

# **Proweld™ Equipment**

## **Operations & Maintenance**

### **Manual**

#### **Hand Socket Welding Tool**



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## **Section I - Safety Precautions**

1. Keep working area clean and tidy.
2. Keep electrical tools away from moisture. Never use in wet environment or humid conditions. Working area should be well illuminated. Keep tools away from chemicals and other corrosive materials.
3. Keep visitors at a safe distance.
4. Ensure the electrical supply is suitable for the machine.
5. The heating element reaches 500° F (260° C). Do not touch the surface and wear safety gloves.
6. Never carry tools by the electric cable. Never unplug by pulling the cable. Keep cables away from oil, heat and sharp edges.
7. Prior to use, check that no components are damaged. Missing and worn-outparts should be replaced immediately. Only use factory parts.
8. Electrical tools not in use should be stored away safely.

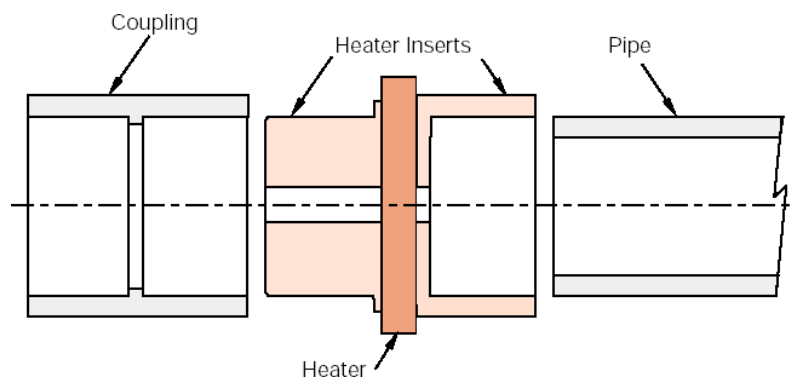
## Section II – Machine Operation

### 1. *Welding Tool Setup*

- A. Assemble tool with appropriate heater inserts for the pipe size to be welded. Place heater plate into the provided mounting bracket for easier handling.
- B. Plug in the heating mirror (110V) and allow time to heat up. Unit temperature is pre-set at the factory for 500° F.

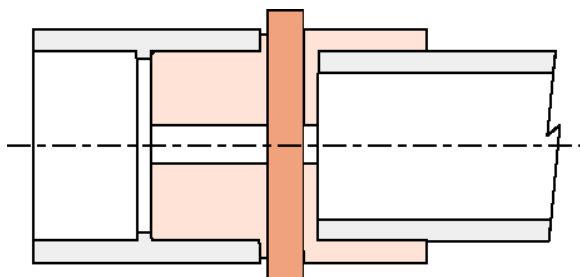
### 2. *Pipe Prep*

- A. Cut the pipe faces at right angles and remove the burrs with a deburring tool. For sizes 1-1/4" and larger, the ends of the pipe must be chamfered using a scraper tool. Work the pipe face until the blades of the scraper are flush with the pipe end.
- B. Clean the pipe and fitting surfaces with lint-free paper and isopropyl alcohol.
- C. Mark the depth of the socket on the pipe in order to ensure that the pipe is inserted to the correct depth during heating.
- D. Clean heater inserts and check the unit's temperature.

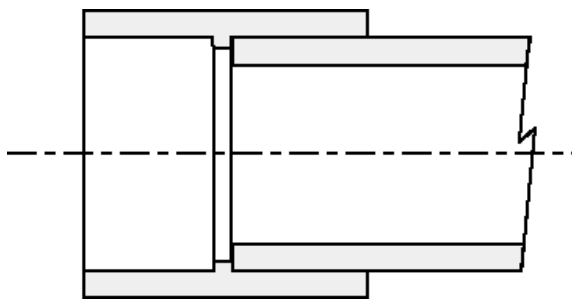


### 3. Heat Soak

- A. Align the pipe and fitting in the machine with the heating element inserts.
- B. Quickly and smoothly push the fitting and pipe in an axial direction until the fitting bottoms out and the pipe reaches the marked depth. It may be advantageous to start pushing the pipe in before the fitting. **(Never twist while heating).**
- C. Heat for the indicated time on chart (see weld parameters in section III).



- D. After heating time is finished, quickly remove pieces from the machine and fit them together until both welding beads meet. Allow time to cool.



## Section III - Welding Parameters

Weld parameters are located on a separate document. All rented or purchased tools will include a physical copy of the latest weld parameters.

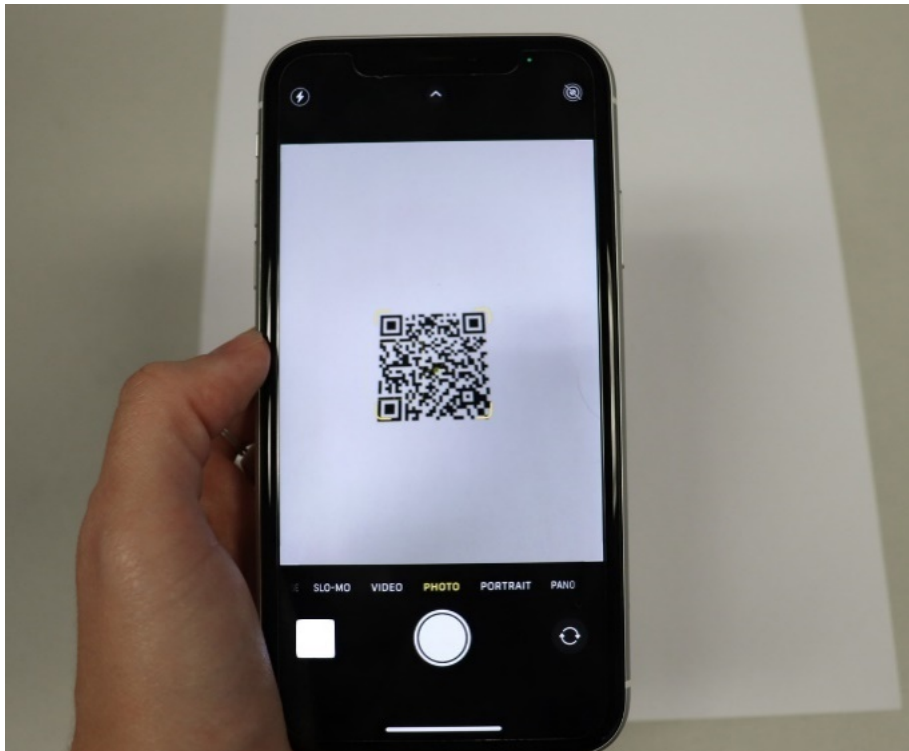
Parameters can also be accessed in the following ways:

- A. Located on our website at [www.asahi-america.com](http://www.asahi-america.com) under the resources tab of each product page.
- B. Through Asahi/America's welding web app at <https://myasahi.asahi-america.com/welding> or scan the QR code on the right.

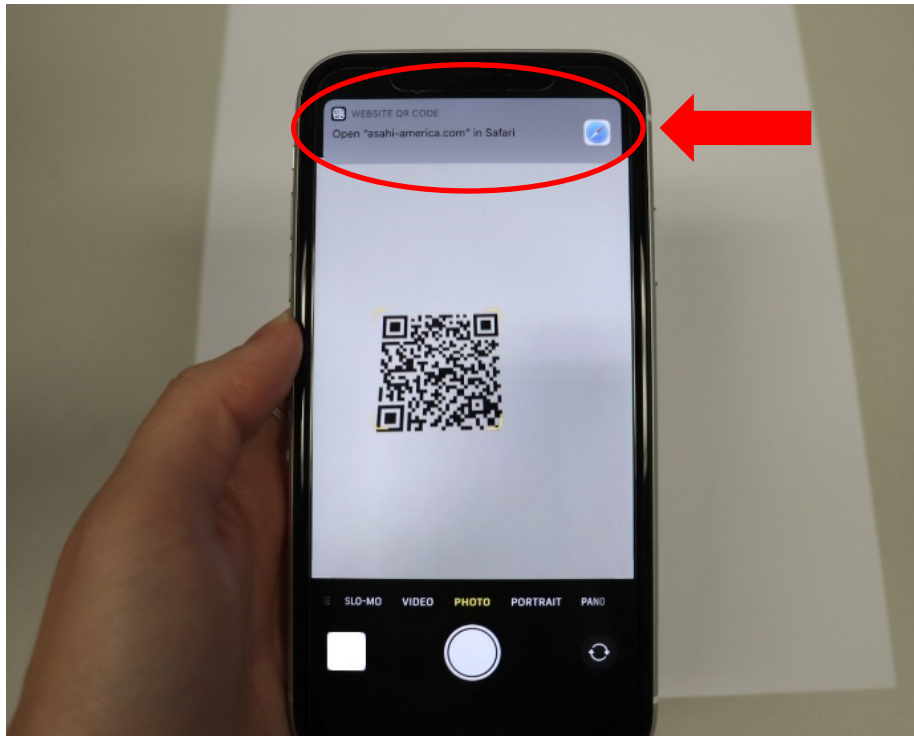


### How to scan the QR code:

1. Most phones now have the native capability to scan QR codes using the camera on the phone, with no additional QR app required. If you're having trouble with this, there are multiple free QR reader apps available wherever you download your apps.
2. Open up the camera app on your phone or tablet.
3. Hover the camera over the QR code (without taking a photo); focus the camera if needed.



4. Wait for a web address pop-up to appear. Click on the pop-up to take you the weld parameter app.



### How to use the weld web app:

1. To search for a parameter, fill out all four fields: tool, piping system, product line & material, and pipe size from the drop-down options. Then, click 'search'.

AA myasahi.asahi-america.com

SEARCH PARAMETER

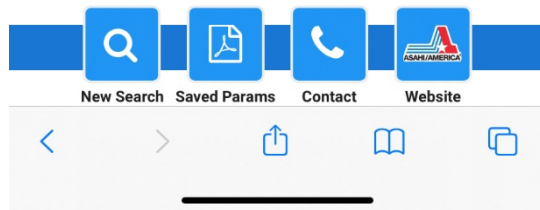
Tool

Piping System

Product Line & Material

Pipe Size

Search



2. The appropriate parameters will appear. Click the 'start' and 'reset' buttons to use the timer. To search for a different parameter, click 'search' in the upper left corner.

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< Search PARAMETER

Miniplast® (Butt):  
Chem Proline® (PE)  
1-1/2" (50mm) SDR11

Please review our [Liability / Terms of Use](#) policy

Welding Temp: 420°F - 446°F (215°C - 230°C)

Initial Melt Pressure: 22.5 lbs

Bead Height: 1 mm

Melt Pressure: Almost Zero

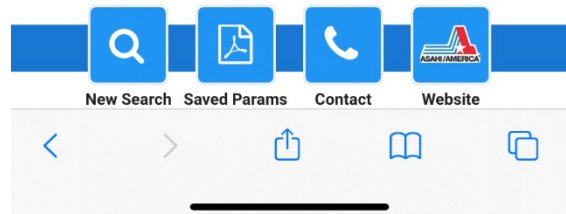
Heat Soak Time: 46 seconds

Change Over Time: 5 seconds

Weld Pressure: 22.5 lbs

Cooling Time: 5.1 min

Reset 00:00 Start





## **Section IV - Maintenance**

To keep the machine in good working condition, the following should be observed:

1. Assure that the machine is always connected to proper power supply.
2. Keep heating element clean. Whenever necessary, wipe residue off with clean, lint-free cloth while the element is at operating temperature.
3. Asahi/America recommends maintenance work after one year for contractor-owned tools.

# TOOL DEPARTMENT CONTACTS

## **Equipment Rental**

### **Rental Equipment Manager**

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### **Field Training**

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