

ROTHENBERGER

ROWELD P 63 S6

ROWELD P 63 S6



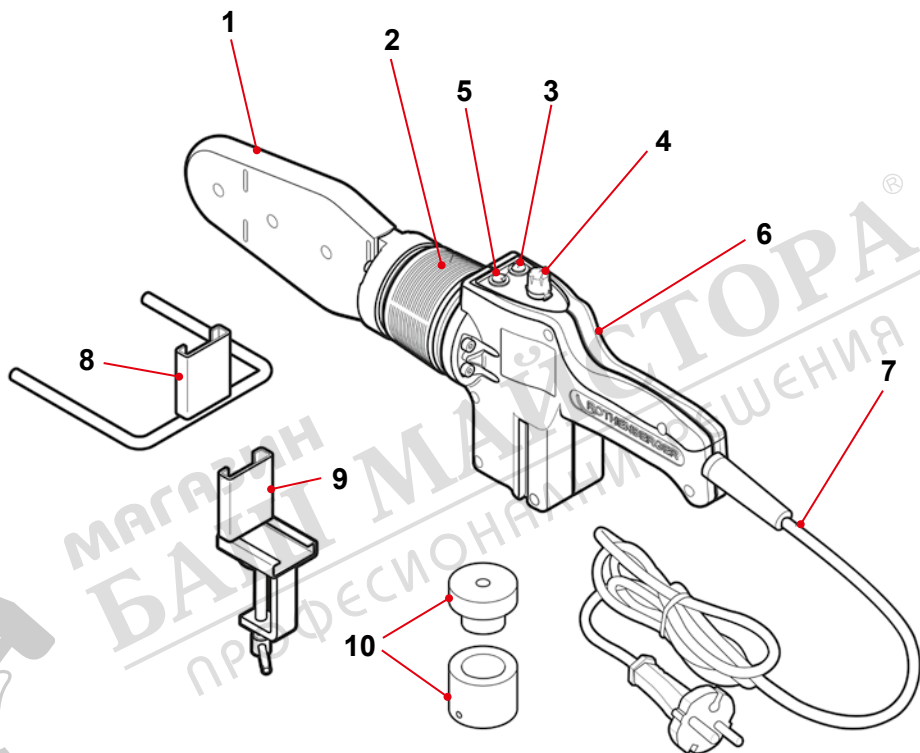
DE Bedienungsanleitung
EN Instructions for use
FR Instruction d'utilisation
ES Instrucciones de uso

IT Istruzioni d'uso
PT Instruções de serviço
CZ Návod k používání



www.rothenberger.com

A Overview



ROWELD P63 S-6 thermostatic
Basic 230V no.: 053897X
Basic 110/115V no.: 100001270



ROWELD P63 S-6 electronic
Basic 230V no.: 053896X

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Markings in this document:



Danger!

This sign warns against the danger of personal injuries.



Caution!

This sign warns against the danger of property damage and damage to the environment.



Call for action



1.1 Intended use

The SOCKET WELDER P63-S6 has been designed to weld tubes and accessories made of PE, PP, PB and PVDF, both in the workshop and on worksites.

Ensure that the persons that use this equipment have the necessary attitudes and aptitudes.

Do not use the socket welding device in any way except that described in this instruction manual.

1.2 General Power Tool Safety Warnings

**WARNING!**

Read all safety warnings and all instructions.

Failure to follow the warnings and instructions may result in electric shock, fire and/or serious injury.

Save all warnings and instructions for future reference.

The term "power tool" in the warnings refers to your mains-operated (corded) power tool or battery-operated (cordless) power tool.

1) Work area safety

- a) **Keep work area clean and well lit.** Cluttered and dark areas invite accidents.
- b) **Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.** Power tools create sparks which may ignite the dust or fumes.
- c) **Keep children and bystanders away while operating a power tool.** Distractions can cause you to lose control.

2) Electrical safety

- a) **Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools.** Unmodified plugs and matching outlets will reduce risk of electric shock.
- b) **Avoid body contact with earthed or grounded surfaces such as pipes, radiators, ranges and refrigerators.** There is an increased risk of electric shock if your body is earthed or grounded.
- c) **Do not expose power tools to rain or wet conditions.** Water entering a power tool will increase the risk of electric shock.
- d) **Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts.** Damaged or entangled cords increase the risk of electric shock.
- e) **When operating a power tool outdoors, use an extension cord suitable for outdoor use.** Use of a cord suitable for outdoor use reduces the risk of electric shock.
- f) **If operating a power tool in a damp location is unavoidable, use a residual current device (RCD) protected supply.** Use of an RCD reduces the risk of electric shock.

3) Personal safety

- a) **Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication.** A moment of inattention while operating power tools may result in serious personal injury.
- b) **Use personal protective equipment. Always wear eye protection.** Protective equipment such as dust mask, non-skid safety shoes, hard hat, or hearing protection used for appropriate conditions will reduce personal injuries.
- c) **Prevent unintentional starting. Ensure the switch is in the off-position before connecting to power source and/or battery pack, picking up or carrying the tool.** Carrying power tools with your finger on the switch or energising power tools that have the switch on invites accidents.

- d) **Remove any adjusting key or wrench before turning the power tool on.** A wrench or a key left attached to a rotating part of the power tool may result in personal injury.
- e) **Do not overreach. Keep proper footing and balance at all times.** This enables better control of the power tool in unexpected situations.
- f) **Dress properly. Do not wear loose clothing or jewellery. Keep your hair, clothing and gloves away from moving parts.** Loose clothes, jewellery or long hair can be caught in moving parts.
- g) **If devices are provided for the connection of dust extraction and collection facilities, ensure these are connected and properly used.** Use of these devices can reduce dust related hazards.

4) Power tool use and care

- a) **Do not force the power tool. Use the correct power tool for your application.** The correct power tool will do the job better and safer at the rate for which it was designed.
- b) **Do not use the power tool if the switch does not turn it on and off.** Any power tool that cannot be controlled with the switch is dangerous and must be repaired.
- c) **Disconnect the plug from the power source and/or the battery pack from the power tool before making any adjustments, changing accessories, or storing power tools.** Such preventive safety measures reduce the risk of starting the power tool accidentally.
- d) **Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool.** Power tools are dangerous in the hands of untrained users.
- e) **Maintain power tools. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tools operation. If damaged, have the power tool repaired before use.** Many accidents are caused by poorly maintained power tools.
- f) **Keep cutting tools sharp and clean.** Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.
- g) **Use the power tool, accessories and tool bits etc., in accordance with these instructions, taking into account the working conditions and the work to be performed.** Use of the power tool for operations different from those intended could result in a hazardous situation.

5) Service

Have your power tool serviced by a qualified repair person using only identical replacement parts. This will ensure that the safety of the power tool is maintained.

1.3 Special safety instructions

Ensure that the voltage supply is correct. The correct voltage is indicated on the name plate of the main unit or in the instruction manual. If the wrong voltage is used, this may cause overheating, smoke or fire.

The unit should only be connected to the mains supply and used for welding once the unit is attached to the workbench using the G-Clamp. The legs of the unit should only be used to handle the unit when cold until it is held firmly in place with the G-clamp and connected to the mains supply.

Never touch the mains plug with wet hands.

Keep the unit's handles, etc., dry, clean and grease- and oil-free, to ensure safe handling. If the unit is dropped, this could lead to injury.

2 Technical Data

Voltage.....	230 V AC/ 115 V AC
Power/ Current	Nominal power = 800 W
Frequency:	50/60 Hz
Working range	Ø 20-63 mm
Temperature range.....	max. 330 °C
Dimensions:	475 x 359 x 110 mm
Weights:	
P63-S6 Thermostatic.....	1,5 kg
P63-S6 Electronic.....	1,4 kg
G-clamp.....	0,4 kg

3 Function of the Unit

3.1 Overview

(A) 

1	Heating plate	6	Body
2	Cooling plate	7	Cable and plug, with earth connection
3	Power LED (red)	8	Legs
4	Regulator knob	9	G-clamp
5	Temperature-control LED (green)	10	Adapters

3.2 Operating instructions

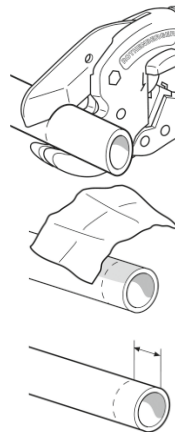
Welding with this unit consists of three phases:

- preparing the tube
- preparing the socket welding device
- the welding process

This equipment leaves the factory completely finished and ready to use; it needs no adjustment or preparation for use.

3.2.1 Preparing the tube

- Cut the tube straight across using a suitable tool (pipe cutter or cropper).
- Clean the surface to be welded and the adapters with cellulose tissue dampened with isopropanol.
- Mark the length of the weld on the tube.





The surfaces to be welded must be cleaned immediately before welding. Protect the surfaces from weather conditions.

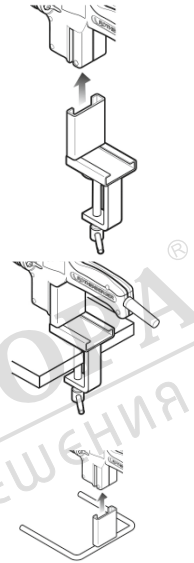
3.2.2 Preparing the socket welding device

- Mount the socket welding device.

Mounting using the G-clamp

The socket welding device is supplied with a G-clamp that can be used to attach it firmly to a workbench.

- Introduce the top section of the G-clamp into the slot in the bottom of the unit.



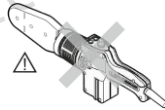
- Mount the unit on the edge of the workbench and tighten the screw of the G-clamp until the unit is firmly held in place

Mounting without the G-clamp

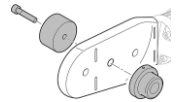
- Spread out the legs and rest the socket welding device on a flat surface, ensuring that it is stable.



Precaution: The unit must not be connected to the mains supply and used for welding whilst the G-clamp has not been mounted. The legs can be used to position the unit once it has been removed from the case, to mount the adapters when cold, etc.

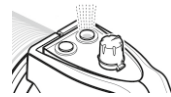


- Mount the correct adapters for the diameter of the tube to be welded onto the heating plate.
- Locate the male and female adapter halves on each side of the heating plate and bolt them to it using the allen key supplied with the equipment.



In order to mount the adapters onto the heating plate, make sure that the plate is cold and that the unit is unplugged.

- Connect the unit to the power source (230V/110V).
- Check that the red power LED lights when the unit is plugged in.



- Select the working temperature with the regulator knob. Turn the regulator knob to the working position.

SOCKET WELDER P63-S6 Thermostatic Model

The thermostat-controlled model has 6 position for the regulator knob:

0 Off

6 Working position



SOCKET WELDER P63-S6 Electronic Model

The SOCKET WELDER P63-S6 Electronic Model has a temperature scale marked from 200 °C to 300 °C:

260 °C - 280 °C - Working position



→ Wait until the socket welding device reaches its working temperature.

SOCKET WELDER P63-S6 Thermostatic Model

When the socket welding device has reached its optimum working temperature, the green temperature-control LED will light. Welding can now start. The temperature control LED will turn on and off as the thermostat operates.

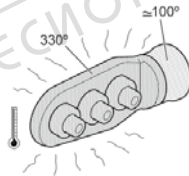
SOCKET WELDER P63-S6 Electronic Model

When the socket welding device has reached its optimum working temperature, the green temperature-control LED will start to blink.



The time required to reach working temperature is approximately 5 to 7 min.

- ! **Precaution:** The parts of the equipment can reach temperatures between 100 and 300 °C. Never handle the heating plate while the unit is hot. Never attach or remove adapters while the heating plate is hot. Only handle items that could be hot when it is safe to do so.



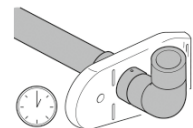
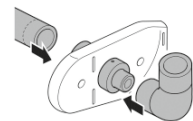
NOTE: The socket welder is equipped with two safety thermostats which disconnect the unit if the temperature reaches 330 °C and reconnects it when the temperature has fallen to 265 °C.

3.2.3 The welding process

This consists of four steps: heating, assembly, setting and cooling.

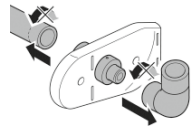
Heating:

- Using light pressure, insert the tube and the accessory simultaneously onto the corresponding adapters (tube in the female adapter, accessory on the male adapter).
- Maintain the tube and the accessory on the adapters during the time indicated under HEATING TIME in table 2.



Assembly:

- Remove the tube and the accessory from the adapters.
- Without rotating them, introduce the tube into the accessory until the weld-length mark is reached. This operation should be carried out as quickly and carefully as possible, within the time (MAX ASSEMBLY TIME) shown in Table 2.



Setting:

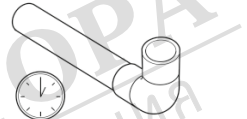
- Hold the two parts together during the time indicated under SETTING TIME in Table 2.



NOTE: Ensure that the region of the weld is not subjected to any force during this time.

Cooling:

- Allow the tube to cool for the time recommended in Table 2 (COOLING TIME).



After the cooling time has finished, the welded tubes and accessories can be used as recommended by the tube manufacturer.

Diameter (mm)	Tube		Heating time (sec)	Max assembly time (sec)	Setting time (sec)	Cooling time (min)
	Wall thickness (mm)					
16	2,0		5	4	5	2
20	2,5		5	4	5	2
25	2,7		7	4	7	2
32	3,0		8	6	8	4
40	3,7		12	6	12	4
50	4,6		18	6	18	4
63	3,6		24	8	24	6
75	4,3		30	8	30	6
90	5,1		40	8	40	6
110	6,3		50	10	50	8

Table 2 Process times for welding PP tubing

3.2.4 Shut-down

When the equipment is no longer going to be used, you are recommended to turn it off and allow it to cool in order to store it.

Store it carefully in a locked, dry place out of reach of children.



If the socket welding device is packed into its storage case while it is still hot, take care to place it in the correct position. Incorrect storage could damage the equipment and the storage case.

4 Care and Maintenance

Inspect the adapters before using them.

Carefully remove any material remaining from previous welding operations.

Check the condition of the adapters from time to time, to ensure correct welding.



Do not use metallic items or solvents to remove residues, as these could damage the surface of the adapter!

5 Troubleshooting

If the socket welding device does not operate correctly, check the following points:

- Check that the unit is connected to a functioning power source of the correct voltage (230 V/110 V)
- Check that the temperature regulator is in the correct position

If the unit still does not work properly, contact our local representative or distributor.

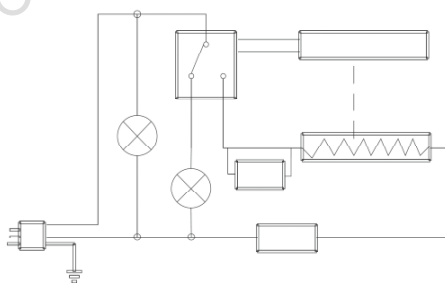
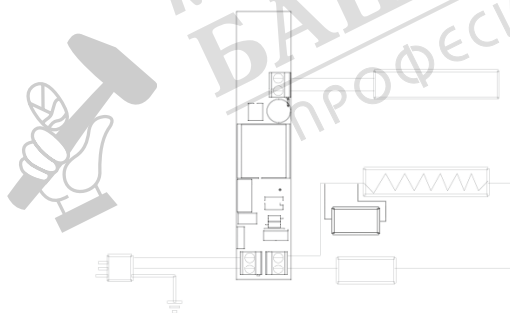
6 Accessories

Accessory Name	ROTHENBERGER Part Number
Adapter 20 mm ROWELD P63-S6 therm.	53511
Adapter 25 mm ROWELD P63-S6 therm.	53512
Adapter 32 mm ROWELD P63-S6 therm.	53513
Adapter 40 mm ROWELD P63-S6 elek.	53514
Adapter 50 mm ROWELD P63-S6 elek.	53515
Adapter 63 mm ROWELD P63-S6 elek.	53516
Spare parts	www.rothenberger.com

7 Wiring diagram

053896X ROWELD P63-S6 Electronic:

053897X ROWELD P63-S6 Thermostatic:



8 Customer service

The ROTHENBERGER service locations are available to help you (see listing in catalog or online) and replacement parts and service are also available through these same service locations. Order your accessories and spare parts from your specialist retailer or using RoService+ online:

Phone: + 49 (0) 61 95 / 800 – 8200

Fax: + 49 (0) 61 95 / 800 – 7491

Email: service@rothenberger.com

www.rothenberger.com

Components of the unit are recyclable material and should be put to recycling. For this purpose registered and certified recycling companies are available. For an environmental friendly disposal of the non-recyclable parts (e.g. electronic waste) please contact your local waste disposal authority.

For EU countries only:



Do not dispose electric tools with domestic waste. In accordance with the European Directive 2012/19/EU the disposal of electrical and electronic equipment and its implementation as national law, electric tools that are no longer serviceable must be collected separately and utilised for environmentally compatible recycling.



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