

Friction welding machine RS02

Instruction manual

Friction welding machine RS02 for Polyurethane profiles consisting of:

- Drive motor 230 Volt/AC with speed control and ON/OFF switch
- Eccentric drive with automatically activated piston stroke
- Clamping device with centre lever and release button key
- Exchangeable profile jaws
- Adjusting knob for contact pressure





Patent EU: EP 0 974 772
Patent US: 6,250,178B1
Patent DE: DE4318781

Work sequence:


- Select and insert the clamping jaws(9) (remove adapter (10) for customised profiles if required and insert the customised clamping jaws).
- Cut off both ends of the profile to be connected.
- Open the clamping device (5) (turn the Allen head screw with key to the left to do this)
- Insert the profile in the middle of the clamping jaws (9) and hold it tight with the centre lever (6). Tighten both Allen head screws (11) with the Allen key. (Profiles touch slightly, small gap for large profiles of approx 0.2 - 0.4mm)
- Place the small soft profiles in the clamping jaws (9) and let them protrude some 2.0 to 3.0 mm over the clamping jaws. Tighten the Allen head screws (11) - Profile swells up and may touch itself (some practice may be necessary for smaller profiles, PU materials behave in various ways).
- Set the speed regulator (2) (steps 1-6) depending on the profile to be welded. Small profiles step 4 - 6; depending on PU quality, large profiles step 5-6.

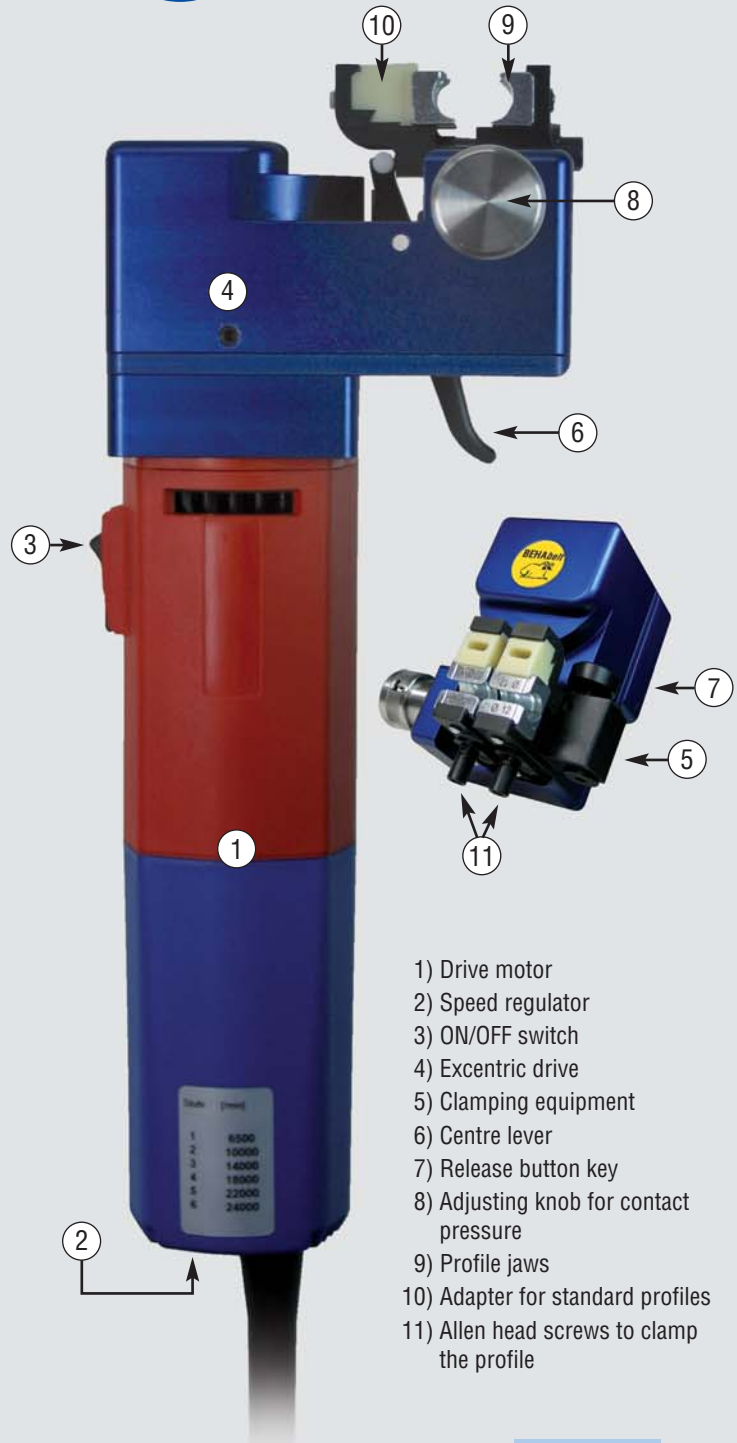
- Small profiles up to Ø 10: adjust contact pressure (8) to low or high, depending on the PU quality, large profiles from Ø 12: adjust contact pressure (8) to high.

 Connect devices to 230 Volt/AC mains

 Switch the machine on (3) (only when profile is clamped)

- Press release button key (7) on the left → welding process starts.
- When profile swells up, switch off the machine (3)
- Welding process is finished and the profile is now completely spliced.
- Leave profile clamped for 2-3 min. in the machine to cool off.
- Open the clamping jaws (9) with the Allen key via the Allen head screws (11), take the profile out and remove the bead upset with the edge cutter.
- Now the next welding process can be performed.

 **Please observe the safety and warning notes printed on the rear!**



- 1) Drive motor
- 2) Speed regulator
- 3) ON/OFF switch
- 4) Eccentric drive
- 5) Clamping equipment
- 6) Centre lever
- 7) Release button key
- 8) Adjusting knob for contact pressure
- 9) Profile jaws
- 10) Adapter for standard profiles
- 11) Allen head screws to clamp the profile

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Safety and warning notes

Notes on the appliance or in the operating instructions:

-  Warning of a dangerous situation. Read the operating instructions.
-  Note. It is essential that you read this
-  Caution! Dangerous voltage, danger of electrical shock.
-  Continuous double or reinforced installation in accordance with Class II IEC 536.
-  **CE** Conformity mark, confirms that the applicable guidelines have been observed. The EMC guideline (89/336/EEC) with the Standards EN 50081-1 and EN 50082-1 have been met. The low voltage guideline (73/23/EEC) with the Standard EN 61010-1 has also been met.
-  Before the appliance is used, the operating instructions must be read carefully and followed in all aspects.
-  If the instructions are not observed, or if you should forget to follow the warnings and notes, serious injuries to the user or damage to the appliance could occur.





Technical Data:

Nominal voltage:	230 VAC \pm 10%
Frequency:	50-60 Hz
Rev/min:	max. 24.000
Power:	500 W
Dimensions:	295 x 111 x 100 mm
Weight:	2.5 kg

Transport and Storage


The appliance must be stored in a dry and closed area. If the appliance has been transported at extremely high temperatures, it needs to be acclimatised until it is completely dried out before it is switched on.

Safety Measures

-  For all work, the applicable accident prevention regulations of the professional association must be observed.
-  The friction welding machine RS02 may only be held on the handles provided for this. Touching the welding head during operation must be avoided at all costs.
-  The appliance may only be connected to the input voltage specified on the nameplate.
-  If the safety of the operator can no longer be guaranteed, the appliance must be taken out of operation and secured against unintended use. This is the case if the appliance:
 - displays obvious damage
 - no longer performs the desired functions
 - was stored for too long under unfavourable conditions
 - was subject during transport to mechanical strains.

Intended use

The appliance may only be used under those conditions and for those purposes for which it was constructed.

In particular the safety notes ( work procedure) and use in a dry environment must be observed.

 Operational safety is no longer guaranteed if the appliance is modified or converted.

Subject to alterations!



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