

ACT 80V

(Data logging 80v welding unit)

Operating manual



Index

Operating Controls	3
Safety Notes	4
Product Specification	5
Intended Use	6
Introduction	6
Delivered Items	7
Electrical Safety	7
Using the Equipment	8
Data Log Memory	9
Manual Welding	10
Easigrip Welding	11
Extreme Low Temperature Operation	13
Downloading the Weld Memory	14
Upgrading the Operating Software	14
Set Up Options	15
Information	16
Fault Finding	17
Maintenance	20
Disposal	21
Calibration and Warranty	21
Declaration of Conformity	24
Service and Repair	25
Quick Start Guide	27

Operating Controls

1. Welding Cable (can be provided with optional right angle plug)
2. USB Memory Drive
3. USB Socket
4. Welding Cable Socket
5. Protective Lid
6. Display
7. Buttons
8. Protective Frame
9. Supply Breaker
10. Supply Cable



IMPORTANT!

80 volt welding units require a BLUE welding cable.

Safety Notes

- **RISK OF EXPLOSION! This welding unit must not be used in a gaseous atmosphere.**
- **RISK OF ELECTRIC SHOCK! Do not open. No user serviceable parts inside.**
- Before using, always visually inspect the unit to see that the cables and connectors are not worn or damaged. Replace the damaged part before welding.
- Switch off and remove the plug from the mains before adjusting, cleaning, or if the cables are entangled and before leaving the equipment unattended for any period.
- To avoid damaging the unit, do not interrupt the supply voltage or disconnect the welding cable, while the unit is welding a fitting.
- Do not lift or pull the equipment by its cables.
- Do not disconnect the welding cables by pulling on them, always pull off the connectors from the fitting.
- Do not start a weld without the pipe correctly inserted into the fitting.
- Do not touch the fitting while welding.
- Do not weld in the rain or leave the equipment outdoors whilst it is raining.
- Weld only in daylight or in good artificial light.
- The operator is responsible for accidents or hazards occurring to other people or their property while using this equipment. Keep the work area safe!
- Keep bystanders a safe distance away from the machine while welding.
- Never allow people unfamiliar with these instructions to use the welding unit.

Product Specification

Input Power Connections for this model:

- 110V version
 - 120V version
- ONLY AVAILABLE IN 110/120V SUPPLY AREAS

Input plug for your region or country are available

Contact us for more information

Bespoke OEM

As a bespoke OEM Original Manufacturer we can produce this product as an OEM to suit your business

Contact us to discuss your requirements

Specification details - ACT 80V

Operating Modes	Manual, EasiGrip *
Welding Voltage	79V
Welding Current	1-65A (100A Peak)
Welding Time	1-6000 seconds
Supply Voltage	115V ± 15% (40-60Hz)
Supply Current	1-63A
Supply Power	7500 W
Weight	20 kg
Size	38 x 38 x 40cm
Operating Temp.	-15°C to +50°C **



* Easigrip is a registered name of Radius Systems Ltd

** An extended temperature unit is available with limits -40°C to +50°C.

Advance Welding has a policy of continuously improving product design, and as such reserve the right to change specification of its products without prior notice and with impunity.

Intended Use

This equipment is intended to weld large diameter (“80v”) constant voltage electrofusion fittings suitable for low, medium and high pressure pipe work systems.

The equipment has been approved by Radius Systems for use with Easigrip fittings.



This welding unit has been approved in the UK by Transco to the standard T/SP/ECE/1 2005 ‘Specification for Electrofusion Control Boxes’, and is approved for use on all UK gas distribution networks.

This welding unit complies with the UK Water Industry Specification WIS 04-32-08 ‘Specifications for the fusion jointing of polyethylene pressure pipeline systems using PE80 and PE100 materials’, and is suitable for use on all UK water distribution networks.

This welding unit has been designed to comply with the International Organization for Standardization standard ISO12176-2:2000 “Plastic pipes and fittings, equipment for fusion jointing polyethylene systems , part 2, electrofusion”.

Introduction

This manual gives instructions on the correct assembly and safe use of your welding unit. It is important that you read these instructions carefully, and keep these instructions for the life of the unit.

This manual does not detail the specific welding procedure for the fittings: scraping, clamping and assembly of joints. For this information you must contact the manufacturer of the fittings.



Delivered Items

Carefully remove the welding unit from its packaging and check that you have the following items:

- Welding unit.
- Welding cable.
- USB flash memory drive.

When parts are missing or damaged, please contact your dealer.

Electrical Safety

WARNING! Switch off and remove the plug from the mains before adjusting, cleaning or if the cable is cut, damaged or entangled.

This welding unit is Class 1 and requires an earthed (grounded) connection. An earth spike must be used with generators.

This unit is 110 volt operation.

The power source must be capable of providing 6930 Watts.

This equipment must be fitted with a 63 amp mains plug.

Extension cables should only be used if they comply with the H07RNF harmonized standard. They must be fitted with connectors to the BS EN 60309-2 standard. All cables must be unwound from the reel to stop inductive heating effects. Only use one 10m extension cable with a conductor size 4.0mm².

This equipment is fitted with a Residual Current Device (RCD) with a tripping current of 30 mA. Always check the RCD every time you use it.

The supply cable must be inspected for signs of damage before each use and the equipment may only be used if in perfect condition. Damaged cables must be replaced by an approved service agent.

This equipment is classified as “Portable for use on industrial applications”, and must undergo a formal electrical safety check (Portable Appliance Test) as per local regulations.



Using the equipment

This welding unit takes the ambient temperature into account when calculating the energy required to weld the fitting. It must therefore be allowed to reach ambient temperature before use and must be at the same temperature as the fitting to be welded.

Prepare and clamp the pipe and fittings inline with the manufacturers recommendations.

Connect the welding cable to the unit and the fitting to be welded. Connect the supply cable to the correct supply voltage and switch the unit on.

The screen will show a welcome message along with the software version and date. The owner details are then shown

The main menu is now shown on the display. During operation, except while welding, pressing the star key on the keypad will jump back to this menu.

Notes:

The operation of the unit can be customised by turning welding modes on and off, along with some features like the cooling time and data logging. This manual details all available modes and features. For information on how to customise the welding unit see the “Set Up” section later on in this manual.

The welding unit is fitted with an alpha-numeric keypad, which is used by the operator to input data. Down the right hand side there are four Quick-Keys, A B C D. These act as quick shortcut keys, their function being prompted on the screen.

When entering data, letters and numbers can be selected by repeatedly pressing the same key, e.g. A B C 2 A B C 2 . After a short pause the cursor will move to the next position. Special characters and spaces can be selected by pressing the 1 or 0 keys. (This is the same method used for text with mobile cell phones.) Pressing the B Quick-Key will step Back one position. Pressing the C Quick-Key will Clear the input field.

Data Log Memory (Optional)

The unit can record information about the weld, along with the date and time, and additional operator entered information.

It is possible to enter three pieces of information to identify the weld. The first is the Operator's Name, the second is the Location where the weld is being done, and the third is an Information field for more details.

The display will show all three pieces of information:

Pressing the B Quick-key will select the 'Operator Name' and allow changes to be made. Enter the required information and press the A Quick-key to accept it.

Pressing the C Quick-key will select the 'Location' and allow changes to be made.

Enter the required information and press the A Quick-key to accept it.

Pressing the D Quick-key will select the 'Information Field' and allow changes to be made. Enter the required information and press the A Quick-key to accept it.

When all the information has been entered, press the A Quick-key to accept it. This information will be saved when the weld has been completed, and will be prompted the next time a new weld is carried out.

The display will also ask if the pipe/fitting has been scraped and clamped. Select yes or no using the Quick-Keys. This information will be saved on the data log memory. The unit can save 2048 welds in memory. When the memory is full, it will be overwritten from the beginning in blocks of 24 welds. This will allow the last 2000 welds to be held in memory.

An optional "lifetime weld memory" feature is available. This uses an SD memory card fitted internally that records every weld carried out by the unit. This is designed as a backup device and can only be downloaded by an approved service agent.

Manual Welding (Optional)

This mode of operation is designed to weld all 79 volt fittings in manual mode. It is the operator's responsibility to make sure the correct fitting is being welded.

From the main menu:

Press the A Quick-Key to select manual welding, then:

Press the A Quick-Key to weld with data logging OFF.

Press the B Quick-Key to weld with data logging ON.

The display will ask for the welding cable to be connected to the fitting. When this has been done it will show the data logging options (if selected). Enter the information as required.

The display will now prompt for the welding time to be entered. Press the C Quick-key to select the welding time. Enter this from the numbered keypad, e.g. 100. This can be between 1 second and 3600 seconds. Press the A Quick-key to accept the new time. When the correct time has been selected, press the A Quick-key to accept them. The display will now ask for the START button to be pressed. Press Start to begin welding. During the weld, the display will show the set welding time, the remaining welding time, the set welding voltage and the welding power generated in the fitting. The unit will also monitor the welding to make sure it does not go out of limits. Any faults that are detected will terminate the welding and cause an error message to be displayed. These are listed later on in this manual.

(Optional cooling time) At the end of the weld the cooling time will be shown. This counts upwards from zero and will continue until stopped by the operator. This is shown as an aid to the operator to allow them to know how long it was since the weld finished. Press any key to continue.

The display will ask for the welding cable to be disconnected from the fitting. Doing this will reset the unit back to the welding menu.

Easigrip Welding (Optional)

This mode of operation is designed to weld Easigrip 79 volt fittings, manufactured and sold by Radius Systems. It is the operator's responsibility to make sure the correct fitting is being welded.

Ensure the pipes to be joined can be aligned and are supported so that the assembled pipes and fitting can be jointed unstressed.

Use rerounding clamps on large diameter pipes 450mm and above. These should remain on the pipe ends for 10 minutes.

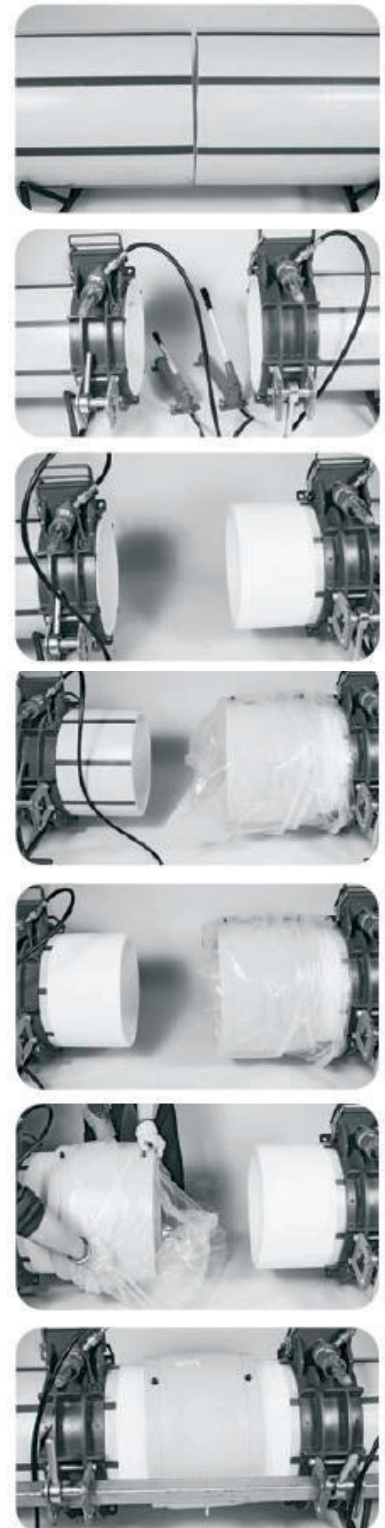
Reposition the first clamp and use the PET to score through the skin. Peel the skin off the pipe when ready to position the electrofusion coupler.

Slide the coupler into position and check the socket fit. The socket should be positioned up to the centre stops. Mark the outside of the pipe at the edge of the coupler.

Reposition the second clamp and score through the skin on the second pipe section. Peel off the skin and position the coupler.

Mark the insertion depth on the second pipe and using the appropriate lifting aids, slide the second pipe into the coupler up to the correct insertion depth.

Position the tie bars through the locking cams to immobilise the pipes and fitting.





The fitting can now be welded using the following procedure. When complete, allow to fully cool before removing the alignment clamps.

From the main menu:

Press the B Quick-Key to select Easigrip welding, then:

Press the A Quick-Key to weld with data logging OFF.

Press the B Quick-Key to weld with data logging ON.

The display will ask for the welding cable to be connected to the fitting. When this has been done it will show the data logging options (if selected). Enter the information as required.

The display will now prompt for the three welding times to be entered:

To enter the Pre-heat time, press the B key then enter the time using the numeric keypad. Press the A key to accept.

To enter the Soak time, press the C key then enter the time using the numeric keypad. Press the A key to accept.

To enter the Weld time, press the D key then enter the time using the numeric keypad. Press the A key to accept.

When the correct times have been selected, press the A Quick-key to accept them.

The display will now ask for the START button to be pressed. Press Start to begin welding.

During the weld, the display will show the set welding time and the remaining welding time for each section of the weld. The unit will also monitor the welding to make sure it does not go out of limits. Any faults that are detected will terminate the welding and cause an error message to be displayed. These are listed later on in this manual.

(Optional cooling time) At the end of the weld the cooling time will be shown. This counts upwards from zero and will continue until stopped by the operator. This is shown as an aid to the operator to allow them to know how long it was since the weld finished. Press any key to continue. The display will ask for the welding cable to be disconnected from the fitting. Doing this will reset the unit back to the welding menu.



Extreme Low Temperature Operation (Optional)

The welding unit has an extended temperature range option, which allows it to work down to -40°C . This unit has special supply and welding cables that remain flexible at extremely low temperatures. It also has an internal case heater to warm the electronics to an acceptable working temperature.

When the temperature inside the unit is below -15°C , the following operation will apply:

Plug the welding unit into the correct supply voltage and switch it on. The internal case heater will switch on and an indicator light will show on the lid next to the display.

When the internal temperature warms to the correct level, the case heater will switch off, the indicator light will switch off and the electronics will switch on.

The operation of the unit is now as previously described.

Extended temperature range facility is a factory-fitted option and must be requested when ordering the product from your supplier.



Downloading the Weld Memory

The data log memory is downloaded by using an 'industry standard' USB flash memory device. The data can be encrypted for protection, to stop unauthorised alteration of the information.

A data download manager is available free of charge and is supplied on the USB memory device with the welding unit. This allows the encrypted data to be read, filtered, printed and saved. It also allows the data to be saved as an encrypted file or as a Microsoft Excel spreadsheet.

Plug the USB flash memory drive into the USB connector on the side of the welding unit.

From the main menu:

Press the D Quick-Key to select options.

Press the A Quick-Key to select download data.

Confirm that you want to download the data. The display will show that it is "Enumerating the device". While this is showing, the unit is initialising the memory drive. The data will now be downloaded.

The display will ask if you want to reset the data log memory. Select yes or no then disconnect the memory drive when prompted to do so.

The data can be download as either an encrypted PFD file, or as a plain text XLS file. To change the setting please contact your approved service centre.

Upgrading the Operating Software

The operating software can be upgraded through the external USB connector. New software is loaded onto a USB memory drive then flashed into the welding unit using a password code. This allows the software to be upgraded without opening up the unit or changing the memory chip.

Software upgrade must be carried out by an approved service agent, and are emailed from the manufacturer.

Set Up Options

From the main menu:

Press the D Quick-Key to select options.

From here the time can be set by the operator. Other changes can be made, however, these are password protected and must be carried out by an approved service agent.

The following options are available:

Date.

The date can be set.

Display Language.

Available languages can be selected and set.

Modes of Operation.

Manual: On/Off, Cooling time On/Off, Data logging On/Off,

Easigrip: On/Off, Cooling time On/Off, Data logging On/Off.

Calibration Period.

The calibration period can be set between 1 month and 99 months (or turned off). For 28 days prior to the calibration expiry date, the unit will prompt that the calibration is due and will count down the remaining days. When the calibration has expired, it can be set to warn the operator or lock the unit.

Owner Details.

The owner details, shown when the unit is first switched on, can be entered or changed.

Download Format.

The format of the data log download can be changed from protected PFD to plain text XLS.



Hidden Data Download.

Even when data logging is not selected for a weld, details are still recorded but then hidden from the normal data download, and not selected when the data is downloaded to a USB memory disk. To aid fault finding, all welds carried out including those “not logged” can be downloaded.

Lifetime Weld Memory.

(Optional hardware) The entire weld memory for the lifetime of the welding unit is stored in an internal SD memory card. This can be downloaded as an archive of all welds carried out.

Purchase Date.

The date the unit was sold to the customer can be set and viewed. This allows more accurate record keeping.

Warranty Period.

The date the unit was first used can be viewed. This allows accurate control of the warranty period.

Clear Data Log.

The data log memory can be cleared by entering a password.

Information

Information about the welding unit can be viewed from the options menu. Select more options and then enter the password A I N F followed by the A Quick-Key.

The serial number and part number of the unit are shown. The calibration date and calibration period are also shown. Press the A Quick-Key and the following weld counters are shown: Total weld count, weld count at last calibration, welds done since last calibration.

Fault Finding

During operation, the welding unit monitors all aspects of its operation. If a fault occurs then an error message will be shown.

0: Weld OK

No Fault, weld completed OK.

1: Stuck button on start up

This fault shows when the power is first switched on. Either the Stop, Start, or a keypad button is stuck in. Free the button to clear the fault.

2: Output fault before weld start

This fault shows when the power is first switched on. The unit will check the output terminals to make sure no voltage is present when first switched on. If this fault happens then the internal power relays have stuck in the closed position. The unit will need to be returned for service.

3: Toroid thermal switch tripped

This fault happens when the toroidal transformer becomes too hot. This will happen if the unit is used for a long period of time on large fittings. Let the unit cool down and the fault will clear. If this happens when the unit is cold, then there could be a bad connection on one of the internal plugs. In this case, the unit will need to be returned for repair.

4: No calibration

This fault happens when the unit has no calibration. This will normally not show, and if the unit has been calibrated, would be caused by a fault with the internal memory. Return the unit for service.

5: Case temperature sensor fault (if fitted)

Some units have a case temperature sensor fitted to switch the unit off if the electronics become too hot. This fault will show if the sensor is faulty. Return the unit for service.

6: Case temperature out of limits (if fitted)

Some units have a case temperature sensor fitted to switch the unit off if the electronics become too hot. This fault will show if the temperature is too hot. Let the unit cool down.

7: Ambient temperature less than -40°C.

The unit has detected that the ambient temperature is very cold or the sensor has broken. If the temperature is not below -40°C then the unit will need to be returned to a service agent for repair.



8: Ambient temperature more than +600°C.

The unit has detected that the ambient temperature sensor has broken or a wire has gone open circuit. The unit must be returned to a service agent for repair.

10: Low supply frequency <40Hz

The unit has detected that the supply frequency is below 40 Hz. This will normally be caused by a poor quality generator. If this fault happens then check the supply or change the generator.

11: High supply frequency >70Hz

The unit has detected that the supply frequency is above 70 Hz. This will normally be caused by a poor quality generator. If this fault happens then check the supply or change the generator.

12: High supply voltage >140v (or 280v with a 220v supply)

The unit has detected that the supply voltage is more than 140 volts (280 volts with a nominal 220v supply). Check the supply voltage and if necessary use a different generator.

13: Low supply voltage <95v (or 190v with a 220v supply)

This fault can be caused by a few problems. It could be that the generator is running slowly and so the supply voltage is low. Try speeding the generator up or use a different generator. It could also be caused by a generator that is too small. If a large fitting is welded, then a large amount of power will be needed from the generator. If it can not supply this power then it will stall and the voltage will drop away. Check that the generator is the correct size, if needs be try another generator.

It could be caused by the use of long extension leads. If a large fitting is welded then a high current will be taken from the supply. If extension leads are used, there will be a volts drop down the lead making the unit sense a low supply voltage. Try not to use extension leads with the unit. If you have to then use just 10 meters of 4.0mm² cable, the same size fitted to the unit.

14: Relay failed to latch on weld start

This fault could happen when the start button is pressed. If the main power relays do not operate correctly then this fault will be shown. The unit needs to be returned for service.

20: Low output volts (-1.25%)

This fault will happen if the output voltage is 1.25% lower than the set point for more than 3 seconds. This can be caused by a generator that is not big enough to supply the required power to the fitting. Check the size of the generator and if needs be try another generator. It can also be caused by using long extension leads with the unit. It is recommended that only 10 meters of extension are used, and the cable should be the same thickness as the input lead on the unit (4.0mm²).



21: High output volts (+1.25%)

This fault will happen if the output voltage is 1.25% higher than the set point for more than 3 seconds. It will normally be caused by a poor quality generator with the supply voltage fluctuating. Try a different generator.

22: Excess output volts (+6.25%)

This fault will happen if the welding voltage is 6.25% more than the set point for more than 2 seconds. This fault is normally caused by a fault within the unit, a short circuit triac. The unit must be returned for service.

23: Low output current (<2.5A)

This fault will happen if the welding current is below 2.5 amps for more than 3 seconds. It can be caused by a faulty fitting. Try another fitting. If this doesn't clear the fault then there is a problem inside the unit and it must be returned for repair.

24: Shorted turn detected in fitting.

While welding, the unit has detected a sharp increase in welding current. This is normally caused by a shorted turn happening in the fitting. (An increase OF 10%). If this happens then it is most likely a faulty fitting. This must be replaced. If the fault persists then it could be a fault within the unit.

25: User stop button pressed

The operator has pressed the stop button.

26: Relay unlatched

During welding, if the main power relay disconnects then this fault will be shown. It could be caused by the unit being knocked or a temporary dip in the power supply. If the fault persists then the unit should be returned for repair.

27: Fitting open circuit

This fault is shown if the output lead disconnects from the fitting while welding. Follow the guidelines from the fitting manufacturer, reconnect the lead and try welding again.

50: USB Memory: Disc full.

This fault will happen if the USB flash memory pen is full. Delete some files from the device.

51: USB Memory: File allocation table full.

This will happen if the USB flash memory pen's file structure becomes fragmented. Follow the instructions with Windows to defragment the memory pen.

52: USB Memory: File not found.

When performing a software upgrade, the required file was not found on the memory drive. Reload the upgrade files onto the memory drive.



127: Power off failure.

If the power is turned off while the unit is welding, this fault will be recorded to the datalog.

Maintenance

Regularly check for obvious defects such as loose or damaged cables and connectors. Look for worn components and broken covers or housings.

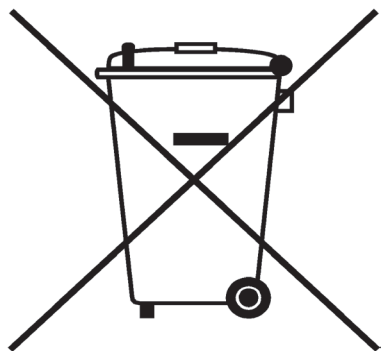
There are no user serviceable parts inside the unit. It should be returned to an approved service agent for repair and calibration.

It is recommended that the unit is calibrated every twelve months.

After use, clean the outside of the unit with a soft brush or cloth. Carefully wind up and store the cables around the frame in the location provided.

Disposal

The equipment and packaging should be sorted for environmentally friendly recycling.



RoHS Compliant
Directive 2005/ 95/ EC



DO NOT DISPOSE OF THIS EQUIPMENT INTO HOUSEHOLD WASTE !

According to the European Directive 2002/96/EC Waste Electrical and Electronic Equipment (WEEE), when no longer suitable for use, this equipment must be separately collected and sent for recycling.

According to the European Directive 2005/95/EC Restriction of Hazardous Substances (RoHS), this equipment does not contain more than the agreed levels of lead, cadmium, mercury, hexavalent chromium, polybrominated biphenyl (PBB) and polybrominated diphenyl ether (PBDE) flame retardants.



Calibration and Warranty

This welding unit has been manufactured, inspected and tested in accordance with the quality control systems in place at Advance Welding.

This welding unit has been calibrated using equipment that is traceable to national and international standards, through a NAMAS accredited laboratory. NAMAS (National Accreditation of Measurement and Sampling) is a service of UKAS (United Kingdom Accreditation Service).

This welding unit has a TWELVE month calibration and warranty period, active from the first use of the unit by the end user customer.

Conditions of Warranty:

This warranty covers only those defects to the product which arise from normal use of the product, and will become invalid if any of the following apply:

- Failure to follow the operating instructions.
- Improper or inadequate maintenance.
- Unauthorised modification.
- Misuse or any use not in accordance with the operating manual or good industry practice.
- Physical abuse of the product.
- Operation outside the products specifications.
- Improper site preparation or site maintenance.
- Faulty pipe or fitting.

Extent of Warranty:

Subject to the conditions and limitations of warranty; Advance Welding warrants that its electrical products will be free from defects in materials and workmanship for a period of twelve months, and its mechanical products for six months, from the date of purchase by the end-user customer.

If during this period, notice of a defect which is covered by this warranty is received, then Advance Welding will either repair or replace the product at its option. Any replacement product will have functionality at least equal to that of the product being replaced, and will in our opinion, perform consistently with its age and usage.

Unless otherwise agreed, all warranty work will be carried out by Advance Welding or an authorised and approved service facility.



Customers will prepay all shipping charges for products returned under warranty, and Advance Welding will charge for return of the products back to the customer.

This warranty statement gives the customer specific legal rights. The customer may also have other rights which vary from country to country in the world.

Limitations of Warranty:

Advance Welding does not warrant the operation of any product to be uninterrupted or error free.

Advance Welding specifically disclaims the implied warranties of satisfactory quality and fitness for a particular purpose.

Advance Welding makes no other warranty of any kind, whether express or implied, with respect to its products.

To the extent that this warranty statement is inconsistent with the law of the locality where the customer uses the product, this warranty statement shall be deemed modified by the minimum necessary to be consistent with such local law.

To the extent allowed by local law, the remedies provided in this warranty statement are the customer's sole and exclusive remedies.

This equipment has been designed for use with the range of fittings and pipe available at the time of its design and development. Advance Welding can accept NO liability for the equipments ability or otherwise to be used with new or different fittings or pipe that subsequently appear in the market place.

This equipment is not intrinsically safe and must not be used in a gaseous or explosive atmosphere. Advance Welding can accept NO liability if the equipment is used in these circumstances.

Declaration of Conformity



This welding unit has been designed to comply with the harmonised standards under the “New Approach” directives, and has been CE marked accordingly.

The applicable standards are:

89/336/EEC	Electromagnetic compatibility
73/23/EEC	Low voltage equipment
98/37/EC	Machinery safety

More detailed information is available on our web site at www.ElectrofusionWelding.com

On behalf of
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Quick Start Guide

- Prepare the pipe and fitting according to the manufacturer's specification.
- Unwind all cables from the welding unit.
- Connect the welding cable to the fitting.
- Connect the supply cable to the correct voltage and switch it on.
- The unit will power up and go to the main menu.
- Press the B Quick-key to select Automatic welding.
- Press the D Quick key to select Bar Code welding.
- If the unit is set to data log, enter the details as shown on the screen.
- Read the bar code on the fitting with the pen/scanner.
- Press the Start button.
- The time will count down to zero as the fitting is being welded. Any faults will be indicated on the display.
- At the end of the weld, disconnect the welding cable to reset the unit.
- Press the Star key to return to the main menu if required.