.....	11
2.7. Dangers while handling the machine	12
2.8. Maintenance, inspection and repair.....	12
2.9. Dangers caused by electric energy.....	12
2.10. Dangers caused by the hydraulics.....	12
2.11. Specific dangers	13
2.11.1. Danger of catching clothes by the planer.....	13
2.11.2. Danger of being burnt by heating element, reception box and welding area	13
2.11.3. Danger of stumbling over electric / hydraulic wires	13
2.11.4. Danger of squeezing by clamping devices and guideways.....	13
2.11.5. Risk of injury by noises	14
2.12. Structural modifications on the machine	14
2.13. Cleaning the machine	14
2.14. Warranty and liability.....	14
3. FUNCTIONAL DESCRIPTION	15
4. OPERATING AND INDICATING ELEMENTS	16
4.1. Elements on the aggregate	16
4.2. Elements at planer and heating element	17
4.3. Separating device for heating element.....	17

5. STARTING AND OPERATING	18
5.1. Safety indications	18
5.2. Connection of hydraulic aggregate with basic machine	19
5.3. Replacing the reduction inserts	19
5.4. Setting the heating element temperature	20
5.5. Welding process	20
5.6. Lift-off device (optional)	22
5.6.1. Mounting of the machine	22
5.6.2. Mounting the lift-off device	22
5.6.3. Transport	22
6. WELDING LOG AND TABLES	23
7. MAINTENANCE AND REPAIR	25
7.1. Maintenance and inspection, repair	25
7.2. Clamping elements	25
7.3. Planer	25
7.4. Storage	25
7.5. Used hydraulic oil	25
7.6. Checking the hydraulic oil level	26
7.7. Venting the hydraulic cylinders	26
7.8. Disposal	27
8. TRANSPORT	28
9. HYDRAULIC AND ELECTRIC DIAGRAMS	29
9.1. Electric diagram 400 V	30
9.2. Electric diagram 230 V	38
10. SPARE PARTS LIST	41
11. DECLARATION OF CONFORMITY	42

1. Description of the product

This chapter gives important basic information about the product and its prescribed use.

All technical details of the machine are put together as a general arrangement.

1.1. Usage and purpose-oriented use

The WIDOS 6100 has been designed for heating element butt welding of pipes and fittings with a diameter range of $\varnothing = 315 - 630\text{mm}$.

(standard diameters: 315 / 355 / 400 / 450 / 500 / 560 / 630mm)

It is a machine for construction sites and particularly designed for the usage on-site, as well as in the workshop.

For this reason, the frame is kept small so that it can be used even under difficult conditions (e.g. ditch).

All use going beyond is not purpose-oriented.

The manufacturer is not responsible for damages caused by misuse.

The risk is held only by the user.

Also part of the purpose oriented use is

- respecting all the indications of the working instructions and
- performing the inspection and maintenance works.

1.2. Safety measures

In case of wrong use, wrong operation or wrong maintenance, the machine itself or products standing nearby can be damaged or destroyed.

Persons being in the endangered area may be injured.

Therefore these working instructions have to be thoroughly read and the corresponding safety regulations must be necessarily adhered to.

1.3. Conformity

The machine corresponds in its construction to the valid recommendations of the European Community as well as to the according European standard specifications.

The development, manufacturing and mounting of the machine were made very carefully.

1.4. Designation of the product

The product is designated by two type labels which are attached at the aggregate and at the basic machine.

They contain the type, the serial number and the year of construction of the machine.

1.4.1. Technical data

1.4.1.1. WIDOS 6100 General data

Material which can be welded:	PP, PE80, PVDF, PE 100
Pipe diameter range:	$\varnothing_{\text{outside}} = 315 - 630 \text{ mm}$
Transport box: (lxwxh): Weight:	approx. 1700 x 1560 x 1360 (mm) approx. 150 kg
Weight (without accessories):	500 kg
Fuse:	16 A
Wire cross section:	1.5 mm ²
Emissions	<ul style="list-style-type: none"> - Noises exceeding 80 dB (A) may occur; during planing it is obligatory to wear ear protection! - When using the named pipe materials and when welding below 260°C no toxicant damp arises
Ambient conditions in the welding area	<ul style="list-style-type: none"> - take care for cleanness (no dust at the welding area) - if secured by an appropriate measurement that allowed conditions for welding are indicated, it is possible to work in any outside temperature condition as far as the welder is not constrained in its manual skill. - avoid humidity, if necessary use a welding tent - avoid strong sun rays influence - protect from wind, shut the pipe ends

1.4.1.2. Heating element

	400 V	230 V
Power:	5,9 kW	10,08 kW
Voltage:	400 V (+- 10%)	230 V (+- 10%)
Current:	26 A	25,2 A
Frequency:	50 Hz	50 Hz
Surface:	nonstick-coated	
Outside- \varnothing :	684 mm	
Weight:	- appr. 32 kg	
Attached elements:	<ul style="list-style-type: none"> - Electronic temperature control - Control lamps, on/off-switch - Connecting cable with plug 	

1.4.1.3. Planer

	400 V	230 V
Motor:	Three-phase alternating current motor	
Power:	1,5 kW	5,75 kW
Voltage:	400 V (+- 10%)	230 V (+- 10%)
Nominal current	3,7 A	2,5 A
Frequency:	50 Hz (+- 10%)	50 Hz (+- 10%)
Speed of motor:	appr. 140 rpm	
Attached elements:	<ul style="list-style-type: none"> - On/off switch - Connecting cable with plug - Locking device 	
Weight:	appr. 100 kg	

1.4.1.4. Hydraulic aggregate

	400 V	230 V
Power:	0,56 kW	0,3 kW
Voltage:	400 V (+- 10%)	230 V (+- 10%)
Nominal current	4 A	2,7 A
Frequency:	50 Hz	50 Hz
Displacement of phase:	appr. 18°	
Hydraulic oil tank:	appr. 1 L	
Insulation system	IP 54	
Electromotor and pump:		
Speed:	2720 rpm	
Max. working pressure of pump:	appr. 130 bar	
Working pressure:	0-130 bar adjustable	
Volume velocity:	3,5 L/min	
Weight:	appr. 30 kg	

1.4.1.5. Basic frame

Reduction inserts, pipe supports:	Optional dimensions
Material frame:	Structural steel
Material reduction inserts:	Aluminium
Max. force (F=P*A):	17.3 kN (at p= 100 bar)
Cylinder-Ø:	60 mm
Piston rod-Ø:	50 mm
Length of stroke of cylinder:	300 mm
Weight	appr. 226 kg
Velocity of piston rod:	3,4 cm/s

1.4.1.6. Lift-off device (optional)

Lift capacity:	appr. 100 kg
Weight (complete)	appr. 32 kg

See spare parts list for order numbers and single parts

1.5. Machine overview



1	Hydraulic aggregate
2	Heating element
3	Planer
4	Reception box
5	Basic machine with clamping devices
6	Lift-off device (optional)

1.6. Accessories:

Following tools and accessories are part of the delivery:

1	Tool bag for 10 parts
1	Socket spanner size 27
1	Torx screwdriver T10
1 each	Allen key angulate, size 3 / 12
1	Allen key with T grip size 7
Optional	<ul style="list-style-type: none"> • Different reduction inserts, • roller stands for the pipes, • transformer 42V, • crane for insertion and removal of heating element and planer

2. Safety rules

The base for the safe handling and the fault-free operation of this machine is the knowledge of the basic safety indications and rules.

- These working instructions contain the most important indications to run the machine safely.
- The safety indications are to be followed by all persons working on the machine.

2.1. Explanation of the symbols and indications

In the working instructions, following denominations and signs are used for dangers:



This symbol means a possibly danger for the life and the health of persons.

- The disrespect of these indications may have heavy consequences for the health.



This symbol means a possible dangerous situation.

- The disrespect of these indications may cause slight injuries or damages on goods.



This symbol means a possible dangerous situation by moving parts of the machine

- The disrespect of these indications may cause heavy crushings of parts of the body resp. damages of parts of the machine.



This symbol means a possible dangerous situation due to hot surfaces.

- The disrespect of these indications may conduct to heavy burns, respectively to self-ignition or even fire.



This symbol means a possible risk of injury by noises exceeding 80 dB(A).

- Ear protection is obligatory



This symbol gives important indications for the proper use of the machine.

- The disrespect of these indications may conduct to malfunctions and damages on the machine or on goods in the surrounding.



Under this symbol you get user tips and particularly useful information.

- It is a help for using all the functions on your machine in an optimal way and helps you to make the job easier.

The regulations for the prevention of accidents are valid (UVV).

2.2. Obligations of the owner

The owner is obliged only to let persons work at the machine, who

- know about basic safety and accident prevention rules and are instructed in the handling of the machine, as well as who
- have read and understood the safety chapter of this manual and certify this by their signature.

The safety-conscious working of the staff has to be checked in regular intervals.

2.3. Obligations of the worker

All persons who are to work at the machine are obliged before working:

- to follow the basic safety and accident protection rules.
- to have read and understood the safety chapter and the warnings in this manual and to confirm by their signature that they have well understood them.
- to inform themselves about the functions of the machine before using it.

2.4. Measures of organisation

- All equipment required for personal safety is to be provided by the owner.
- All available safety equipment is to be inspected regularly.

2.5. Information about safety precautions

- The working instructions have to be permanently kept at the place of use of the machine. They are to be at the operator's disposal at any time and without effort.
- In addition to the manual, the common valid and the local accident protection rules and regulations for the environmental protection must be available and followed.
- All safety and danger indications on the machine have to be in a clear readable condition.
- Every time the machine changes hands or is being rent to third persons, the working instructions are to be sent along with and their importance is to be emphasized.

2.6. Instructions for the staff

- Only skilled and trained persons are allowed to work at the machine.
- It must be clearly defined who is responsible for transport, mounting and dismounting, starting the operation, setting and tooling, operation, maintenance and inspection, repair and dismounting.
- A person who is being trained may only work at the machine under supervision of an experienced person.

2.7. Dangers while handling the machine

The machine WIDOS 6100 is constructed according to the latest technical standard and the acknowledged technical safety rules. However, dangers for the operator or other persons standing nearby may occur. Also material damages are possible.

The machine may only be used

- according to the purpose-oriented usage
- in safety technical impeccable status

Disturbances, which may affect the safety of the machine must be cleared immediately

2.8. Maintenance, inspection and repair



All maintenance and repair works have to be basically performed with the machine in off position.

During this the machine has to be secured against unauthorized switching on.



Prescribed maintenance and inspection works should be performed in time. The DVS gives the advice of inspection works after 1 year.

For machines with a specially high usage percentage the testing cycle should be shortened .

The works should be performed at the WIDOS GmbH company or by an authorized partner.

2.9. Dangers caused by electric energy



Only skilled persons are allowed to work at electrical appliances!

- The electrical equipment of the machine has to be checked regularly. Loose connections and damaged cables have to be replaced immediately.
- If works at alive parts are necessary, a second person has to assist who can disconnect the machine from the mains if necessary.
- All electric tools (heating element, planer and aggregate) have to be protected from rain and dropping water (if need be use a welding tent).
- According to VDE 0100, the use on construction sites is only allowed with a power distributor with a FI-safety switch.

2.10. Dangers caused by the hydraulics



System parts and pressure hoses should be made pressureless before beginning of any repair works. Even if the machine is switched off, pressure may be in the hydraulic accumulator!

There is a danger of injuring the eyes by hydraulic oil squirting out.

- Damaged hydraulic hoses have to be immediately replaced.
- Make a visual inspection of the hydraulic hoses before each work beginning.
- The hydraulic oil is inedible !

2.11. Specific dangers

2.11.1. Danger of catching clothes by the planer



You can cut yourself or even get bones broken!

- Only wear clothes tight to the body.
 - Do not wear rings or jewellery during the work.
 - If necessary, wear a hair-net.
 - Always put the planer back into the reception box after and before each use.
 - Transport the planer at the handle only. Do not touch the surfaces.
 - Switch the planer on only for usage.
- If the planing pressure is too high, there is the danger that the planer tilts during planing. For that reason do not press the pipe ends stronger than necessary against the planer. If necessary, hold the planer firmly.

2.11.2. Danger of being burnt by heating element, reception box and welding area



You can burn yourself, inflammable materials can be ignited.

The heating element temperature is heated up to more than 250°C !

- Do not touch the surfaces of the heating element.
- Do not leave the heating element unsupervised.
- Take enough safety distance to inflammable materials.
- Do wear safety gloves.
- Always put the heating element back into the reception box after and before each use.
- Transport the heating element at the handle only.

2.11.3. Danger of stumbling over electric / hydraulic wires

- Make sure that no person has to step over the wires.
- Lay the wires in such a way that the danger is kept to a minimum.

2.11.4. Danger of squeezing by clamping devices and guideways



There is a danger of serious injuries: on the one hand between the inner clamping devices and on the other hand between the outer clamping device and the end of the guideway.

- Do not stand or put hands between clamped pipe ends.
- Do not stand or put hands between the inner clamping tools with not yet clamped pipes.
- Do not block opening and closing of the machine slides.

2.11.5. Risk of injury by noises



Noises exceeding 80 dB (A) may occur; during planing it is obligatory to wear ear protection!

2.12. Structural modifications on the machine

- No modifications, extensions or reconstructions may be made on the machine without permission of the manufacturer.
- Machine parts which are not in a perfect condition are to be replaced immediately.
- Only use original **WIDOS** spare and wear parts.
- In case of purchase orders please always state the **machine number!**

2.13. Cleaning the machine

The used materials and tissues are to be handled and disposed of properly, especially:

- when cleaning with solvents
- when lubricating with oil and grease

2.14. Warranty and liability

Fundamentally our "General Sales and Delivery Conditions" are valid.

They are at the owner's disposal latest when signing the contract.

Guarantee and liability demands referring to personal injuries or damages on objects are excluded if they are caused by one or several of the following reasons:

- not using the machine according to the prescriptions
- inexpert transport, mounting, starting, operating, and maintenance of the machine
- running the machine with defective or not orderly mounted safety appliances
- ignoring the information given in this manual
- structural modifications on the machine without permission
- unsatisfactory checking of parts of the machine, which are worn out
- repairs performed in an inexpert way
- In case of catastrophes and force majeure

3. Functional description

Basically, the international and national process guidelines are to be followed !

The plastic pipes are clamped in the clamping devices. Then the front sides of the pipes are cut plane and parallel by means of the **planer** and the misalignment of the pipes is checked.

The cleaned and heated heating element is inserted and the pipes are pressed against the heating element under defined adjusting pressure. This process is called "**adjusting**".

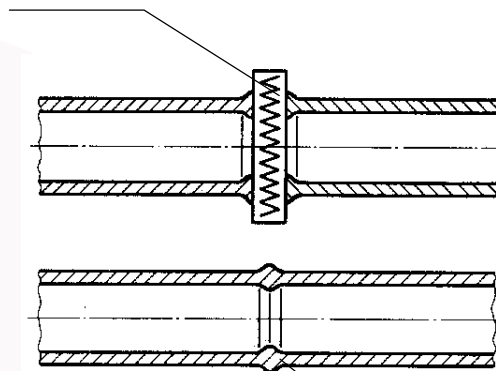
After the prescribed bead height being reached, pressure is reduced, the **heating time** begins. The function of this time is to heat up the pipe ends.

After expiration of the heating time, the slides are opened, the heating element is removed quickly and the pipes are driven together again. The time gap from the removal of the heating element to joining the pipes is called **change over time**.

The pipes are joined under prescribed welding pressure and then cool down under pressure (**cooling time**).

The welded joint can be unclamped, the welding process is finished.

Heating element heats the pipes up to welding temperature



Finished welding with internal and external bead

4. Operating and indicating elements

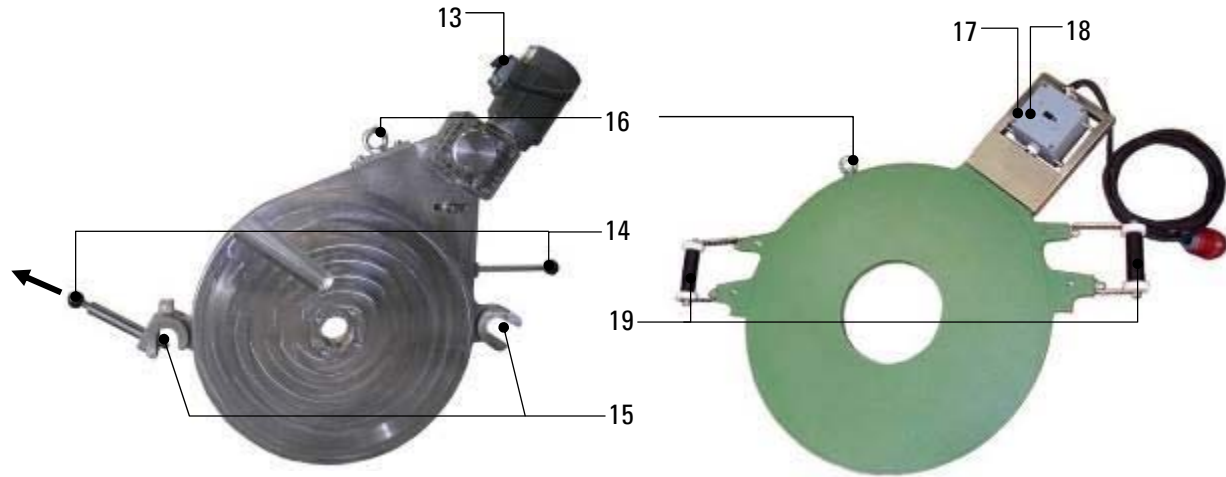
4.1. Elements on the aggregate



No.	Name	Function
7	Pressure gauge	Digital display of the hydraulic pressure
8	Valve lever	Opening the slides. There are 4 different positions: - to the left side : slides close. - in the middle (usual position): the pressure which is currently achieved is kept (also by means of the built-in hydraulic accumulator) - slightly to the right side (position pressureless): a possibly existing pressure is released without moving the slides. Due to the hydraulic accumulator, it takes about 10 s until the pressure is completely released. - to the right side : slides open
9	Setting screw for pressure relief valve	- Limitation of the pressure to the desired value.
10	Hydraulic connection for closing the slides	- Non-dropping quick-acting coupling
11	Hydraulic connection for opening the slides	- Non-dropping quick-acting coupling
12	Screw with oil dipstick	- checking the oil level - oil filler neck

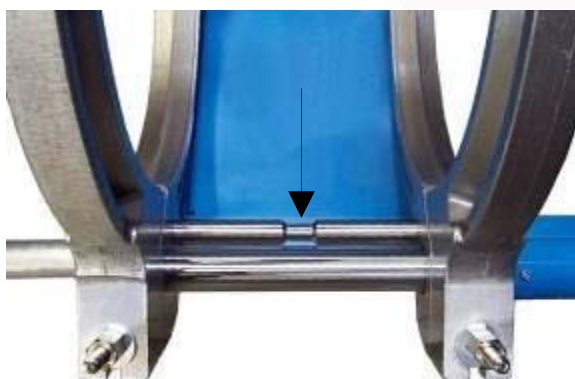
Planer and heating element have to be connected to a power distributor for building sites (400 Volt).

4.2. Elements at planer and heating element



No.	Name	Function
13	On/off switch for planer	- For switching on/off the planer. - Switch off the planer after use.
14	Lever	- For holding the planer when lifting/removing. - Lever can be screwed off.
15	Eye and eye with locking bolt	- locking the planer/ heating element- For holding the planer when lifting/removing. - Lever can be screwed off. in basic machine, (In order to remove the planer, pull locking bolt into arrow direction.
16	Lifting screw	- For lifting / inserting the heating element / planer with the lift-off device.
17	Display of temperature	- Digital display of set heating element temperature. Three different displays are possible. For meaning of the displays please refer to point 5.4 Setting the heating element temperature
18	Thermostat	- For setting the required temperature.
19	Grip	- For holding the heating element when lifting / removing.

4.3. Separating device for heating element



There is a tear-off bar mounted between the movable and the fixed clamping shells on the basic machine. It prevents the heating element from sticking to the heated-up pipe ends. When inserting the heating element take care that it lies in the zone of the throat of the tear-off bar (see arrow).

5. Starting and operating

The instructions of this chapter are supposed to initiate in the operation of the machine and lead during the appropriate starting of the machine.

This includes:

- the safe operation of the machine
- using all the possible options of the machine
- economic operation of the machine

5.1. Safety indications



The machine may only be operated by initiated and authorized persons.

For the qualification, a plastic welding exam can be taken according to DVS and DVGW. In situations of danger for persons and the machine, the mains plug has to be unplugged immediately.

In case of power failure, there may still be pressure in the hydraulic system.

Therefore release pressure if need be.

After completion of the welding work and during breaks the machine has to be switched off. Further take care that no unauthorized person has access.

Protect the machine from wetness and humidity !

According to VDE 0100, the use on construction sites is only allowed with a power distributor with a FI-security protective switch.



Check the oil level of the hydraulic system before each starting of the control unit in order to avoid damages on the pump. The oil level must be between the two marks at the oil dipstick.

If necessary, add hydraulic oil of the quality HLPD 32.



The heating element surfaces must be clean, especially non greasy, therefore they need to be cleaned shortly before each welding or in case of dirtiness by means of a **fibre-free paper** and a cleaning agent (e.g. PE cleaner or pipe cleaning tissues which are available at the WIDOS company).

The anti-adhesive coating of the heating element must remain undamaged in the working area.



Take care that all hydraulic and electric connections are connected.



Make sure that pump and planer are connected in a way that they turn in right-hand direction.

- Take into account the surrounding conditions:
 - The welding may not be performed under direct sun rays influence.
 - Use a welding umbrella if necessary.
- If the surrounding temperature is under 5°C, measures have to be taken:
 - Use a welding tent or preheat the pipe ends if necessary.

In addition, take measures against rain, wind and dust.

5.2. Connection of hydraulic aggregate with basic machine

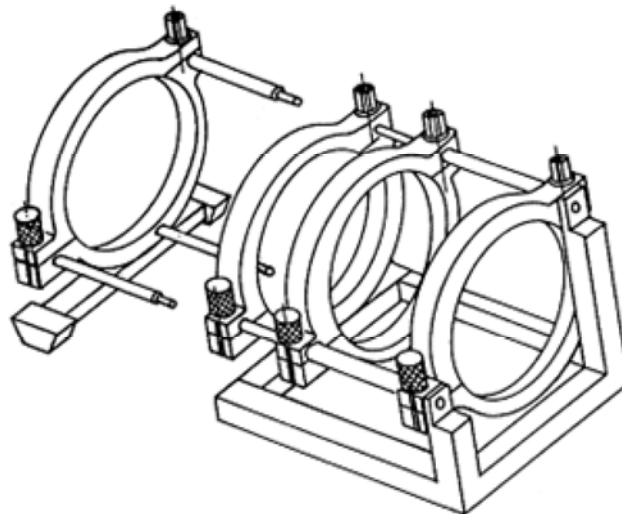
- Connect the aggregate to the mains supply (230 V/50 Hz).
- Connect planer and heating element to a power distributor for building sites with 400 V (right rotary field).
- Put the hydraulic hoses of the basic machine into the quick-acting couplings of the hydraulic aggregate.



Lay the hydraulic and electric wires carefully (danger of stumbling)

5.3. Replacing the reduction inserts

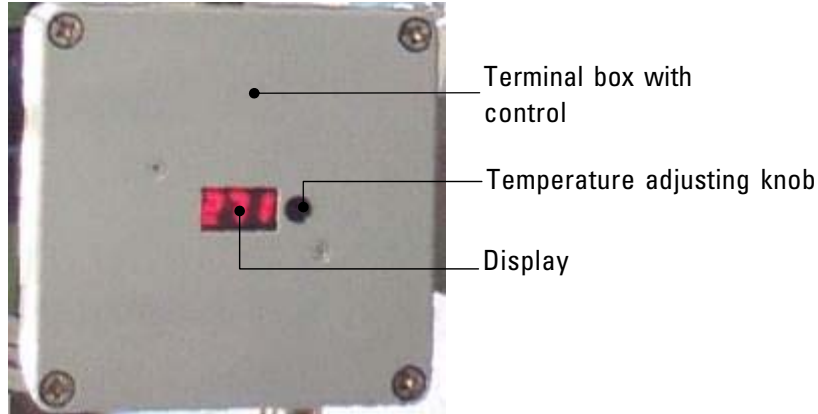
- Unscrew the mounted reduction inserts by means of the provided Allan key.
- Screw the reduction inserts with the corresponding diameter into the clamping devices. Pipes with OD 630 have to be clamped in the basic clamping devices.
- If necessary (e.g. for T-pieces) the outer fixed clamping device can be dismantled by unscrewing the three hexagon socket screws.



Dismantling of the outer fixed clamping device

5.4. Setting the heating element temperature

As soon as the heating element is connected to the mains (400 V / 16A), it starts heating up to the desired temperature. Set the temperature with a screw driver at the adjusting knob.



2 . 2 . 0

Display: DESIRED temperature + blinking points between the numbers.
The heating element is being heated up, the desired temperature is not yet reached. This display disappears after short time, followed by three lines.

- - -

Display: Three lines.
The heating element is being heated up, the desired temperature is not yet reached.

1 8 0

Display: ACTUAL temperature (without blinking points).
Appears as soon as a temperature of > 170 °C is reached and rises continuously to DESIRED temperature. The desired temperature is maintained by a certain pulse-position ratio.

5.5. Welding process

The respectively valid welding prescriptions (ISO / CEN / DVS...) are to be basically followed.



There is the danger of serious bruising.

On the one hand between the inner clamping devices, on the other hand between the outer clamping device and the end of the guide bar.

- Do wear safety gloves as a protection against burning !
- A stop-watch must be available for recording the actual times for heating and cooling.
- A welding table must be available from which the parameters for the pipe dimensions to be welded prescribed by the welding prescriptions may be taken.
- Connect the heating element and set the heating element temperature (see chapter 5.4).
- Screw in the reduction inserts according to the outside diameter of the pipes to be welded.
- Lay the pipes to be welded into the clamping devices, tighten firmly the clamping nuts and align the pipes with respect to each other. In case of long pipe ends, use WIDOS roller stands for that purpose.

- Close the slides, thereby reading the **movement pressure** on the manometer. The movement pressure is displayed exactly when the slide with the clamped pipe passes over into its movement. Subsequently, open the slides again such that the planer fits therebetween.
- Insert the planer between the pipe ends lock it and switch it on; the pressure onto the planer may not exceed 20 bar.



Noises exceeding 80 dB (A) may occur; during planing it is obligatory to wear ear protection!



There is the danger that the planer pulls in clothes ! Do not hold the planer on its front sides in any case.

If the planing pressure is too high, there is the danger that the planer tilts and falls out of the machine during planing. If necessary, hold the planer firmly.

- Move the pipe ends towards one another by means of the valve lever and plane same with a planing pressure between 1 and 15 bar above the movement pressure. Planing must be carried out until a revolving cutting has been formed on both sides.
- Open the slides again by means of the valve lever, switch off planer motor, pull the locking bolt for remove planer and put it into the protection box. Remove the produced cuttings without contacting the worked surfaces
- Close slides.
- Check pipe mismatch and gap on the joining pipe ends. According to DVS 2207, the mismatch on the pipe outer side must not exceed 0.1 x pipe wall thickness, the admissible gap must not exceed 0.5 mm. The mismatch compensation is carried out by further tightening or releasing of the clamping nuts. In case mismatch compensation was carried out, planing must be repeated afterwards.
- The adjustment pressure for the pipe dimension to be welded can be gathered from the welding table. Add the movement pressure.
Set the resulting pressure value at the pressure relief valve and check it by actuating the valve lever.
- Open slides again slightly.
- Gather heating time, maximum change over time, cooling time and bead height for the pipe dimension to be welded from the table.
- Move the heating element, which has been cleaned and brought to desired temperature, between the pipes, take care that it lies in the zone of the throat of the tear-off bar (see chapter 4.3).
- Close slides smoothly to the set adjustment pressure.
When the prescribed revolving bead height is reached, reduce pressure. For this purpose, move the valve lever to position „pressureless“ until the desired heating pressure is built up (heating pressure = approx. 10% of the adjustment pressure).
- The heating up time starts now. Press the stop-watch and compare the actual time with the nominal time taken from the table.
- After expiration of the heating time, open the slide, remove the heating element as quickly as possible, put it into the protection box and close the slide smoothly.

The maximum time frame for this process is predetermined by the value for the change over time taken from the table.

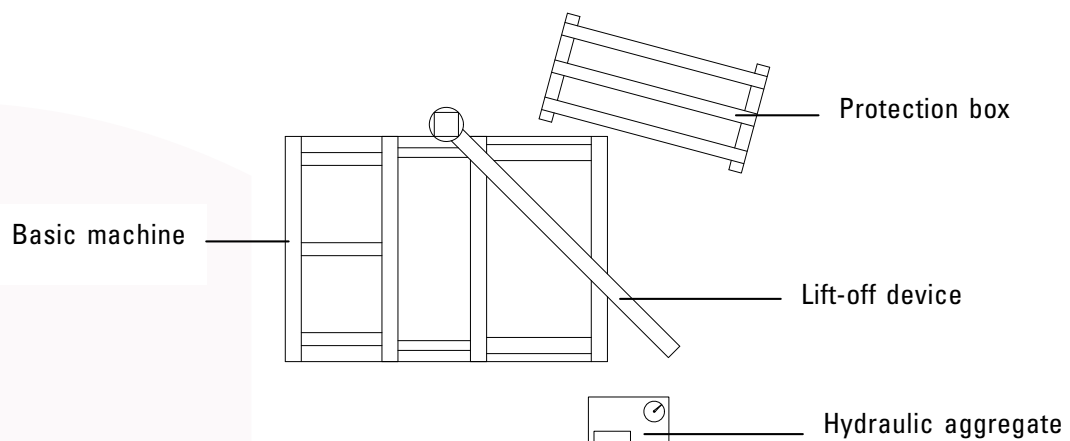
- When the welding pressure is built up, press the stop-watch and keep the control lever for approximately 10s on position „pressure“ so that the hydraulic accumulator can be filled. During the cooling time re-adjust pressure, if necessary (the pressure for cooling is the same as the set adjustment pressure).
- After expiration of the cooling time, release pressure, remove the welded parts and open the slide.

5.6. Lift-off device (optional)

- General description
- Safety rules
- Danger indications
- Starting and maintenance
see the separate documentation (company ABUS).

5.6.1. Mounting of the machine

When mounting the machine, follow the positioning sketch:



5.6.2. Mounting the lift-off device

- Insert the crane jib into the reception at the backside of the basic machine.
- Loosen the screw and the lock washer at the hook at the top of the mast, hang in the chain hoist, tighten again lock washer and screw.
- Connect the chain hoist with the mains (230 V/50 Hz).
- The operation of the lift-off device can be started now (see the separate documentation)

5.6.3. Transport

Dismount the chain hoist from the mast for transportation of the machine.

6. Welding log and tables



You can access our website and select our welding tables via the qr code shown here. Select " WIDOS 6100 Stahl-8000" and the corresponding material (PE / PP /PVDF).

7. Maintenance and repair

Goal of the chapter is:

- Keeping the nominal state and the operation capacity of the machine.
- Increasing the efficiency by avoiding non-planned outage.
- Efficient planning of the maintenance works and the maintenance tools.

7.1. Maintenance and inspection, repair



All maintenance and repair works have to be basically performed with the machine in off position.

During this the machine has to be secured against unauthorized switching on.



Prescribed maintenance and inspection works should be performed in time.

The DVS gives the advice of inspection works after 1 year.

For machines with a specially high usage percentage the testing cycle should be shortened.

The works should be performed at the WIDOS GmbH company or by an authorized partner.

7.2. Clamping elements

- For a long service life clean and grease regularly the threaded spindles and the joint parts which are used for clamping the pipes.

7.3. Planer

- Check the stress of the drive chain in the planer and grease it regularly. The cover of the planer can be screwed off by means of the provided socket spanner.
- Do not lay the planer on its blades.
- Check the blades of the planer for sharpness, turn them if necessary (grinded on both sides, max. thickness of the shavings: 0,2 mm !).

7.4. Storage

- The cylindrical waves of the basic machine are to be kept free from dirtiness and need to be covered with a thin oil film if they are not being used.
- Store dry.

7.5. Used hydraulic oil

Only use **HLPD 32**.

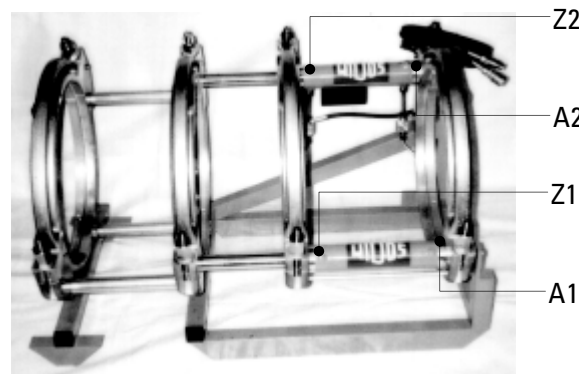
Features: protection against corrosion, resistance to ageing, abrasion-reducing additives, high carrying capacity and particularly water retending.

The hydraulic oil has to be disposed of properly.

7.6. Checking the hydraulic oil level

- Unscrew the red cover screw on the top of the aggregate. Remove the integrated oil dipstick, clean it with a dry tissue and insert it again in the tank by screwing. Remove the oil dipstick again and check the oil level.
- The oil level must be between the two marks. If the oil level is under the lower mark, then hydraulic oil of the quality HLDP 32 must be added.

7.7. Venting the hydraulic cylinders



- Venting the hydraulic cylinder is not required, if
 - the hoses have been disconnected from the quick-action couplings at the control unit because the remaining oil in the hose is being kept by valves and for this reason no air can enter.
- The hydraulic cylinder **must be vented** if
 - there has been too less oil in the tank and air has been attracted.
 - there were leaky spots at the hoses or in the connections.
 - the hoses were unscrewed from the basic machine.
- Eliminate the cause of the air entrance.
- Open the machine completely.
- First unscrew the lower „vent screw (Z1) for closing“ (lefthand side).
- Connect the transparent venting hose and insert it in the collecting vessel of the aggregate.
- Close until there is no more air visible in the venting hose, then tighten again the vent screw.
- Close the machine completely.
- Unscrew the lower „vent screw (A1) for opening“ (righthand side).
- Connect the transparent venting hose and insert it in the collecting vessel of the aggregate.
- Open until there is no more air visible in the venting hose, then tighten again the vent screw.
- When the venting process at the lower vent screws is completed, repeat the process at the upper „vent screw (Z2) for closing“ (lefthand side), as well as at the upper „vent screw (A2) for opening“ (righthand side).



The lower vent screws always have to be vented at first because there is a direct connection between the upper and the lower cylinders.

- If air remains in the lower cylinder, it will ascend in the upper cylinder when pressure is applied.

7.8. Disposal



At the end of the life time, the machine has to be disposed of properly, non-polluting and in accordance with the national laws of waste disposal.

8. Transport

The machine can be transported in two transport boxes or in one packing box.
One transport box contains the basic machine, the aggregate and the reception box with planer and heating element, the other box contains the reduction inserts.

- In each box holders are included which are suitable for each single component in order to avoid slipping.
⇒ Put the components into the box in such a way that they fit in the holders.
- The hydraulic hoses at the basic machine should not be unscrewed (air penetration).
⇒ Make sure that they are not squeezed.
- Handle the machine carefully.
⇒ Do not tilt the aggregate too much. Otherwise there is the danger that oil may come out.
⇒ Protect the machine from heavy chocs.
⇒ Make sure that the box cover is closed correctly.
- During the construction of the transport box a stress was put on a light-weight construction.
⇒ Take much care when using automatic handling and carrying machines.

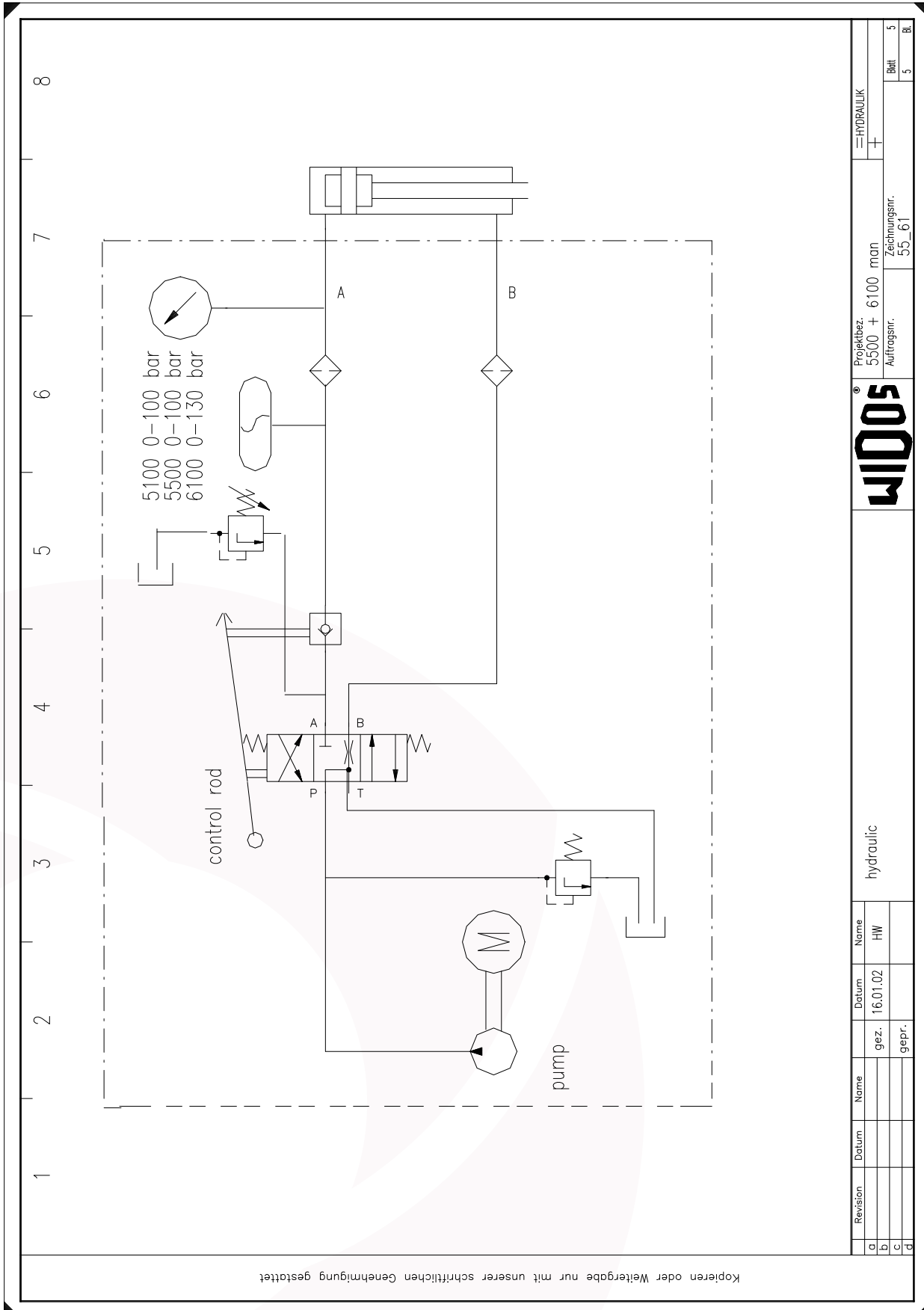


During the transport of the machine there may be cold weldings between the piston rod and the eyes of the planer housing. These spots on the piston rod may damage the sealing.





Therefore the eyes must be lubricated with PTFE spray before each transport!

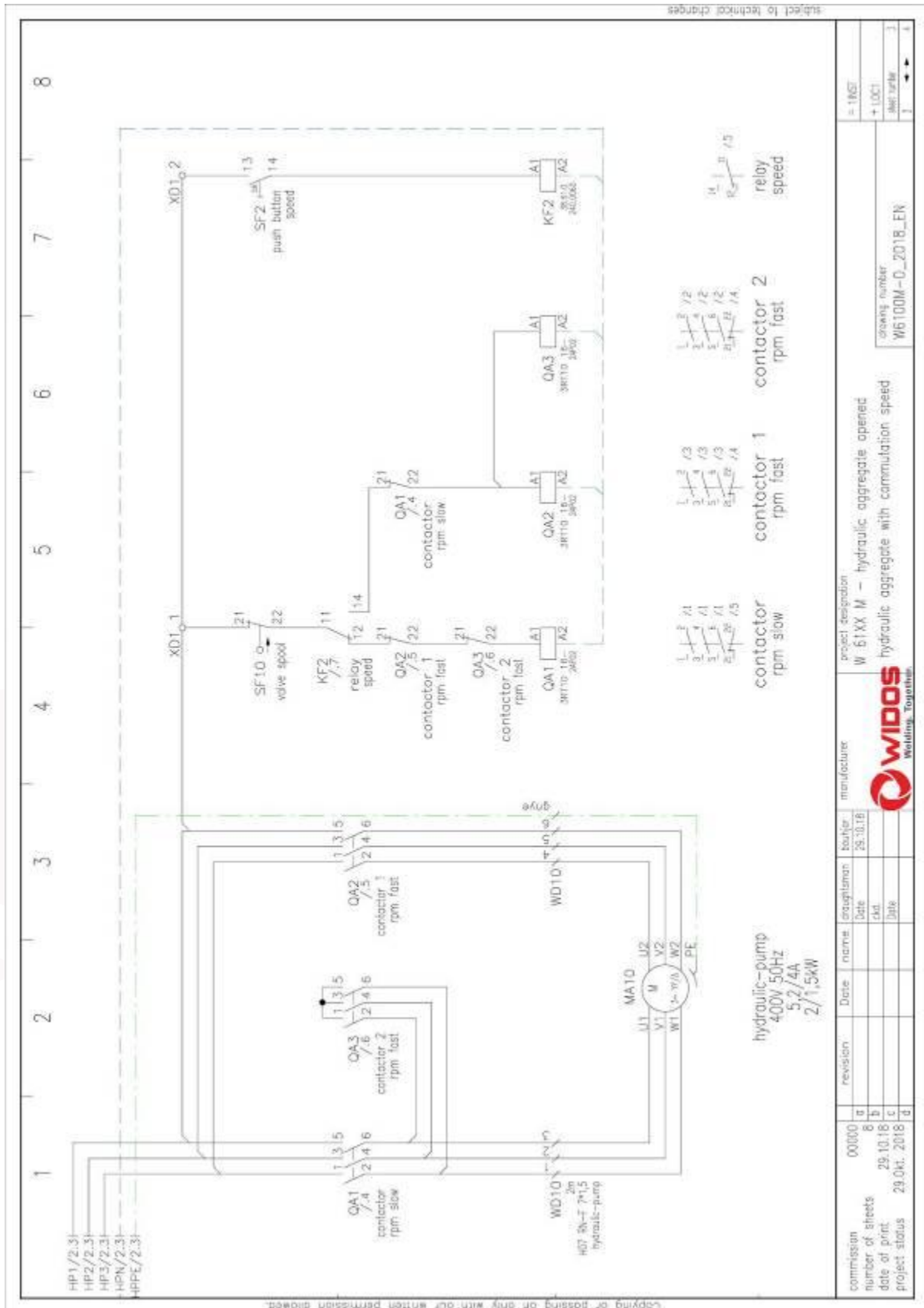
9. Hydraulic and electric diagrams

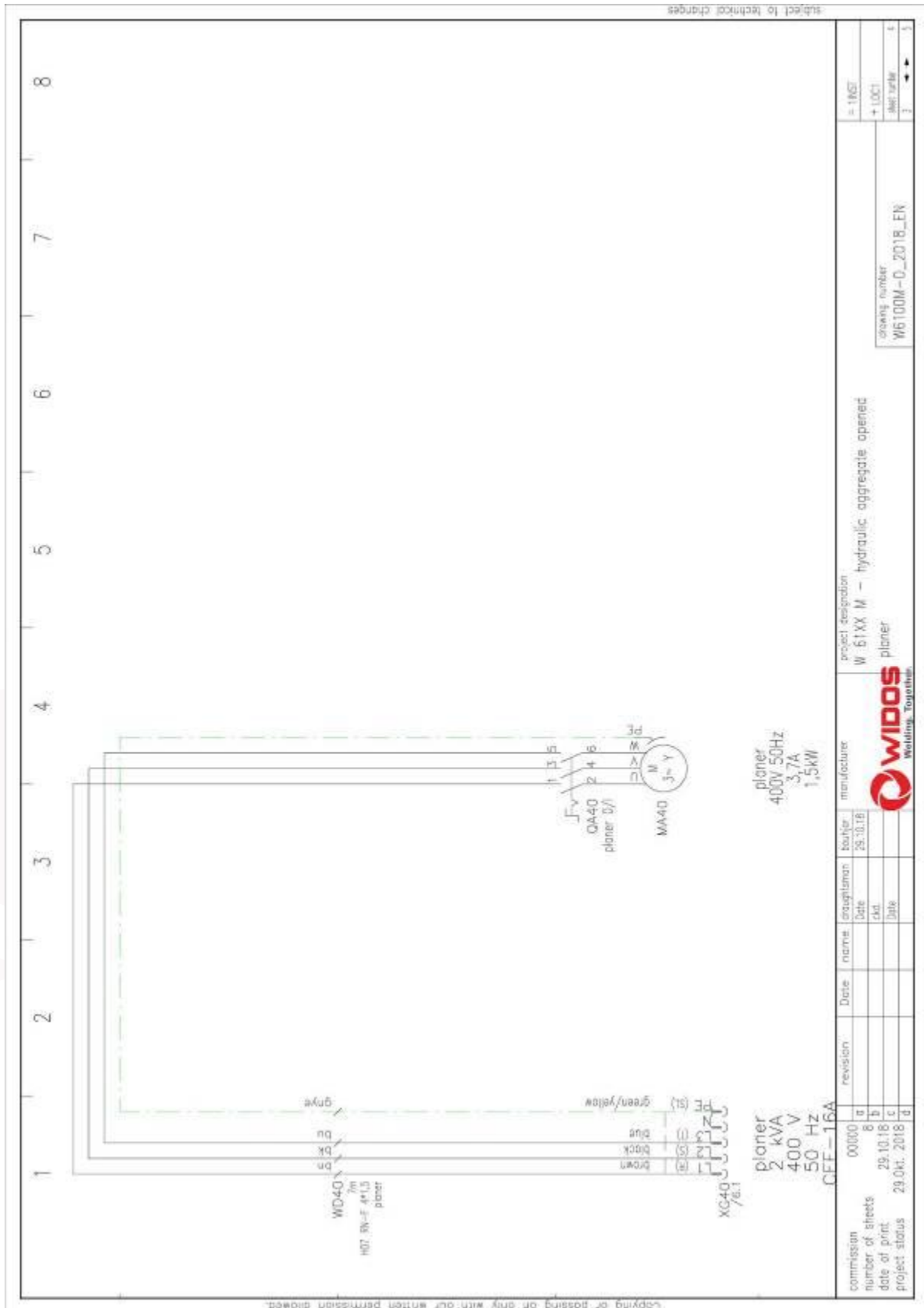


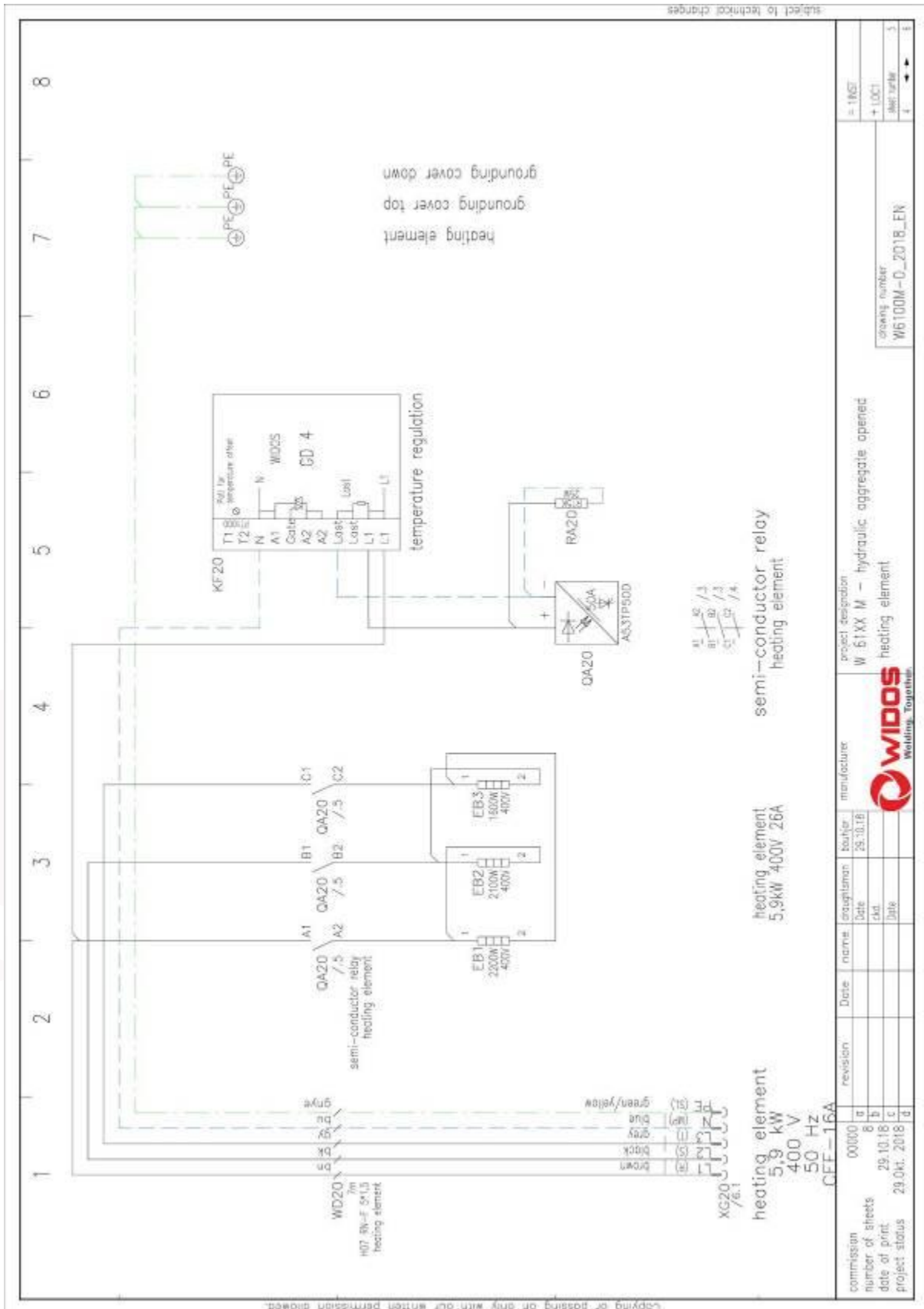
9.1. Electric diagram 400 V

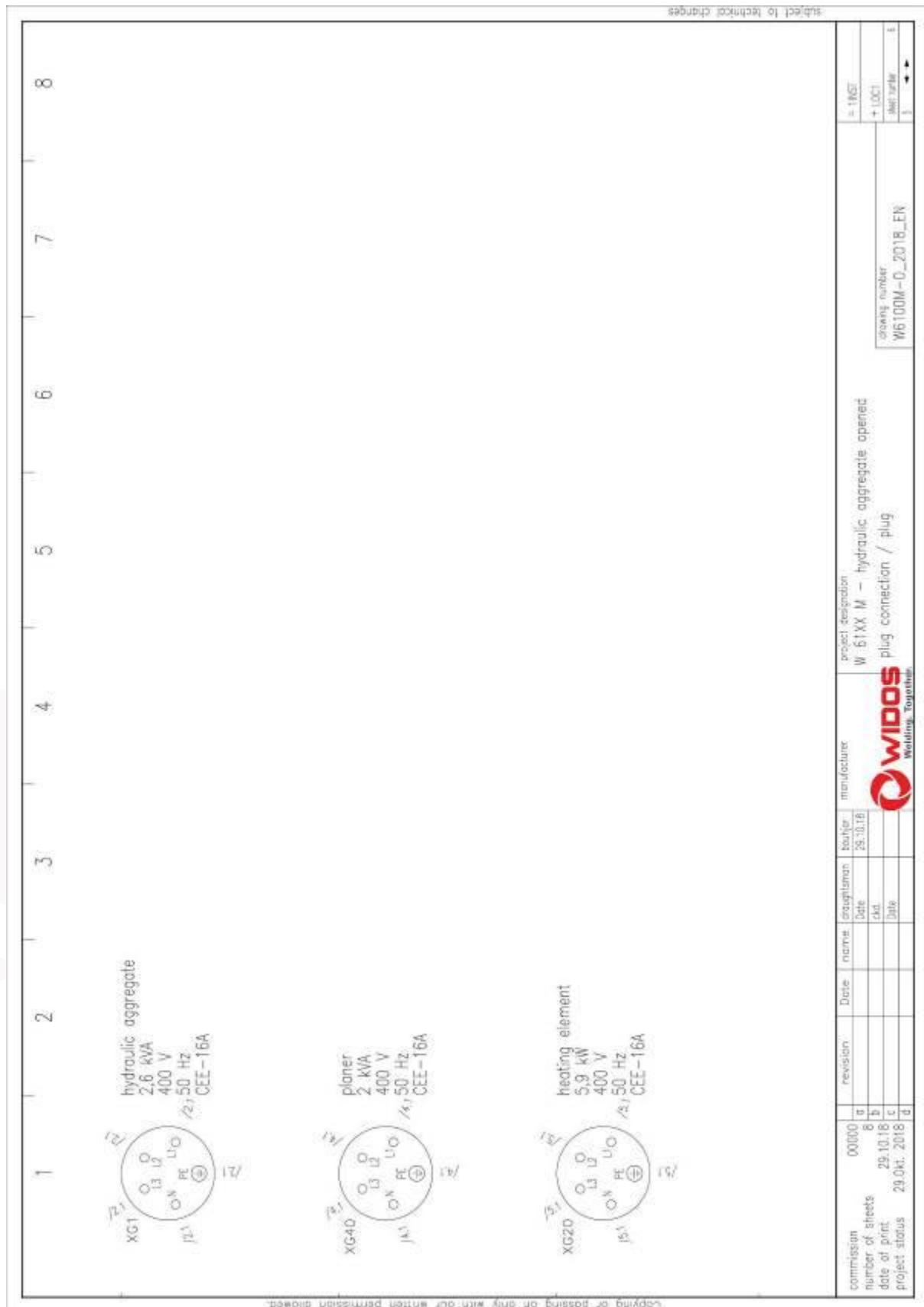
	<p>WIDOS GmbH Kunststoffschweißtechnik Plastic Welding Technology</p>	<p>Einsteinstroße 5 D-71234 Ditzingen Tel.: +49 (0) 7152 / 9939-0 Fax: +49 (0) 7152 / 9939-40 http://www.widos.de</p>
<h1 style="margin: 0;">circuit diagram</h1>		
<p>project designation W 61XX M - hydraulic aggregate opened</p> <p>machine type W61XXM</p> <p>number of sheets 8</p> <p>Date 29.10.18</p>		
commission number of sheets date of print project status	job designman job date 29.10.18 29.10.18 2018	29.10.18 beulker W61XXM cone sheet
manufacturer  WIDOS Welding. Together.		project designation W 61XX M - hydraulic aggregate opened job number 00000 drawing number W6100M-D_2018_EK sheet / sheet 0 / 8 sheet / sheet 0 / 8

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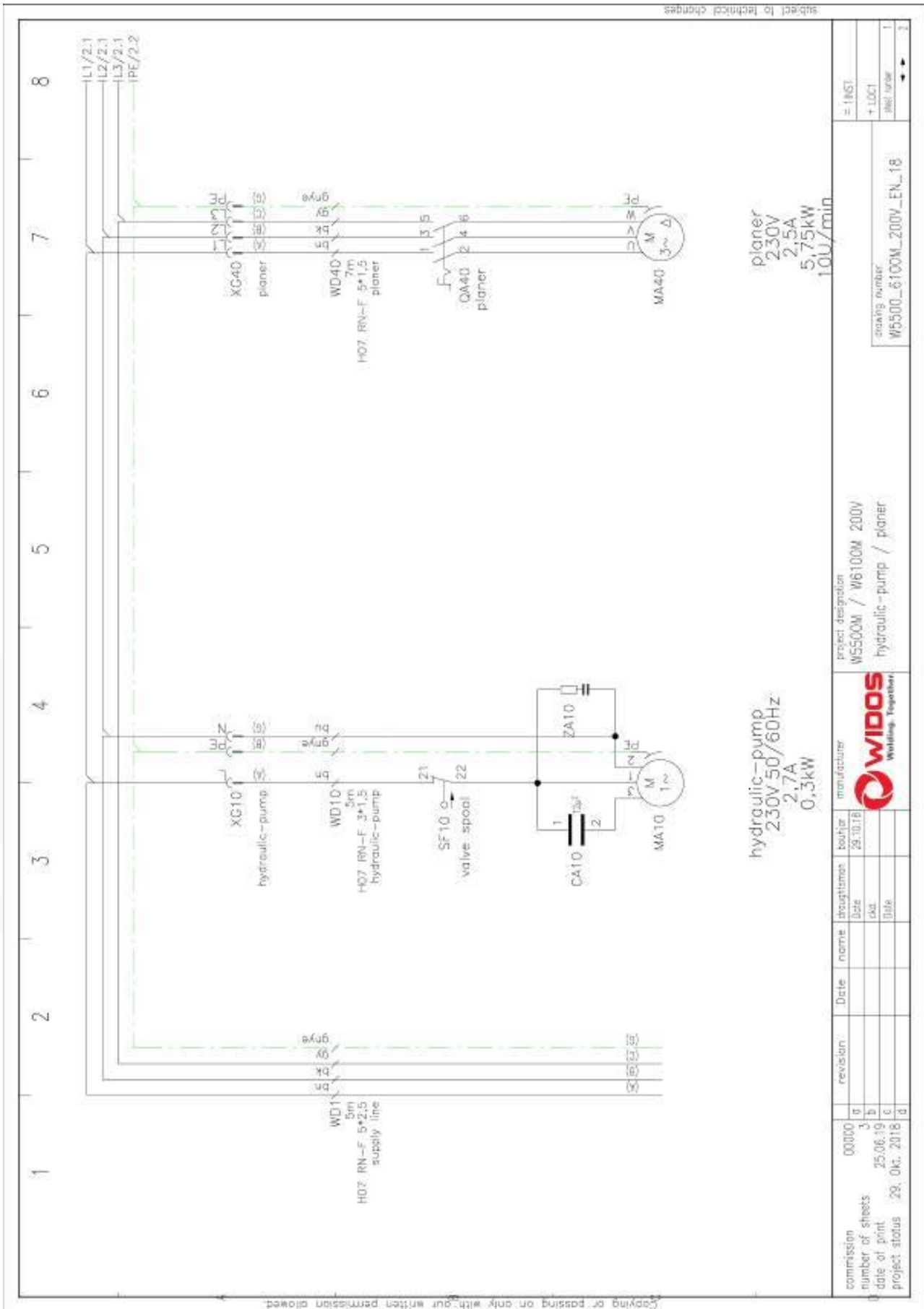




9.2. Electric diagram 230 V

	WIDOS GmbH Kunststoffschweißtechnik Plastic Welding Technology	Eisenstrasse 5 D-71254 Ditzingen Tel: +49 (0) 7152 / 9939-0 Fax: +49 (0) 7152 / 9939-40 http://www.widos.de	
<h1 style="margin: 0;">circuit diagram</h1>			
project designation W5500M / W6100M 200V machine type welding machine W5500/6100M – 200V			
number of sheets 3 Date 29.10.18			
commission number of sheets date of print project status	00000 3 25.06.19 29. OKL 2018	Date 29.10.18 draughtsman tschljar Date 29.10.18 sig.	welding machine W5500/6100M – 200V cover sheet
		manufacturer 	project designation W5500M / W6100M 200V Job number 000000 drawing number W5500_6100M_200V_EN_18
		= 00000 = L001 sheet number 1 articles per sheet 1	18 pages / sheets 1

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10. Spare parts list



You can access our website and select our spare parts lists via the qr code shown here. Select "6100"

11. Declaration of conformity

Issuing the declaration of conformity with regard to complying with the basic requirements and assembling the technical documentation is in the sole responsibility of:	
Manufacturer / Installation company:	WIDOS Wilhelm Dommer Söhne GmbH
Address:	WIDOS GmbH Einsteinstr. 5 D-71254 Ditzingen

Subject of the present declaration is the following device:	
Product name:	Heating element butt welding machine
Model name:	WIDOS 6100
Machine number:	
Year of construction:	

For the stated device we herewith declare that it complies with the basic requirements stipulated in the following designated harmonizing regulations:
in the sense of the EC guideline EC-Machinery Directive 2006/42/EC

Statement of the relevant harmonizing standards referred to, or indication of the specifications that the conformity is declared for:	
Standard	Title
DIN EN ISO 12100	Safety of machines, basic concepts, general layout guidelines
DIN EN 1037	Safety of machines, prevention of unexpected starting
DIN EN 614-1	Safety of machines, ergonomic layout principles
DIN EN 60204.1	Electrical equipment of industrial machinery
DIN EN 1005-2	Human physical performance – manual handling of objects
DIN EN ISO 4413	Fluid technology, general regulations and safety-related requirements of hydraulic appliances
DVS 2208	Machines for the heating element butt welding of pipes, pipe fittings and sheets
ISO 12176-1	Pipes and fittings out of plastic- equipment for PE weld connections

Entitled to compile the technical documentation:	
Name:	WIDOS Wilhelm Dommer Söhne GmbH
Address:	Einsteinstr. 5 D-71254 Ditzingen

Signed on behalf of the company:	
Name, first name:	Dommer, Martin
Function:	Technical director



Heimerdingen, 26.06.2019

Place / Date

Legally binding signature

This declaration is to certify the compliance with the mentioned harmonizing regulations, however does not include any assurance of properties.