



FKS & CORRUGATED PIPE WELDING MACHINE

ALKATEM



OPERATOR'S MANUAL

Dear Customer,

Thank you for choosing a machine from the ALKATEM range of products. This is designed to illustrate the features and operating methods of your new ALKATEM model machine

It contains all the necessary information and prescriptions for correct and safe use of the equipment by professional operators.

We are confident that you will enjoy getting to know your new equipment and will be able to use it profitably for many years to come.

*All the best from, ALKATEM
Turkey*

MANUFACTURER'S CONFORMITY DECLARATION



ALKATEM

a company which implements a Quality System in compliance with the requirements of the UNI EN ISO 9001 standards, as verified by the SGS ICS Services Co. for International Certification, and certified under No. 96.061,

Hereby declares

that the corrugated pipe welding machine ALKATEM

Object of the present document has been manufactured according to the following Standards and Regulations having legal value:

2006/42/CE	
2004/108/CE	
2006/95/CE	
UNI EN ISO 12100	2010
CEI 44-5	
ISO 12176-2	2008
UNI 10566	2013

This declaration becomes null and void in the event of any changes being made to the equipment without the written and explicit manufacturer's approval.

Legal Representative
ALKATEM

Machine's Description

- ✓ Ø400 - Ø2000 mm corrugated pipes can be welded
- ✓ The machine works with 220 volt , 10 kw generator
- ✓ Working Technique: Thyristor Controlled Module
- ✓ Control: Manual
- ✓ Efficiency:> 90% (Single Phase)
- ✓ Isolation Voltage: 1500 V (Phase - Neutral - Earth)

INPUT

Input:Single Phase

Input Voltage Tolerance: ± % 5

Operating Frequency: 50-60 Hz.

Operating Frequency Tolerance: ± % 5

Input Transformer: Trogen Transformer

Power Factor: > 0,8

Input Protection : W Automat

OUTPUT

Nominal Output Voltage: 50 V DC

Nominal Voltage Adjustment Range: Between % 1 – % 100 can be set from the front panel

Static Tolerance: % 1

Output Current: 100 A

Output Current Adjustment Range: Between % 1 – 100 can be set from the panel

Output Protection: Electronic Over Current Protection

PANEL

Display and Buttons: 5×20 LCD Panel, Menu Selection and Parameter Setting Buttons

Warning Message: End of Process

Monitored Values: Voltage,Current,Time

Adjustable Values: Working Voltage,Current,Time

ENVIRONMENTAL

Cooling: With Air Cooling

Working Temperature 0 / + 50 °C

Colour: Black

Relative Humidity: <% 90 Without Condensation

Noise Level: Less than 60 dB at 1 Meter Distance

Protection Class: IP 21

The logo for ALKATEM, featuring the brand name in a bold, red, sans-serif font with a registered trademark symbol (®) to the right.

SAFETY STANDARDS

Voltaj : 220

Speed : 50

Kw : 10

*Diameter : 400 * 2000*

- ✓ After powering up the machine , absolutely do not touch to sockets*
- ✓ Before using the machine wait 3-5 minutes while the machines is powered*
- ✓ Grind the area to be welded and clean with alcohol*
- ✓ Pay attention to welding time of resistance wires on the pipe that is to be welded. (welding time will be determined as the pipe producer informs)*
- ✓ When welding, according to the thickness of the wire ; between 1-3 mm , at 3rd level, 46 volts, 20-25 minutes ; between 2-4 mm at the 5th level , 50 volts, 25-35 minutes should be maintained.*
- ✓ As machine tests and proposed values are conducted in closed area in factory , in open area these values will subject to change. User must be aware of it.*
- ✓ Power extension cord should not be longer than 10 m*
- ✓ Welding values should be entered to the machine manually.*

ALKATEM®

CHECKS AND MAINTENANCE

Before performing welding and before connecting to power outlet, check the following:

NOMINAL TENSION AND FREQUENCY : see technical features

OUTLETS AND EXTENSION CABLES: they must be suitable for the power absorbed by machine

CABLES: isolation has to be intact, they have to be placed away from places where vehicles transit and where they can be damaged .

MACHINE BODY: it has to be isolated and placed steadily.

Keep machine and cables clean and dry. Before cleaning operations disconnect machine from power supply. Use a humid soft cloth with water and alcohol (avoid any kind of solvent).

ALKATEM corrugated pipe welding machine is an electronic equipment therefore it has to be handled safely avoiding impacts and sudden temperature changes.

In case of any anomaly machine has to be checked by manufacturer or by an authorized service centre.

In any case machine has to be serviced every 2 years by manufacturer or by an authorized

