

Proweld™ Equipment

Owner & Maintenance

Manual

Hand Held

Socket Welding Tool



35 Green Street, PO Box 653, Malden, MA 02148
Tel: (781) 321-5409 - Fax (781) 321-4421 - Toll Free: (800) 343-3618
www.asahi-america.com - asahi@asahi-america.com
Direct Sales: East (800) 232-7244 / Central (800) 442-7244 / West (800) 282-7244

TABLE OF CONTENTS

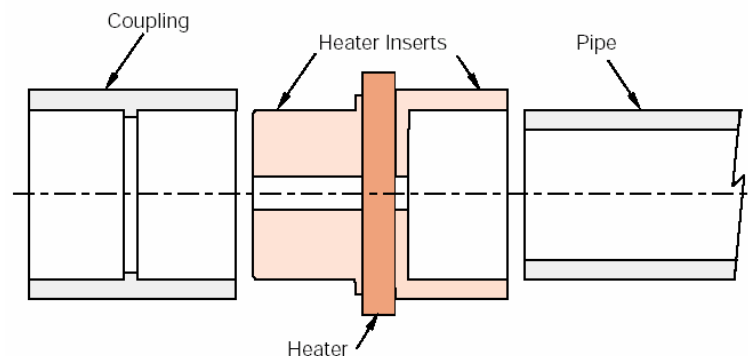
Section	Page
I. Safety Precautions	3
II. Machine Operation	4
III. Welding Parameters	6
IV. Asahi/America Contacts	7

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-out parts should be replaced immediately. Only use factory parts.
8. Electrical tools not in use should be stored away safely.

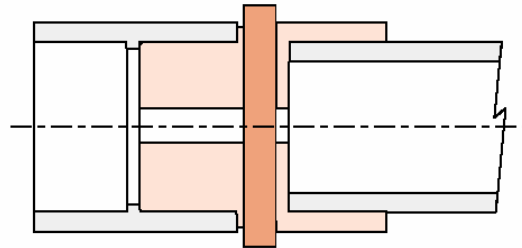
Section II- Proweld™ Hand Held Socket Fusion Instructions

- 1)
 - 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 preset at the factory for 500°F.
- 2)
 - 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 fluffless 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.

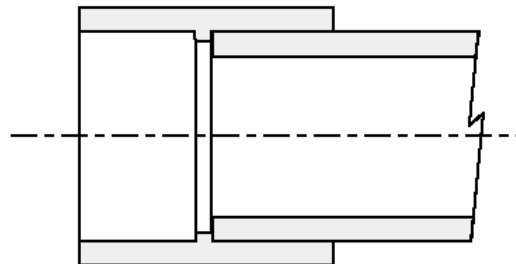


3)

- 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.



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



Section III- Socket Welding Parameters

Nominal Pipe Size (inches)	Heat Soak Time (sec)	Adjusting Time (sec)	Cooling Time (min)
Pro 150			
1/2	5	4	2
3/4	7	4	2
1	8	6	4
1-1/4	12	6	4
1-1/2	18	6	4
2	24	8	6
Air-Pro			
1/2	5	4	2
3/4	7	4	2
1	8	6	4
1-1/4	12	6	4
1-1/2	19	6	4
2	24	8	6
PVDF			
1/2	3	3	3
3/4	4	3	3
1	5	3	3
1-1/4	6	4	4
1-1/2	8	4	5
2	10	5	6

Welding Temperatures:

Pro 150	260°C = 500°F
Air Pro	260°C = 500°F
PVDF	260°C = 500°F

Tool Department Contacts

Asahi/America
35 Green St, Malden, MA 02148
Phone: 1-800-343-3618 or 781-321-5409
Fax: 781-321-4421
www.asahi-america.com
asahi@asahi-america.com

Equipment Rental

Rental Equipment Manager

781-388-4618
toolmanager@asahi-america.com

Rental Administration, Billing & Returns

781-388-4623
toolrental@asahi-america.com

Field Technician/Onsite Training

617-480-7071
info@asahi-america.com

Technical Service

High Purity, Double Wall or Industrial Piping

781-321-5409
pipe@asahi-america.com



35 Green Street, PO Box 653, Malden, MA 02148
Tel: (781) 321-5409 - Fax (781) 321-4421 - Toll Free: (800) 343-3618
www.asahi-america.com - asahi@asahi-america.com
Direct Sales: East (800) 232-7244 / Central (800) 442-7244 / West (800) 282-7244