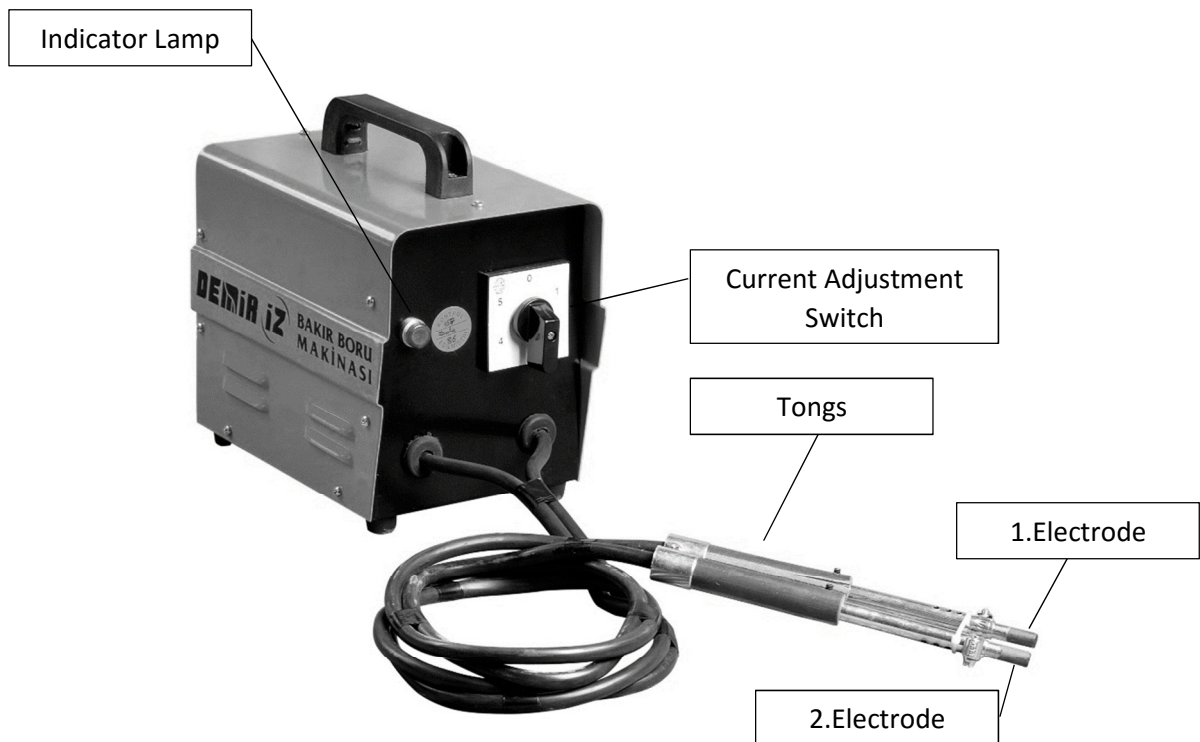


Instruction Manual



DCP-3

COPPER PIPE WELDING MACHINE



General Safety Warnings

- Read all instructions. Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury. The term „power tool“ in all of the warnings listed below refers to your mains operated (corded) power tool or battery operated (cordless) power tool, also machines and electric units.
- Only use the power tool for the purpose for which it was intended, with the due attention to the general safety and accident prevention regulations

SAVE THESE INSTRUCTIONS

A) Work area

- 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.

B) 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. If the power tool comes with an earthed wire, the plug may only be connected to an earthed receptacle. At work sites, in damp surroundings, in the open or in the case of comparable types of use, only operate the power tool off the mains using a 30 mA fault current protected switch (FI breaker).
- 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.

C) 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 safety equipment. Always wear eye protection. Safety equipment such as dust mask, non skid safety shoes, hard hat, or hearing protection used for appropriate conditions will reduce personal injuries.
- c) Avoid accidental starting. Ensure the switch is in the off position before plugging in. Carrying power tools with your finger on the switch or plugging in 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.
- h) Only allow trained personnel to use the power tool. Apprentices may only operate the power tool when they are over 16, when this is necessary for their training and when they are supervised by a trained operative.

D) 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 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 by a qualified expert or by an authorized DEMIRIZ after-sales service facility before use. Many accidents are caused by poorly maintained power tools.
- f) Secure the workpiece. Use clamps or a vice to hold the workpiece. This is safer than holding it with your hand, and also it frees both hands to operate the equipment.
- g) Use the power tool, accessories and tool bits etc., in accordance with these instructions and in the manner intended for the particular type of power tool, 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. All unauthorized modifications to the power tool are prohibited for safety reasons.

E) Service

- a) 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.
- b) Comply with maintenance instructions and instructions on tool replacements.
- c) Check mains lead of power tool regularly and have it replaced by a qualified expert or an authorised DEMIRIZ after-sales service facility in case of damage.
Check extension cable regularly and replace it when damaged.

Specific Safety Warnings

- The electrodes reach a working temperature of around 900°C so never touch either the electrodes or the front of the tongs or the work piece, whether during or after soldering!
- When putting down the tongs after soldering, ensure that the front part of the tongs, which is still hot, is kept away from inflammable materials.
- Change worn electrodes and electrode holders.
- Persons (including children) whose physical, sensory or mental abilities or lack of experience and knowledge do not allow safe operation of the device without supervision or instruction may not use the device.
- Children may not be allowed to play with the device.

Only use for the intended purpose of soft soldering of copper pipes.
All other uses are not for the intended purpose and are prohibited

1. Technical Data

1.1. Electrical Data

Supply Voltage U1	1~ 220 V
Maximum Input Power	1 kVA
Welding Thickness	1/4 Pipe -28 mm
Protection Class	IP 21
Dimensions (w/l/h) (mm)	170x250x230
Weight	14,5 kg

2. Operation

2.1. Electrical connection

The soldering unit must be connected to a socket with a protective earth (earthed wire). Ensure that the mains voltage is correct! Before connecting the unit, check that the mains voltage is the same as that specified on the rating plate.

2.2. Mode of operation

Once the electrodes of the soldering unit are applied to a metallic conductor, e. g. a copperpipe, a circuit with low voltage and high current intensity is closed by pressing the switch. The electrodes have a relatively high resistance in the transformer/cable/electrodes/work piece circuit, and therefore heat up. They may become red hot with larger pipe sizes. The resultant heat is transmitted to the workpiece by heat conduction, and the workpiece is heated to soldering temperature **in a matter of seconds.**

2.3. Operating sequence

Prepare the soldering joint properly. Connect the unit to a protectively earthed socket. Attach the tongs with the electrodes to the workpiece. Operate the switch. Keep the switch pressed during the soldering operation. The soldering temperature is reached within seconds. Feed in the solder until the soldering gap is filled. Release the switch. Remove the tongs from the Workpiece. If the workpiece is not precisely fixed, it can be held in the tongs while the switch is open until the solder has solidified. The increase of the temperature of the workpiece can be controlled via current adjustment switch on the front panel. The 5th step of the switch operates the welding tool in full power. Lower steps of the switch can be used for thinner workpieces. Using higher step, thus higher current levels, can be caused damages on thin workpieces.

2.4. Soldering material

Use soldering materials containing 63 Sn / 37 Pb chemical rates for soft welding applications.

3. MAINTENANCE

3.1. Maintenance

Maintance-free

3.2. Inspection/servicing

Keep the electrodes free of solder and flux, as these impair heat transmission.

Check the electrodes for damage and consumption from time to time. Change the electrodes if necessary.

Clean the contact surfaces of the holder with a wire brush. Replace deformed or burnt holders.

4. ACTION IN THE EVENT OF PROBLEMS

4.1.

Fault: Solder point does not heat up.

Cause: ● Mains lead is not plugged in or is defective.

● Mains socket is defective (mains fuse).

● Temperature switch in the transformer winding has been operated. The temperature switch comes back on automatically once the winding has cooled down.

● Unit is defective.

4.2.

Fault: Solder point takes longer to heat up.

Cause: ● Heavy wear on electrodes.

GARANTİ BELGESİ

Üretici Firmanın

Unvanı: **DEMİRİZ ELEKTRİK VE İNŞAAT SAN.TİC.LTD.ŞTİ.**

Adresi:

Tel/Fax:

Malın

Cinsi: **BAKIR BORU KAYNAK MAKİNASI**

Markası: **DEMİRİZ**

Modeli: **DCP-3**

Üretim Tarihi:

Teslim tarihi ve yeri:

Azami Tamir Süresi: **30 İŞ GÜNÜ**

Garanti Süresi: **2 YIL**

Distribütörün

Unvanı:

Adresi:

Tel/Fax:

Fatura Tarihi-No:

Firma yetkilisi

(Kaşe İmza)

Tarih: .../.../20...

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