

**PLASTİK BORU ALIN
KAYNAK MAKİNALARI**
**PLASTIC PIPE
WELDING MACHINESS**



Dünya'da Daha İyi Bir
ALTYAPI İçin Çalışıyoruz...

We Are Working for a better
INFRASTRUCTURE on the world...

AL 250

AL 315

AL 400

AL 500

AL 630

AL 800

AL 1000

AL 1200

AL 1600

KULLANMA KİLAVUZU
TECHNICAL INFORMATION

- Makinalarımız üstün teknoloji ile üretilmektedir. İnsan sağlığı ve güvenirliliği açısından son derece güvenli ve kolay kullanılabılır olması müşterilerimiz tarafından tercih edilme nedenlerimizdir. Buna rağmen yanlış kullanımdan doğabilecek hata ve kazaların önlenmesi için aşağıdaki hususlara dikkat edilmesini öneririz.
- 1-Lütfen makinayı maksadının haricinde herhangi bir iş için kullanmayın.
 - 2-Makina hakkında bilgiyi olmayan kişilere makinayı kullandırmayın.
 - 3-Rutubetli ve ıslak yerlerde kullanmamaya özen gösteriniz.
 - 4-Elektrik kablolarını araç ve insan yoğunluğu olan yerlerden geçirmeyiniz.
 - 5-İş bitiminde, ısıtıcı tamamen soğumadan makinayı terk etmeyiniz. Acilen başka yere nakletme mecburiyeti olduğunda elektrik kablolarının ısıtıcıya temas etmemesine dikkat ediniz.
 - 6-Her kullanmadan önce (iş başlangıcında) elektrik kablolarının ve ısıtıcının yalıtımını kontrol ediniz.
 - 7-Yanıcı gaz, patlayıcı madde vb. maddelerin bulunduğu ortamda makinayı kullanmamaya özen gösteriniz.
 - 8-Kaynak işlemi sırasında ağıza çıkan gazlar solunulmamalı, mümkün olduğunda kaynak yapılan yerin iyi havalandırması sağlanmalıdır.
 - 9-Kaynak yapan operatörün çalışma esnasında hareketli parçalardan sakınması ve sıkı giysiler giyinmesine özen göstermesi gerekmektedir.
 - 10-Çalışma alanının yeterince aydınlatılmasına dikkat edilmelidir.
 - 11-Operatör haricindeki kişileri çalışma esnasında makinadan uzak tutunuz.
 - 12-Isıtıcı ısınmaya başladığında veya soğumaya başladığında el sürmeyiniz.
 - 13-Kaynak yerine yakın yerlere dokunmayın.
 - 14-Çalışma esnasında hareketli parçalardan uzak durulmalı ve tıraşlayıcı bıçağı hiçbir zaman el ile kontrol edilmemelidir.

Technical Information

RULES THAT MUST BE CARED FOR OPERATOR SECURITY

We produce our machines with superior technology. Our plastic pipe-welding machine is very easy to use and reliable. But to avoid inducements because of wrong usage, the rules below must be cared for operator security.

- 1-Plastic pipe butt-welding machine must not be used for other purposes.
- 2-Uneducated personal must not be allowed to use machine
- 3-In wet places machine must not be used because of electrical system's security.
- 4-Cables of machines must not be on the way is used by people or vehicles.
- 5-Machine must not be moved just after welding process is finished and heater didn't get cold. If it must move, electric cables must be kept away from heater.
- 6-Before usage electric cables and other apparatus isolation must be okay.
- 7-Machine must not be used in places that include explosive gases etc...
- 8-Welding operation must not be executed for the materials that could be explosive and make toxic gases when temperature is high.
- 9-There must be ventilation in place that pipes are welded because of gasses must not be inhaled.
- 10-Operator who use machine, must not have long hair, necklace etc.. That can be dangerous during moving of machine. The clothes of operator must be compact.
- 11-Working place must be light enough.
- 12-During welding operation audience especially children must stay away machine.
- 13.The heater must not be touched when its temperature is and also during welding (includes cooling time) welding is must not be touched.
- 14-During trimmer operator must beware for his hands.

Tüketicinin kendi yapabileceği bakım, onarım veya ürünün temizliğine ilişkin bilgiler;
Cihazı toz, nem ve sudan uzak tutunuz.

Temizlik ve Bakım

Periyodik bakım gerektirmez. Lüzumu halinde toz birikintilerini itina ile temizleyiniz.
Bunun için yağ çözücü maddeler kullanmayınız.

Periyodik bakım gerektirmesi durumunda, periyodik bakımın yapılacağı zaman aralıkları ile kimin tarafından yapılması gerekiğine ilişkin bilgiler;
Periyodik bakımı yoktur.

UYARI: Plastik boru alın kaynak makinasını yalnızca eğitim almış kişiler tarafından kullanılması gerekmektedir.
eğitimler için firmamızla irtibata geçiniz.
makinayı kullanacak olan operatör makinanın çalışması sırasında makinanın 1 mt uzağında durmalıdır.
isıticıyi tutarken yanmaz eldiven kullanınız.
kullanılan eldiven EN407 standartlarına uygun olmalıdır.

Technical Information

RULES THAT MUST BE CARED FOR OPERATOR SECURITY

The consumer can do their own maintenance, repair and cleaning information;
Device from dust, moisture, and keep away from water.

Cleaning and Maintenance

Periodic maintenance is required. If necessary, carefully clean the dust deposits.
To do this, use a degreasing agents.

If they require periodic maintenance, periodic maintenance and by whom the time interval of Given to to be done;
There is no periodic maintenance.

WARNING: Do not Get Plastic pipe welding machine must be used only by persons trained.
Please contact us for training.
during the operation of the machine, the machine that will use the machine at 1 m away from the stop.
Use gloves when handling the heater does not burn.
gloves must be used in accordance with the standards EN407.

ALIN KAYNAĞI YAPARKEN DİKKAT EDİLECEK HUSUSLAR

Sağlıklı bir kaynak yapabilmek için aşağıdaki hususlara dikkat edilmesini öneririz.

- 1-Kaynak yapılacak malzemelerin çap, cins, et kalınlığı vb... özelliklerile birbirlerine uyumlu olmasına dikkat ediniz.
- 2-Kaynağı etkileyebilecek rutubet, rüzgar (hava akımları) ve düşük sıcaklıklarda isınan yüzeyleri muhafaza ediniz.
- 3-Kaynak işlemi öncesinde kaynatılacak borular tıraşlanır. İyi bir kaynak kalitesi için tıraşlanan yüzeye elle temas edilmemelidir.
- 4-Kaynak işlemi başlamadan önce boruların üst kenarları sıkılarak sabitleştirilir. Bu işlem boruların tam olarak merkezlenip, sağlıklı bir kaynak elde edilebilmesi için gerekli hem de boruların tıraşlama esnasında gevşememesi için önemlidir.
- 5-Kaynak işlemi ve soğuma süresi esnasında parçalar hiçbir şekilde kuvvet ve zorlamaya maruz bırakılmamalıdır.
- 6-Kaynak yapılan borunun bir tarafı kolay hareket edebilecek şekilde yataklarılmış bir zemin üzerinde bulunmalı ve kolayca ileri geri hareket edebilmesi sağlanmalıdır.
- 7-Tıraşlayıcı bıçağın keskin olduğundan emin olunmalıdır. Belirli zamanlarda körlenmiş bıçak bilenmeli veya değiştirilmelidir.
- 8-Isıtıcının teflon yüzeyine yapışmış yabancı madde ve derin çizikler bulunmamalıdır.
- Yukarıdaki hususları göz önünde bulundurduğumuz müddetçe yapacağınız kaynak son derece sağlıklı ve temiz olacaktır.

Technical Information

RULES THAT MUST BE CARED FOR WELDING QUALITY

There are some rules below that must be care for a good welding quality

- 1-Materials (Diameter, type, wall thickens) that will be welded must be appropriate for each other.
- 2-Machines working area must be isolated from outer impacts like wind, humidity, low temperature not to alter welding parameters.
- 3-Before welding process pipes foreheads must be trimmed by facing tool. You must not touch pipes foreheads by hands for a good welding quality.
- 4-Before welding process pipes foreheads must be fixed. This process is necessary for a good welding quality and also is very important for workers safety.
- 5-During welding process and cooling time pipes not be exposed to external force.
- 6-Other part of welding pipe must be on a sliding floor and pipe must be move easily back and forward.
- 7-Trimmer's knife must be sharp enough. Knife must be sharpened in period of specified times.
- 8-There must not be scratch etc. On teflon coating of heater. Heater face must be controlled.



Ölüm Tehlikesi
Danger of Death



Eldiven Kullan
Use Gloves



DİKKAT SICAK
CAUTION HOT



ANA MAKİNA

Ana makinanın parçaları

- İki başı şaseye monte edilmiş silindirler.
- Bir adet oynar çene, mil sistemi üzerinde hareketli ve değişik pozisyonlarda takılabilir.

Millere monte edilen çeneler ana makina da hareketli bölüm oluşturur. Hareketli çeneler sabit çeneleri destekler. Makinayı uygun pozisyonda yerleştirdikten sonra kaynak işlemeye başlanır.

Aşağıdaki çalışmalar sırasıyla uygulanır.

1-Esnek hortumları hidrolik otomatik rekörlerle bağlayın.

2-Bağlantıları test edin. Hidrolik ünite kontrolünü çalıştırın.

3-Hidrolik kontrol bölümü çalışırken makinanın hareketli bölümünü tamamıyla serbest bırakın.

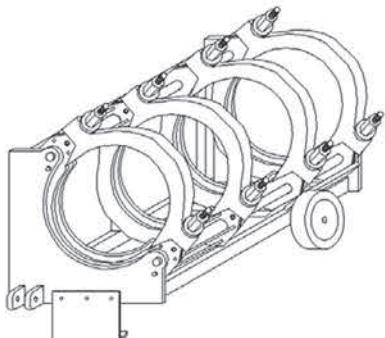
4-Dört çenendenin üst kısmını açın.

5-Borulardan bir tanesini hareketli bölümde diğerini ise sabit bölüme koyun.

6-Borular kaymayacak şekilde çeneleri sıkıştırın.

7-Tıraşlama işlemeye başlayın.

8-Kaynatacığınız borunun çapını, PN'sini çizelgeden bulunuz. Gerekli zaman ve basınçları uygulayarak kaynak işlemini yapınız. 90° dirsek 45° dirsek boru kaynatmak için bu tarz boruların makinaya doğru bir şekilde monte edilmesi gerekmektedir.



Technical Information

BASIC MACHINE

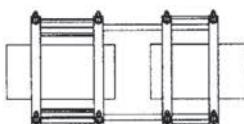
The basic machine is composed by:

- Two cylinders on which heads are mounted two complete clamps.
 - One movable clamp dia. 500 mm sliding on cylinder's system and fixable in different position.
- 1-Connect the flexible hoses quick couplings
- 2-Test the connections and the Movable Trolley's function by means on acting on the hydraulic unit control.
- 3-Leave the moveable part of the machine when hydraulic unit start acting.
- 4-Open the clamps upper part.
- 5-The two pipes of to be welded, one into the Fixed trolley the other one into the movable trolley.
- 6-Check the alignment of the pipes by approaching together in case by acting on the middle clamps nut.
- 7-Start the facing operation.
- For a good welding quality on these types of pipes (90° fittings and 45° fittings) you must put the pipes into the machine in right position.

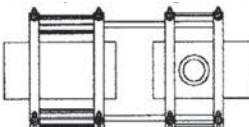
Kullanma Kılavuzu

KAYNAK BORUSU İLE İLGİLİ TERTİBATLAR

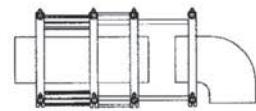
Her borunun makinaya nasıl bağlanacağı aşağıda gösterilmiştir.



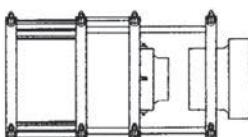
İki Düz Boru Kaynağı
Pipe with pipe



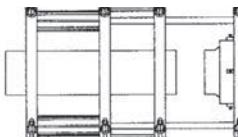
Düz ve İngel Te Boru Kaynağı



Dirsek ve düz boru kaynağı
Pipe with short spigot fittings



Flanş adaptörlerinin kaynağı
Fitting with stub flange



Flanş adaptörlü ve düz boru k:z
Pipe with stub flange

- Kısa flanşların kaynatılmasında kullanılır.
- Kısa flanşı flanş aparatına bağlayın.
- Flanş aparatı makinanın çenelerine takılacak şekilde işlenmiştir.
- Flanş aparatını makinanın çenesine bağlayın.
- Üst çeneyi flanş aparatının üzerine takip sıkıştırın.

FLANŞ APARATI



- Flanş adaptörünü flanş aparatına resimdeki gibi bağlayın
- Flanş aparatını makinanın çenelerine bağlayın
- İki düz boru kaynağı yapıyormuş gibi kaynak işlemlerini uygulayın.

Technical Information

THE FOLLOWING EXAMPLES EXPLAIN THESEVERALPOSSIBILITIES

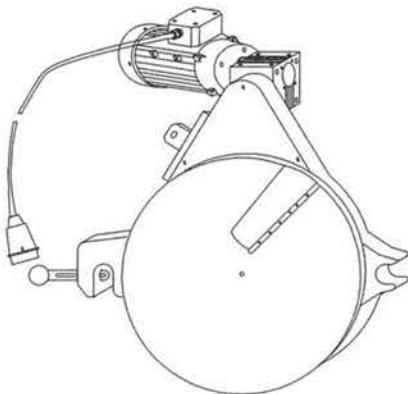
- Kısa flanşların kaynatılmasında kullanılır.
- Kısa flanşı flanş aparatına bağlayın
- Flanş aparatı makinanın çenelerine takılacak şekilde işlenmiştir.
- Flanş aparatını makinanın çenesine bağlayın.
- Üst çeneyi flanş aparatının üzerine takip sıkıştırın.



- Connect flange adaptor to flange aparatus like as shownen at picture.
- Connect flange aparatus to clamps.
- And star welding like as doing pipe but welding.

TIRAŞLAYICININ PARÇALARI

- Tiraşlayıcı gövdesi
- Bıçaklara monte edilmiş iki tane disk.
- Motor Redüktörü
- Güvenlik şalteri sadece motorun çalışmasını sağlar. Tiraşlayıcı makinanın dışındayken tiraşlayıcıyı çalıştırmayın.
- 1-Tiraşlayıcıyı iki borunun arasına koyun, bu boruların alın alına bkmaları gerekdir. Bu da tiraşlayıcıya özel destek sağlar. Boruların bitiş yerlerindeki, içindeki ve dışındaki pıslıkları temizleyin.
- 2-Tiraşlayıcı çalışmaya başladığında boruların yüzeylerini birbirine yaklaştırmaya başlayın.
- 3-Tiraşlayıcı bıçağı ile borular teması geçtiğinde tiraşlama işlemi başlamış olur. Kestığınız parçalar birbirine eşdeğer olduğunda tiraşlama işlemi tamamlanmış olur.
- Tiraşlayıcı basıncı makinanın yüreğine 5 ile 10 bar eklerek tiraşlama yapılır.
- 4-Boruları tiraşlayıcıdan ayıran daha sonra tiraşlayıcıyı kapatın ve kabinine yerleştirin.
- 5-Kesilen parçaları temizleyin. Tiraşlanan yüzeye el sürmeyin.



Muhtemel Dez Avantajları ve Çözüm Önerileri:

- a)Tiraşlayıcı çalışmazsa:
 - 1-Elektrik bağlantılarını kontrol edin.
 - 2-Her ihtimale karşı vidaların sağlamlığını kontrol edin.
 - 3-Güvenlik düğmesini kontrol edin.
- b)Bıçaklar kimildamayan malzeme değildir. Körlediğinde iki tarafı kesen bıçakların keskin taraflarını takın.

Bıçakları her zaman temiz tutmak çok önemlidir.

Technical Information

FACING TOOL DESCRIPTION AND OPERATING THE FACING TOOL COMPOSED BY:

- The facing tool body
- Two disks where are mounted the blades
- A drill engine with a reducing gear supplied with a safety pin that while connected keep the facing tool hooked to the machine.
- A safety micros witch allowing the engine start only when the facing tool is fit into the machine, avoiding the start of the engine out of this position.

- 1-Fit in the facing tool between the two pipes ends to be faced, by means of connecting the facing tool into the special supports, taking care that the pipe's ends are internally and externally clean from dust and sand.
- 2-The two pipes faced get closer when the facing tool started.
- 3-While the pipes ends will be in contact with the facing tool blades will start facing by removing material as shavings, when the shavings from both sides will appear continues and homogeneous, the facing operation is completed. During this operation keep in mind to the machine. Usually the facing pressure can be set up between by a value of 3-5 bar.
- 4-Proceed to take away the pipes ends from the facing tool and switched off the facing tool engine, remove the facing tool and place it into the support.
- 5-Before carry out further operation remove all the shavings from the pipes and from the ground avoiding to dirty the faced pipes ends Possible drawback's description and relative solutions.

i.The facing tool does not start:

- 1.Check the electric connections and the safety micros switch
- 2.In case its need to replace the engine the following operations must be done.

2a.Check the screws and items

2b.Check the safety micros switch end

2c.Remove the engine

2d.To fit in the new engine just proceeds on opposite way, taking care to not strain the cahin too much.

2e.Connect to safety micros switch connecting wires to the new engine after disconnect from the old one.

ii.The blades does not remove material

1.Wear and tear of one cutting side unlighted the screws and turns the blades using the other side.

2.Wear and tear of both cutting side of the blades replace with original spare parts. Important: It's very important to keep always clean the blades and wash the pulleys by using detergent. At regular intervals carry out a complete cleaning operation with a internal lubrication as well, as per Following instructions:

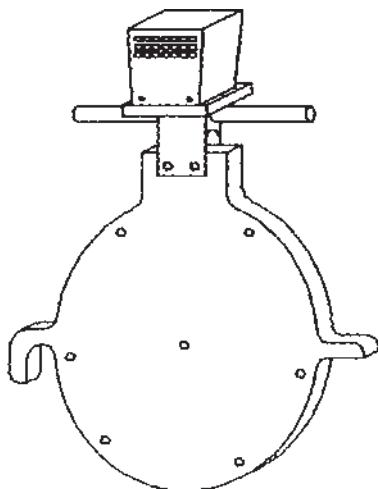
1.Remove the carter by unlighted the screws

2.Take out the shavings might be a present

3.Clean and lubricate the chain utilizing specific products.

Isıtıcı aynasını oluşturan parçalar:

Isıtıcı aynası PTFE ile kaplanmıştır. Termokupol ve ısı kontrol kutusu vardır. İki adet PTFE kaplı alüminyum disk. Genellikle kullanılan sıcaklık değerleri aşağıdaki gibidir.



HDPE : $210^{\circ}\text{C} \pm 10$

PP : $200^{\circ}\text{C} \pm 10$

Sıcaklık değerlerinde herhangi bir hata yapmamak için sıcaklık 220°C 'ye ayarlanmıştır.

ISITICININ KULLANILMASI

1-Fisi panodaki prize takın ve ısıtıcı aynasının 220°C 'ye ulaşmasını bekleyin.

2-Kaynak olacak boru ile ısıtıcıyı temas halinde dikey bir şekilde istenilen dudak kalınlığı oluşana kadar bekleyiniz.

3-Devam eden sürede t2 aşaması basınçsız ısıtma süresini (kaynak grafiğine bakın) uygulayın.

Daha sonra ısıtıcıyı çıkartın ve kabine yerleştirin.
Önemli:

Technical Information

HEATING MIRROR

The heating mirror composed by:

The heating mirror coated with green colour PTFE complete with thermometer and connecting box. The support suitable for the heating Where is located the connecting box. The electronic thermostat located on the connecting box.

In order to select the necessary temperature act on the

Push buttons increasing or reducing the value according to the type of material and wall thickness of the pipe to be weld, the most common values are the following:

HDPE $10^{\circ}\text{C} +/-10$
PP $200^{\circ}\text{C} +/-10$

The above values are also depending on pipe's wall thickness, therefore for accurate temperature setting up we suggest to check enclosed graphic.

In order to avoid big mistake on temperature selecting the maximum possible setting values is 299°C .

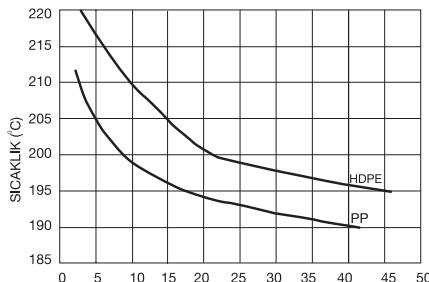
1.Connect the plug to the power supply and check if the light power on is switched on, wait until the heating mirror archive the selected temperature, during this operation the two lights will be switched. One achieved the selected temperature the lights will switched off and will switch on or off only when the thermostat would start in order to automatically keep the selected temperature.

2.Before to proceed to the first welding wait until the lights has been switched on and off three times, this allows the stabilization of the temperature on the heating mirror is surface.

3-Take care to insert the heating mirror into the machine only after the facing operation has been completed, the lower part of the heating mirror is supplied with a stable to be insert into the slide bar of the machine's trolley and the upper part of the heating mirror is supplied with a support keeping the mirror in centered position.

4-Elapsed the phase t2 Continual heating (see the Welding Cycle Graph) opening the machine's trolleys, the heating mirror will come off one pipe end, in order to come off the other pipe end just give a blow on the handles, then take off the mirror and put it back into the support.

Isıtıcının sıcaklığı 220° C den fazla olmamalı, herhangi bir yanık için korunaklı eldivenler takılmalıdır.



BORUNUN ET KALINLIĞI (mm)

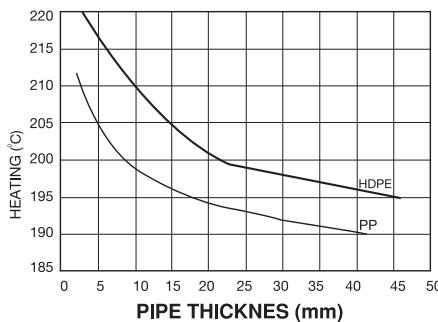
PTFE kaplamasının yüzeyini daima temiz tutun, temizlik yüzey hala sıcakken yapılmalı yumuşak bez ya da kağıt ile, aşındırıcı malzemelerden uzak durulmalı bu PTFE'nin yüzeyine zarar verebilir.

Önerilen Bakım Yöntemleri:

Isıtıcının dış yüzeyini çabuk yok olan bir deterjanla temizleyiniz (Alkol vs.).

Vidaların sıkılığını kontrol edin, kablo ve fişlerinde...

Aşağıdaki tabloda ısıtıcı aynasındaki değişmekte olan sıcaklıklar gösteriyor.



Technical Information

Important

The heating mirror's temperature during the working operations is always above 220° C , therefore keep attention and utilize if possible protective gloves in order to avoid burns.

Possible drawback's description and relative solutions

i.The heating mirror doesn't warm up:

- 1.Check if the light is switched off. In case check the plug
- 2.The light is switched on. Probably a wire disconnected, check the contacts as follows:
 - Take off the plug from the power
 - Unscrew the nuts and take out the thermostat support
 - Unscrew the screws and remove the cap
 - Check all the electric connections and reassemble
 - Unscrew the screws and take out the cover
 - Check all the electric connections and reassemble

3.By utilizing a Tester check if all the resistances are in good condition. If one or more are broken the heating mirror must be changed

4.By utilizing a tester check the working of the thermostat, in case substitute

5.For additional information on electric components, please refer to our Technical Dept Temperature of the welding mirror for welding HDPE and PP

MAINTANENCE

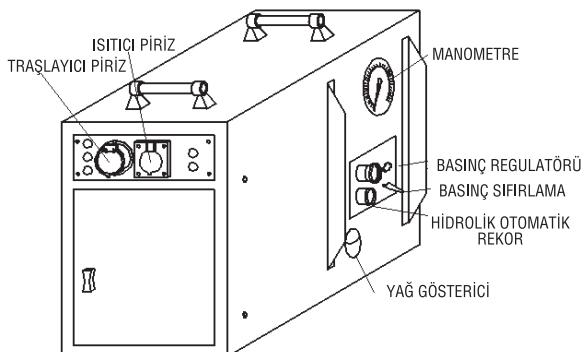
Please take care on handling the heating mirror in order to avoid damages to the PTFE coating. Keep always clean the PTFE coated surfaces, cleaning must be done with surfaces still warm by using a soft cloth or paper, avoiding abrasive materials in that might damage the PTFE coated surfaces.

At regular intervals we suggest you to:

Clean the surfaces by a quick evaporation detergent (alcol)

Check the tightening of the screws and the cable and plug condition.

The following table has shows temperature of the welding mirror for welding.



250/315/500/630/800/1000/1200/1600 kaynak makinalarında basınç ayarları bir hidrolik ünite vasıtası ile sağlanmaktadır. Hidrolik bağlantılar hidrolik otomatik rekör türündedir. Ters takılma işlemi tamamen önlenmiştir.

Hidrolik ünite (SHELL TELLUS 46), (HYDRO OIL HD 46 PETROL OFİSİ)(MOBİL DTE 25 MOBİL)(PRESS OIL 46 KLORA)(BP ENERGOL HLP-HM 46)(CASTROL HYSPIN AWS 46) yağı ve emsalleri kullanılmaktadır. Yağ, göstergede seviyesinin altında ise üniteye yağ ekleyiniz.

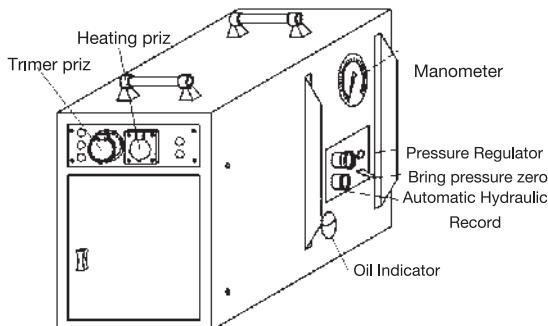
Depo kapağını taşırımayacak şekilde yağ ilave ediniz.

Nakliye sırasında: Yağ tankının havalandırma kapağı nakliyeden önce çıkarılır yerine körtapa takılır. Körtapa makine kullanılacağı zaman çıkarılarak tekrar havalandırılmış kapak takılır. Ambalajlama sırasında ziftli kağıtla yağmura karşı korunma yapılması sağlanır.

ÖNEMLİ: Hidrolik ünitesi taşıırken yan yatırmayınız.

Kaynak ve Tıraşlama Basıncının Ayarlanması:

Elektrik butonlu modeller için; Panelin üzerinde bir manometre ve altında kaynak sırasında basıncın ayarlanabileceği bir basınç regülatörü bulunmaktadır. Kaynak ve tıraşlama işlemi sırasında basınç ayarı bu regülatörün çevrilmesiyle yapılır. Elektronik (CNC) Modeller için bütün kaynak işlemi aşamaları için basınç ayarlaması elektronik olarak makinenin ana programlayıcı kontrol ünitesi tarafından yapılmaktadır. Kullanıcı çap ve et kalınlığı girdiğinde işlem boyunca kullanılan tıraşlama ve ısıtma basınçları, zamanları ve sıcaklıklarını program ünitesi tarafından elektronik olarak ayarlanmaktadır.



Setting of welding and trimmer Pressure

The model for Electric switch

Over the panel has been found there is one manometer and pressure regulator.

In operatin welding and trimmer system pressure setting has been done by tunning on the regulator.

Electronic cnc models

The machine of main control unit has been doing electronically controlled welding and pressure settings.

When the user entered diameter and wall thickness The unit has been electronically programmed all operation as a trimmer and heating programs.

Technical Information

HYDRAULIC SYSTEM

Hydraulic unit has been doing the pressure settings in 250/315/500/630/800/1000/1200/1600 welding machines. The type of hydraulic unit is hydraulic automatic record. The operation of opposite affixed has been prevented completely. We use for hydraulic unit SHELL TELLUS 46, PRESS OIL 46, HYDRO OIL HD 37, MOBİL DTE 25, BP ENERGOL HLP-HM 46, CASTROL HYSPIN AWS 46 oil.

Kullanma Kılavuzu

KAYNAK İLE İLGİLİ KISA AÇIKLAMALAR

- 1-Makinanın hazırlanması
- 2-Çalışacağınız bölgeyi düzenleyiniz.
- 3-Hidrolik otomatik rekorları panoya takınız.
- 4-Elektrik bağlantınızı yapınız. (hidrolik ünite, tıraşlayıcı ve ısıtıcı) daha sonra ana gücün kontrol ediniz.
- 5-İsíticinin 220° C'ye gelmesini bekleyiniz.
- 6-Her ihtimale karşı boru çaplarını kontrol ederek makinaya bağlayınız.

BORULARIN MAKİNA İÇİNDEKİ POZİSYONLARI

- 1-Makinanın çenelerini açınız.
- 2-Boruları makinaya yerleştirirken tıraşlayıcı için yeterli mesafenin kalmamasına dikkat ediniz.
- 3-Bu işlemler sonunda boruların tıraşlanacak yüzeylerini temizleyiniz.

Tıraşlama Çalışması

- 1-Makinanın hareket eden kısmını açınız.
- 2-İki borunun arasına tıraşlayıcıyı yerleştiriniz.
- 3-Güvenlik mandalını bağlayınız ve tıraşlayıcıyı çalıştırınız.
- 4-Boruları tıraşlayıcıya doğru yaklaştırınız. Motora fazla yükleme yapmayın.
- 5-Tıraşlayıcının iki tarafında çapaklar çıkmaya başladıkten sonra tıraşlama işlemini sonlandırınız.
- 6-Tıraşlayıcının elektrik bağlantısını kapatıp kabinine koynuz.
- 7-Boruların yüzeyindeki çapakları temizleyiniz. Tıraşlanan yüzeye el sürmeyiniz.
- 8-Kaynak yapılacak boruları birbirine delegecek şekilde bırakınız ve iki boru arasındaki boşluk değerlerinin aşağıdaki gibi olup olmadığına dikkat ediniz.

OUT DIAMETER (Dış Çap) (mm)	BLANK (Ortalama Boşluk) (mm)	Sayı tablodaki değerler tutmuyorsa tıraşlamayı tekrar ediniz.
dn<400	0,5	In case the following values cannot be fulfilled the facing operation must be repeat.
dn>400	1,0	

Technical Information

BUTT WELDING IN BRIEF

Prepare to machine

1a- You should arrange working area.

1b-Connect to flexible hoses machines hydraulic part

1c-Connect to plugs power supply. (Hydraulic unite, trimmer and heating mirror) afterwards check the main power.

1 d-Select the correct temperature on the heating mirror.

1 e-The pipes must be same diameter

Pipes positioning into the machine:

2a-Open the movable trolley of the machine

2b-Take care to leave enough space between the two pipes ends in order to allow the facing tool inserting.

2c-The pipes foreheads must be fixed tightly.

2d-After this operation you must clean the pipes.

Facing tool operation:

3a-Open the movable trolley of the machine

3b-Fit in the facing tool between the two pipes. The two pipes ends to be faced by means

Of connecting the special supports.

3c-Connect to the safety pin and start trimmer operation.

3d-Star to facing operation. Beware to facing tool engine.

3e-While the pipes ends will be in contact with the facing tool blades will start facing by removing material as shavings, when the shavings from both sides will appear the facing.

Operation is completed.

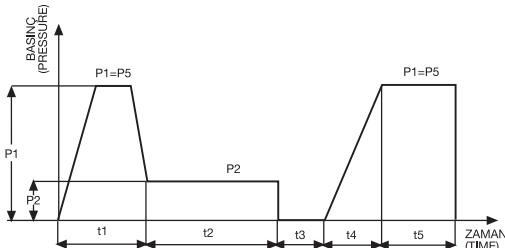
3f-After facing tool operations switch off the power supply. Remove the facing tool and Place it into the support.

3g-Before canny out further operation remove all the shavings from the pipes and from the

Ground avoiding dirtying the faced pipes ends.

3h-You should leave the pipes ends in touching position and the between of the blank ranges show as below table.

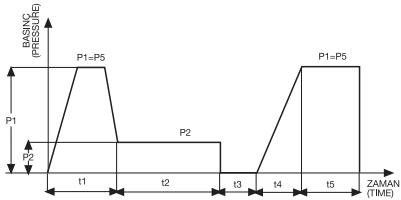
Kullanma Kılavuzu



Malzeme PE ise itme katsayısi 1.5 kg/cm²
Malzeme PP ise itme katsayısi 1kg/cm²
Silindir alanı 250/315/500 için 14.13 cm²
Silindir alanı 630/800 için 23.06 cm² alanır.

- t1: Basınçlı ısıtma yaparken dudak kalınlığı için gereken zaman.
- t2: Basınçsız ısıtma için gereken zaman
- t3: Isıtıcı boruların arasından alma zamanı
- t4: Basınç artırma zamanı.
- t5: Kaynak yapılan boruların soğumaya bırakıldığı zaman.
- P1: Dudak kalınlığı için gereken basınç.
- P2: Devamlı ısıtma için gereken basınç.
- P5: Soğuma esnasında gereken basınç

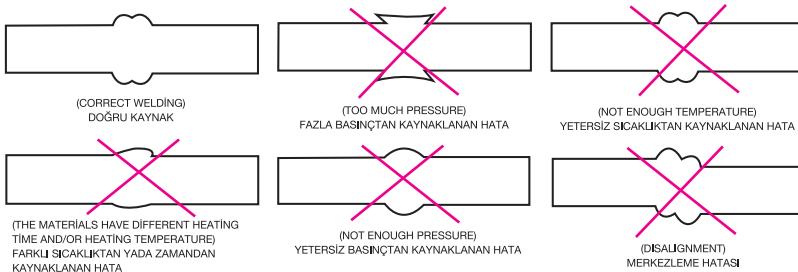
Technical Information



Total machine cylinders section (cm²)
Material thrust coefficient for PE 1,5 Kg./cm²
Material thrust coefficient for PP 1,0 Kg./cm²
Total PT 250-315-500 cylinders section 14.13 cm²
Total PT 630-800 cylinders section 23.06 cm²

Pressure-Time diagram for butt welding

- t1= Time requested for the bead formation with the specified wall thickness.
 - t2= Time requested for the continual heating
 - t3= Time requested for the change over
 - t4= Time requested for bringing up the pressure
 - t5= Time requested for cooling down
- P1 and P5= Pressure during the bead formation and the cooling down, this value is the result of the formula:
(Pipe section)cm²) x Material thrust coefficient) Kg/cm²) =bar
Total machine cylinders se



IMPORTANT: PULLING PRESSURE + PRESSURE ON DIAGRAM + WHILE ON WELDING PROCESS.
ÖNEMLİ: ÇEKME BASINÇ + ÇİZELGEDEKİ BASINÇ KAYNAK ANINDA UYGULANACAKTIR.

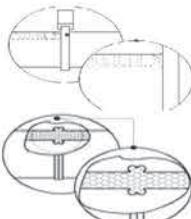
Kullanma Kılavuzu

ÖNEMLİ: ÇEKME BASINCI + ÇİZELGEDEKİ BASINÇ, KAYNAK ANINDA UYGULANACAK ÇEKME BASINCI:

Borular makinaya bağlandıktan sonra makinanın basıncı sıfırken makinanın ileri yürüyüş butonunu basılı tutunuz. Bu arada basıncı yavaş yavaş artırınız. Makina boruları çekmeye başladığında manometreye bakınız. Manometrede okuduğunuz basıncı makinanın çekme basıncıdır. Bu basıncada 5(beş) ile 10(on) bar ekleyerek tıraşma yapınız.

ISITMA İŞLEMİNDE BORUNUN KİMYASAL YAPISI

Isıtma işleminin ana prensibi iki yüzeyi de aynı sıcaklık seviyesinde eritmektir. Isıtma yapıılırken iki yüzeyde de aynı basıncı uygulanır. Bu basınç erimiş yüzeylerin dışarı çıkmasını sağlar. Buda erişmiş yüzeylerin birbirine karışımını sağlar. PE boru sisindiği zaman, moleküler yapı kristal yapıdan biçimsiz bir yapı haline dönüşür. Isıtma basıncı uygulandığı zaman iki borunun moleküler yapıları birbirine karışır. Ek yerleri soğudduğunda moleküler yapı kristal yapıya dönüşür. İki boru bir homojen boru haline gelir. Kaynatılmış borular kendisinden de çok daha güçlü olmaktadır.



Borular ısıtılmaya başlandığında moleküler yapı değişmeye başlar ve biçimsiz bir yapı alır.

Buda borunun erişmiş yüzeyini katlanabilir hale getirir.

Borular eridikten ve soğuduktan sonra tekrar kristal yapıya doğru dönüşüm başlar.
Buda bir tek homojen boru oluşmasını sağlar



Kaynak yapılan bölüm borunun kendisinden de güçlü olmaktadır.

Technical Information

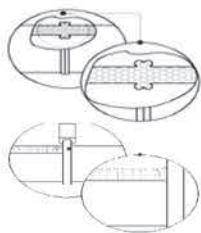
IMPORTANT: PULLING PRESSURE + PRESSURE ON DIAGRAM + WHILE ON WELDING PROCESS.

Pulling Pressure: After fit in the pipes into the machine, keep on pressing machine net button while pressure is zero. Bring the pressure up slowly. Check out the manometer when the machine start pulling the pipes. Manometer shows the pulling pressure. In this case add this pressure 5 or 10 bar and start the trimming process.

PIPES CHEMICAL STRUCTURE ON THE HEATING PROCESS

The principle of heat fusion is the heat two surface to a designed temperature and then fuse them together by application of force. This pressure causes flow of the melted materials. Which causes mixing of the melted materials. When the PE pipes is heated, the molecular structure is transformed from a crystalline state into a amorphous condition.

When fussion pressure is applied, the molecules from each pipe end mix. As the joint cools, the molecules return the their crystalline form, the two pipes have be come one homegeneous pipe. A fusion joint that is as strong or stronger than the pipe itself.



The pipe is being heated changing it's molecular structure to an amorphous state making it a very pliable material.

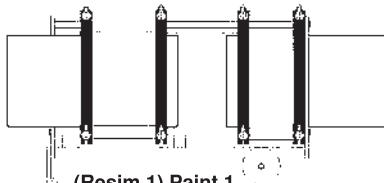
After pipe has been fused and is cooling it returns to crystalline structure creating one homogeneous pipe.

Fusion joint that is as strong as or stronger than the pipe itself.

Kullanma Kılavuzu

PLASTİK BORU ALIN KAYNAĞI NASIL YAPILIR?

Yapılacak bütün işlemlerin borular ekşenel olarak tutturulmalıdır.



(Resim 1) Paint 1

* Borular orta kelepçelerden ikişer cm ileride bağlanmalıdır. (Resim 1)

* Kelepçeler çok fazla sıkılmamalıdır.

* Tıraşlayıcı boruların arasına yerleştirip tıraşlamayı yapınız. (Tıraşlama yaparken yürüme basıncına 5 ile 10 bar ekleyerek tıraşlama yapılmalıdır.)

YÜRÜME BASINCININ MAKİNA ÜZERİNDE AYARLANMASI NASIL YAPILIR?

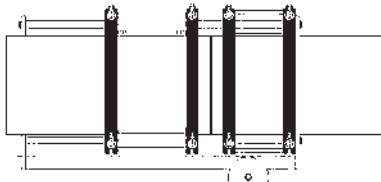
Borular makinaye bağlandıktan sonra, makinanın basıncı sıfırken makinanın ileri yürüyüş butonuna basılı tutunuz. Bu arada basıncı yavaş yavaş artırın. Makina boruları çekmeye başladığında manometreye bakınız. Manometrede okuduğunuz basınç makinanın yürüme basıncıdır. Bu basıncı 5(beş) ile 10(on) bar ekleyerek tıraşlama yapınız.

* Boruların etrafında tam bir tur çapak çıkışında tıraşlama işlemi bitmiş demektir.

* Tıraşlama işlemi bittiğinden sonra boruları alın alına getiriniz. Boruların birbirine tam olarak temas edip etmediğine bakınız. (Resim 2)

* Borular alın alına iken boruların eksenlerine bakınız. Borular eksende değilse orta kelepçelerden birini gevsetip diğerini sıkarak boruların eksenlerini ayarlayınız.

* Kaynak basıncını ayarlayınız.



(Resim 2) Paint 2

Technical Information

HOW WE MANAGE TO DO PLASTIC PIPE BUTT WELDING?

The pipe pieces are hold axially to allow all subsequent operations to take place.

*The pipe ends has to be hold 2 cm ahead from the middle clamps. (Paint 1)

*The force on the clamps must be constant.

*Fit in the facing tool between the two pipes and start to facing operation. (During the facing operations add to walking pressure 5 or 10 bar and keep on facing operation)

HOW DO WE SET TO THE WALKING PRESSURE ON THE MACHINE?

When the pipes are located on the machine, keep on press the machine next button when the pressure is zero. Meanwhile increase the pressure slowly. When the machine movable part start acting look at to manometer. The pressure on the manometer shows walking pressure. On this pressure add to 5 or 10 bar and start to trimming operation.

When the shavings from both sides will appear the facing operation is completed.

Check if the pipe ends are axially. If the pipes ends are not on the axis we must untight one of the middle clamps and tightening to other one and arrange to pipe axis (Paint 2)

Arrange the welding pressure.

KAYNAK BASINCININ MAKİNA ÜZERİNDE AYARLANMASI NASIL YAPILIR?

Kaynatacığınız borunun çapını, PN değerini çizelgeden bulunuz. Makinanın ileri yürüyüş butonuna sürekli basılı tutunuz. Borular alın alına geldiğinde manometrede yüreme basıncını göreceksiniz. Basınç regülatörü saat yönünde çevirerek çizelgedeki kaynak basıncı ne kadarsa, kaynak basıncını yüreme basıncına ekleyip basıncı ayarlayınız.

*Isıtıcı 220° C'ye ulaştığında ısıtıcıyı boruların arasına yerleştirip makinanın ileri yürüyüş butonuna sürekli basınız.

*Isıtıcının her iki tarafında dudak oluşana kadar bekleyiniz. Isıtıcının etrafında eriyen yüzey yükselmeye başlayacaktır. Yeterli dudak oluşunca hidrolik üniteden basıncı sıfırlayınız. (Basınç sıfırlama kolundan) Basıncı sıfırlandıktan sonra basınç sıfırlama kolunu sıkınız.

*Çizelgedeki t2 süresi kadar bekleyiniz.

*t2 süresi dolduğunda geri yürüyüş butonuna sürekli basarak makinayı açınız. Yanlışlıkla geri yerine ileri yürüyüş butonuna basarsanız, bütün işlemleri baştan yapmanız gerekmektedir.

*Hızlı bir şekilde ısıtıcıyı boruların arasından alıp makinanın ileri yürüyüş butonuna sürekli basarak boruları alın alına yapıştırınız. (Boruların erişmiş yüzeyleri birbirine iyice yaklaştırıldığında ileri yürüyüş butonuna ara ara basınız.)

Technical Information

HOW DO WE ARRENGE ON THE MACHINE WELDING PRESSURE?

Find from the diagram, diameter and PN value the pipe which you weld. Keep on pressing machine next button when the pipes became together, on the manometer shows the walking pressure. Turn up to pressure regulator on the time direction add the welding pressure to walking pressure and arrange to pressure.

*When the heating mirror archive the 220° C insert the heating mirror between two pipes and press on the machine next button.

*A melt pattern that penetrates into the pipe must be formed around both pipe ends. Turn the pressure zero from hydraulic unit. (By pressure handle) After bringing the pressure zero tighten to pressure handle.

*When until t2 period from the diagram.

*Open the machine by pressing the back button when the t2 period is finished. If you press the next button by mistake, you must have to repeat all the process.

*Take off the heating mirror and press the machine next button, pipe end come off the other pipe end. (When the pipes ends comes closer to each other ends, we must press machine next button step by step.

CNC MACHINE INSTRUCTION MANUAL



CNC plastic pipe butt-welding machine is operated in two ways: manually and CNC. Never use manual operating mode for the machine while operating in CNC mode!

CNC plastic pipe butt-welding machine is with touch screen.

Plug into the machine .

Above mentioned menu is shown on the screen.

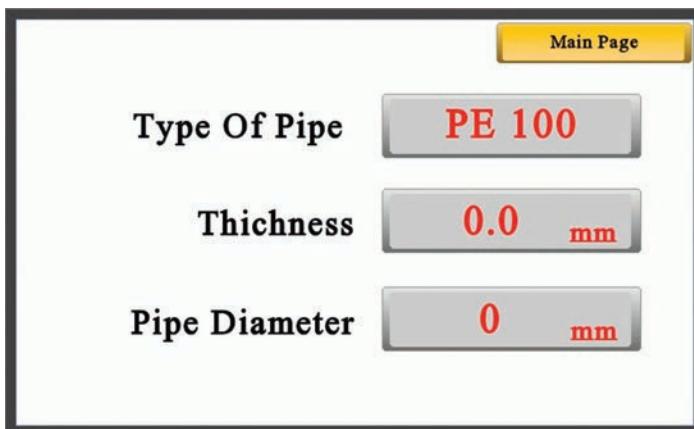
After the selection of language option, the screen shown below will be seen



- You can enter the name of the Project you will arrange on this screen by pressing the Project icon .
- You can see ambient temperature and pressure on this screen.
- Click on MAIN PAGE icon to weld.
- The screen below will be seen.



- Press PROGRAM icon to enter pipe values.
- The screen below will be seen.



- Enter type, wall thickness and external diameter of the pipe to be welded.
- You can alter the type of the pipe by pressing the icon next to PIPE TYPE.
- You can enter wall thickness by pressing the icon next to WALL THICKNESS.
- You can alter pipe diameter by pressing the icon next to PIPE DIAMETER.
- After entering all values, press MAIN PAGE icon.
- The screen below will be seen.



- Press AUTOMATIC icon.
- Values calculated by CNC machine will be seen.



- If pistons of the machine is forward, open machine pistons backwards by pressing BACKWARD icon.
- If machine pistons are not behind, do not start welding operation.
- Press START icon.
- The screen below will be seen.



- If pipe endings are not smooth, press RED icon.
- Place shaver between pipes.
- Do not activate shaver without placing shaver on the machine
- The screen below will be seen.



- Press SHAVER OPEN icon.
- Shaver will be activated and machine will be moved forward.
- Go on shaving process a complete tour on the pipe until plastic pipe burrs are seen.
- Press CLOSE SHAVING icon.
- The shaver will stop. Bring shaver into cabin.



- Bring pipes face to face after pressing FORWARD icon.
- Examine whether there is any space or not between pipes.
- If there is highness or lowness in the pipe axis, adjust axis by loosening one of jaw clamping stud and tightening the other one.
- Press START button.
- The screen below will be seen.



- When heater rises to $220\text{ }^{\circ}\text{C} \pm 10$, place heater between pipes.
- Press green icon.
- The screen below will be seen.



- CNC will calculate T1 duration based on the order of machine procedure, After the termination of T1 duration, the pressure will decrease automatically, afterward it will continue counting T2 duration.
- After duration of T2 is completed, piston will be opened backwards automatically.
- The screen below will be seen.



- Remove heater located between pipes immediately, pres GREEN icon.
- The screen below will be seen.



- T5 cooling period will begin.
- While cooling period continues, ERROR screen below will be seen when pressed STOP icon.
- Do not press STOP icon in the duration of T5 cooling period.



- The screen below will be seen in the termination of T5 period.



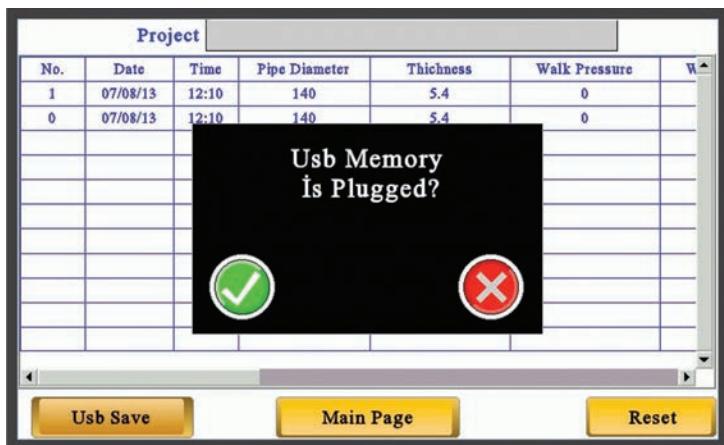
- You can demount pipes on the machine after the expiration of cooling period.
- IF YOU WANT TO BE MAKE RECORD
- The page below will be seen if pressed MAIN PAGE icon.



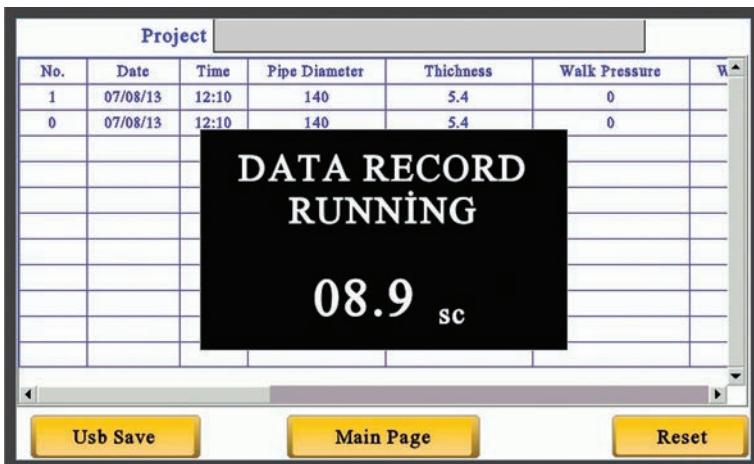
- Select RECORD icon.
- The page below will be seen.



- You can select whichever RECORD type you want.
- If you want to make USB RECORDING, select USB icon.
- The page below will be seen.
- The values of welding made will be seen on the screen.
- If you want to record, press USB RECORD icon.
- The screen below will be seen.



- Press Green icon.
- The screen below will be seen.

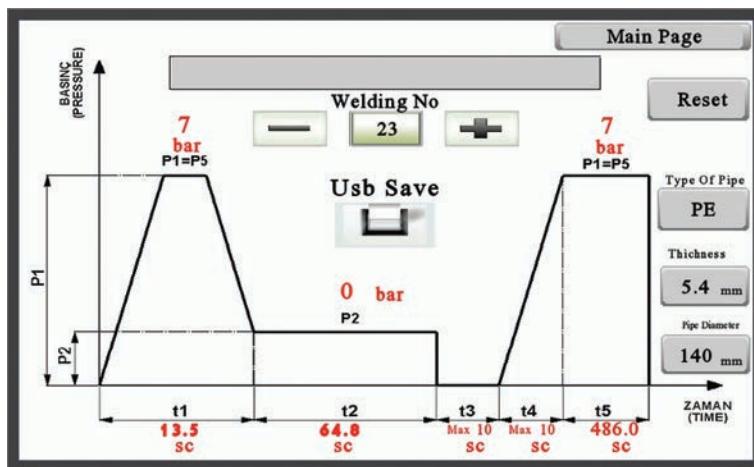


- After the duration expires, welding values obtained will be recorded to flash memory.
- If you want to delete welding values obtained, press RESET icon.
- The machine will be closed and opened automatically.

GRAPHIC RECORD PRINTING



- Press GRAPHIC icon to print graphics .
- The screen below will be seen.



- You can see last 25 welding data by pressing plus-minus icons.
- You can record visually the image on screen selected welding by pressing USB RECORD icon.
- Wait a minute for the recording period during recording.
- Press RESET icon to delete graphic records.

TABLE RECORD

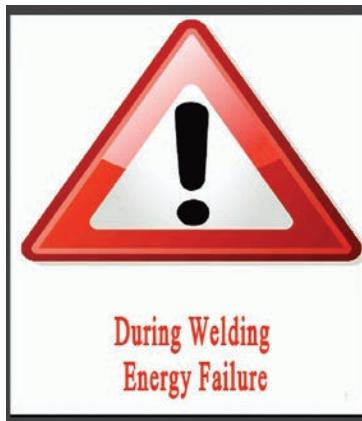
Borus Çapı	Et Kalınlığı	Yurume Basıncı	Kaynak Basıncı	Basınçlı Isıtma	Basınçsız Isıtma	Sogutma Süresi	Borus Cinsi
140 mm	5.4 mm	0 bar	7 bar	13.5 sc	64.8 sc	486.0 sc	1

Below the table are several icons representing different components of the welding machine. On the right side of the table, there are buttons for 'Usb Save' and 'Reset'. At the bottom of the page, there is contact information for TURAN MAKİNA METAL İŞİS GÜLTİC LTD ŞTİ.

- Press USB RECORD icon to record Usb.
- Wait a minute for the recording period during recording.
- Press RESET icon to delete recording.

ERROR ICONS

- The screen below will be seen in terms of energy cut during welding.
- Press any part of the screen to exit this screen.



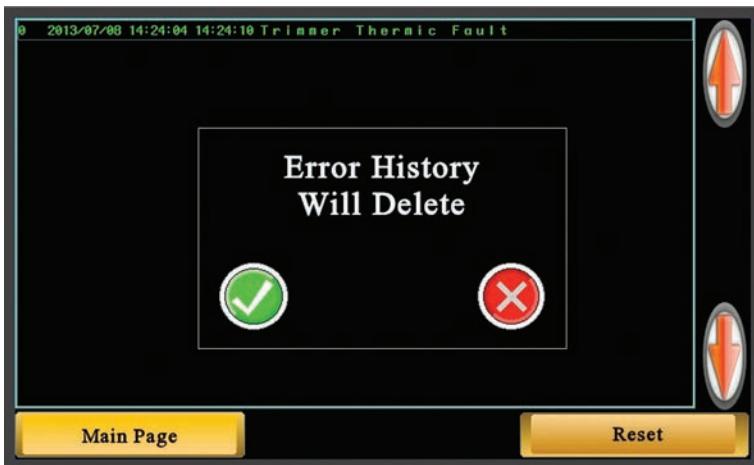
- Select ERROR icon on the MAIN PAGE to see all errors.



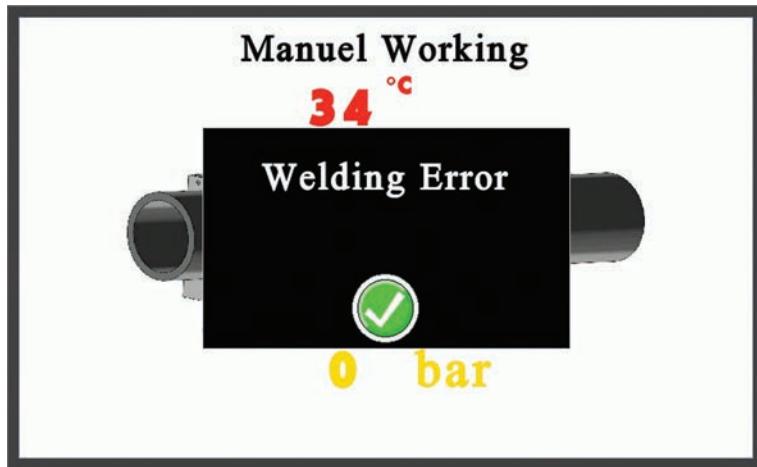
- The screen below will be seen if you select ERROR icon.



- To delete ERROR history select error on ERROR page and press RESET icon.
- The screen below will be seen.



- Press green icon.
- If manual mode is selected while machine is operated in CNC mode, the error screen below will be seen.

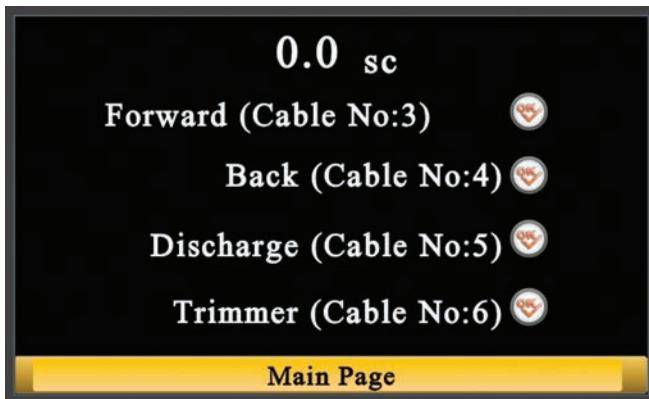


CONTROL CABLE TEST

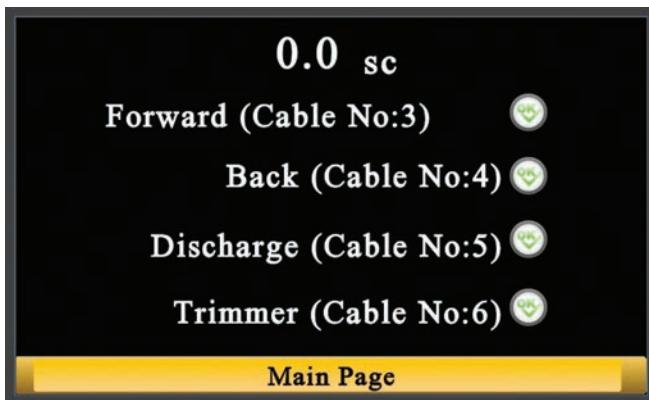
In order to make this operation, select CABLE TEST on the MAIN PAGE.



- The page below will be seen.



- Turn MANUAL OPERATING key on the control box.
- Press forward button for 3 seconds and wait for the termination of time. If it is solid, OK sign will turn green.
- The same application is valid for the solidity control of Backward, Discharge and Shaver buttons.
- The screen below will be shown.



MANUAL USAGE OF CNC MACHINE

- In case of emergency press EMERGENCY STOP button on control box. Machine will stop automatically.
- If you desire to pass to manual operation, turn MANUAL OPERATION key on control box.
- You can follow ambient temperature and pressure applied on the screen shown.

CNC MAKİNA KULLANMA TALİMATI



CNC plastik boru alın kaynak makinesi manüel ve CNC olarak iki şekilde çalışmaktadır.
CNC modda çalışırken , makineyi manuel çalışma moduna kesinlikle almayın !
CNC plastik boru alın kaynak makinesi dokunmatik ekranlıdır.
Makineyi fişe takın .
Yukarıdaki menü ekrana gelecektir.
Dil seçeneğini seçtiğden sonra aşağıdaki ekran karşınıza çıkacaktır.



- Bu ekranda yapacağınız projenin ismini PROJE ikonuna basarak girebilirsiniz.

- Ortam sıcaklığını ve basıncı bu ekrandan görebilirsiniz.
- Kaynak yapabilmeniz için ANASAYFA ikonuna tıklayınız.
- Aşağıdaki ekran karşınıza çıkacaktır.



- Boru değerlerini girmek için PROGRAM ikonuna basınız.
- Aşağıdaki ekran karşınıza çıkacaktır.



- Bu menüde kaynatacağınız boru cinsini , borunun et kalınlığını ve borunun dış çapını giriniz.

- Boru cinsini değiştirmek için BORU CİNSİ yanındaki ikona basarak değiştirebilirsiniz.
- Et kalınlığını girmek için ET KALINLIĞI yanındaki ikona basarak değiştirebilirsiniz.
- Boru çapını girmek için BORU ÇAPı yanındaki ikona basarak değiştirebilirsiniz.
- Bütün değerleri girdikten sonra ANASAYFA ikonuna basınız.
- Aşağıdaki ekran karşınıza çıkacaktır.



- OTOMATİK ikonuna basınız.
- CNC makine tarafından hesaplanan değerler karşınıza çıkacaktır.



- Eğer makinenin pistonları ilerideyse GERİ ikonuna basarak makinenin pistonlarını geriye doğru açınız.
- Makinenin pistonları geride değil ise kesinlikle kaynak işleme başlamayınız.
- START ikonuna basınız.
- Aşağıdaki ekran karşınıza çıkacaktır.



- Boru uçları düzgün değil ise KIRMIZI ikona basınız.
- Traşlayıcıyı boruların arasına yerleştiriniz.
- Traşlayıcıyı makinenin üzerine yerleştirmeden kesinlikle Traşlayıcıyı çalıştmayınız.
- Aşağıdaki ekran karşınıza çıkacaktır.



- TRAŞLAMA AÇ ikonuna basınız .
- Traşlayıcı çalışacak ve makine ileri doğru hareket edecektir.
- Boruların üzerinde tam bir tur plastik boru çapağı çıkana kadar Traşlama işlemeye devam ediniz.
- TRAŞLAMA KAPAT ikonuna basınız .
- Traşlayıcı duracaktır. Traşlayıcıyı kabine alınız.



- İLERİ ikonuna basarak boruları alın alına getiriniz.
- Boruların arasında herhangi bir boşluk olup olmadığına bakınız.
- Boruların eksenlerinde yükseklik veya alçaklık varsa çene sıkma saplamalarından birini gevsetip diğerini sıkarak eksenleri ayarlayınız.
- START tuşuna basınız.
- Aşağıdaki ekran karşınıza gelecektir.



Kullanma Kılavuzu - Technical Information

- Isıtıcı $220\text{ }^{\circ}\text{C} \pm 10$ geldiğinde , ısıtıcıyı boruların arasına yerleştiriniz.
- Yeşil ikona basınız.
- Aşağıdaki ekran karşınıza çıkacaktır.



- CNC makine prosedürdeki sıraya göre önce T1 süresini sayacaktır , T1 süresi bitiminde basınç kendiliğinden düşecektir , devamında T2 süreni saymaya başlayacaktır.
- T2 süresi bittiğinde piston otomatik olarak geriye açılacaktır.
- Aşağıdaki ekran karşınıza gelecektir.



- Hiç vakit kaybetmeden ısıtıcıyı boruların arasından alınız , YEŞİL ikona basınız.
- Aşağıdaki ekran karşınıza çıkacaktır.



- T5 soğuma süresi saymaya başlayacaktır.
- Soğuma süresi devam ederken STOP ikonuna bastığınızda aşağıdaki HATA ekranı karşınıza çıkacaktır.
- T5 soğuma süresi devam ederken STOP butonuna kesinlikle basmayınız.



- T5 süresi bittiğinde aşağıdaki ekran karşınıza çıkacaktır.



- Soğuma süresi bitiminde boruları makinenin üzerinden sökebilirsiniz.

KAYIT YAPMAK İSTİYORSANIZ

- ANASAYFA ikonuna basınca aşağıdaki sayfa karşınıza çıkacaktır.



- KAYIT ikonunu seçiniz.
- Aşağıdaki sayfa karşınıza çıkacaktır.



- İstedığiniz KAYIT şeklini seçebilirsiniz.
- USB KAYIT almak istiyorsanız USB ikonunu seçiniz.
- Aşağıdaki sayfa karşınıza çıkacaktır.

The image shows a table titled "Proje" with columns: No., Date, Time, Boru Çapı, Bt Kalınlığı, and Yürüme Basıncı. The table has a single row of data: No. 0, Date 06/13/13, Time 15:28, Boru Çapı 90, Bt Kalınlığı 5.4, and Yürüme Basıncı 0. Below the table are three buttons: "Usb Kaydet", "Ana Sayfa", and "Reset".

Proje					
No.	Date	Time	Boru Çapı	Bt Kalınlığı	Yürüme Basıncı
0	06/13/13	15:28	90	5.4	0

- Yapılan kaynakların değerleri ekranda olacaktır.
- Eğer kaydetmek istiyorsanız USB KAYDET ikonuna basınız.
- Aşağıdaki ekran karşınıza çıkacaktır.



- Yeşil ikona basınız.
- Aşağıdaki ekran karşınıza çıkacaktır.

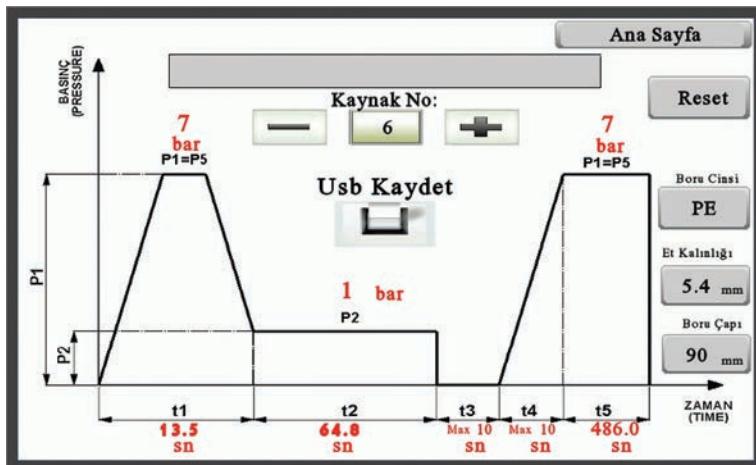


- Süre bittiğden sonra yapılan kaynak değerleri flash belleğe kayıt edilmiş olacaktır.
- Yapılan kaynak değerlerini silmek istiyorsanız RESET ikonuna basınız.
- Makine otomatik olarak kapanıp açılacaktır.

GRAFİK KAYIT ÇIKTI ALMA



- Grafik çıktısı almak için GRAFİK ikonuna basınız.
- Aşağıdaki ekran karşınıza çıkacaktır.



- Artı-Eksi ikonlarına basarak son 25 kaynak verilerine ulaşabilirsiniz.
- Seçtiğiniz kaynağı USB KAYDET ikonuna basarak ekrandaki görüntüyü görsel olarak kayıt yapabilirsiniz.
- Kayıt yaparken 1 dakika boyunca kayıt süresini bekleyiniz.
- Grafik kayıtlarını silmek için RESET ikonuna basınız.

TABLO KAYIT



- Usb kaydetmek için USB KAYDET ikonuna basınız.
- Kayıt yaparken 1 dakika boyunca kayıt süresini bekleyiniz.
- Kaydı silmek için RESET ikonuna basınız.

HATA İKONLARI

- Kaynak esnasında enerji kesildiğinde aşağıdaki ekran karşınıza çıkar.
- Bu ekranın çıkmak için ekranın herhangi bir yerine dokununuz.



Kullanma Kılavuzu - Technical Information

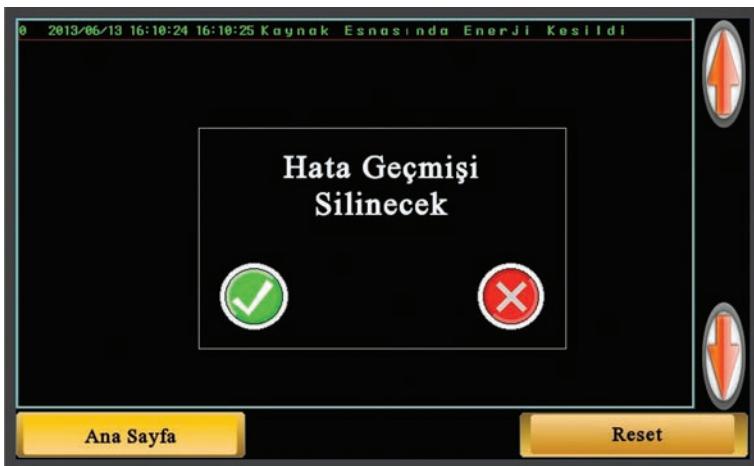
- Hataların tümünü görmek için ANASAYFA 'dan HATA ikonunu seçiniz.



- HATA ikonunu seçtiğinizde aşağıdaki ekran karşınıza çıkacaktır.



- Hata geçmişini silmek için HATA sayfasındaki hatayı seçerek RESET ikonuna basınız.
- Aşağıdaki ekran karşınıza çıkacaktır.



- Yeşil ikona basınız.
- Makineyi CNC modda çalıştırırken , Manuel moda alınırsa aşağıdaki hata ekranı karşınıza çıkacaktır.



KUMANDA KABLO TESTİ

- Bu işlemi yapabilmeniz için ANASAYFADA 'Kİ KABLO TESTİ ikonunu seçiniz.



- Aşağıdaki sayfa karşınıza çıkacaktır.



- Kumanda Kutusu üzerindeki MANUEL ÇALIŞMA anahtarını çeviriniz.
- İleri Butonuna 3 saniye basılı tutarak sürenin bitmesini bekleyiniz.
- Sağlamsa OK işaretü yeşile dönecektir.
- Geri , Boşaltma ve Traşlayıcı butonlarının sağlamlık kontrolünü aynı şekilde yapınız .
- Aşağıdaki ekran karşınıza çıkacaktır.



CNC MAKİNAYI MANUEL KULLANMA

- Acil bir durum olduğu zaman kumanda kutusu üzerindeki ACİL STOP butonuna basınız.
- Makine otomatik olarak duracaktır.
- Manuel çalışmaya geçmek istiyorsanız Kumanda Kusutu üzerindeki MANUEL ÇALIŞMA anahtarını çeviriniz.
- Açılan ekranda ortam sıcaklığını ve uygulanan basıncı takip edebilirsiniz.

ИНСТРУКЦИЯ ДЛЯ ИСПОЛЬЗОВАНИЯ МАШИНЫ СНС (СТАНОК С ЧПУ)



- CNC(СТАНОК С ЧПУ) сварочная машина с пластиковой трубой стыковой сварки работает в двух направлениях ручного и в режиме CNC (ЧПУ).
- Когда работа происходит в режиме CNC (ЧПУ), не подключайте ручной режим работы!
- CNC (ЧПУ) сварочная машина с пластиковой трубой стыковой сварки, имеет сенсорный дисплей, подключите в розетку.
- Вышеуказанное меню, появиться на экране .



- После выбора языка, появиться нижеуказанный экран.

- В этом экране, сделанное название проекта, Вы сможете записать с помощью нажатия кнопки ПРОЕКТ.
- Температуру окружающей среды и давление, Вы сможете увидеть на этом экране.
- Чтобы произвести сварку, кликните на значок ГЛАВНАЯ СТРАНИЦА.
- Появиться нижеуказанный экран..



- Для ввода данных трубы нажмите значок ПРОГРАММА.
- Появиться нижеуказанный экран.





Для ввода данных трубы нажмите значок ПРОГРАММА.
Появиться нижеуказанный экран.



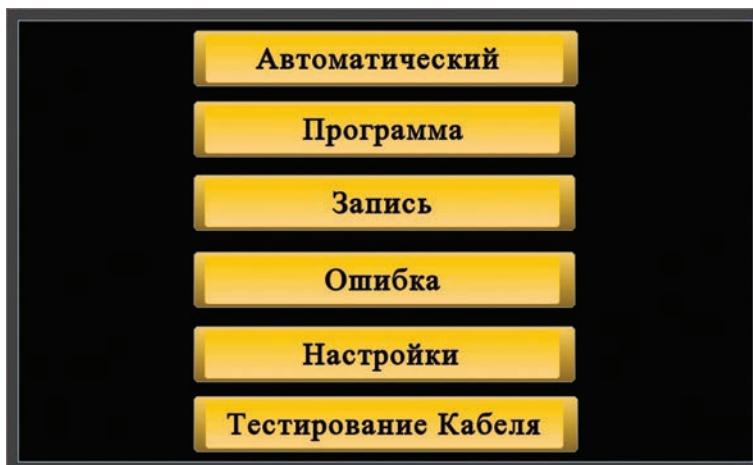
В этом меню Вы можете ввести, тип трубы, которую нужно сварить, толщину стенок трубы и внешний диаметр трубы.
Чтобы поменять тип трубы, достаточно нажать значок ТИП ТРУБЫ.

Для ввода толщины стенки трубы нажмите значок ТОЛЩИНА СТЕНКИ .

Для ввода диаметра трубы нажмите ДИАМЕТР ТРУБЫ.

После ввода всех данных нажмите значок ГЛАВНАЯ СТРАНИЦА.

Появиться нижеуказанный экран.



Нажмите АВТОМАТ.3

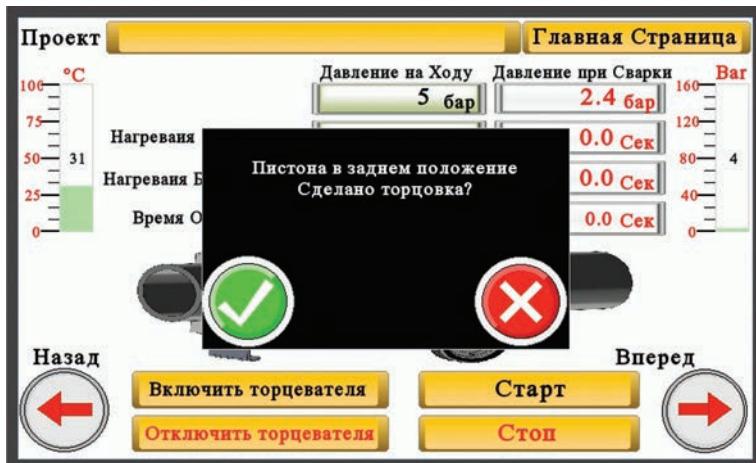
Появиться данные рассчитанные машиной СНС (ЧПУ)



Если поршни машины направлены вперед, нажатие на значок НАЗАД, это позволит поршни повернуть назад.

Если поршни машин направлены назад, безусловно не начинайте процесс сварки. Нажмите значок СТАРТ.

Появиться нижеуказанный экран.

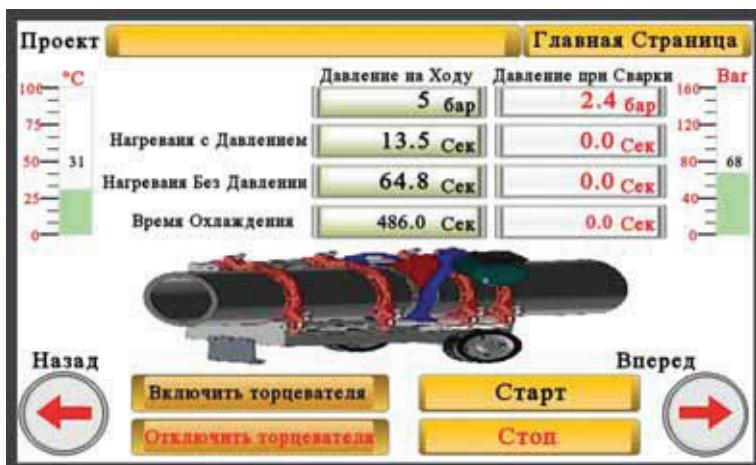


Если концы трубы не ровные, то нажмите значок КРАСНЫЙ.

Разместите триммер между трубами

Без размещения триммера на машине, безусловно, не подключайте триммер.

Появиться нижеуказанный экран



Нажмите на значок ВКЛЮЧИТЬ ТРИММЕР.

Триммер будет работать, и машина будет двигаться вперед.

До того времени, когда на трубах появиться одна окружность отходов, продолжайте процесс сбивания.

Нажмите ОТКЛЮЧЕНИЕ ТРИММЕРА.

Триммер остановиться. Заберите триммер в кабину.



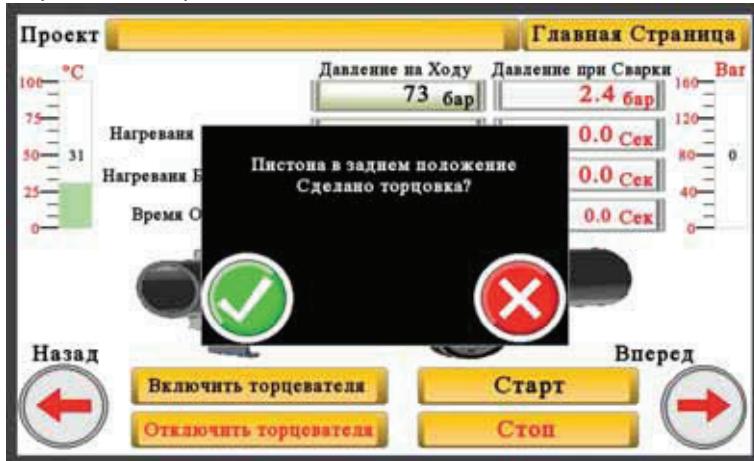
При нажатии значка ВПЕРЕД, соедините трубы одна к одной.

Проверьте, есть ли расхождения между трубами.

Если трубы не равномерны, то один из захватных аппаратов ослабьте, а другой наоборот усильте, т. е установите правильный диаметр.

Нажмите значок СТАРТ.

Появиться нижеказанный экран.



Когда нагреватель показывает $220^{\circ}\text{C} \pm 10$, разместите нагреватель между трубами.
Нажмите зелёный значок.

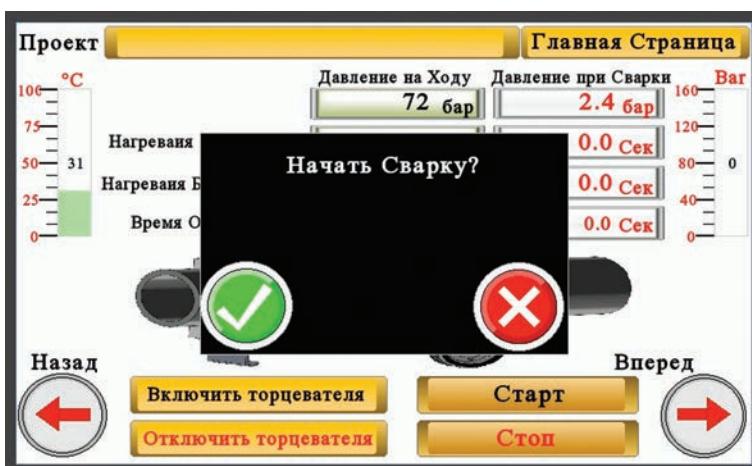
Появиться нижеуказанный экран



По порядку машинной процедуры, CNC (ЧПУ) сначала посчитает время T1, затем после окончания времени T1, давление снизиться само, в продолжении процесса ЧПУ начинает считать время T2 .

Когда закончиться время T2, поршень автоматически направляется назад .

Появиться нижеуказанный
экран.



Не теряя времени, верните обратно нагреватель, размешённый между трубами, нажмите значок ЗЕЛЕНЫЙ.

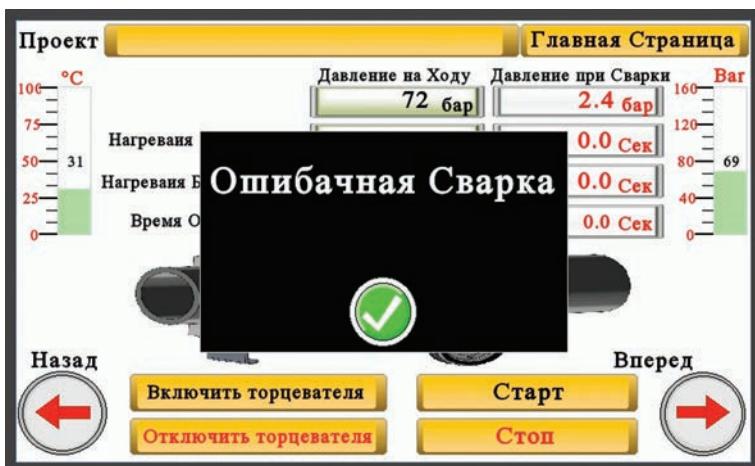
Появиться нижеуказанный экран.



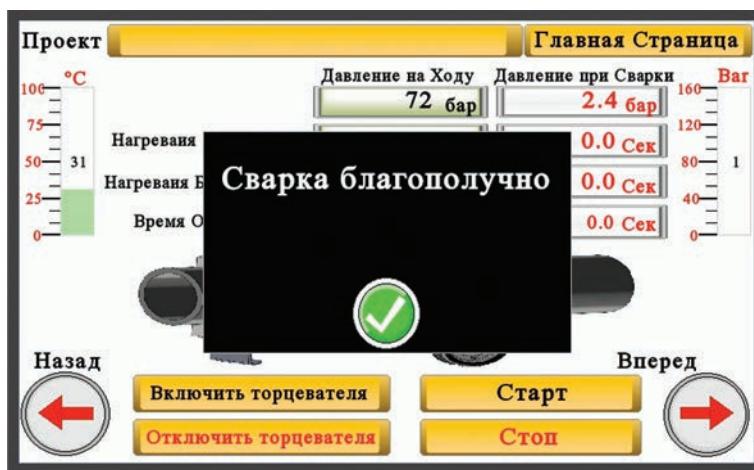
T5 начнет рассчитывать время охлаждения

Когда продолжиться время охлаждения и при нажатии значка СТОП, на нижеуказанном экране, появиться ошибка.

Когда продолжается время охлаждения T5, не нажимайте кнопку СТОП



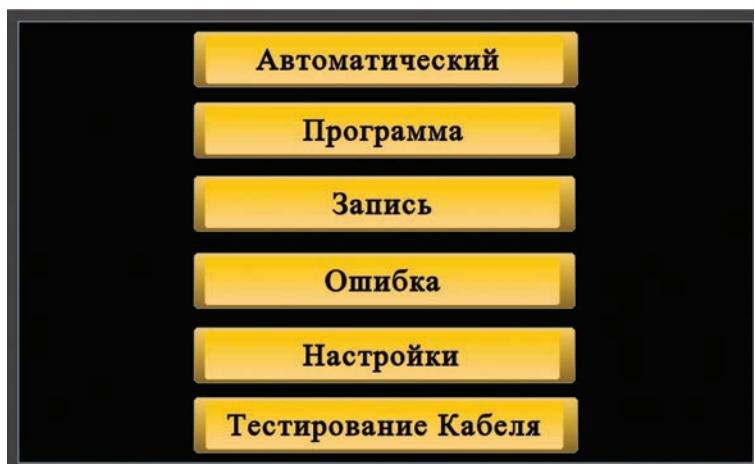
Когда заканчивается время T5, появиться нижеуказанный экран.



Когда заканчивается время охлаждения, уберите трубы с машины.

ЕСЛИ ВЫ ХОТИТЕ СДЕЛАТЬ ЗАПИСЬ

При нажатии значка ГЛАВНАЯ СТРАНИЦА, появится нижеуказанная страница.



Выберете значок ЗАПИСЬ.

Появиться нижеуказанная страница.



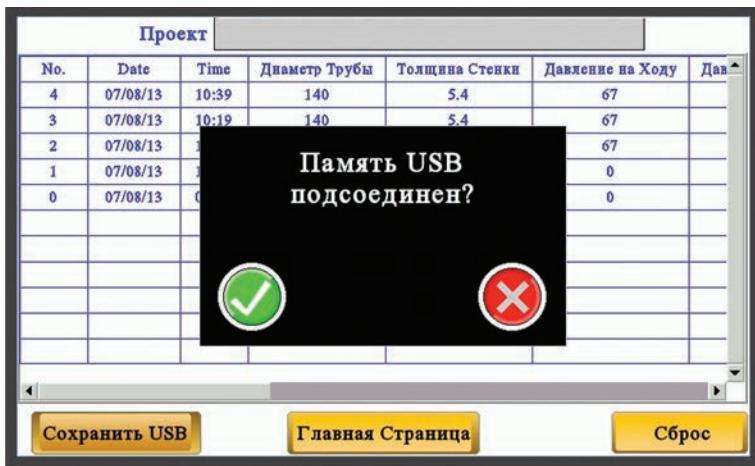
Вы можете выбрать форму записи, которую захотите.
Если вы хотите записать USB запись, нажмите на значок USB.
Появиться нижеуказанная страница.

No.	Date	Time	Диаметр Трубы	Толщина Стенки	Давление на Ходу	Дав...
4	07/08/13	10:39	140	5.4	67	
3	07/08/13	10:19	140	5.4	67	
2	07/08/13	10:09	140	5.4	67	
1	07/08/13	10:06	140	5.4	0	
0	07/08/13	09:59	140	5.4	0	

Сохранить USB Главная Страница Сброс

Значения сделанной сварки, выходят на экран.

Если вы хотите записать, нажмите на значок USB запись.
Появиться нижеуказанный экран.



Нажмите зеленый значок.
Появиться нижеуказанный экран.

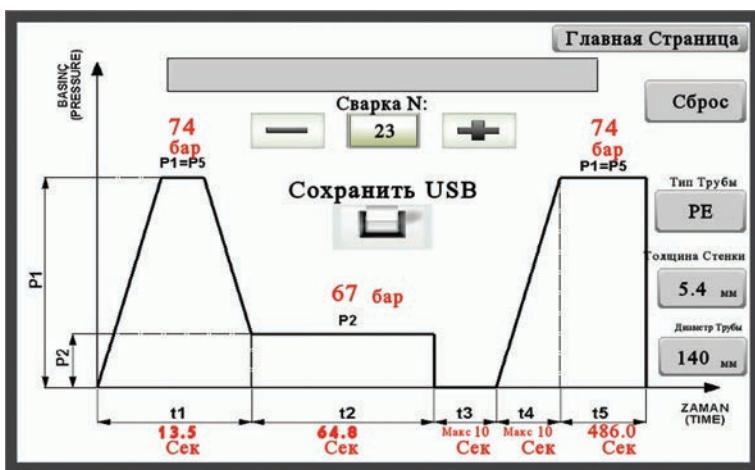


После окончания времени, сделанные значения сварки, записываются на флеш-карту.
Если Вы хотите удалить сделанные значения сварки, нажмите RESET.
Машина автоматически перезагрузится.

РАСПЕЧАТКА ЗАПИСЕЙ ГРАФИКОВ



Чтобы получить распечатку графиков, нажмите на значок ГРАФИК. Появиться нижеуказанный экран.



При нажатии значений Плюс Минус, Вы можете достичь последних 25 данных.
При нажатии USB ЗАПИСЬ, вы сможете визуально записать изображения в экране.
При исполнении записи, подождите время записи, в течении одной минуты.
Чтобы удалить данные графика, нажмите RESET.

ЗАПИСЬ ТАБЛИЦЫ



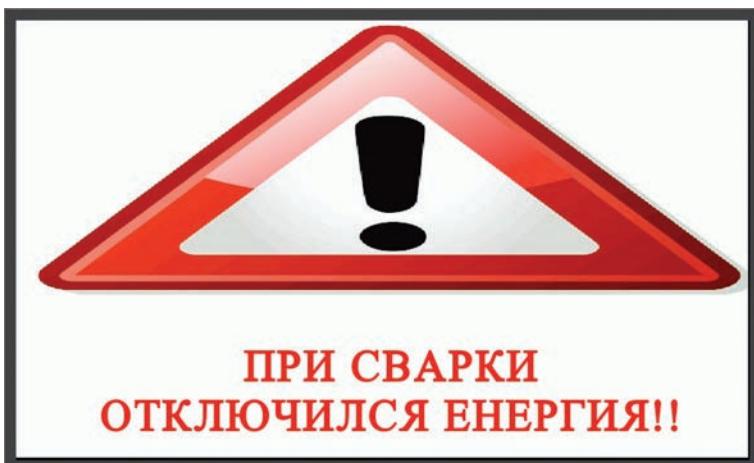
Чтобы записать на USB, нажмите значок USB запись.

При исполнении записи, подождите время записи, в течении одной минуты.

Чтобы удалить запись, нажмите RESET.

ЗНАЧКИ ОШИБКИ

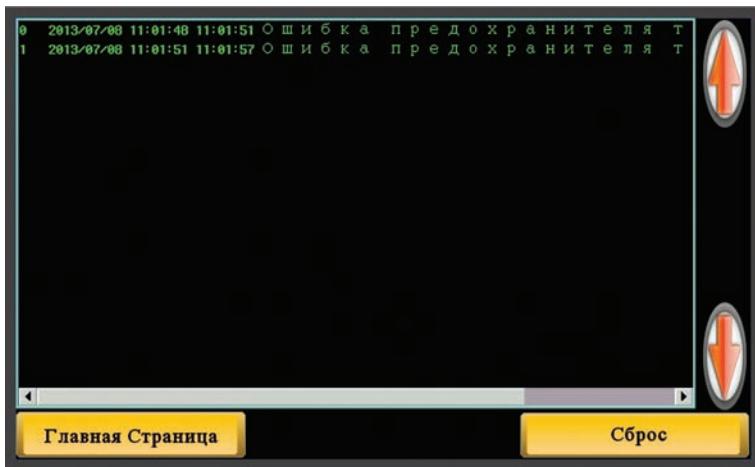
При исполнении сварки, когда прекращается энергия, появиться нижеуказанный экран.
Чтобы выйти из этого экрана, дотроньтесь до любого места экрана.



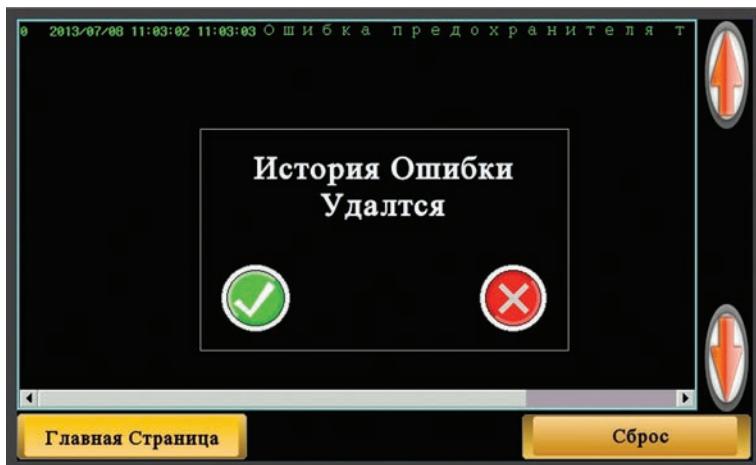
Чтобы увидеть все ошибки, выберете значок ОШИБКА из ГЛАВНОЙ СТРАНИЦЫ.



При выборе значка ОШИБКА, появиться нижеуказанный экран.



Чтобы очистить историю ошибок, в странице ОШИБКА, выберете ошибку и нажмите RESET. Появиться нижеуказанный экран.



Нажмите зеленый значок.

Если при работе машины в режиме CNC (ЧПУ), сделать ручной режим, то появится нижеуказанная ошибка.



ТЕСТ КАБЕЛЬНОГО УПРАВЛЕНИЯ

Чтобы исполнить этот процесс, выберете значок ТЕСТ УПРАВЛЕНИЯ в ГЛАВНОЙ СТРАНИЦЕ.



Появиться нижеуказанная страница.



На блоке управления поверните ключ РУЧНАЯ РАБОТА.

Удерживайте кнопку ВПЕРЕД 3 секунды и ждите окончания времени. Если все в порядке, то значок ОК становится зеленым.

Контроль неповрежденности кнопок Назад, Выполнить и Триммер.

Появиться нижеуказанный экран.



ИСПОЛЬЗОВАНИЕ МАШИНЫ СНС (ЧПУ) В РУЧНОМ РЕЖИМЕ

Когда возникает чрезвычайная ситуация, нажмите кнопку АВАРИЙНАЯ ОСТАНОВКА, которая находится на блок-контроле. Машина автоматически остановится.

Если Вы хотите перейти в ручной режим, поверните ключ РУЧНАЯ РАБОТА, который находится на блок-контроле.

В открывающемся экране, Вы сможете отследить температуру окружающей среды и примененное давление.

ت عل ي مات اس ت خدام ما كي نه س ي ان س ي



م ي دوي بمدخل انابيب و س ي ان س ي.
الماكينة نهائى اللى وضع اليدوى. خلال العمل فسي وضع عية س ي ان س ي، يجوب عدم تغىير وضع عية
تىكى يمتلك شاشة تعمل باللمس. لاسماكينة س ي ان س ي لحام يودى مدخل انبوب ب
وصيل الماكينة بامكبس.
ر القائمه التي أعلان في الشاشة. سوف يظهر
عد اختيار اللعنة سوف تظاهر الشاشة التي ادن اداب



- ممكن عليكم ادخال اسم المشروع الذي سيتم تنفيذه بالضغط على زر (المشروع)

- الشاشة يمكن رؤية ضغط حرارة المحيط في هذه حتي يمكن عمل الدحام يجب الضغط على زر (الدريسيه)
- سوف تظهر الشاشة التي ادناء



- اضغط على زر (برنامجه) حتى يمكن ادخال قيم الانبوب.
- سوف تظهر الشاشة التي ادناء.



- في هذه القائمة ادخل هنا القطر الخارجي للأنبوب، و سمكن الانبوب، و نوع الانبوب الذي يقونه التي بجانب (نوع لتخفيض نوع الانبوب يمكن تنفيذه عبر الضغط على الـ (انبوب))

- لادخال السmek يمكّن التغّيير بالضغط على الایقونة التي بجانب زر (السمك) لادخال قطر الانبوب يمكن التغّيير بالضغط على الایقونة التي بجانب زر (قطر الانبوب)
- يم يجّب الضغط على يتم الضغط على (الرئيسي) (بعد ادخال جميع القيم سوف تظهر الشاشة التي ادناه)



- اضغط على ور (الاوتوماتيك) سوف يظهر في الشاشة القيم التي تم حسابها من قبل ماكينة سي ان سي



- اذا كان مكابس الالة في الامام، اضغط على زر (خلف) حتى يتم سحب مكابس الماكينة الى الخلف

- إذا كان مكابس الماكينة في الخلف، لا يجب نهائياً البدء في عملية اللحام.
- اضغط على زر البدء (Start).
- سوف تظهر الشاشة التي أدناه.



- يمكن اطراف الانابيب متتساوية ففيجب الضغط على الزر (الاحمر).
- وضع الحلقات ما بين الانابيب.
- لا تزيل الحلقات نهائياً قبل وضعه على الماكينة.
- شاشة التي أدناه سوف يظهر الشاشة.



- اضغط على زر (افتح الحلقات).

- سوف يشتغل الحلق والماكينة سوف تتحرك الى الامام والى الخلف
- استهرب بعملية الحلق حتى تظهر قشرة انبوب قبل اسقاطها كاملاً فوق الانابيب
- اضغط على زر ايقاف الحلق
- سوف يقف الحلق. خذ الحلق الى الكابين.



- الامام (لتأتي الانابيب بجانب بعض اضغط على زر).
- انظر لعدم وجود اي مسافة ما بين الانابيب.
- اذا تواجد اي ارتفاع او انخفاض في محاور الانابيب، قم بارتفاع المحاور عبر الشد على الامر المشبك وتخفيض المنساب.
- اضغط على زر (البدء)
- سوف تأتي الشاشة التي ادنى



- درجة مئوية، اعلى او اقل 10 درجات، ضع السخان ما بين عندهما تأتي الشخان الى الانابيب
- اضغط على الزر الاخضر
- سوف تظهر الشاشة التي أدناه



- سوف تبدأ مراحل ماكينة سبيسيالتى تمر بمرحلة ت1 سوف تبعد، سوف تختفي الضغط في نهاية مرحلة ت1، وفي متابعته سوف يبدأ مرحلة ت2 بالعداء مرحلة ت2، سوف تفتح المكبس في اتجاه خلفي تلقائيًا عند انتهاء مرحلة ت2.
- سوف تظهر الشاشة التي أدناه



- ضع الشخان ما بين الانابيب بدون تضييع اي وقت، اضغط على الزر (الأخضر) سوف تظهر الشاشة التي أدناه



- سوف تبدأ مرحلة ت5 للاستبriد بالعدد 8.8
- خلال استمرار مرحلة الاستبriد، عند الضغط على زر (قف) (سوف تظهر شاشة) الخطأ (التي أدناه).
- لـ تضغط نهائيا على زر (قف) (خلال مرحلة ت5 للاستبriد)



- عند انتهاء مرحلة ت5 سوف تظهر الشاشة التالية



- يمكن فك الابناب من على الماكينة عند انتهاء مرحلة التبريد.



- في حالة ارادة التسجيل •
- عند الضغط على زر (البرئيسي) سوف تظهر الشاشة أدناه



- اختر زر (التسجيل) •
- سوف تظهر الشاشة أدناه.



- يمكن اختيار شكل التسجيل •
- ان كنت تري دخذ التسجيل من يو اس بي، اختر ايقونة (يو او بي بي) •
- من الشاشة أدناه سوف تظ

- سوف تظهر قيم اللحام المنفذ في الشاشة.
- ان كنت تري داتس جيل، اضغط على زر (اتسجيل) و اس بي (S).
- سوف تظهر الشاشة التي ادن اه



- اضغط على الزر الاخضر
- سوف تظهر الشاشة التي ادن اه

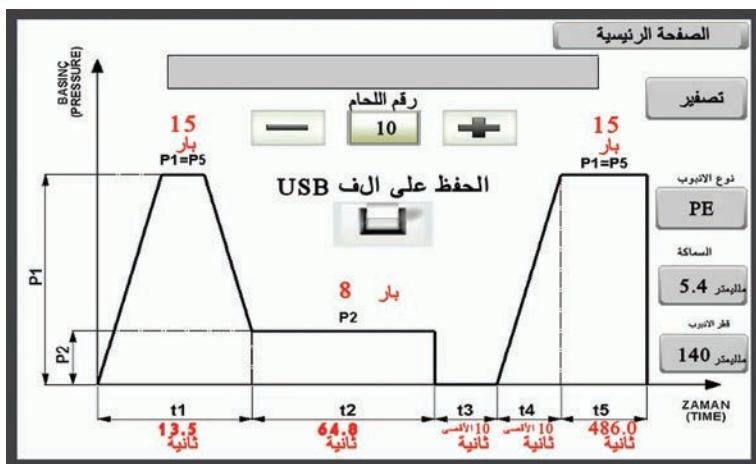


- بعده انتها الفترة سوف يتم تسجيل قيم اللحام في الـ USB
- نلعن ترتيد حذف قيم اللحام المنسف، اضغط على زر (اعادة تعيين) (ا)
- سوف تتفق فل و تشغيل الحذار تلقائيا

طباعة السجل المرئي)



- للحصول على طباعة مرئية اضغط على ايقونة (مرئي).
- سوف تظهر الشاشة التي أدناه



Boru Çapı	Et Kalınlığı	Yükleme Sıcaklığı	Kaynak Basıncı	Basınçlı Isıtma	Basınçsız Isıtma	Soğutma Süresi	Boru Cinsi
140	5.4	8	15	13.5	64.8	486.0	1

الحفظ على الف USB

تصدير

TURAN MAKİNA METAL İŞLETİMİ LTD.ŞTİ.
Şenay Mah. Orhanlı Yolu Cad. Mezarlık Sk. No:6 KURTÖY/PEŞEMEK
İSTANBUL-TÜRKİYE

الصفحة الرئيسية

Telefon: +90 (216) 595 07 51 / Fax: +90 (216) 595 07 71

- ل ال اي قيم 25 لحام الاخيرة. وصوبالضغط على ايقونات الموجب والسلبي يمكن ان يمكّن ال التسجيل المرئي لشكل الذي في الشاشة عبر الضغط على ايقونة يو اس بي.
- يمكّن التسجيل المرئي للحام المختار.
- خلال التسجيل ان تنظر لطول فترة 1 دقايقة.
- لمسح سجلات المرئي، اضغط على ايقونة اعادة التسجيل.

تسجيـل الـجدول



- ة (تسجيـلـيـوـاـسـبـيـلـيـوـاسـبـيـاضـغـطـعـلـيـايـقـونـ) لـتـسـجـيلـيـوـاـسـبـيـلـيـوـاسـبـيـاضـغـطـعـلـيـايـقـونـ خـلـالـاـلـتـسـجـيلـيـلـانـتـظـرـلـطـوـالـفـتـرـةـ 1ـ دـقـيـقـةـ
- لـمـسـحـالـسـجـلـ،ـاضـغـطـعـلـيـايـقـونـةـاعـادـةـالـتـسـجـيلـ



(ايقونة الخطأ)

- سـوفـتـظـهـرـالـشـاشـةـالـتـيـادـنـاـهـفـايـحـالـةـانـقـطـاعـالـطـاـقـةـخـلـالـالـلـحـامـ لـلـخـرـوجـمـنـهـذـهـالـشـاشـةـاضـغـطـعـلـيـايـجـزـءـمـنـالـشـاشـةـ.



- لؤيّة الأخطاء بأكمله، اضغط على ايقونة خطأ (من الرئيسيّة).



- عند اختيار ايقونة خطأ (خطأ) سوف تظهر الشاشة أدناه.



- يار الخطأ في صفحة لمس حماضي الخطأ، اضغط على زر (إعادة التعريف) (الرئيسي) .
- اه. سوف تظهر الشاشة التي أدن



- لزر الأخضر. اضغط على ١



- سوف تظهرشاشة خلال عمل الماكينة في وضع سي ان سي، اذا تم نقلها الي وضع يدوي بالخطا الاتي ادناه.



كابل البت حكم اختبار

حتى يمكن عليكم القيام بهذه العملية، اختر اي قونة (اخبار السلك) الذي في (الرئيسي سيارة)

تخدام ماكينه سي ان سي يدوي (اس

- في حالة الطوارئ، اضغط على زر ايقاف طارئ (والذي على صندوق البت حكم ان كنت تريده ان تقال الي التشغيل الي دوي، لف مفتاح) الا تشغيل الي دوي (والذي فوق صندوق البت حكم يمكنه اتباعه الضغط المنفذ و حرارة المحيط في الشاشة المفتوحة

TECHNICAL INFORMATION

- t1:** Basıncılı ısıtma yaparken oluşacak dudak kalınlığı için gereken zaman.
 - t2:** Basıncısız ısıtma için gereken zaman.
 - t3:** Isıtıcıyı boruların arasından alma zamanı.
 - t4:** Basıncı artırma zamanı.
 - t5:** Kaynak yapılan boruların soğumaya bırakıldığı zaman.
- P1:**Dudak kalınlığı için gereken basınç.
- P2:**Devamlı ısıtma için gereken basınç
- P5:**Soğuma esnasında gereken basınç.

- t1:** Required time for the lips at the pressure heating moment.
 - t2:** Required time for the heating without pressure.
 - t3:** Required time to taking the heater from pipes.
 - t4:** Pressure increase time.
 - t5:** After welding cooling time.
- P1:** Required time for the lips.
- P2:** Required pressure for increasing heating.
- P5:** At the cooling time required pressure.

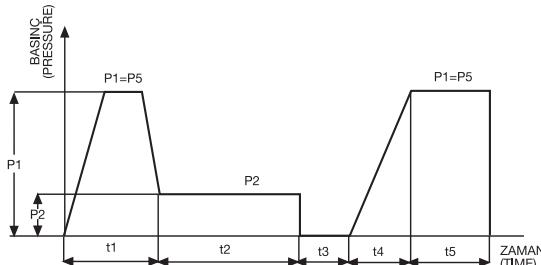
250-315-400-500
KAYNAK MAKİNALARININ
PARAMETRE ÖLÇÜLERİ

250-315-400-500
MACHINE PRESSURE
AND TIME PARAMETERS

MALZEME/MATERIAL PE 100			SDR 41 PN 4		Silindir alanı/Cylinder area 14.13 cm ²				
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
75	1,8	0,5	0,7	25 sn/sec	5	10	3	3	
90	2,3	1	0,7	30 sn/sec	5	10	3	4	
110	2,7	1	0,8	35 sn/sec	5	10	4	5	
125	3,1	2	0,8	40 sn/sec	5	10	5	6	
140	3,5	2	0,9	45 sn/sec	5	10	5	6	
160	4,0	2	0,9	50 sn/sec	5	10	6	7	
180	4,4	3	0,9	55 sn/sec	5	10	7	8	
200	4,9	3	1,0	1 dk/min	5-6	10	7	9	
225	5,5	4	1,1	1.10 min/sec	5-6	10	8	10	
250	6,2	5	1,1	1.15 min/sec	5-6	10	9	11	
280	6,9	7	1,2	1.20 min/sec	5-6	10	10	12	
315	7,7	8	1,3	1.30 min/sec	6-8	10	12	13	
355	8,7	10	1,4	1.45 min/sec	6-8	10	13	15	
400	9,8	13	1,5	2 dk/min	6-8	10	15	17	
450	11,0	15	1,6	2.15 min/sec	6-8	10	17	19	
500	12,3	20	1,7	2.30 min/sec	8-10	10	18	21	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 33 PN 5		Silindir alanı/Cylinder area 14.13 cm ²				
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
75	2,3	1	0,7	30 sn/sec	5	10	3	4	
90	2,8	1	0,8	35 sn/sec	5	10	4	5	
110	3,4	2	0,8	45 sn/sec	5	10	5	6	
125	3,9	2	0,9	50 sn/sec	5	10	6	7	
140	4,3	2	0,9	55 sn/sec	5	10	6	8	
160	4,9	3	1,0	1 dk/min	5-6	10	7	9	
180	5,5	3	1,1	1.10 min/sec	5-6	10	8	10	
200	6,2	4	1,1	1.15 min/sec	5-6	10	9	11	
225	6,9	5	1,2	1.25 min/sec	5-6	10	10	12	
250	7,7	6	1,3	1.30 min/sec	6-8	10	12	13	
280	8,6	8	1,4	1.45 min/sec	6-8	10	13	15	
315	9,7	10	1,5	2 dk/min	6-8	10	15	17	
355	10,9	13	1,6	2.15 min/sec	6-8	10	16	19	
400	12,3	16	1,7	2.30 min/sec	8-10	10	18	21	
450	13,8	20	1,9	2.45 min/sec	8-10	10	21	24	
500	15,3	25	2,0	3 dk/min	8-10	10	23	27	

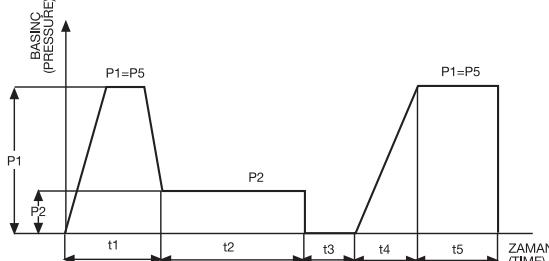
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 100			SDR 26 PN 6		Silindir alanı/Cylinder area 14.13 cm ²				
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	mm	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
75	2,9	1	0,8	35 sn/sec	5	10	4	5	
90	3,5	1	0,8	40 sn/sec	5	10	5	6	
110	4,2	2	0,9	50 sn/sec	5	10	6	7	
125	4,8	2	1,0	55 sn/sec	5-6	10	7	8	
140	5,4	2	1,0	1 dk/min	5-6	10	8	9	
160	6,2	3	1,1	1.10 min/sec	5-6	10	9	10	
180	6,9	4	1,2	1.20 min/sec	5-6	10	10	11	
200	7,7	5	1,2	1.30 min/sec	6-8	10	11	13	
225	8,6	6	1,3	1.40 min/sec	6-8	10	12	14	
250	9,6	7	1,4	1.50 min/sec	6-8	10	14	16	
280	10,7	10	1,5	2 dk/min	6-8	10	15	18	
315	12,1	12	1,6	2.20 min/sec	8-10	10	17	20	
355	13,6	15	1,8	2.35 min/sec	8-10	10	19	22	
400	15,3	20	2,0	3 dk/min	8-10	10	22	25	
450	17,2	25	2,1	3.15 min/sec	8-10	10	24	28	
500	19,1	30	2,3	3.40 min/sec	10-12	10	27	31	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 21 PN 8		Silindir alanı/Cylinder area 14.13 cm ²				
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	mm	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
75	3,6	1	0,9	45 sn/sec	5	10	5	6	
90	4,3	2	0,9	55 sn/sec	5	10	6	8	
110	5,3	2	1,0	1.5 min/sec	5-6	10	8	9	
125	6	3	1,1	1.15 min/sec	5-6	10	9	11	
140	6,7	3	1,2	1.20 min/sec	5-6	10	10	12	
160	7,7	4	1,3	1.30 min/sec	6-8	10	12	13	
180	8,6	5	1,4	1.45 min/sec	6-8	10	13	15	
200	9,6	6	1,5	2 dk/min	6-8	10	14	17	
225	10,8	8	1,6	2.10 min/sec	6-8	10	16	19	
250	11,9	9	1,7	2.25 min/sec	6-8	10	18	21	
280	13,4	12	1,8	2.40 min/sec	8-10	10	20	23	
315	15,0	15	2,0	3 dk/min	8-10	10	23	26	
355	16,9	20	2,2	3.25 min/sec	8-10	10	25	29	
400	19,1	25	2,4	3.50 min/sec	10-12	10	29	33	
450	21,5	30	2,7	4.20 min/sec	10-12	10	32	37	
500	23,9	38	2,9	4.40 min/sec	10-12	10	36	41	

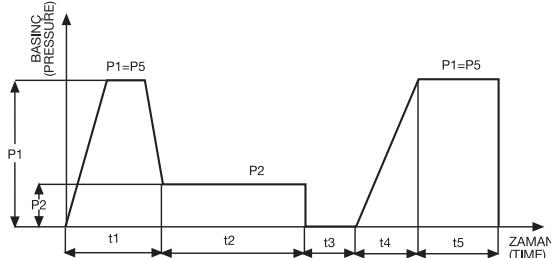
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 100			SDR 17 PN 10		Silindir alanı/Cylinder area 14.13 cm ²				
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
75	4,5	1	1,0	55 sn/sec	5	10	7	8	
90	5,4	2	1,0	1.5 sn/sec	5-6	10	8	10	
110	6,6	2	1,2	1.20 sn/sec	5-6	10	10	12	
125	7,4	3	1,2	1.40 sn/sec	6-8	10	11	13	
140	8,3	4	1,3	1.50 sn/sec	6-8	10	12	14	
160	9,5	5	1,5	2 dk/min	6-8	10	14	16	
180	10,7	6	1,6	2.10 min/sec	6-8	10	16	19	
200	11,9	8	1,7	2.25 min/sec	6-8	10	18	21	
225	13,4	10	1,8	2.40 min/sec	8-10	10	20	23	
250	14,8	12	2,0	3 dk/min	8-10	10	22	25	
280	16,6	15	2,2	3.20 min/sec	8-10	10	25	29	
315	18,7	20	2,4	3.45 min/sec	8-10	10	28	32	
355	21,1	25	2,6	4.15 min/sec	10-12	10	32	36	
400	23,7	30	2,9	4.45 min/sec	10-12	10	36	41	
450	26,7	40	3,2	5.20 min/sec	12-16	10	40	46	
500	29,7	50	3,5	6 dk/min	12-16	10	45	51	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 13,6 PN 12.5		Silindir alanı/Cylinder area 14.13 cm ²				
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	mm	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
75	5,6	1	1,1	1.10 min/sec	5-6	10	8	10	
90	6,7	2	1,2	1.20 min/sec	5-6	10	10	12	
110	8,1	3	1,3	1.45 min/sec	6-8	10	12	14	
125	9,2	4	1,4	1.50 min/sec	6-8	10	14	16	
140	10,3	5	1,5	2.5 min/sec	6-8	10	15	18	
160	11,8	6	1,7	2.25 min/sec	6-8	10	18	20	
180	13,3	8	1,8	2.40 min/sec	8-10	10	20	23	
200	14,7	9	2,0	3 dk/min	8-10	10	22	25	
225	16,6	12	2,2	3.20 min/sec	8-10	10	25	29	
250	18,4	15	2,3	3.40 min/sec	8-10	10	28	32	
280	20,6	18	2,6	4.10 min/sec	10-12	10	31	35	
315	23,2	23	2,8	4.40 min/sec	10-12	10	35	40	
355	26,1	30	3,1	5.15 min/sec	12-16	10	39	45	
400	29,4	35	3,4	6 dk/min	12-16	10	44	50	
450	33,1	45	3,8	6.40 min/sec	12-16	10	50	57	
500	36,8	60	4,2	7.25 min/sec	12-16	10	55	63	

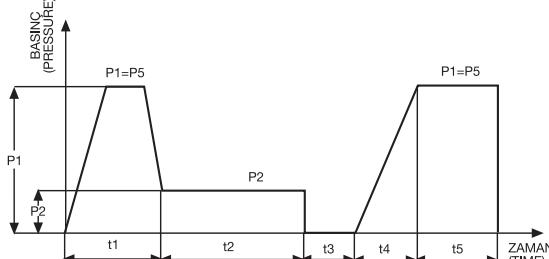
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 100			SDR 11 PN 16		Silindir alanı/Cylinder area 14.13 cm ²				
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
75	6,8	2	1,2	1.25 min/sec	5-6	10	10	12	
90	8,2	3	1,3	1.50 min/sec	6-8	10	12	14	
110	10,0	4	1,5	2 dk/min	6-8	10	15	17	
125	11,4	5	1,6	2.20 min/sec	6-8	10	17	20	
140	12,7	6	1,8	2.35 min/sec	8-10	10	19	22	
160	14,6	7	2,0	3 dk/min	8-10	10	22	25	
180	16,4	9	2,1	3.15 min/sec	8-10	10	25	28	
200	18,2	11	2,3	3.40 min/sec	8-10	10	27	31	
225	20,5	15	2,6	4 dk/min	10-12	10	31	35	
250	22,7	18	2,8	4.35 min/sec	10-12	10	34	39	
280	25,4	22	3,0	5 dk/min	10-12	10	38	44	
315	28,6	28	3,4	5.45 min/sec	12-16	10	43	49	
355	32,2	35	3,7	6.25 min/sec	12-16	10	48	55	
400	36,3	45	4,1	7.15 min/sec	12-16	10	54	62	
450	40,9	55	4,6	8.15 min/sec	16-20	10	61	70	
500	45,4	70	5,0	9 dk/min	16-20	10	68	78	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 9 PN 20		Silindir alanı/Cylinder area 14.13 cm ²				
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	mm	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
75	8,4	2	1,3	1.40 min/sec	6-8	10	13	15	
90	10,1	3	1,5	2 dk/min	6-8	10	15	18	
110	12,3	4	1,7	2.30 min/sec	8-10	10	18	21	
125	14,0	5	1,9	2.50 min/sec	8-10	10	21	24	
140	15,7	7	2,1	3.10 min/sec	8-10	10	24	27	
160	17,9	10	2,3	3.40 min/sec	8-10	10	27	31	
180	20,1	11	2,5	4 dk/min	10-12	10	30	35	
200	22,4	15	2,7	4.30 min/sec	10-12	10	34	38	
225	25,2	17	3,0	5 dk/min	10-12	10	38	43	
250	27,9	20	3,3	5.35 min/sec	12-16	10	42	48	
280	31,3	25	3,6	6.15 min/sec	12-16	10	47	54	
315	35,2	35	4,0	7 dk/min	12-16	10	53	60	
355	39,7	40	4,5	8 dk/min	16-20	10	60	68	
400	44,7	55	5,0	9 dk/min	16-20	10	67	76	
450	50,3	70	5,5	10 dk/min	20-25	10	75	86	
500	55,8	85	6,1	11.10 min/sec	20-25	10	84	95	

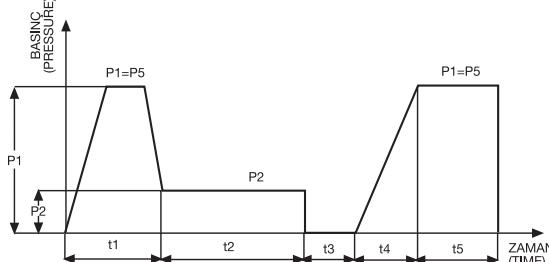
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 100			SDR 7,4 PN 25	Silindir alanı/Cylinder area 14.13 cm ²				
Diş Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	10,3	2	1,5	2 dk/min	6-8	10	15	18
90	12,3	3	1,7	2.30 min/sec	8-10	10	18	21
110	15,1	5	2,0	3 dk/min	8-10	10	23	26
125	17,1	6	2,2	3.25 min/sec	8-10	10	26	29
140	19,2	8	2,4	3.50 min/sec	10-12	10	29	33
160	21,9	10	2,7	4.25 min/sec	10-12	10	33	38
180	24,6	13	3,0	5 dk/min	10-12	10	37	42
200	27,4	15	3,2	5.30 min/sec	12-16	10	41	47
225	30,8	20	3,6	6.10 min/sec	12-16	10	46	53
250	34,2	25	3,9	6.50 min/sec	12-16	10	51	58
280	38,3	30	4,3	7.40 min/sec	16-20	10	57	65
315	43,1	40	4,8	8.40 min/sec	16-20	10	65	74
355	48,5	50	5,4	9.40 min/sec	16-20	10	73	83
400	54,7	65	6,0	11 dk/min	20-25	10	82	93
450	61,5	80	6,7	12.20 min/sec	20-25	10	92	105
500								

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 6 PN 32	Silindir alanı/Cylinder area 14.13 cm ²				
Diş Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	12,5	3	1,8	2.30 min/sec	8-10	10	19	22
90	15,0	4	2,0	3 dk/min	8-10	10	23	26
110	18,3	6	2,3	3.40 min/sec	8-10	10	27	31
125	20,8	7	2,6	4.10 min/sec	10-12	10	31	36
140	23,3	10	2,8	4.40 min/sec	10-12	10	35	40
160	26,6	12	3,2	5.20 min/sec	12-16	10	40	46
180	29,9	15	3,5	6 dk/min	12-16	10	45	51
200	33,2	20	3,8	6.40 min/sec	12-16	10	50	57
225	37,4	25	4,2	7.30 min/sec	16-20	10	56	64
250	41,5	30	4,7	8.20 min/sec	16-20	10	62	71
280	46,5	35	5,2	9.20 min/sec	16-20	10	70	79
315	52,3	45	5,7	10.30 min/sec	20-25	10	78	89
355	59,0	60	6,4	11.50 min/sec	20-25	10	89	101
400	66,7	75	7,2	13.20 min/sec	20-25	10	100	114
450								
500								

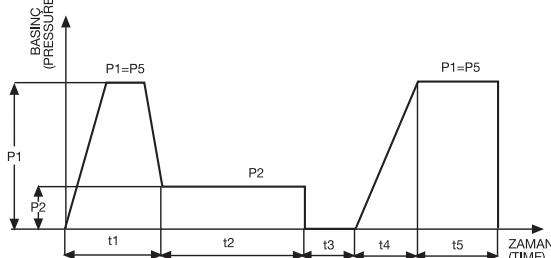
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 80			SDR 41 PN 3.2		Silindir alanı/Cylinder area 14.13 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75								
90	2,3	1	0,7	30 sn/sec	5	10	3	4
110	2,7	1	0,8	35 sn/sec	5	10	4	5
125	3,1	2	0,8	40 sn/sec	5	10	5	6
140	3,5	2	0,9	45 sn/sec	5	10	5	6
160	4,0	2	0,9	50 sn/sec	5	10	6	7
180	4,4	3	0,9	55 sn/sec	5	10	7	8
200	4,9	3	1,0	1 dk/min	5-6	10	7	9
225	5,5	4	1,1	1.5 min/sec	5-6	10	8	10
250	6,2	5	1,1	1.15 min/sec	5-6	10	9	11
280	6,9	6	1,2	1.25 min/sec	5-6	10	10	12
315	7,7	8	1,3	1.35 min/sec	6-8	10	12	13
355	8,7	10	1,4	1.45 min/sec	6-8	10	13	15
400	9,8	13	1,5	2 dk/min	6-8	10	15	17
450	11,0	15	1,6	2.15 min/sec	6-8	10	17	19
500	12,3	20	1,7	2.3 min/sec	8-10	10	1	21

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 80			SDR 33 PN 4		Silindir alanı/Cylinder area 14.13 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	2,3	1	0,7	30 sn/sec	5	10	3	4
90	2,8	1	0,8	35 sn/sec	5	10	4	5
110	3,4	2	0,8	40 sn/sec	5	10	5	6
125	3,9	2	0,9	45 sn/sec	5	10	6	7
140	4,3	2	0,9	55 sn/sec	5	10	6	8
160	4,9	3	1,0	1 dk/min	5-6	10	7	9
180	5,5	3	1,1	1.5 min/sec	5-6	10	8	10
200	6,2	4	1,1	1.15 min/sec	5-6	10	9	11
225	6,9	5	1,2	1.25 min/sec	5-6	10	10	12
250	7,7	6	1,3	1.35 min/sec	6-8	10	12	13
280	8,6	8	1,4	1.45 min/sec	6-8	10	13	15
315	9,7	10	1,5	2 dk/min	6-8	10	15	17
355	10,9	13	1,6	2.10 min/sec	6-8	10	16	19
400	12,3	15	1,7	2.30 min/sec	8-10	10	18	21
450	13,8	20	1,9	2.45 min/sec	8-10	10	21	24
500	15,3	25	2,0	3 dk/min	8-10	10	23	26

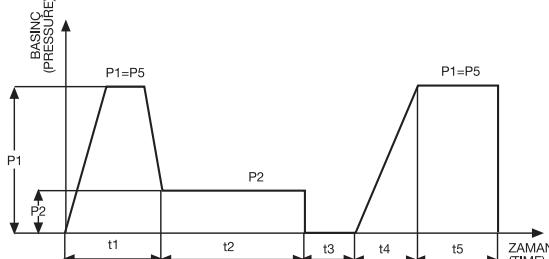
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 80			SDR 26 PN 5		Silindir alanı/Cylinder area 14.13 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	2,9	1	0,8	35 sn/sec	5	10	4	5
90	3,5	1	0,9	45 sn/sec	5	10	5	6
110	4,2	1	0,9	50 sn/sec	5	10	6	7
125	4,8	2	1,0	1 dk/min	5-6	10	7	8
140	5,4	3	1,0	1.5 min/sec	5-6	10	8	9
160	6,2	3	1,1	1.15 min/sec	5-6	10	9	11
180	6,9	4	1,2	1.25 min/sec	5-6	10	10	12
200	7,7	5	1,3	1.30 min/sec	6-8	10	12	13
225	8,6	6	1,4	1.45 min/sec	6-8	10	13	15
250	9,6	8	1,5	2 dk/min	6-8	10	14	17
280	10,7	10	1,6	2.10 min/sec	6-8	10	16	19
315	12,1	12	1,7	2.25 min/sec	8-10	10	18	21
355	13,6	15	1,9	2.45 min/sec	8-10	10	20	23
400	15,3	20	2,0	3.5 min/sec	8-10	10	23	26
450	17,2	25	2,2	3.25 min/sec	8-10	10	26	30
500	19,1	30	2,4	3.50 min/sec	10-12	10	29	33

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 80			SDR 21 PN 6		Silindir alanı/Cylinder area 14.13 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	3,4	1	0,8	40 sn/sec	5	10	5	6
90	4,1	1	0,9	50 sn/sec	5	10	6	7
110	5,0	2	1,0	1 dk/min	5-6	10	8	9
125	5,7	3	1,1	1.10 min/sec	5-6	10	9	10
140	6,4	3	1,1	1.20 min/sec	5-6	10	10	11
160	7,3	4	1,2	1.30 min/sec	6-8	10	11	13
180	8,2	5	1,3	1.40 min/sec	6-8	10	12	14
200	9,1	6	1,4	1.50 min/sec	6-8	10	14	16
225	10,2	7	1,5	2 dk/min	6-8	10	15	18
250	11,4	9	1,6	2.20 min/sec	6-8	10	17	20
280	12,7	10	1,8	2.30 min/sec	8-10	10	19	22
315	14,3	15	1,9	2.50 min/sec	8-10	10	21	25
355	16,1	20	2,1	3.15 min/sec	8-10	10	24	28
400	18,2	25	2,3	3.40 min/sec	8-10	10	27	31
450	20,5	30	2,6	4.5 min/sec	10-12	10	31	35
500	22,7	35	2,8	4.30 min/sec	10-12	10	34	39

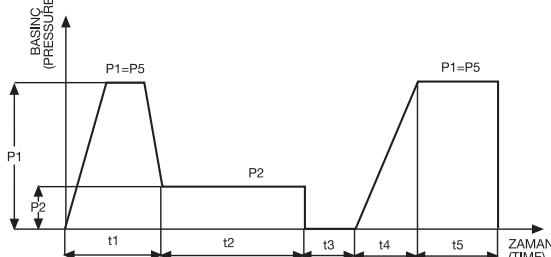
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 80			SDR 17 PN 8		Silindir alanı/Cylinder area 14.13 cm ²			
Diş Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	4,5	1	1,0	55 sn/sec	5	10	7	8
90	5,4	2	1,0	1.5 min/sec	5-6	10	8	9
110	6,6	2	1,2	1.20 min/sec	5-6	10	10	11
125	7,4	3	1,2	1.30 min/sec	6-8	10	11	13
140	8,3	4	1,3	1.40 min/sec	6-8	10	12	14
160	9,5	5	1,5	1.55 min/sec	6-8	10	14	16
180	10,7	6	1,6	2.10 min/sec	6-8	10	16	18
200	11,9	8	1,7	2.25 min/sec	6-8	10	18	20
225	13,4	10	1,8	2.40 min/sec	8-10	10	20	23
250	14,8	12	2,0	3 dk/min	8-10	10	22	25
280	16,6	15	2,2	3.20 min/sec	8-10	10	25	29
315	18,7	20	2,4	3.45 min/sec	8-10	10	28	32
355	21,1	25	2,6	4.15 min/sec	10-12	10	32	36
400	23,7	30	2,9	4.45 min/sec	10-12	10	36	41
450	26,7	40	3,2	5.20 min/sec	12-16	10	40	46
500	29,7	50	3,5	6 dk/min	12-16	10	45	51

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 80			SDR 13,6 PN 10		Silindir alanı/Cylinder area 14.13 cm ²			
Diş Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	5,6	1	1,1	1.10 min/sec	5-6	10	8	10
90	6,7	2	1,2	1.20 min/sec	5-6	10	10	12
110	8,1	3	1,3	1.40 min/sec	6-8	10	12	14
125	9,2	4	1,4	1.50 min/sec	6-8	10	14	16
140	10,3	5	1,5	2 dk/min	6-8	10	15	18
160	11,8	6	1,7	2.25 min/sec	6-8	10	18	20
180	13,3	7	1,8	2.40 min/sec	8-10	10	20	23
200	14,7	8	2,0	3 min/sec	8-10	10	22	25
225	16,6	9	2,2	3.20 min/sec	8-10	10	25	29
250	18,4	10	2,3	3.40 min/sec	8-10	10	28	32
280	20,6	11	2,6	4.10 min/sec	10-12	10	31	35
315	23,2	14	2,8	4.40 min/sec	10-12	10	35	40
355	26,1	18	3,1	5.15 min/sec	12-16	10	39	45
400	29,4	22	3,4	6 dk/min	12-16	10	44	50
450	33,1	28	3,8	6.40 min/sec	12-16	10	50	57
500	36,8	35	4,2	7.25 min/sec	12-16	10	55	63

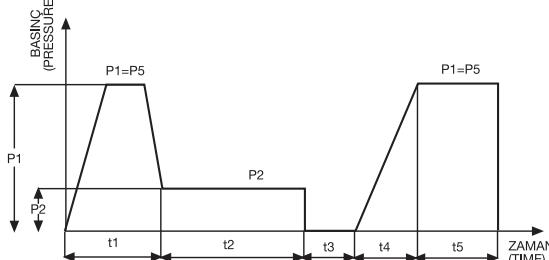
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 80			SDR 11 PN 12.5		Silindir alanı/Cylinder area 14.13 cm ²				
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
75	6,8	1	1,2	1,25 min/sec	5-6	10	10	12	
90	8,2	2	1,3	1,40 min/sec	6-8	10	12	14	
110	10,0	3	1,5	2 dk/min	6-8	10	15	17	
125	11,4	4	1,6	2,20 min/sec	6-8	10	17	20	
140	12,7	5	1,8	2,35 min/sec	8-10	10	19	22	
160	14,6	7	2,0	3 dk/min	8-10	10	22	25	
180	16,4	9	2,1	3,20 min/sec	8-10	10	25	28	
200	18,2	10	2,3	3,40 min/sec	8-10	10	27	31	
225	20,5	15	2,6	4 dk/min	10-12	10	31	35	
250	22,7	17	2,8	4,30 min/sec	10-12	10	34	39	
280	25,4	22	3,0	5 dk/min	10-12	10	38	44	
315	28,6	27	3,4	5,45 min/sec	12-16	10	43	49	
355	32,2	35	3,7	6,25 min/sec	12-16	10	48	55	
400	36,3	45	4,1	7,15 min/sec	12-16	10	54	62	
450	40,9	55	4,6	8,10 min/sec	16-20	10	61	70	
500	45,4	70	5,0	9 dk/min	16-20	10	68	78	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 80			SDR 9 PN 16		Silindir alanı/Cylinder area 14.13 cm ²				
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
75	8,4	2	1,3	1,40 min/sec	6-8	10	13	14	
90	10,1	3	1,5	2 dk/min	6-8	10	15	17	
110	12,3	4	1,7	2,30 min/sec	8-10	10	18	21	
125	14,0	5	1,9	2,50 min/sec	8-10	10	21	24	
140	15,7	7	2,1	3,10 min/sec	8-10	10	24	27	
160	17,9	9	2,3	3,35 min/sec	8-10	10	27	31	
180	20,1	10	2,5	4 dk/min	10-12	10	30	34	
200	22,4	13	2,7	4,30 min/sec	10-12	10	34	38	
225	25,2	17	3,0	5 dk/min	10-12	10	38	43	
250	27,9	20	3,3	5,35 min/sec	12-16	10	42	48	
280	31,3	25	3,6	6,15 min/sec	12-16	10	47	54	
315	35,2	35	4,0	7 dk/min	12-16	10	53	60	
355	39,7	40	4,5	8 dk/min	16-20	10	60	68	
400	44,7	55	5,0	9 dk/min	16-20	10	67	76	
450	50,3	70	5,5	10 dk/min	20-25	10	75	86	
500	55,8	85	6,1	11,10 min/sec	20-25	10	84	95	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

250-315-400-500

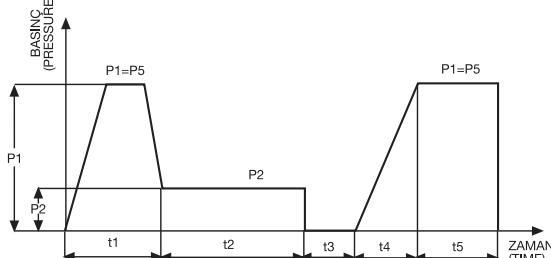
Kullanma Kılavuzu
Technical Information

250-315-400-500 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ
250-315-400-500 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PE 80				SDR 7,4 PN 20		Silindir alanı/Cylinder area 14.13 cm ²				
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2	t3	t4	t5	Toplam/Total dk/min		
75	10,3	2	1,5	2 dk/min	6-8	10	15	18		
90	12,3	3	1,7	2.30 min/sec	8-10	10	18	21		
110	15,1	5	2,0	3 dk/min	8-10	10	23	26		
125	17,1	6	2,2	3.25 min/sec	8-10	10	26	29		
140	19,2	8	2,4	3.50 min/sec	10-12	10	29	33		
160	21,9	10	2,7	4.25 min/sec	10-12	10	33	37		
180	24,6	13	3,0	5 dk/min	10-12	10	37	42		
200	27,4	15	3,2	5.30 min/sec	12-16	10	41	47		
225	30,8	20	3,6	6.10 min/sec	12-16	10	46	53		
250	34,2	25	3,9	6.50 min/sec	12-16	10	51	58		
280	38,3	30	4,3	7.40 min/sec	16-20	10	57	65		
315	43,1	40	4,8	8.40 min/sec	16-20	10	65	74		
355	48,5	50	5,4	9.40 min/sec	16-20	10	73	83		
400	54,7	65	6,0	11 dk/min	20-25	10	82	93		
450	61,5	80	6,7	12.20 min/sec	20-25	10	92	105		
500										

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 80				SDR 6 PN 25		Silindir alanı/Cylinder area 14.13 cm ²				
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2	t3	t4	t5	Toplam/Total dk/min		
75	12,5	3	1,8	2.30 min/sec	8-10	10	19	21		
90	15,0	5	2,0	3 dk/min	8-10	10	23	26		
110	18,3	6	2,3	3.40 min/sec	8-10	10	27	31		
125	20,8	7	2,6	4.10 min/sec	10-12	10	31	36		
140	23,3	10	2,8	4.40 min/sec	10-12	10	35	40		
160	26,6	12	3,2	5.20 min/sec	12-16	10	40	46		
180	29,9	15	3,5	6 dk/min	12-16	10	45	51		
200	33,2	20	3,8	6.40 min/sec	12-16	10	50	57		
225	37,4	25	4,2	7.30 min/sec	16-20	10	56	64		
250	41,5	30	4,7	8.20 min/sec	16-20	10	62	71		
280	46,5	40	5,2	9.20 min/sec	16-20	10	70	79		
315	52,3	45	5,7	10.30 min/sec	20-25	10	78	89		
355	59,0	60	6,4	11.50 min/sec	20-25	10	89	101		
400	66,7	75	7,2	13.20 min/sec	20-25	10	100	114		
450										
500										

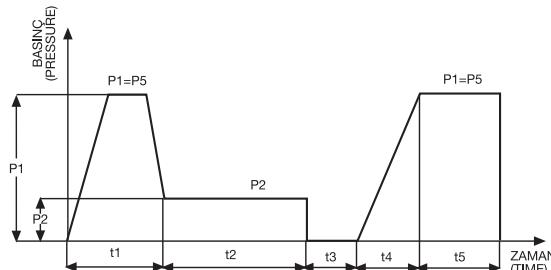
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PP			PN 2.5		Silindir alanı/Cylinder area 14.13 cm ²				
Diş Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
90	2,2	0,5	0,7	25 sn/sec	5	10	3	4	
110	2,7	0,5	0,8	30 sn/sec	5	10	4	5	
125	3,1	1	0,8	40 sn/sec	5	10	5	6	
140	3,5	1	0,9	45 sn/sec	5	10	5	6	
160	4,0	2	0,9	50 sn/sec	5	10	6	7	
180	4,4	2	0,9	55 sn/sec	5	10	7	8	
200	4,9	2	1,0	1 min/sec	5-6	10	7	9	
225	5,5	3	1,1	1.5 min/sec	5-6	10	8	10	
250	6,2	3	1,1	1.15 min/sec	5-6	10	9	11	
280	6,9	4	1,2	1.25 min/sec	5-6	10	10	12	
315	7,7	5	1,3	1.30 min/sec	6-8	10	12	13	
355	8,7	7	1,4	1.45 min/sec	6-8	10	13	15	
400	9,8	9	1,5	2 dk/min	6-8	10	15	17	
450	11,0	10	1,6	2.15 min/sec	6-8	10	17	19	
500	12,3	13	1,7	2.30 min/sec	8-10	10	18	21	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PP			PN 4		Silindir alanı/Cylinder area 14.13 cm ²				
Diş Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
90	3,5	0,5	0,9	45 sn/sec	5	10	5	6	
110	4,3	1	0,9	55 sn/sec	5	10	6	8	
125	4,9	1	1,0	1 dk/min	5-6	10	7	9	
140	5,4	2	1,0	1.5 min/sec	5-6	10	8	9	
160	6,2	2	1,1	1.15 min/sec	5-6	10	9	11	
180	7,0	3	1,2	1.25 min/sec	5-6	10	11	12	
200	7,7	3	1,3	1.35 min/sec	6-8	10	12	13	
225	8,7	4	1,4	1.45 min/sec	6-8	10	13	15	
250	9,7	5	1,5	2 dk/min	6-8	10	15	17	
280	10,8	7	1,6	2.10 min/sec	6-8	10	16	19	
315	12,2	8	1,7	2.25 min/sec	8-10	10	18	21	
355	13,7	10	1,9	2.45 min/sec	8-10	10	21	24	
400	15,4	15	2,0	3 dk/min	8-10	10	23	27	
450	17,4	17	2,2	3.30 min/sec	8-10	10	26	30	
500	19,3	20	2,4	4 dk/min	10-12	10	29	33	

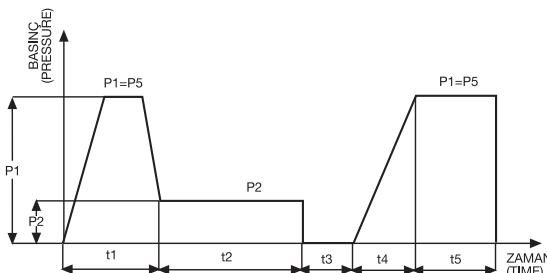
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PP			PN 6		Silindir alanı/Cylinder area 14.13 cm ²				
Diş Çap Outer Dia.	Etkalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
90	5,1	1	1,0	1 dk/min	5-6	10	8	9	
110	6,3	1,5	1,1	1.15 min/sec	5-6	10	9	11	
125	7,1	2	1,2	1.25 min/sec	6-8	10	11	12	
140	8,0	2	1,3	1.35 min/sec	6-8	10	12	14	
160	9,1	3	1,4	1.50 min/sec	6-8	10	14	16	
180	10,2	4	1,5	2 dk/min	6-8	10	15	18	
200	11,4	5	1,6	2.20 min/sec	6-8	10	17	20	
225	12,8	6	1,8	2.35 min/sec	8-10	10	19	22	
250	14,2	7	1,9	2.50 min/sec	8-10	10	21	24	
280	15,9	10	2,1	3.10 min/sec	8-10	10	24	27	
315	17,9	12	2,3	3.35 min/sec	8-10	10	27	31	
355	20,1	15	2,5	4 dk/min	10-12	10	30	35	
400	22,7	20	2,8	4.30 min/sec	10-12	10	34	39	
450	25,5	25	3,1	5 dk/min	10-12	10	38	44	
500	28,3	30	3,3	5.40 min/sec	12-16	10	42	48	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PP			PN 10		Silindir alanı/Cylinder area 14.13 cm ²				
Diş Çap Outer Dia.	Etkalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
90	8,2	1	1,3	1.40 min/sec	6-8	10	12	14	
110	10,0	2	1,5	2 dk/min	6-8	10	15	17	
125	11,4	3	1,6	2.20 min/sec	6-8	10	17	20	
140	12,7	4	1,8	2.30 min/sec	8-10	10	19	22	
160	14,6	5	2,0	3 dk/min	8-10	10	22	25	
180	16,4	6	2,1	3.20 min/sec	8-10	10	25	28	
200	18,2	7	2,3	3.40 min/sec	8-10	10	27	31	
225	20,5	10	2,6	4 dk/min	10-12	10	31	35	
250	22,7	12	2,8	4.30 min/sec	10-12	10	34	39	
280	25,4	15	3,0	5 dk/min	10-12	10	38	43	
315	28,6	20	3,4	5.45 min/sec	12-16	10	43	49	
355	32,2	25	3,7	6.30 min/sec	12-16	10	48	55	
400	36,3	30	4,1	7.15 min/sec	12-16	10	54	62	
450	40,9	40	4,6	8.10 min/sec	16-20	10	61	70	
500	45,4	45	5,0	9 dk/min	16-20	10	68	78	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PP			PN 12.5		Silindir alanı/Cylinder area 14.13 cm ²				
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
90	10,0	2	1,5	2 dk/min	6-8	10	15	17	
110	12,3	3	1,7	2.30 min/sec	8-10	10	18	21	
125	14,0	4	1,9	2.50 min/sec	8-10	10	21	24	
140	15,7	4	2,1	3.10 min/sec	8-10	10	24	27	
160	17,9	5	2,3	3.35 min/sec	8-10	10	27	31	
180	20,1	7	2,5	4 dk/min	10-12	10	30	34	
200	22,4	9	2,7	4.30 min/sec	10-12	10	34	38	
225	25,2	10	3,0	5 dk/min	10-12	10	38	43	
250	27,9	15	3,3	6.35 min/sec	12-16	10	42	48	
280	31,3	18	3,6	6.45 min/sec	12-16	10	47	54	
315	35,2	22	4,0	7 dk/min	12-16	10	53	60	
355	39,7	30	4,5	8 dk/min	16-20	10	60	68	
400									
450									
500									

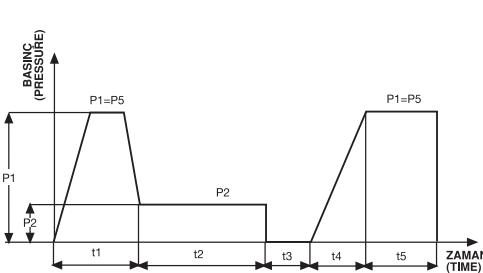
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PP			PN 16		Silindir alanı/Cylinder area 14.13 cm ²				
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
90	12,5	2	1,8	2.30 min/sec	8-10	10	19	22	
110	15,2	3	2,0	3 dk/min	8-10	10	23	26	
125	17,3	4	2,2	3.30 min/sec	8-10	10	26	30	
140	19,4	5	2,4	4 dk/min	10-12	10	29	33	
160	22,1	7	2,7	4.25 min/sec	10-12	10	33	38	
180	24,9	9	3,0	5 dk/min	10-12	10	37	43	
200	27,6	10	3,3	5.30 min/sec	12-16	10	41	47	
225	31,1	15	3,6	6.15 min/sec	12-16	10	47	53	
250	34,5	17	4,0	7 dk/min	12-16	10	52	59	
280	38,7	20	4,4	7.45 min/sec	16-20	10	58	66	
315									
355									
400									
450									
500									

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



$$\text{BAR} = \frac{(D_1 \text{ alanı} - D_2 \text{ alanı}) \times \text{itme katsayı}}{\text{silindirin alanı}}$$

D1 - Dış çap

D2 - İç çap

e - et kalınlığı

Malzeme PE ise itme katsayı 1.5 kg/cm^2

Malzeme PP ise itme katsayı 1 kg/cm^2

250-315-500 silindir alanı = 14.13 cm^2

630-800 silindir alanı = 23.06 cm^2

- t1:** Basıncılı ısıtma yaparken oluşacak dudak kalınlığı için gereken zaman.
 - t2:** Basıncızısız ısıtma için gereken zaman.
 - t3:** Isıtıcıyı boruların arasından alma zamanı.
 - t4:** Basıncı artırma zamanı.
 - t5:** Kaynak yapılan boruların soğumaya bırakıldığı zaman.
- P1:**Dudak kalınlığı için gereken basınç.
- P2:**Devamlı ısıtma için gereken basınç
- P5:**Soğuma esnasında gereken basınç.

- t1:** Required time for the lips at the pressure heating moment.
 - t2:** Required time for the heating without pressure.
 - t3:** Required time to taking the heater from pipes.
 - t4:** Pressure increase time.
 - t5:** After welding cooling time.
- P1:** Required time for the lips.
- P2:** Required pressure for increasing heating.
- P5:** At the cooling time required pressure.

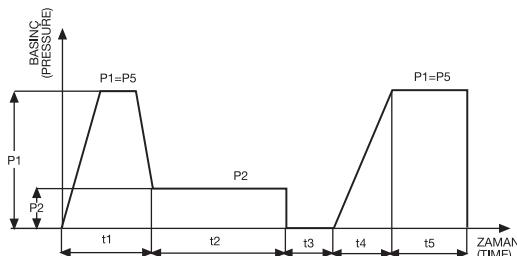
630 - 800 KAYNAK MAKİNALARININ PARAMETRE OLÇÜLERİ

630 - 800 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PE 100			SDR 41 PN 4		Silindir alanı/Cylinder area 23.06 cm ²			
Diş Cap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min
180	4,4	1,5	0,9	55 sn/sec	5	10	7	8
200	4,9	2	1,0	1 dk/min	5-6	10	7	9
225	5,5	2,5	1,1	1.10 min/sec	5-6	10	8	10
250	6,2	3	1,1	1.15 min/sec	5-6	10	9	11
280	6,9	4	1,2	1.20 min/sec	5-6	10	10	12
315	7,7	5	1,3	1.30 min/sec	6-8	10	12	14
355	8,7	6	1,4	1.45 min/sec	6-8	10	13	15
400	9,8	8	1,5	2 dk/min	6-8	10	15	17
450	11,0	10	1,6	2.15 min/sec	6-8	10	17	19
500	12,3	13	1,7	2.30 min/sec	8-10	10	18	21
560	13,7	15	1,8	2.45 min/sec	8-10	10	21	24
630	15,4	20	1,9	3 dk/min	8-10	10	23	27
710	17,4	25	1,9	3.30 min/sec	8-10	10	26	30
800	19,6	30	1,9	4 dk/min	10-12	10	29	34

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 33 PN 5		Silindir alanı/Cylinder area 23.06 cm ²			
Diş Cap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min
180	5,5	2	1,1	1.10 min/sec	5-6	10	8	10
200	6,2	2,5	1,1	1.15 min/sec	5-6	10	9	11
225	6,9	3	1,2	1.25 min/sec	5-6	10	10	12
250	7,7	4	1,3	1.30 min/sec	6-8	10	12	14
280	8,6	5	1,4	1.45 min/sec	6-8	10	13	15
315	9,7	6	1,5	2 dk/min	6-8	10	15	17
355	10,9	8	1,6	2.15 min/sec	6-8	10	16	19
400	12,3	10	1,7	2.30 min/sec	8-10	10	18	21
450	13,8	13	1,8	2.45 min/sec	8-10	10	21	24
500	15,3	15	1,9	3 dk/min	8-10	10	23	26
560	17,2	20	2,2	3.25 min/sec	8-10	10	26	30
630	19,3	25	2,4	4 dk/min	10-12	10	29	33
710	21,8	30	2,2	4.25 min/sec	10-12	10	33	37
800	24,5	40	2,4	5 dk/min	10-12	10	37	42

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

630-800

630-800 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ

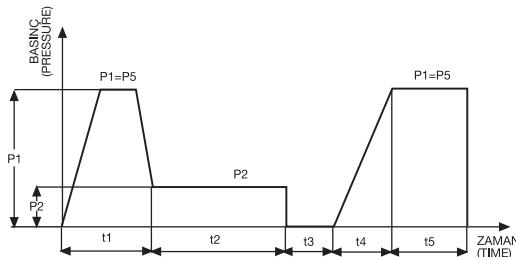
Kullanma Kılavuzu
Technical Information

630-800 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PE 100			SDR 26 PN 6			Silindir alanı/Cylinder area 23.06 cm ²			
Dis Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
180	6,5	2	1,2	1.20 min/sec	5-6	10	10	11	
200	7,2	3	1,2	1.30 min/sec	6-8	10	11	13	
225	8,2	4	1,3	1.40 min/sec	6-8	10	12	14	
250	9,1	5	1,4	1.50 min/sec	6-8	10	14	16	
280	10,1	6	1,5	2 dk/min	6-8	10	15	18	
315	11,4	7	1,6	2.20 min/sec	6-8	10	17	20	
355	12,9	10	1,8	2.35 min/sec	8-10	10	19	22	
400	14,5	12	2,0	3 dk/min	8-10	10	22	25	
450	16,3	15	2,1	3.15 min/sec	8-10	10	24	28	
500	18,1	20	2,3	3.40 min/sec	8-10	10	27	31	
560	20,3	25	2,5	4 dk/min	10-12	10	30	35	
630	22,8	30	2,9	4.35 min/sec	10-12	10	34	39	
710	25,7	35	3,4	5.10 min/sec	10-12	10	39	44	
800	29,0	45	3,9	5.50 min/sec	12-16	10	44	50	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 21 PN 8			Silindir alanı/Cylinder area 23.06 cm ²			
Dis Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
180	8,6	3	1,4	1.45 min/sec	6-8	10	13	15	
200	9,6	4	1,5	2 dk/min	6-8	10	14	17	
225	10,8	5	1,6	2.10 min/sec	6-8	10	16	19	
250	11,9	6	1,7	2.25 min/sec	6-8	10	18	21	
280	13,4	7	1,8	2.40 min/sec	8-10	10	20	23	
315	15,0	10	2,0	3 dk/min	8-10	10	23	26	
355	16,9	12	2,2	3.25 min/sec	8-10	10	25	29	
400	19,1	15	2,4	3.50 min/sec	10-12	10	29	33	
450	21,5	20	2,7	4.20 min/sec	10-12	10	32	37	
500	23,9	25	2,9	4.40 min/sec	10-12	10	36	41	
560	26,7	30	3,2	5.20 min/sec	12-16	10	40	46	
630	30,0	35	3,7	6 dk/min	12-16	10	45	51	
710	33,9	45	4,1	6.45 min/sec	12-16	10	51	58	
800	38,1	60	4,5	7.30 min/sec	16-20	10	57	65	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

630-800

630-800 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ

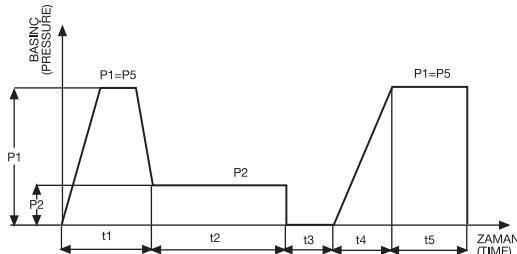
Kullanma Kılavuzu
Technical Information

630-800 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PE 100			SDR 17 PN 10		Silindir alanı/Cylinder area 23.06 cm ²				
Dış Cap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
180	10,7	4	1,6	2.10 min/sec	6-8	10	10	19	
200	11,9	5	1,7	2.25 min/sec	6-8	10	18	21	
225	13,4	6	1,8	2.40 min/sec	8-10	10	20	23	
250	14,8	7	2,0	3 dk/min	8-10	10	22	26	
280	16,6	10	2,2	3.20 min/sec	8-10	10	25	29	
315	18,7	12	2,4	3.45 min/sec	8-10	10	28	32	
355	21,1	15	2,6	4.15 min/sec	10-12	10	32	36	
400	23,7	20	2,9	4.45 min/sec	10-12	10	36	41	
450	26,7	25	3,2	5.20 min/sec	12-16	10	40	46	
500	29,7	30	3,5	6 dk/min	12-16	10	45	51	
560	33,2	35	3,8	6.40 min/sec	12-16	10	50	57	
630	37,4	45	4,1	7.30 min/sec	16-20	10	56	64	
710	42,1	60	4,7	8.25 min/sec	16-20	10	63	72	
800	47,4	70	5,3	9.30 min/sec	16-20	10	71	81	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 13,6 PN 12.5		Silindir alanı/Cylinder area 23.06 cm ²				
Dış Cap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
180	13,3	5	1,8	2.40 min/sec	8-10	10	20	23	
200	14,7	6	2,0	3 dk/min	8-10	10	22	25	
225	16,6	7	2,2	3.20 min/sec	8-10	10	25	29	
250	18,4	9	2,3	3.40 min/sec	8-10	10	28	32	
280	20,6	10	2,6	4.10 min/sec	10-12	10	31	35	
315	23,2	15	2,8	4.40 min/sec	10-12	10	35	40	
355	26,1	20	3,1	5.15 min/sec	12-16	10	39	45	
400	29,4	25	3,4	6 dk/min	12-16	10	44	50	
450	33,1	30	3,8	6.40 min/sec	12-16	10	50	57	
500	36,8	35	4,2	7.25 min/sec	12-16	10	55	63	
560	41,2	45	4,7	8.15 min/sec	16-20	10	62	70	
630	46,3	55	5,5	9 dk/min	16-20	10	69	79	
710	52,2	70	5,9	10.25 min/sec	20-25	10	78	89	
800	58,8	90	6,5	11.45 min/sec	20-25	10	88	100	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

630-800

630-800 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ

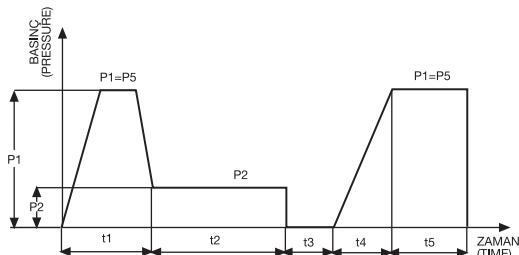
Kullanma Kılavuzu
Technical Information

630-800 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PE 100			SDR 11 PN 16		Silindir alanı/Cylinder area 23.06 cm ²				
Diş Çap Outer Dia.	Etkalı Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
180	16,4	6	2,3	3,15 min/sec	8-10	10	25	28	
200	18,2	7	2,6	3,40 min/sec	8-10	10	27	31	
225	20,5	8	2,8	4 dk/min	10-12	10	31	35	
250	22,7	10	3,0	4,35 min/sec	10-12	10	34	39	
280	25,4	15	3,4	5 dk/min	10-12	10	38	44	
315	28,6	18	3,7	5,45 min/sec	12-16	10	43	49	
355	32,2	20	4,1	6,25 min/sec	12-16	10	48	55	
400	36,3	30	4,6	7,15 min/sec	12-16	10	54	62	
450	40,9	35	5,0	8,15 min/sec	16-20	10	61	70	
500	45,4	45	5,2	9 dk/min	16-20	10	68	78	
560	50,8	50	5,5	10,10 min/sec	20-25	10	76	87	
630	57,2	65	6,0	11,25 min/sec	20-25	10	86	98	
710	64,5	85	6,9	13 dk/min	20-25	10	97	110	
800	72,6	108	7,8	15 dk/min	25-30	10	109	124	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 9 PN 20		Silindir alanı/Cylinder area 23.06 cm ²				
Diş Çap Outer Dia.	Etkalı Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
180	20,1	7	2,5	4 dk/min	10-12	10	30	35	
200	22,4	8	2,7	4,30 min/sec	10-12	10	34	38	
225	25,2	10	3,0	5 dk/min	10-12	10	38	43	
250	27,9	13	3,3	5,35 min/sec	12-16	10	42	48	
280	31,3	15	3,6	6,15 min/sec	12-16	10	47	54	
315	35,2	20	4,0	7 dk/min	12-16	10	53	60	
355	39,7	25	4,5	8 dk/min	16-20	10	60	68	
400	44,7	35	5,0	9 dk/min	16-20	10	67	76	
450	50,3	40	5,5	10 dk/min	20-25	10	75	86	
500	55,8	50	6,1	11,10 min/sec	20-25	10	84	95	
560	62,5	30	6,8	13 dk/min	20-25	10	94	106	
630	70,3	80	7,5	14 dk/min	25-30	10	105	120	
710	79,3	100	8,4	16 dk/min	25-30	10	119	135	
800	89,3	130	9,4	18 dk/min	25-30	10	134	152	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

630-800

630-800 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ

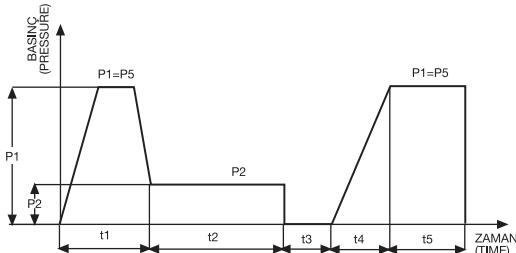
Kullanma Kılavuzu
Technical Information

630-800 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PE 100			SDR 7,4 PN 25		Silindir alanı/Cylinder area 23.06 cm ²			
Diş Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	24,6	8,0	3,0	5dk/min	10-12	10	37	42
200	27,4	10,0	3,2	5.30 min/sec	12-16	10	41	47
225	30,8	12,0	3,6	6.10 min/sec	12-16	10	46	53
250	34,2	15,0	3,9	6.50 min/sec	12-16	10	51	59
280	38,3	20,0	4,3	7.40 min/sec	16-20	10	57	66
315	43,1	25,0	4,8	8.40 min/sec	16-20	10	65	74
355	48,5	30,0	5,4	9.40 min/sec	16-20	10	73	83
400	54,7	40,0	6,0	11 dk/min	20-25	10	82	93
450	61,5	50,0	6,7	12.20 min/sec	20-25	10	92	105
500								
560								
630								
710								
800								

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 6 PN 32		Silindir alanı/Cylinder area 23.06 cm ²			
Diş Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	29,9	10	3,0	6 dk/min	12-16	10	45	51
200	33,2	12	3,8	6.40 min/sec	12-16	10	50	57
225	37,4	15	4,2	7.30 min/sec	16-20	10	56	64
250	41,5	20	4,7	8.20 min/sec	16-20	10	62	71
280	46,5	25	5,2	9.20 min/sec	16-20	10	70	79
315	52,3	30	5,7	10.30 min/sec	20-25	10	78	89
355	59,0	35	6,4	11.50 min/sec	20-25	10	89	101
400	66,7	45	7,1	13.20 min/sec	20-25	10	100	114
450								
500								
560								
630								
710								
800								

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

630-800

630-800 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ

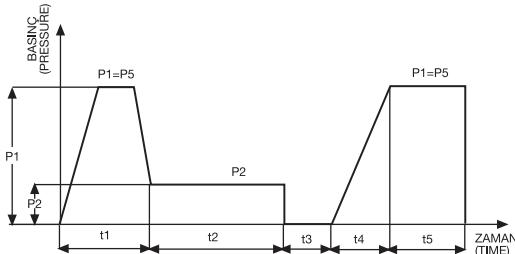
Kullanma Kılavuzu
Technical Information

630-800 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PE 80			SDR 41 PN 3.2		Silindir alanı/Cylinder area 23.06 cm ²			
Diş Cap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	4,4	1,5	0,9	55 sn/sec	5	10	7	8
200	4,9	2	1,0	1 dk/min	5-6	10	7	9
225	5,5	2,5	1,1	1.5 min/sec	5-6	10	8	10
250	6,2	3	1,1	1.15 min/sec	5-6	10	9	11
280	6,9	4	1,2	1.25 min/sec	5-6	10	10	12
315	7,7	5	1,3	1.35 min/sec	6-8	10	12	14
355	8,7	6	1,5	1.45 min/sec	6-8	10	13	15
400	9,8	8	1,5	2 dk/min	6-8	10	15	17
450	11,0	10	1,5	2.15 min/sec	6-8	10	17	19
500	12,3	13	2,0	2.30 min/sec	8-10	10	18	21
560	13,7	15	2,2	2.45 min/sec	8-10	10	21	24
630	15,4	20	2,5	3 dk/min	8-10	10	23	27
710	17,4	25	3,0	3.30 min/sec	8-10	10	26	30
800	19,6	30	3,6	4 dk/min	10-12	10	29	34

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 80			SDR 33 PN 4		Silindir alanı/Cylinder area 23.06 cm ²			
Diş Cap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	5,5	2	1,1	1.5 min/sec	5-6	10	8	10
200	6,2	2,5	1,1	1.15 min/sec	5-6	10	9	11
225	6,9	3	1,2	1.25 min/sec	5-6	10	10	12
250	7,7	4	1,3	1.35 min/sec	6-8	10	12	14
280	8,6	5	1,4	1.45 min/sec	6-8	10	13	15
315	9,7	6	1,5	2 dk/min	6-8	10	15	17
355	10,9	8	1,6	2.10 min/sec	6-8	10	16	19
400	12,3	10	1,7	2.30 min/sec	8-10	10	18	21
450	13,8	13	1,8	2.45 min/sec	8-10	10	21	24
500	15,3	15	2,0	3 dk/min	8-10	10	23	26
560	17,2	20	2,3	3.25 min/sec	8-10	10	26	30
630	19,3	25	2,8	4 dk/min	10-12	10	29	33
710	21,8	30	3,4	4.25 min/sec	10-12	10	33	37
800	24,5	40	3,9	5 dk/min	10-12	10	37	42

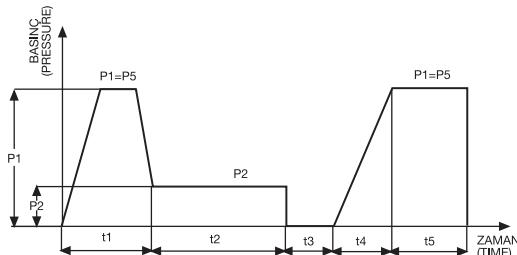
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 80			SDR 26 PN 5		Silindir alanı/Cylinder area 23.06 cm ²			
Diş Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	6,9	2	1,2	1.25 min/sec	5-6	10	10	12
200	7,7	3	1,3	1.30 min/sec	6-8	10	12	14
225	8,6	4	1,4	1.45 min/sec	6-8	10	13	15
250	9,6	5	1,5	2 dk/min	6-8	10	14	17
280	10,7	6	1,7	2.10 min/sec	6-8	10	16	19
315	12,1	8	1,8	2.25 min/sec	8-10	10	18	21
355	13,6	10	1,9	2.45 min/sec	8-10	10	20	24
400	15,3	12	2,0	3.5 min/sec	8-10	10	23	26
450	17,2	15	2,2	3.25 min/sec	8-10	10	26	30
500	19,1	20	2,4	3.50 min/sec	10-12	10	29	33
560	21,4	25	2,6	4.20 min/sec	10-12	10	32	37
630	24,1	30	2,8	4.50 min/sec	10-12	10	36	41
710	27,2	40	3,2	5.25 min/sec	12-16	10	41	47
800	30,6	50	3,8	6 dk/min	12-16	10	46	52

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 80			SDR 21 PN 6		Silindir alanı/Cylinder area 23.06 cm ²			
Diş Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	8,2	3	1,3	1.40 min/sec	6-8	10	12	14
200	9,1	4	1,4	1.50 min/sec	6-8	10	14	16
225	10,2	5	1,5	2 dk/min	6-8	10	15	18
250	11,4	6	1,6	2.20 min/sec	6-8	10	17	20
280	12,7	7	1,8	2.30 min/sec	8-10	10	19	22
315	14,3	9	1,9	2.50 min/sec	8-10	10	21	25
355	16,1	10	2,0	3.15 min/sec	8-10	10	24	28
400	18,2	15	2,3	3.40 min/sec	8-10	10	27	31
450	20,5	20	2,6	4.5 min/sec	10-12	10	31	35
500	22,7	25	2,8	4.30 min/sec	10-12	10	34	39
560	25,5	30	3,0	5 dk/min	10-12	10	38	44
630	28,6	35	3,4	5.45 min/sec	12-16	10	43	49
710	32,3	45	3,9	6.30 min/sec	12-16	10	48	55
800	36,4	55	4,5	7.15 min/sec	12-16	10	55	62

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

630-800

630-800 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ

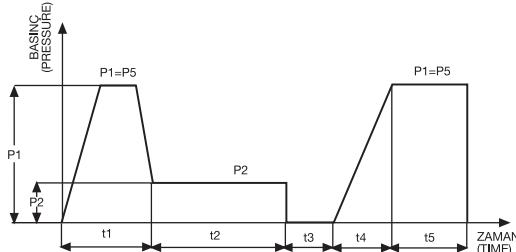
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630-800 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PE 80			SDR 17 PN 8		Silindir alanı/Cylinder area 23.06 cm ²				
Dış Cap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
180	10,7	4,0	1,6	2.10 min/sec	6-8	10	16	19	
200	11,9	5,0	1,7	2.25 min/sec	6-8	10	18	21	
225	13,4	6,0	1,8	2.40 min/sec	8-10	10	20	23	
250	14,8	7,0	2,0	3 dk/min	8-10	10	22	26	
280	16,6	9,0	2,2	3.20 min/sec	8-10	10	25	29	
315	18,7	10,0	2,4	3.45 min/sec	8-10	10	28	32	
355	21,1	15,0	2,6	4.15 min/sec	10-12	10	32	36	
400	23,7	20,0	2,8	4.45 min/sec	10-12	10	36	41	
450	26,7	25,0	3,2	5.20 min/sec	12-16	10	40	46	
500	29,7	30,0	3,5	6 dk/min	12-16	10	45	51	
560	33,2	35,0	4,0	6.40 min/sec	12-16	10	50	57	
630	37,4	45,0	4,6	7.30 min/sec	16-20	10	56	64	
710	42,1	60,0	5,3	8.25 min/sec	16-20	10	63	72	
800	47,4	70,0	5,9	10.10 min/sec	16-20	10	71	81	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 80			SDR 13,6 PN 10		Silindir alanı/Cylinder area 23.06 cm ²				
Dış Cap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
180	13,3	5	1,8	2.40 min/sec	8-10	10	20	23	
200	14,7	6	2,0	3 dk/min	8-10	10	22	25	
225	16,6	7	2,2	3.20 min/sec	8-10	10	25	29	
250	18,4	9	2,4	3.40 min/sec	8-10	10	28	32	
280	20,6	10	2,6	4.10 min/sec	10-12	10	31	35	
315	23,2	15	2,8	4.40 min/sec	10-12	10	35	40	
355	26,1	20	3,1	5.15 min/sec	12-16	10	39	45	
400	29,4	25	3,4	6 dk/min	12-16	10	44	50	
450	33,1	30	3,8	6.40 min/sec	12-16	10	50	57	
500	36,8	35	4,3	7.25 min/sec	12-16	10	55	63	
560	41,2	45	4,9	8.15 min/sec	16-20	10	62	70	
630	46,3	55	5,6	9.15 min/sec	16-20	10	69	79	
710	52,2	70	6,2	10.25 min/sec	20-25	10	78	89	
800	58,8	90	6,8	11.45 min/sec	20-25	10	88	100	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

630-800

630-800 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ

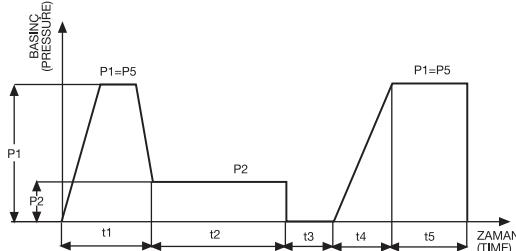
Kullanma Kılavuzu
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630-800 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PE 80			SDR 11 PN 12.5		Silindir alanı/Cylinder area 23.06 cm ²				
Diş Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2	t3	t4	t5	Toplam/Total dk/min	
180	16,4	6	2,1	3.20 min/sec	8-10	10	25	28	
200	18,2	7	2,3	3.40 min/sec	8-10	10	27	31	
225	20,5	8	2,6	4 dk/min	10-12	10	31	35	
250	22,7	10	2,8	4.30 min/sec	10-12	10	34	39	
280	25,4	13	3,0	5 dk/min	10-12	10	38	44	
315	28,6	15	3,4	5.45 min/sec	12-16	10	43	49	
355	32,2	20	3,9	6.25 min/sec	12-16	10	48	55	
400	36,3	30	4,3	7.15 min/sec	12-16	10	54	62	
450	40,9	35	4,6	8.10 min/sec	16-20	10	61	70	
500	45,4	45	5,1	9 dk/min	16-20	10	68	78	
560	50,8	55	5,7	10.10 min/sec	20-25	10	76	87	
630	57,2	65	6,4	11.25 min/sec	20-25	10	86	98	
710	64,5	85	7,1	13 dk/min	20-25	10	97	110	
800	72,6	108	7,8	15 dk/min	25-30	10	109	124	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 80			SDR 9 PN 16		Silindir alanı/Cylinder area 23.06 cm ²				
Diş Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2	t3	t4	t5	Toplam/Total dk/min	
180	20,1	6	2,5	4 dk/min	10-12	10	30	35	
200	22,4	8	2,8	4.30 min/sec	10-12	10	34	38	
225	25,2	10	3,0	5 dk/min	10-12	10	38	43	
250	27,9	13	3,3	5.35 min/sec	12-16	10	42	48	
280	31,3	15	3,6	6.15 min/sec	12-16	10	47	54	
315	35,2	20	4,0	7 dk/min	12-16	10	53	60	
355	39,7	25	4,5	8 dk/min	16-20	10	60	68	
400	44,7	35	5,0	9 dk/min	16-20	10	67	76	
450	50,3	40	5,5	10 dk/min	20-25	10	75	86	
500	55,8	50	6,1	11.10 min/sec	20-25	10	84	95	
560	62,5	29	6,8	13 dk/min	20-25	10	94	106	
630	70,3	80	7,5	14 dk/min	25-30	10	105	120	
710	79,3	102	8,4	16 dk/min	25-30	10	119	135	
800	89,3	130	9,4	18 dk/min	25-30	10	134	152	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

630-800

630-800 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ

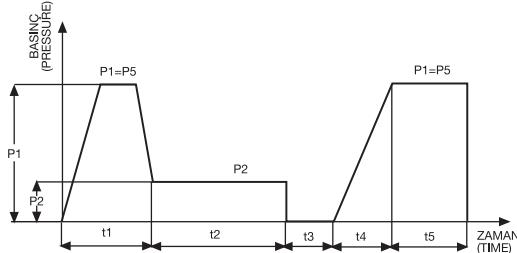
Kullanma Kılavuzu
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630-800 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PE 80			SDR 7,4 PN 20		Silindir alanı/Cylinder area 23.06 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	24,6	8	3,0	5 dk/min	10-12	10	37	42
200	27,4	10	3,2	5.30 min/sec	12-16	10	41	47
225	30,8	12	3,6	6.10 min/sec	12-16	10	46	53
250	34,2	15	3,9	6.50 min/sec	12-16	10	51	59
280	38,3	20	4,3	7.40 min/sec	16-20	10	57	66
315	43,1	25	4,8	8.40 min/sec	16-20	10	65	74
355	48,5	30	5,4	9.40 min/sec	16-20	10	73	83
400	54,7	40	6,1	11 dk/min	20-25	10	82	93
450	61,5	50	6,9	12.20 min/sec	20-25	10	92	105
500								
560								
630								
710								
800								

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 80			SDR 6 PN 25		Silindir alanı/Cylinder area 23.06 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	29,9	10	3,5	6 dk/min	12-16	10	45	51
200	33,2	12	3,8	6.40 min/sec	12-16	10	50	57
225	37,4	15	4,2	7.30 min/sec	16-20	10	56	64
250	41,5	20	4,7	8.20 min/sec	16-20	10	62	71
280	46,5	25	5,2	9.20 min/sec	16-20	10	70	79
315	52,3	30	5,7	10.30 min/sec	20-25	10	78	89
355	59,0	35	6,3	11.50 min/sec	20-25	10	89	101
400	66,7	45	6,9	13.20 min/sec	20-25	10	100	114
450								
500								
560								
630								
710								
800								

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

630-800

630-800 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ

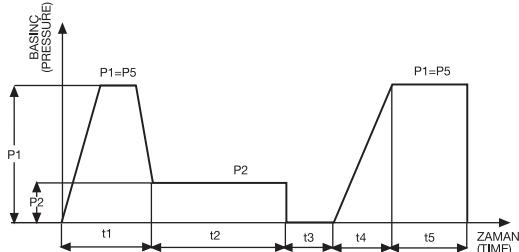
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630-800 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PP			PN 2.5		Silindir alanı/Cylinder area 23.06 cm ²				
Diş Cap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
90	2,2	0,5	0,7	25 sn/sec	5	10	3	4	
110	2,7	0,5	0,8	30 sn/sec	5	10	4	5	
125	3,1	0,5	0,8	40 sn/sec	5	10	5	6	
140	3,5	1	0,9	45 sn/sec	5	10	5	6	
160	4,0	1	0,9	50 sn/sec	5	10	6	7	
180	4,4	1	0,9	55 sn/sec	5	10	7	8	
200	4,9	1,5	1,0	1 dk/min	5-6	10	7	9	
225	5,5	1,5	1,1	1.5 min/sec	5-6	10	8	10	
250	6,2	2	1,1	1.15 min/sec	5-6	10	9	11	
280	6,9	2,5	1,2	1.25 min/sec	5-6	10	10	12	
315	7,7	3	1,3	1.30 min/sec	6-8	10	12	14	
355	8,7	4	1,5	1.45 min/sec	6-8	10	13	15	
400	9,8	5	1,5	2 dk/min	6-8	10	15	17	
450	11,0	7	1,5	2.15 min/sec	6-8	10	17	19	
500	12,3	8	2,0	2.30 min/sec	8-10	10	18	21	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PP			PN 4		Silindir alanı/Cylinder area 23.06 cm ²				
Diş Cap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	mm	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
90	3,5	0,5	0,9	45 sn/sec	5	10	5	6	
110	4,3	0,5	0,9	55 sn/sec	5	10	6	8	
125	4,9	1	1,0	1 dk/min	5-6	10	7	9	
140	5,4	1	1,0	1.5 min/sec	5-6	10	8	10	
160	6,2	1,5	1,1	1.15 min/sec	5-6	10	9	11	
180	7,0	1,5	1,2	1.25 min/sec	5-6	10	11	12	
200	7,7	2	1,3	1.35 min/sec	6-8	10	12	14	
225	8,7	2,5	1,4	1.45 min/sec	6-8	10	13	15	
250	9,7	3	1,5	2 dk/min	6-8	10	15	17	
280	10,8	4	1,6	2.10 min/sec	6-8	10	16	19	
315	12,2	5	1,7	2.25 min/sec	8-10	10	18	21	
355	13,7	7	1,9	2.45 min/sec	8-10	10	21	24	
400	15,4	8	2,0	3 dk/min	8-10	10	23	27	
450	17,4	10	2,2	3.30 min/sec	8-10	10	26	30	
500	19,3	13	2,4	4 dk/min	10-12	10	29	33	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

630-800

630-800 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ

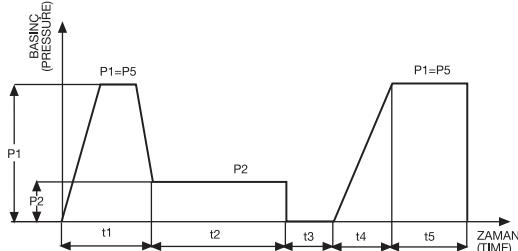
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630-800 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PP			PN 6		Silindir alanı/Cylinder area 23.06 cm ²				
Diş Cap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
90	5,1	0,5	0,8	1 dk/min	5-6	10	8	9	
110	6,3	1	0,8	1.15 min/sec	5-6	10	9	11	
125	7,1	1	0,9	1.25 min/sec	6-8	10	11	12	
140	8,0	1,5	0,9	1.35 min/sec	6-8	10	12	14	
160	9,1	2	1,0	1.50 min/sec	6-8	10	14	16	
180	10,2	2,5	1,1	2 dk/min	6-8	10	15	18	
200	11,4	3	1,1	2.20 min/sec	6-8	10	17	20	
225	12,8	4	1,2	2.35 min/sec	8-10	10	19	22	
250	14,2	5	1,3	2.50 min/sec	8-10	10	21	25	
280	15,9	6	1,4	3.10 min/sec	8-10	10	24	27	
315	17,9	7	1,5	3.35 min/sec	8-10	10	27	31	
355	20,1	10	1,7	4 dk/min	10-12	10	30	35	
400	22,7	12	1,9	4.30 min/sec	10-12	10	34	39	
450	25,5	15	2,2	5 dk/min	10-12	10	38	44	
500	28,3	20	2,5	5.40 min/sec	12-16	10	42	49	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PP			PN 10		Silindir alanı/Cylinder area 23.06 cm ²				
Diş Cap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
90	8,2	1	1,3	1.40 min/sec	6-8	10	12	14	
110	10,0	1,5	1,5	2 dk/min	6-8	10	15	17	
125	11,4	2	1,8	2.20 min/sec	6-8	10	17	20	
140	12,7	2,5	2,0	2.30 min/sec	8-10	10	19	22	
160	14,6	3	2,1	3 dk/min	8-10	10	22	25	
180	16,4	4	2,3	3.20 min/sec	8-10	10	25	28	
200	18,2	4,5	2,6	3.40 min/sec	8-10	10	27	31	
225	20,5	6	2,8	4 dk/min	10-12	10	31	35	
250	22,7	7	3,0	4.30 min/sec	10-12	10	34	39	
280	25,4	9	3,4	5 dk/min	10-12	10	38	44	
315	28,6	11	3,7	5.45 min/sec	12-16	10	43	49	
355	32,2	15	4,1	6.30 min/sec	12-16	10	48	55	
400	36,3	20	4,6	7.15 min/sec	12-16	10	54	62	
450	40,9	25	5,0	8.10 min/sec	16-20	10	61	70	
500	45,4	30	5,2	9 dk/min	16-20	10	68	78	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

630-800

630-800 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ

Kullanma Kılavuzu
Technical Information

630-800 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PP				PN 12.5	Silindir alanı/Cylinder area 23.06 cm ²				
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
90	10,0	1	1,5	2 dk/min	6-8	10	15	17	
110	12,3	1,5	1,7	2.30 min/sec	8-10	10	18	21	
125	14,0	2	1,9	2.50 min/sec	8-10	10	21	24	
140	15,7	3	2,1	3.10 min/sec	8-10	10	24	27	
160	17,9	3,5	2,3	3.35 min/sec	8-10	10	27	31	
180	20,1	4,5	2,5	4 dk/min	10-12	10	30	35	
200	22,4	5	2,7	4.30 min/sec	10-12	10	34	38	
225	25,2	7	3,0	5 dk/min	10-12	10	38	43	
250	27,9	9	3,3	6.35 min/sec	12-16	10	42	48	
280	31,3	10	3,6	6.45 min/sec	12-16	10	47	54	
315	35,2	15	4,0	7 dk/min	12-16	10	53	60	
355	39,7	20	4,5	8 dk/min	16-20	10	60	68	
400									
450									
500									

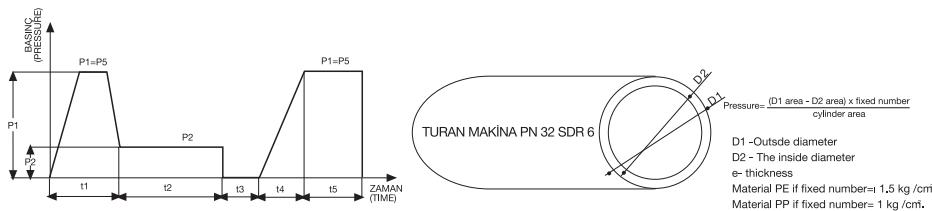
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PP				PN 16	Silindir alanı/Cylinder area 23.06 cm ²				
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
90	12,5	1	1,2	2.30 min/sec	8-10	10	19	22	
110	15,2	2	1,3	3 dk/min	8-10	10	23	26	
125	17,3	2,5	1,4	3.30 min/sec	8-10	10	26	30	
140	19,4	3	1,5	4 dk/min	10-12	10	29	33	
160	22,1	4	1,7	4.25 min/sec	10-12	10	33	38	
180	24,9	5	1,8	5 dk/min	10-12	10	37	43	
200	27,6	7	2,0	5.30 min/sec	12-16	10	41	47	
225	31,1	8	2,2	6.15 min/sec	12-16	10	47	53	
250	34,5	10	2,3	7 dk/min	12-16	10	52	59	
280	38,7	15	2,6	7.45 min/sec	16-20	10	58	66	
315									
355									
400									
450									
500									

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



1000-1200-1600 KAYNAK MAKİNALARININ PARAMETRE ÖLÇÜLERİ

**1000-1200-1600
MACHINE PRESSURE
AND TIME PARAMETERS**

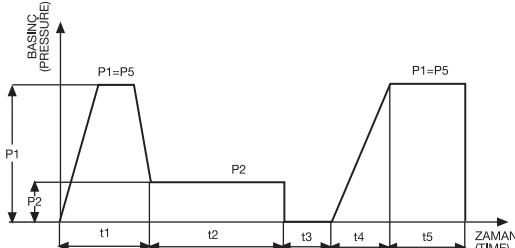
1000-1200-1600

1000-1200-1600 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ
1000-1200-1600 MACHINE PRESSURE AND TIME PARAMETERS

Kullanma Kılavuzu
Technical Information

MALZEME/MATERIAL PE 100			SDR 41 PN 4		Silindir alanı/Cylinder area 50,24 cm ²				
Diş Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
500	12,3	6	1,7	2 dk/min	8-10	10	18	21	
560	13,7	7	1,9	3 dk/min	8-10	10	21	24	
630	15,4	9	2,0	3 dk/min	8-10	10	23	27	
710	17,4	11	2,2	3 dk/min	8-10	10	26	30	
800	19,6	14	2,5	4 dk/min	10-12	10	29	34	
900	22,0	18	2,7	4 dk/min	10-12	10	33	38	
1000	24,5	22	3,0	5 dk/min	10-12	10	37	42	
1200	29,4	32	3,4	6 dk/min	12-16	10	44	50	
1400	34,3	44	3,9	7 dk/min	12-16	10	51	59	
1600	39,2	57	4,4	8 dk/min	16-20	10	59	67	

MALZEME/MATERIAL PE 100			SDR 33 PN 5		Silindir alanı/Cylinder area 50,24 cm ²				
Diş Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/sn/min/sec	sn/sec	sn/sec	dk/min	dk/min	
500	15,3	7	2,0	3 dk/min	8-10	10	23	26	
560	17,2	9	2,2	3 dk/min	8-10	10	26	30	
630	19,2	11	2,4	4 dk/min	10-12	10	29	33	
710	21,3	14	2,6	4 dk/min	10-12	10	32	37	
800	24,5	18	3,0	5 dk/min	10-12	10	37	42	
900	27,6	23	3,3	6 dk/min	12-16	10	41	47	
1000	30,6	28	3,6	6 dk/min	12-16	10	46	53	
1200	36,7	40	4,2	7 dk/min	12-16	10	55	63	
1400	42,9	55	4,8	9 dk/min	16-20	10	64	73	
1600	49,0	71	5,4	10 dk/min	16-20	10	74	84	



MALZEME/MATERIAL PE 100			SDR 26 PN 6		Silindir alanı/Cylinder area 50,24 cm ²				
Diş Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/sn/min/sec	sn/sec	sn/sec	dk/min	dk/min	
500	19,1	9	2,4	4 dk/min	10-12	10	29	33	
560	21,4	11	2,6	4 dk/min	10-12	10	32	37	
630	24,1	14	2,9	5 dk/min	10-12	10	36	41	
710	27,2	18	3,2	5 dk/min	12-16	10	41	46	
800	30,6	22	3,6	6 dk/min	12-16	10	46	52	
900	34,4	28	3,9	7 dk/min	12-16	10	52	59	
1000	38,2	35	4,3	8 dk/min	16-20	10	57	65	
1200	45,9	50	5,1	9 dk/min	16-20	10	69	78	
1400	53,5	68	5,9	11 dk/min	20-25	10	80	91	
1600	61,2	88	6,6	12 dk/min	20-25	10	92	104	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

1000-1200-1600

1000-1200-1600 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ

1000-1200-1600 MACHINE PRESSURE AND TIME PARAMETERS

Kullanma Kılavuzu

Technical Information

MALZEME/MATERIAL PE 100 SDR 21 PN 8 Silindir alanı/Cylinder area 50,24 cm²

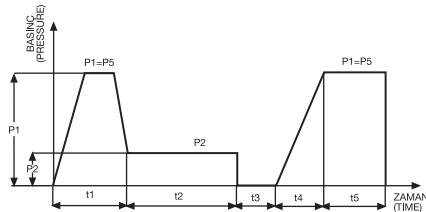
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
500	23,9	11	2,9	5 dk/min	10-12	10	36	41
560	26,7	13	3,2	5 dk/min	12-16	10	40	46
630	30,0	17	3,5	6 dk/min	12-16	10	45	51
710	33,9	21	3,9	7 dk/min	12-16	10	51	58
800	38,1	27	4,3	8 dk/min	16-20	10	57	65
900	42,9	34	4,8	9 dk/min	16-20	10	64	73
1000	47,7	43	5,3	10 dk/min	16-20	10	72	81
1200	57,2	61	6,2	11 dk/min	20-25	10	86	98
1400	66,7	83	7,2	13 dk/min	20-25	10	100	114
1600	76,2	127	9,5	18 dk/min	25-30	10	135	154

MALZEME/MATERIAL PE 100 SDR 17 PN 10 Silindir alanı/Cylinder area 50,24 cm²

Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
500	29,7	13	3,5	6 dk/min	12-16	10	45	51
560	33,2	16	3,8	7 dk/min	12-16	10	50	57
630	37,4	21	4,2	7 dk/min	16-20	10	56	64
710	42,1	26	4,7	8 dk/min	16-20	10	63	72
800	47,4	33	5,2	9 dk/min	16-20	10	71	81
900	53,3	42	5,8	11 dk/min	20-25	10	80	91
1000	59,3	52	6,4	12 dk/min	20-25	10	89	101
1200	71,1	75	7,6	14 dk/min	25-30	10	107	121
1400	83	102	8,8	17 dk/min	25-30	10	125	141
1600	94,84	134	10,0	19 dk/min	25-30	10	142	161

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100 SDR 13,6 PN 12,5 Silindir alanı/Cylinder area 14,13 cm²

Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
500	36,3	16	4,1	7 dk/min	12-16	10	54	62
560	41,2	20	4,6	8 dk/min	16-20	10	62	70
630	46,3	25	5,1	9 dk/min	16-20	10	69	79
710	52,2	32	5,7	10 dk/min	20-25	10	78	89
800	58,8	41	6,4	12 dk/min	20-25	10	88	100
900	66,2	52	7,1	13 dk/min	20-25	10	99	113
1000	73,5	64	7,9	15 dk/min	25-30	10	100	125
1200	71,1	75	7,6	14 dk/min	25-30	10	107	121
1400	83	102	8,8	17 dk/min	25-30	10	125	141
1600	94,84	134	10,0	19 dk/min	25-30	10	142	161

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

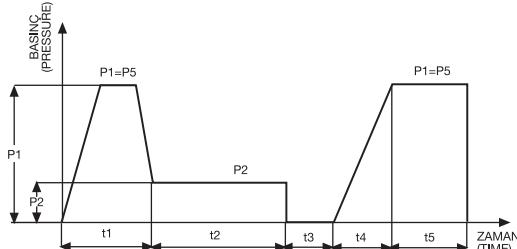
1000-1200-1600

1000-1200-1600 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ
1000-1200-1600 MACHINE PRESSURE AND TIME PARAMETERS

Kullanma Kılavuzu
Technical Information

MALZEME/MATERIAL PE 100			SDR 11 PN 16		Silindir alanı/Cylinder area 50,24 cm ²				
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
500	45,4	19	5,0	9 dk/min	16-20	10	68	78	
560	50,8	24	5,6	10 dk/min	20-25	10	76	87	
630	57,2	31	6,2	11 dk/min	20-25	10	86	98	
710	64,5	39	7,0	13 dk/min	20-25	10	97	110	
800	72,6	108	7,8	15 dk/min	25-30	10	109	124	
900	81,7	137	8,7	16 dk/min	25-30	10	123	139	
1000	90,8	77	9,6	18 dk/min	25-30	10	136	155	
1200									
1600									

MALZEME/MATERIAL PE 100			SDR 9 PN 20		Silindir alanı/Cylinder area 50,24 cm ²				
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
500	55,8	23	6,1	11 dk/min	20-25	10	84	95	
560	62,2	29	6,7	12 dk/min	20-25	10	93	106	
630									
710									
800									
900									
1000									
1200									
1600									



MALZEME/MATERIAL PE 80			SDR 41 PN 3.2		Silindir alanı/Cylinder area 50,24 cm ²				
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
500	12,3	6	1,7	2 dk/min	8-10	10	18	21	
560	13,7	7	1,9	3 dk/min	8-10	10	21	24	
630	15,4	9	2,0	3 dk/min	8-10	10	23	27	
710	17,4	11	2,2	3 dk/min	8-10	10	26	30	
800	19,6	14	2,5	4 dk/min	10-12	10	29	34	
900	22,0	18	2,7	4 dk/min	10-12	10	33	38	
1000	24,5	22	3,0	5 dk/min	10-12	10	37	42	
1200	29,4	32	3,4	6 dk/min	12-16	10	44	50	
1400	34,3	44	3,9	7 dk/min	12-16	10	51	59	
1600	39,2	57	4,4	8 dk/min	16-20	10	59	67	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

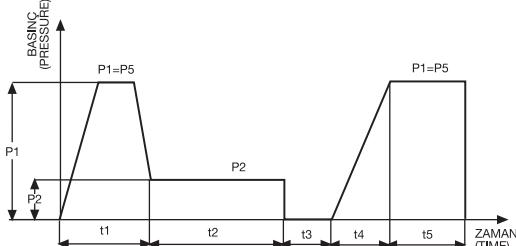
1000-1200-1600

1000-1200-1600 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ
1000-1200-1600 MACHINE PRESSURE AND TIME PARAMETERS

Kullanma Kılavuzu
Technical Information

MALZEME/MATERIAL PE 80			SDR 33 PN 4		Silindir alanı/Cylinder area 50,24 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
500	15,3	7	2,0	3 dk/min	8-10	10	23	26
560	17,2	9	2,2	3 dk/min	8-10	10	26	30
630	19,3	11	2,4	4 dk/min	10-12	10	29	33
710	21,8	14	2,7	4 dk/min	10-12	10	33	37
800	24,5	18	3,0	5 dk/min	10-12	10	37	42
900	27,5	22	3,3	6 dk/min	12-16	10	41	47
1000	30,6	28	3,6	6 dk/min	12-16	10	46	53
1200	36,70	40	4,2	7 dk/min	12-16	10	55	63
1400	42,9	55	4,8	9 dk/min	16-20	10	64	73
1600	49	71	5,4	10 dk/min	16-20	10	74	84

MALZEME/MATERIAL PE 80			SDR 26 PN 5		Silindir alanı/Cylinder area 50,24 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
500	19,1	9	2,4	4 dk/min	10-12	10	29	33
560	21,4	11	2,6	4 dk/min	10-12	10	32	37
630	24,1	14	2,9	5 dk/min	10-12	10	36	41
710	27,2	17	3,2	5 dk/min	12-16	10	41	47
800	30,6	22	3,6	6 dk/min	12-16	10	46	52
900	34,4	28	3,9	7 dk/min	12-16	10	52	59
1000	38,2	34	4,1	7 dk/min	16-20	10	54	62
1200	45,9	47	4,9	9 dk/min	16-20	10	65	74
1400	59,8	64	5,6	10 dk/min	20-25	10	76	87
1600	58,0	84	6,3	12 dk/min	20-25	10	87	99



MALZEME/MATERIAL PE 80			SDR 21 PN 6		Silindir alanı/Cylinder area 50,24 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/min/sn/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
500	23,9	10	2,9	5 dk/min	10-12	10	36	41
560	26,7	15	3,2	5 dk/min	12-16	10	40	46
630	30,0	17	3,5	6 dk/min	12-16	10	45	51
710	33,9	20	3,9	7 dk/min	12-16	10	51	58
800	38,1	30	4,3	8 dk/min	16-20	10	57	65
900	42,9	35	4,8	9 dk/min	16-20	10	64	73
1000	47,7	45	5,3	10 dk/min	16-20	10	72	81
1200	57,2	60	6,2	11 dk/min	20-25	10	86	97
1400	66,7	85	7,2	13 dk/min	20-25	10	100	114
1600	76,2	110	8,1	15 dk/min	25-30	10	114	130

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

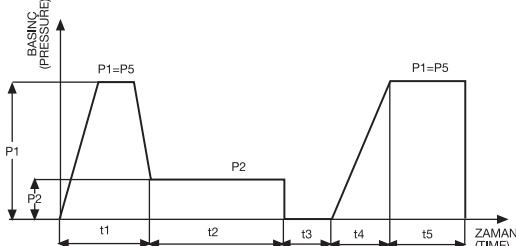
1000-1200-1600

1000-1200-1600 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ
1000-1200-1600 MACHINE PRESSURE AND TIME PARAMETERS

Kullanma Kılavuzu
Technical Information

MALZEME/MATERIAL PE 80			SDR 17 PN 8		Silindir alanı/Cylinder area 50,24 cm ²				
Diş Cap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
500	29,7	13	3,5	6 dk/min	12-16	10	45	51	
560	33,2	16	3,8	7 dk/min	12-16	10	50	57	
630	37,4	21	4,2	7 dk/min	16-20	10	56	64	
710	42,1	26	4,7	8 dk/min	16-20	10	63	72	
800	47,4	33	5,2	9 dk/min	16-20	10	71	81	
900	53,3	42	5,8	11 dk/min	20-25	10	80	91	
1000	59,3	52	6,4	12 dk/min	20-25	10	89	101	
1200									
1400									
1600									

MALZEME/MATERIAL PE 80			SDR 13,6 PN 10		Silindir alanı/Cylinder area 50,24 cm ²				
Diş Cap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
500	36,8	16	4,2	7 dk/min	12-16	10	55	63	
560	41,2	20	4,6	8 dk/min	16-20	10	62	70	
630	46,3	25	5,1	9 dk/min	16-20	10	69	79	
710	52,2	32	5,7	10 dk/min	20-25	10	78	89	
800	58,8	41	6,4	12 dk/min	20-25	10	88	100	
900	66,2	52	7,1	13 dk/min	20-25	10	99	113	
1000	73,5	64	7,9	15 dk/min	25-30	10	110	125	
1200	71,1	75	7,6	14 dk/min	25-30	10	107	121	
1400	83	102	8,8	17 dk/min	25-30	10	125	141	
1600	94,84	134	10,0	19 dk/min	25-30	10	142	161	



MALZEME/MATERIAL PE 80			SDR 11 PN 12,5		Silindir alanı/Cylinder area 50,24 cm ²				
Diş Cap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min	
500	45,4	19	5,0	9 dk/min	16-20	10	68	78	
560	50,8	24	5,6	10 dk/min	20-25	10	76	87	
630	57,2	31	6,2	11 dk/min	20-25	10	86	98	
710	64,5	39	7,0	13 dk/min	20-25	10	97	110	
800	72,6	108	7,8	15 dk/min	25-30	10	109	124	
900	81,7	137	8,7	16 dk/min	25-30	10	123	139	
1000	90,8	77	9,6	18 dk/min	25-30	10	136	155	
1200									
1400									
1600									

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

1000-1200-1600

1000-1200-1600 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ
1000-1200-1600 MACHINE PRESSURE AND TIME PARAMETERS

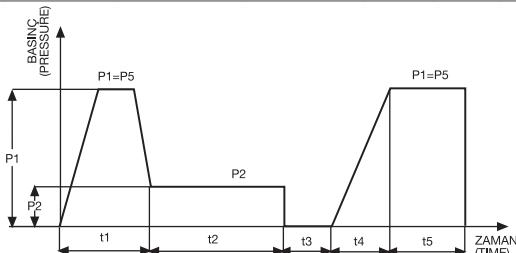
Kullanma Kılavuzu
Technical Information

MALZEME/MATERIAL PE 80 SDR 9 PN 16 Silindir alanı/Cylinder area 50,24 cm²

Diş Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min
500	23,9	11	2,9	5 dk/min	10-12	10	36	41
560	62,5	29	6,8	13 dk/min	20-25	10	94	106
630	70,3	80	7,5	14 dk/min	25-30	10	105	120
710	79,3	102	8,4	16 dk/min	25-30	10	119	135
800	89,3	130	9,4	18 dk/min	25-30	10	134	152
900								
1000								
1200								
1400								
1600								

MALZEME/MATERIAL PE 80 SDR 7,4 PN 20 Silindir alanı/Cylinder area 50,24 cm²

Diş Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min
500								
560								
630								
710								
800								
900								
1000								
1200								



MALZEME/MATERIAL PE 80 SDR 6 PN 25 Silindir alanı/Cylinder area 50,24 cm²

Diş Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total
mm	mm	P1=P5(BAR)	mm	dk/min/sn/sec	sn/sec	sn/sec	dk/min	dk/min
500								
560								
630								
710								
800								
900								
1000								
1200								
1400								
1600								

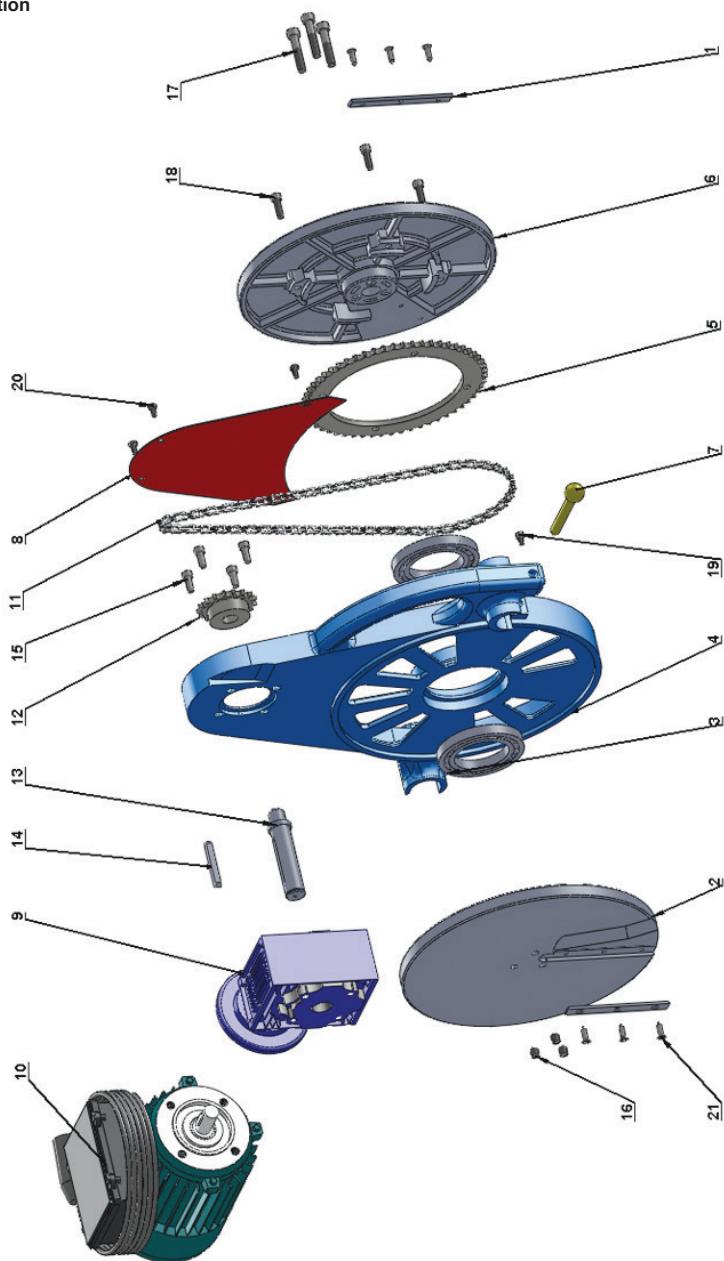
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

AL 250

Kullanma Kılavuzu
Technical Information

AL 250 TIRAŞLAYICI / AL 250 TRIMMER



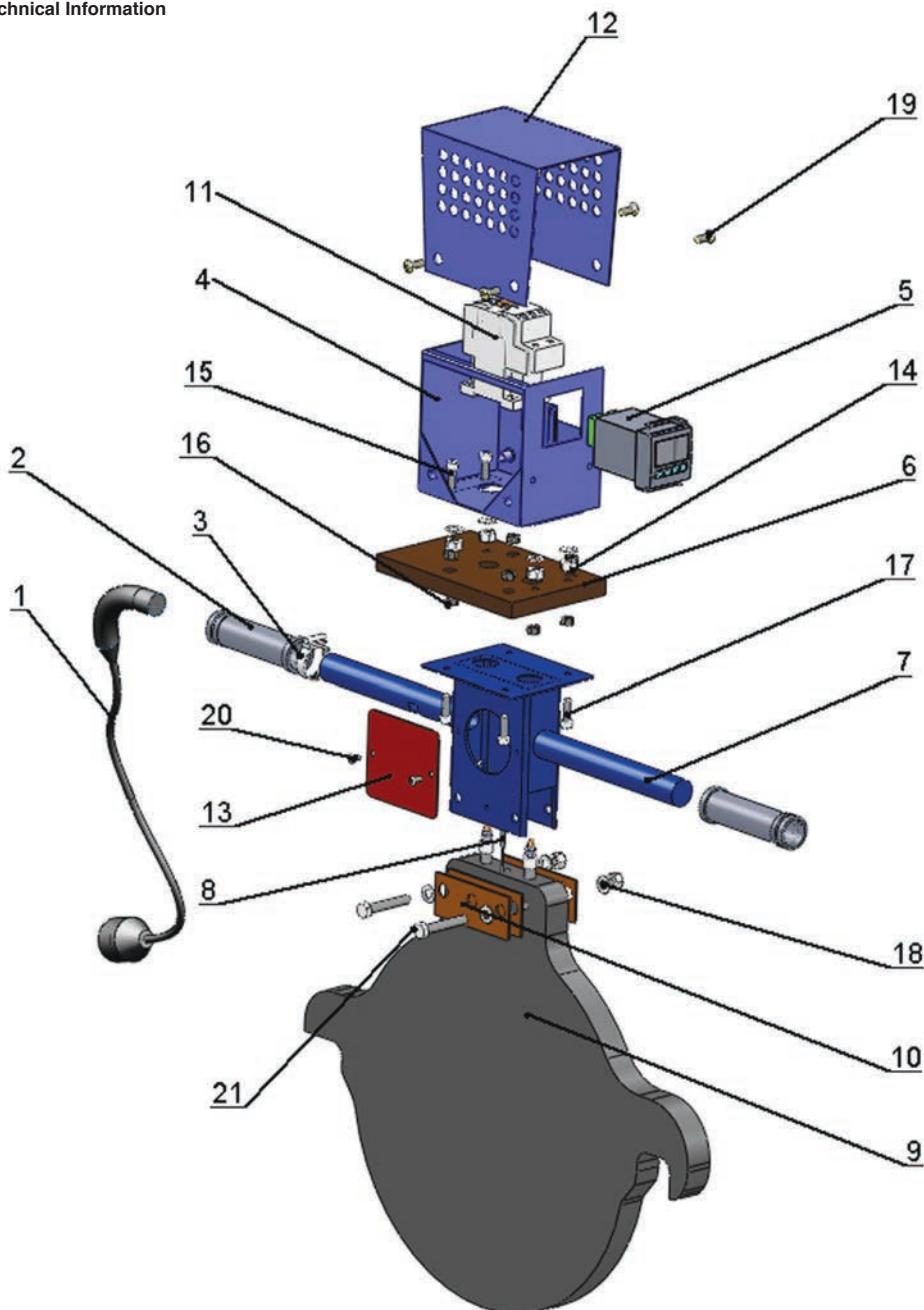
AL 250 TIRAŞLAYICI LİSTESİ			
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL250 70	BIÇAK	2 ADET
2	AL250 71	TIRAŞLAYICI DÜZ DISK	1 ADET
3	AL250 72	RULMAN (16014)	2 ADET
4	AL250 73	TIRAŞLAYICI GÖVDE	1 ADET
5	AL250 74	ZİNCİR DİŞLİ	1 ADET
6	AL250 75	TIRAŞLAYICI DİŞLİ DISK	1 ADET
7	AL250 76	EMNİYET PİMİ	1 ADET
8	AL250 77	TIRAŞLAYICI KAPAK	1 ADET
9	AL250 78	REDÜKTÖR	1 ADET
10	AL250 79	MOTOR (0,55 Kw) MONOFAZE 1400 d/dk	1 ADET
11	AL250 80	ZİNCİR	1 ADET
12	AL250 150	ZİNCİR ÜST DİŞLİ	1 ADET
13	AL250 151	ZİNCİR ÜST DİŞLİ MİLİ	1 ADET
14	AL250 152	ZİNCİR MİLİ KAMASI	1 ADET
15	AL250 153	M8X20 İMBUS CİVATA	4 ADET
16	AL250 154	M10X12 SETUSKUR	3 ADET
17	AL250 155	M10X50 İMBUS CİVATA	3 ADET
18	AL250 156	M8X25 İMBUS CİVATA	4 ADET
19	AL250 157	M6X10 İMBUS	1 ADET
20	AL250 158	M6X12 AKB CİVATA	4 ADET
21	AL250 159	M6X15 VİDA	6 ADET

AL 250 TRIMMER LIST			
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL250 70	BLADE	2 ITEMS
2	AL250 71	TRIMMER PLAIN DISC	1 ITEM
3	AL250 72	BEARING	2 ITEMS
4	AL250 73	TRIMMER BODY	1 ITEM
5	AL250 74	CHAIN BEARING	1 ITEM
6	AL250 75	TRIMMER SCREW DISC	1 ITEM
7	AL250 76	SAFETY PIN	1 ITEM
8	AL250 77	TRIMMER COVER	1 ITEM
9	AL250 78	REDUCTOR	1 ITEM
10	AL250 79	MOTOR	1 ITEM
11	AL250 80	CHAIN	1 ITEM
12	AL250 150	CHAIN UPPER GEAR	1 ITEM
13	AL250 151	CHAIN UPPER GEAR SHAFT	1 ITEM
14	AL250 152	CHAIN SHAFT PIN	1 ITEM
15	AL250 153	M8x20 İMBUS BOLT	4 ITEMS
16	AL250 154	M10x22 SCREW	3 ITEMS
17	AL250 155	M10x50 İMBUS BOLT	3 ITEMS
18	AL250 156	M8x25 İMBUS BOLT	4 ITEMS
19	AL250 157	M6x10 İMBUS BOLT	1 ITEM
20	AL250 158	M6x12 AKC BOLT	4 ITEMS
21	AL250 159	M6x15 SCREW	6 ITEMS

AL 250

Kullanma Kılavuzu
Technical Information

AL 250 İSITICI / AL 250 HEATER



AL 250

Kullanma Kılavuzu
Technical Information

AL 250 ISITICI LİSTESİ / AL 250 HEATER LIST

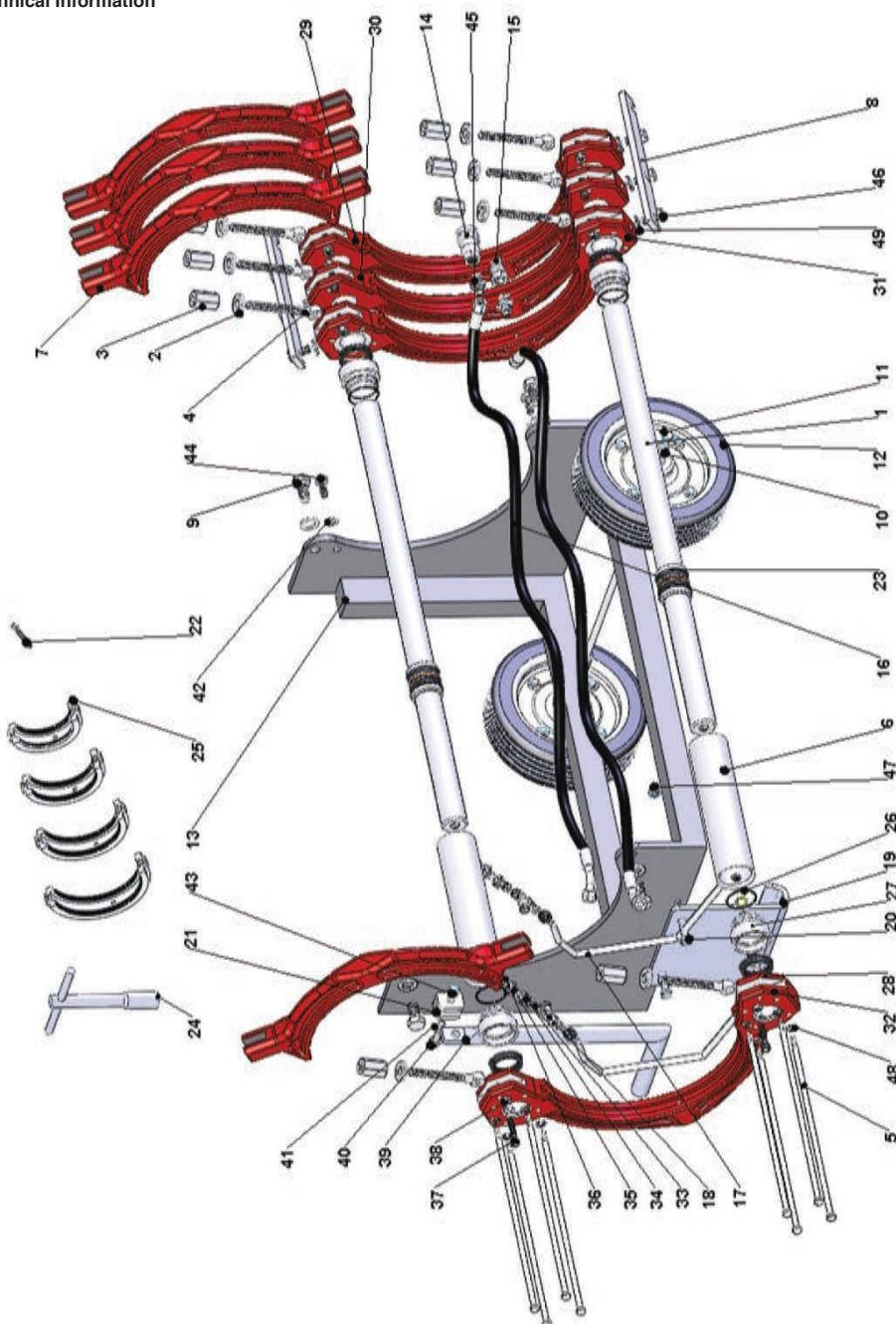
AL 250				ISITICI LİSTESİ
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET	
1	AL250 82	ELEKTRİK KABLOSU	1 ADET	
2	AL250 83	TAŞIMA KOLU İZOLESİ	2 ADET	
3	AL250 84	KELEPÇE	1 ADET	
4	AL250 85	ISITICI KONTROL PANELİ	1 ADET	
5	AL250 86	İSİ KONTROL CİHAZI	1 ADET	
6	AL250 87	İSİ YALITIM FİBERİ	1 ADET	
7	AL250 88	TAŞIMA KOLU	1 ADET	
8	AL250 89	TERMOKULP	1 ADET	
9	AL250 90	ISITICI	1 ADET	
10	AL250 91	KEÇE	1 ADET	
11	AL250 92	KONTAKTÖR	1 ADET	
12	AL250 93	ÜST KAPAK	1 ADET	
13	AL250 94	KORUYUCU KAPAK(KIRMIZI)	1 ADET	
14	AL250 95	M8 SOMUN	4 ADET	
15	AL250 96	M6 X 20 İMBUS CİVATA	4 ADET	
16	AL250 97	M6 SOMUN	8 ADET	
17	AL250 98	M6 X 25 İMBUS CİVATA	4 ADET	
18	AL250 99	PUL	8 ADET	
19	AL250 100	M6 X 14,5 VİDA	4 ADET	
20	AL250 101	M4 VİDA (KORUYUCU KAPAK)	2 ADET	
21	AL250 102	M8 X 50 AKB CİVATA	2 ADET	

AL 250				HEATER LIST
NO	CODE NUMBER	ITEM ID	QUANTITY	
1	AL250 82	ELECTRIC CABLE	1 ITEM	
2	AL250 83	CARRYING HANDLE ISOLATION	2 ITEMS	
3	AL250 84	CLIPS	1 ITEM	
4	AL250 85	CONTROL PANNEL	1 ITEM	
5	AL250 86	ELECTRIC BOX	1 ITEM	
6	AL250 87	HEAT ISOLATION FIBER	1 ITEM	
7	AL250 88	CARRYING HANDLE	1 ITEM	
8	AL250 89	TERMOCOUPLE	1 ITEM	
9	AL250 90	HEATER	1 ITEM	
10	AL250 91	BUSH	1 ITEM	
11	AL250 92	CONTACTOR	1 ITEM	
12	AL250 93	UPPER COVER	1 ITEM	
13	AL250 94	PROTECTIVE COVER (RED)	1 ITEM	
14	AL250 95	M8 NUT	4 ITEMS	
15	AL250 96	M6x20 IMBUS BOLT	4 ITEMS	
16	AL250 97	M6 NUT	8 ITEMS	
17	AL250 98	M6x25 IMBUS BOLT	4 ITEMS	
18	AL250 99	WASHER	8 ITEMS	
19	AL250 100	M6x14,5 SCREW	4 ITEMS	
20	AL250 101	M4 SCREW (FOR PROTECTIVE COVER)	2 ITEMS	
21	AL250 102	M8x50 AKB BOLT	2 ITEMS	

AL 250

Kullanma Kılavuzu
Technical Information

AL 250 GÖVDE / AL 250 BASIC MACHINE



AL 250 GÖVDE LİSTESİ

PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL250 01	SERT KROMLU MİL 40X800mm	2 ADET
2	AL250 02	M12 PUL	8 ADET
3	AL250 03	BAĞLANTI CİVATASI SOMUNU M12	8 ADET
4	AL250 04	BAĞLANTI CİVATASI SAĞLAMASI M8X350 mm	8 ADET
5	AL250 05	PISTON BAĞLANTI SAPLAMASI M8X350 mm	2 ADET
6	AL250 06	HONLANMIŞ BORU 50X60X300 mm	2 ADET
7	AL250 07	BORU BAĞLANTI KELEPÇESİ	4 ADET
8	AL250 08	ARA BAĞLAMA ADAPTÖRÜ	2 ADET
9	AL250 09	MİL BAĞLANTI CİVATASI M16X30 mm	4 ADET
10	AL250 10	TEKER PULU	2 ADET
11	AL250 11	TEKER CİVATASI M10X15 mm	2 ADET
12	AL250 12	TEKER 200X80 mm	2 ADET
13	AL250 13	ANA GÖVDE	1 ADET
14	AL250 14	HİDROLİK OTOMATİK REKOR (ERKEK)	1 ADET
15	AL250 15	HİDROLİK OTOMATİK REKOR (DİŞİ)	1 ADET
16	AL250 16	HİDROLİK HORTUM	1 ADET
17	AL250 17	HİDROLİK YAĞ BORUSU	2 ADET
18	AL250 18	T PARÇASI	4 ADET
19	AL250 19	ANA GÖVDE AYAĞI	1 ADET
20	AL250 20	ANA GÖVDE AYAĞI BAĞLANTI CİVATASI M10X30 mm	2 ADET
21	AL250 21	TAŞIMA KOLU YUVASI	1 ADET
22	AL250 22	PAFTA BAĞLANTI CİVATASI	48 ADET
23	AL250 23	YAĞ KEÇESİ 50X40X10 mm	2 ADET
24	AL250 24	24 LOKMA	1 ADET
25	AL250 25	PAFTALAR (75,90,110,125,140,160,180,200,225)	72 ADET
26	AL250 27	O RİNG 50X46X2 mm	4 ADET
27	AL250 28	SİFERO BOGAZ	4 ADET
28	AL250 29	TOZ KEÇESİ 48X40X7 mm	4 ADET
29	AL250120	ÇİFT DELİK ALT ÇENE	1 ADET
30	AL250121	TEK DELİK ALT ÇENE	1 ADET
31	AL250122	KÖR 4 DELİK ALT ÇENE	1 ADET
32	AL250123	PATLAK 4 DELİK ALT ÇENE	1 ADET
33	AL250124	10 LUK YÜZÜK	6 ADET
34	AL250125	M10 SOMUN	6 ADET
35	AL250126	1/4" 10 TERS REKOR	4 ADET
36	AL250127	1/4" BAKIR PUL	4 ADET
37	AL250128	M8 X 40 İMBUS CİVATA	8 ADET
38	AL250129	M8 SOMUN	8 ADET
39	AL250130	TAŞIMA KOLU	1 ADET
40	AL250131	TAŞIMA KOLU BAĞLANTI CİVATASI M10 X 45	1 ADET
41	AL250132	TAŞIMA KOLU BAĞLANTI PULU M10	1 ADET
42	AL250133	MİL BAĞLANTI PULU M10	4 ADET
43	AL250134	TAŞIMA KOLU SOMUNU M10	1 ADET
44	AL250135	M10 X 25 AKC CİVATA	2 ADET
45	AL250136	3/8" 10 REKOR	2 ADET
46	AL250137	M12 X25 AKC CİVATA	6 ADET
47	AL250138	ÖN AYAK BAĞLANTI SOMUNU M10	6 ADET
48	AL250139	PISTON BAĞLANTI SAPLAMASI M8 PUL	16 ADET
49	AL250140	ARA BAĞLAMA ADAPTÖRÜ M12 PUL	6 ADET

AL 250

Kullanma Kılavuzu
Technical Information

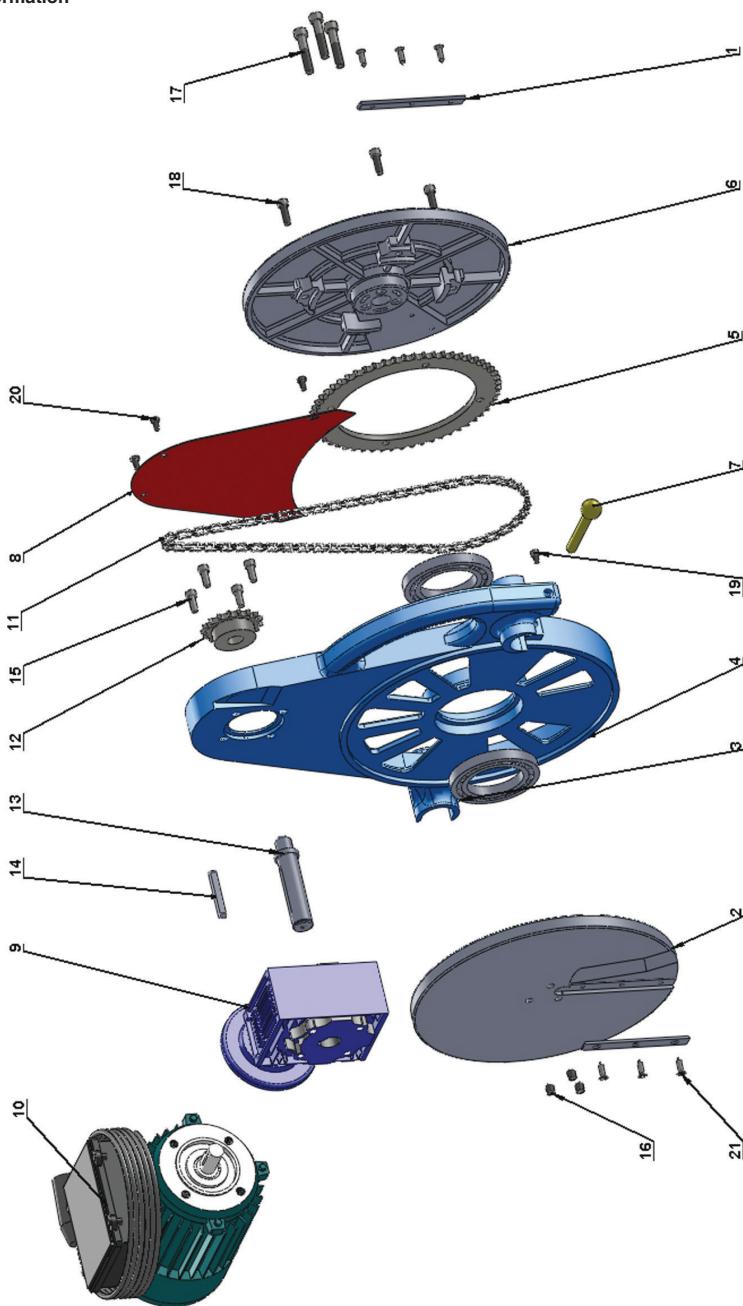
AL 250 BASIC MACHINE LIST

AL 250 BASIC MACHINE LIST			
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL250 01	CHROME COATED SHAFT (40x800 mm)	2 ITEMS
2	AL250 02	M12 WASHER	8 ITEMS
3	AL250 03	M12x40 NUT	8 ITEMS
4	AL250 04	PIN SCREW	8 ITEMS
5	AL250 05	PIN	2 ITEMS
6	AL250 06	POLISHED PIPE (50x60x300 mm)	2 ITEMS
7	AL250 07	UPPER CLAMP	4 ITEMS
8	AL250 08	PLATE ROD	2 ITEMS
9	AL250 09	AKC BOLT M16 x30	4 ITEMS
10	AL250 10	WASHER	2 ITEMS
11	AL250 11	WHEEL BOLT (M10x15)	2 ITEMS
12	AL250 12	WHEEL (250x80 mm)	2 ITEMS
13	AL250 13	FRAME	1 ITEM
14	AL250 14	3/8" MALE QUICK COUPLING	1 ITEM
15	AL250 15	3/8" FEMALE QUICK COUPLING	1 ITEM
16	AL250 16	5/16" HYDRAULIC HOSE	1 ITEM
17	AL250 17	M10 ALUMINUM PIPE	2 ITEMS
18	AL250 18	M10 TE PIECE	4 ITEMS
19	AL250 19	FORE LEG	1 ITEM
20	AL250 20	FORE LEG BOLT (M8x30 mm)	2 ITEMS
21	AL250 21	HANDLE PLACE	1 ITEM
22	AL250 22	BOLT CONNECTING JOINT	48 ITEMS
23	AL250 23	OIL BUSH (50x40x10 mm)	2 ITEMS
24	AL250 24	KEY 24	1 ITEM
25	AL250 25	BOLTS (75,90,110,125,140,160,180,200,225)	72 ITEMS
26	AL250 27	O RING (50x46x2 mm)	4 ITEMS
27	AL250 28	SIFERO NECK	4 ITEMS
28	AL250 29	DUST FELT 48*40*7	4 ITEMS
29	AL250120	DOUBLE HOLE LOWER CLAMP	1 ITEM
30	AL250121	SINGLE HOLE LOWER CLAMP	1 ITEM
31	AL250122	4 HOLE BLIND LOWER CLAMP	1 ITEM
32	AL250123	4 HOLE LOWER CLAMP	1 ITEM
33	AL250124	M10 RING	6 ITEMS
34	AL250125	M10 NUT	6 ITEMS
35	AL250126	REVERSE ADAPTOR 1/4" 10	4 ITEMS
36	AL250127	1/4" COPPER WASHER	4 ITEMS
37	AL250128	M8x 40 IMBUS BOLT	8 ITEMS
38	AL250129	M8 NUT	8 ITEMS
39	AL250130	CARRYING HANDLE	1 ITEM
40	AL250131	CARRYING HANDLE BOLT CONNECTOR M10 X 45	1 ITEM
41	AL250132	CARRYING HANDLE WASHER CONNECTOR M10	1 ITEM
42	AL250133	M10 WASHER	4 ITEMS
43	AL250134	CARRYING HANDLE NUT M10	1 ITEM
44	AL250135	M10 x25 AKC BOLT	2 ITEMS
45	AL250136	3/8" 10 ADAPTOR	2 ITEMS
46	AL250137	M12 x25 AKC BOLT	6 ITEMS
47	AL250138	M8 NUT	6 ITEMS
48	AL250139	M8 WASHER	16 ITEMS
49	AL250140	M12 WASHER	6 ITEMS

AL 315

AL 315 TIRAŞLAYICI / AL 315 TRIMMER

Kullanma Kılavuzu
Technical Information



AL 315

Kullanma Kılavuzu
Technical Information

AL 315 TIRAŞLAYICI LİSTESİ / AL 315 TRIMMER LIST

AL 315 TIRAŞLAYICI LİSTESİ

PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL315 71	BIÇAK	2 ADET
2	AL315 72	TIRAŞLAYICI DÜZ DISK	1 ADET
3	AL315 73	RULMAN (16014)	2 ADET
4	AL315 74	TIRAŞLAYICI GÖVDE	1 ADET
5	AL315 75	ZİNCİR DIŞLI	1 ADET
6	AL315 76	TIRAŞLAYICI DIŞLI DISK	1 ADET
7	AL315 77	EMNİYET PİMİ	1 ADET
8	AL315 78	TIRAŞLAYICI KAPAK	1 ADET
9	AL315 79	REDÜKTÖR	1 ADET
10	AL315 80	MOTOR (0,75 Kw) MONOFAZE 1400 d/dk	1 ADET
11	AL315 81	ZİNCİR	1 ADET
12	AL315150	ZİNCİR ÜST DIŞLI	1 ADET
13	AL315151	ZİNCİR ÜST DIŞLI MİLİ	1 ADET
14	AL315152	ZİNCİR MİLİ KAMASI	1 ADET
15	AL315153	M8X20 İMBUS CİVATA	4 ADET
16	AL315154	M10X12 SETUSKUR	3 ADET
17	AL315155	M10X50 İMBUS CİVATA	3 ADET
18	AL315156	M8X25 İMBUS CİVATA	4 ADET
19	AL315157	M6X10 İMBUS	1 ADET
20	AL315158	M6X12 AKB CİVATA	4 ADET
21	AL315159	M6*15VİDA	6 ADET

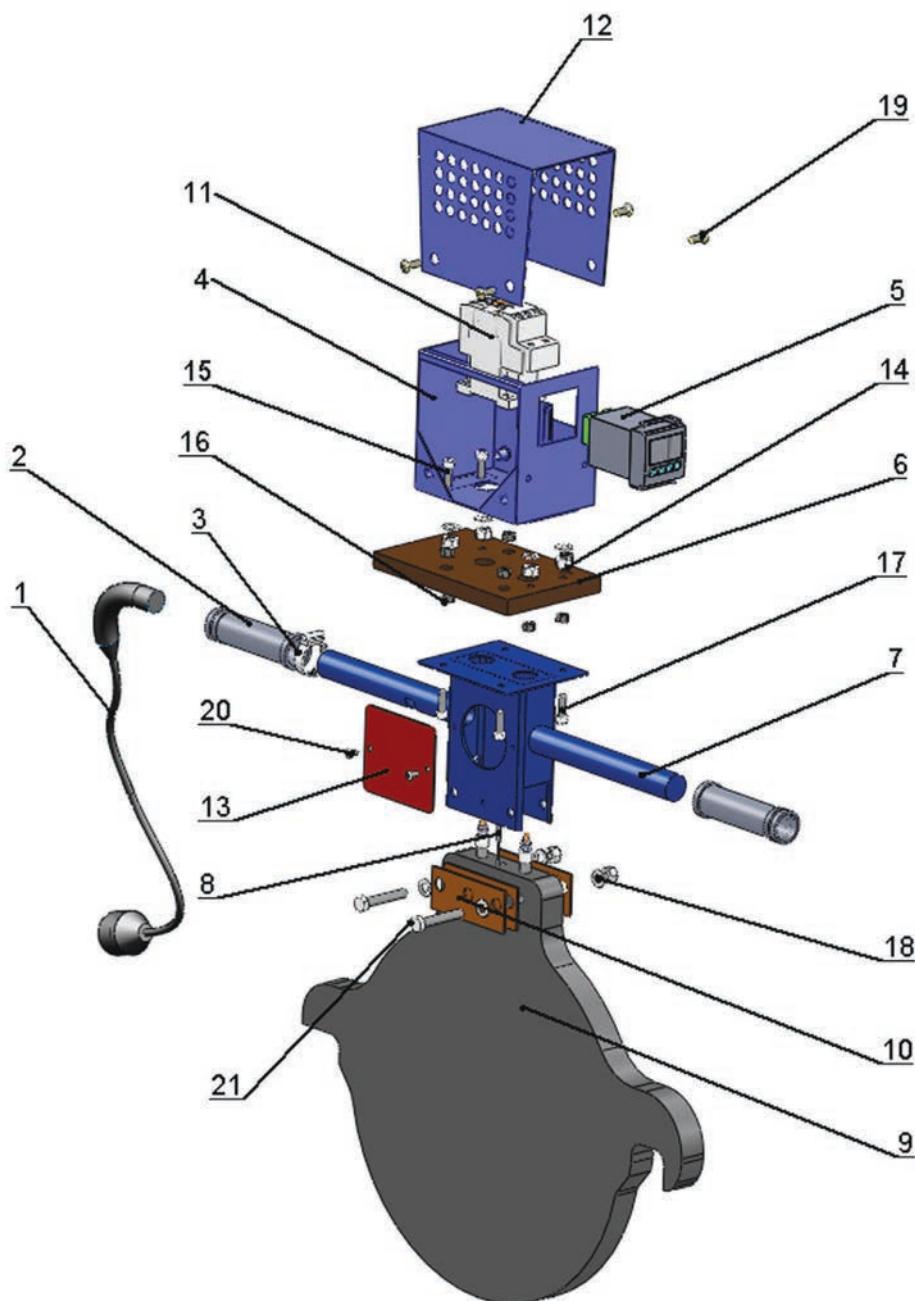
AL 315 TRIMMER LIST

NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL315 71	BLADE	2 ITEMS
2	AL315 72	TRIMMER PLAIN DISC	1 ITEM
3	AL315 73	BEARING	2 ITEMS
4	AL315 74	TRIMMER BODY	1 ITEM
5	AL315 75	CHAIN BEARING	1 ITEM
6	AL315 76	TRIMMER SCREW DISC	1 ITEM
7	AL315 77	SAFETY PIN	1 ITEM
8	AL315 78	TRIMMER COVER	1 ITEM
9	AL315 79	REDUCTOR	1 ITEM
10	AL315 80	MOTOR	1 ITEM
11	AL315 81	CHAIN	1 ITEM
12	AL315150	CHAIN UPPER GEAR	1 ITEM
13	AL315151	CHAIN UPPER GEAR SHAFT	1 ITEM
14	AL315152	CHAIN SHAFT PIN	1 ITEM
15	AL315153	M8x20 İMBUS BOLT	4 ITEMS
16	AL315154	M10x12 SCREW	3 ITEMS
17	AL315155	M10x50 İMBUS BOLT	3 ITEMS
18	AL315156	M8x25 İMBUS BOLT	4 ITEMS
19	AL315157	M6x10 İMBUS BOLT	1 ITEM
20	AL315158	M6x12 AKC BOLT	4 ITEMS
21	AL315159	M6x15 SCREW	6 ITEMS

AL 315

AL 315 ISITICI / AL 315 HEATER

Kullanma Kılavuzu
Technical Information



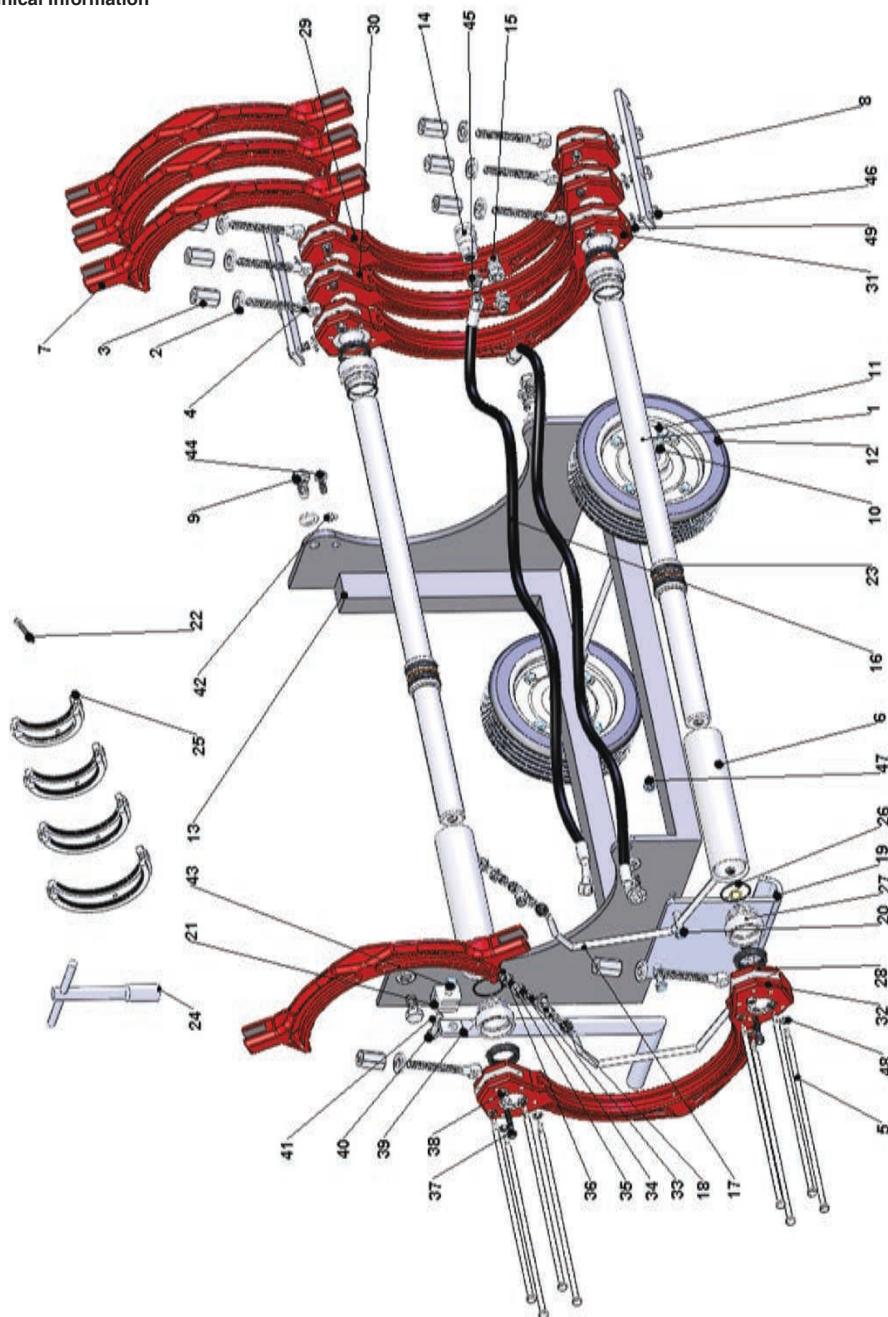
AL 315

Kullanma Kılavuzu
Technical Information

AL 315 İSİTİCİ LİSTESİ / AL 315 HEATER LIST

AL 315 İSİTİCİ LİSTESİ			
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL315 82	ELEKTRİK KABLOSU	1 ADET
2	AL315 83	TAŞIMA KOLU İZOLESİ	2 ADET
3	AL315 84	KELEPÇE	1 ADET
4	AL315 85	İSİTİCİ KONTROL PANELİ	1 ADET
5	AL315 86	İSI KONTROL CİHAZI	1 ADET
6	AL315 87	İSİ YALITIM FİBERİ	1 ADET
7	AL315 88	TAŞIMA KOLU	1 ADET
8	AL315 89	TERMOKULP	1 ADET
9	AL315 90	İSİTİCİ	1 ADET
10	AL315 91	KEÇE	1 ADET
11	AL315 92	KONTAKTÖR	1 ADET
12	AL315 93	ÜST KAPAK	1 ADET
13	AL315 94	KORUYUCU KAPAK(KIRMIZI)	1 ADET
14	AL315 95	M8 SOMUN	4 ADET
15	AL315 96	M6 X 20 İMBUS CİVATA	4 ADET
16	AL315 97	M6 SOMUN	8 ADET
17	AL315 98	M6 X 25 İMBUS CİVATA	4 ADET
18	AL315 99	PUL	8 ADET
19	AL315 100	M6 X 14,5 VİDA	4 ADET
20	AL315 101	M4 VİDA (KORUYUCU KAPAK)	2 ADET
21	AL315 102	M8 X 50 AKB CİVATA	2 ADET

AL 315 HEATER LIST			
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL315 82	ELECTRIC CABLE	1 ITEM
2	AL315 83	CARRYING HANDLE ISOLATION	2 ITEMS
3	AL315 84	CLIPS	1 ITEM
4	AL315 85	CONTROL PANNEL	1 ITEM
5	AL315 86	ELECTRIC BOX	1 ITEM
6	AL315 87	HEAT ISOLATION FIBER	1 ITEM
7	AL315 88	CARRYING HANDLE	1 ITEM
8	AL315 89	TERMOCOUPLE	1 ITEM
9	AL315 90	HEATER	1 ITEM
10	AL315 91	BUSH	1 ITEM
11	AL315 92	CONTACTOR	1 ITEM
12	AL315 93	UPPER COVER	1 ITEM
13	AL315 94	PROTECTIVE COVER (RED)	1 ITEM
14	AL315 95	M8 NUT	4 ITEMS
15	AL315 96	M6x20 IMBUS BOLT	4 ITEMS
16	AL315 97	M6 NUT	8 ITEMS
17	AL315 98	M6x25 IMBUS BOLT	4 ITEMS
18	AL315 99	WASHER	8 ITEMS
19	AL315 100	M6x14,5 SCREW	4 ITEMS
20	AL315 101	M4 SCREW (FOR PROTECTIVE COVER)	2 ITEMS
21	AL315 102	M8x50 AKB BOLT	2 ITEMS



AL 315

GÖVDE LİSTESİ

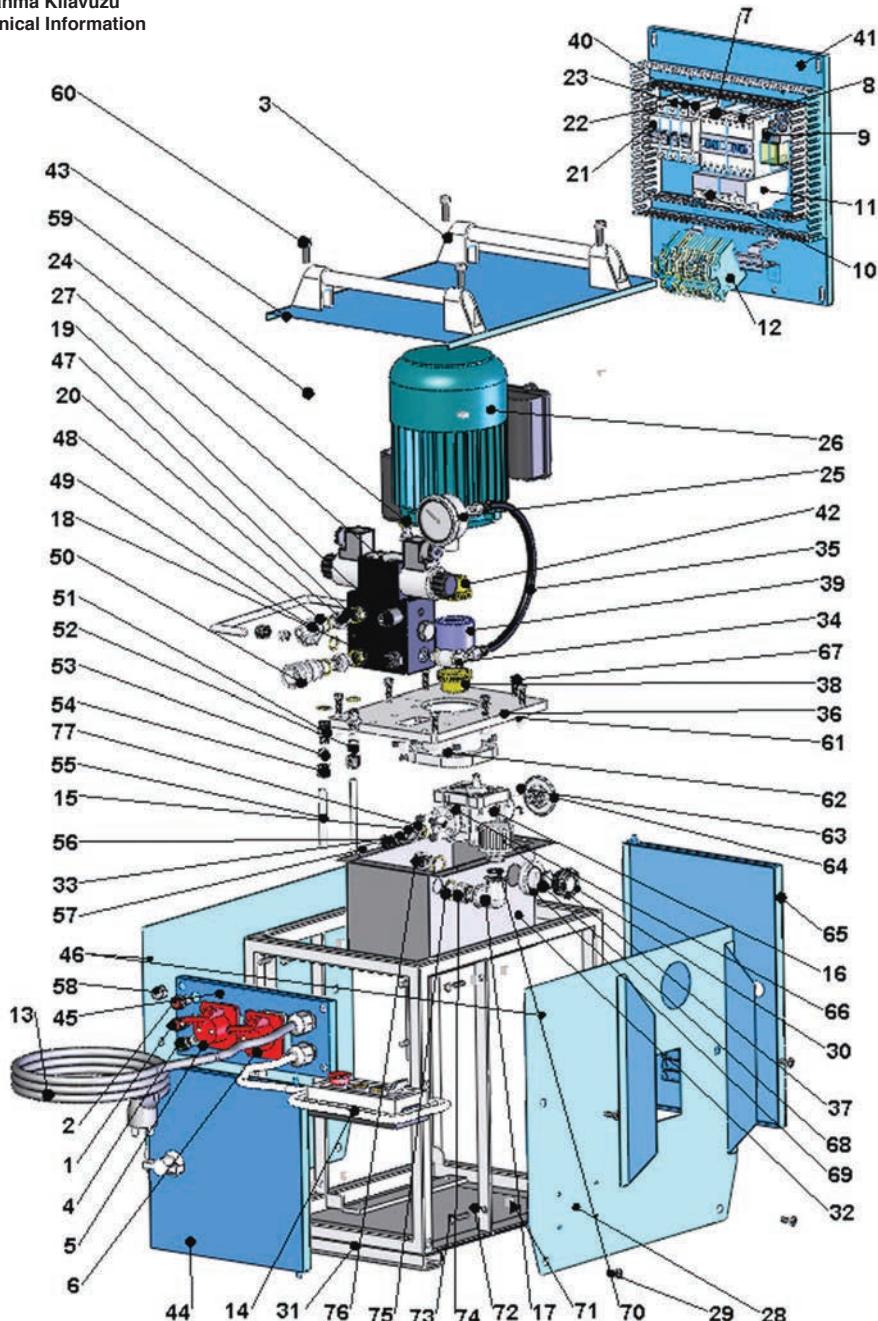
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL315 01	SERT KROMLU MİL 40X800mm	2 ADET
2	AL315 02	PUL	8 ADET
3	AL315 03	BAĞLANTI CİVATASI SOMUNU	8 ADET
4	AL315 04	BAĞLANTI CİVATASI SAPLAMASI	8 ADET
5	AL315 05	PISTON BAĞLANTI SAPLAMASI	2 ADET
6	AL315 06	HONLANMIŞ BORU 50X60X300 mm	2 ADET
7	AL315 07	BORU BAĞLANTI KELEPÇESİ	4 ADET
8	AL315 08	ARA BAĞLAMA ADAPTÖRÜ	2 ADET
9	AL315 09	MİL BAĞLANTI CİVATASI M16X30	4 ADET
10	AL315 10	TEKER PULU	2 ADET
11	AL315 11	TEKER CİVATASI M10X15	2 ADET
12	AL315 12	TEKER 250x80	2 ADET
13	AL315 13	ANA GÖVDE	1 ADET
14	AL315 14	HİDROLİK OTOMATİK REKOR (ERKEK)	1 ADET
15	AL315 15	HİDROLİK OTOMATİK REKOR (DİŞİ)	1 ADET
16	AL315 16	HİDROLİK HORTUM	1 ADET
17	AL315 17	HİDROLİK YAĞ BORUSU	2 ADET
18	AL315 18	T PARÇASI	4 ADET
19	AL315 19	ANA GÖVDE AYAĞI	1 ADET
20	AL315 20	ANA GÖVDE AYAĞI BAĞLANTI CİVATASI M10X30 mm	2 ADET
21	AL315 21	TAŞIMA KOLU YUVASI	1 ADET
22	AL315 22	PAFTA BAĞLANTI CİVATASI	48 ADET
23	AL315 23	YAĞ KEÇESİ 50X40X10 mm	2 ADET
24	AL315 24	24 LOKMA	1 ADET
25	AL315 25	PAFTALAR (75,90,110,125,140,160,180,200,225)	72 ADET
26	AL315 27	O RİNG 50X46X2 mm	4 ADET
27	AL315 28	SİFERO BOĞAZ	4 ADET
28	AL315 29	TOZ KEÇESİ 48X40X7 mm	4 ADET
29	AL315 120	ÇİFT DELİK ALT ÇENE	1 ADET
30	AL315 121	TEK DELİK ALT ÇENE	1 ADET
31	AL315 122	KÖR 4 DELİK ALT ÇENE	1 ADET
32	AL315 123	PATLAK 4 DELİK ALT ÇENE	1 ADET
33	AL315 124	10 LUK YÜZÜK	6 ADET
34	AL315 125	M10 SOMUN	6 ADET
35	AL315 126	1/4" 10 TERS REKOR	4 ADET
36	AL315 127	1/4" BAKIR PUL	4 ADET
37	AL315 128	M8 X 40 İMBUS CİVATA	8 ADET
38	AL315 129	M8 SOMUN	8 ADET
39	AL315 130	TAŞIMA KOLU	1 ADET
40	AL315 131	TAŞIMA KOLU BAĞLANTI CİVATASI M10 X 45	1 ADET
41	AL315 132	TAŞIMA KOLU BAĞLANTI PULU M10	1 ADET
42	AL315 133	MİL BAĞLANTI PULU M10	4 ADET
43	AL315 134	TAŞIMA KOLU SOMUNU M10	1 ADET
44	AL315 135	M10 X 25 AKC CİVATA	2 ADET
45	AL315 136	3/8" 10 REKOR	2 ADET
46	AL315 137	M12 X25 AKC CİVATA	6 ADET
47	AL315 138	ÖN AYAK BAĞLANTI SOMUNU M10	6 ADET
48	AL315 139	PISTON BAĞLANTI SAPLAMASI M8 PUL	16 ADET
49	AL315 140	ARA BAĞLAMA ADAPTÖRÜ M12 PUL	6 ADET

AL 315		BASIC MACHINE LIST	
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL315 01	CHROME COATED SHAFT (40x800 mm)	2 ITEMS
2	AL315 02	M12 WASHER	8 ITEMS
3	AL315 03	M12x40 NUT	8 ITEMS
4	AL315 04	PIN SCREW (M8x350 mm)	8 ITEMS
5	AL315 05	PIN (M8x350mm)	2 ITEMS
6	AL315 06	POLISHED PIPE (50x60x300 mm)	2 ITEMS
7	AL315 07	UPPER CLAMP	4 ITEMS
8	AL315 08	PLATE ROD	2 ITEMS
9	AL315 09	M20 x30 AKC BOLT	4 ITEMS
10	AL315 10	M8 WASHER	2 ITEMS
11	AL315 11	WHEEL BOLT (M8x20)	2 ITEMS
12	AL315 12	WHEEL (250x70 mm)	2 ITEMS
13	AL315 13	FRAME	1 ITEM
14	AL315 14	3/8" MALE QUICK COUPLING	1 ITEM
15	AL315 15	3/8" FEMALE QUICK COUPLING	1 ITEM
16	AL315 16	5/16" HYDRAULIC HOSE	1 ITEM
17	AL315 17	M10 ALUMINUM PIPE	2 ITEMS
18	AL315 18	M10 TE PIECE	4 ITEMS
19	AL315 19	FORE LEG	1 ITEM
20	AL315 20	FORE LEG BOLT (M10x30 mm)	2 ITEMS
21	AL315 21	CARRYING HANDLE HOUSING	1 ITEM
22	AL315 22	BOLT CONNECTION	48 ITEMS
23	AL315 23	OIL BUSH (50x40x10 mm)	2 ITEMS
24	AL315 24	KEY 24	1 ITEM
25	AL315 25	CLAMP	72 ITEMS
26	AL315 27	O RING (50x46x2 mm)	4 ITEMS
27	AL315 28	SIFERO NECK	4 ITEMS
28	AL315 29	DUST FELT 48*40*7	4 ITEMS
29	AL315 120	DOUBLE HOLE LOWER CLAMP	1 ITEM
30	AL315 121	SINGLE HOLE LOWER CLAMP	1 ITEM
31	AL315 122	4 HOLE BLIND LOWER CLAMP	1 ITEM
32	AL315 123	4 HOLE LOWER CLAMP	1 ITEM
33	AL315 124	M10 RING	6 ITEMS
34	AL315 125	M10 NUT	6 ITEMS
35	AL315 126	M10 REVERSE ADAPTOR	4 ITEMS
36	AL315 127	1/4" COPPER WASHER	4 ITEMS
37	AL315 128	M8x 40 IMBUS BOLT	8 ITEMS
38	AL315 129	M8 NUT	8 ITEMS
39	AL315 130	CARRYING HANDLE	1 ITEM
40	AL315 131	CARRYING HANDLE BOLT CONNECTOR M10 X 45	1 ITEM
41	AL315 132	CARRYING HANDLE WASHER CONNECTOR M10	1 ITEM
42	AL315 133	M10 WASHER	4 ITEMS
43	AL315 134	CARRYING HANDLE NUT M10	1 ITEM
44	AL315 135	M10 x25 AKC BOLT	2 ITEMS
45	AL315 136	3/8" M10 ADAPTOR	2 ITEMS
46	AL315 137	M12 x25 AKC BOLT	6 ITEMS
47	AL315 138	M10 NUT	6 ITEMS
48	AL315 139	M8 WASHER	16 ITEMS
49	AL315 140	M12 WASHER	6 ITEMS

AL 250-315

Kullanma Kılavuzu
Technical Information

AL 250-315 HİDROLİK ÜNİTE / AL 250-315 HYDRAULIC UNIT



AL 250-315 HİDROLİK ÜNİTE LİSTESİ

PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL25031530	TIRAŞLAYICI ARIZA LAMBASI	1 ADET
2	AL25031531	HİDROLİK ARIZA LAMBASI	1 ADET
3	AL25031532	TAŞIMA KOLU	2 ADET
4	AL25031533	HİDROLİK SİSTEM DEVREDE LAMBASI	1 ADET
5	AL25031534	TIRAŞLAYICI PRİZİ	1 ADET
6	AL25031535	İSİTİCİ PRİZİ	1 ADET
7	AL25031536	HİDROLİK ÜNİTE KONTAKTÖRÜ ALMK 1210	1 ADET
8	AL25031537	TIRAŞLAYICI KONTAKTÖRÜ MTC 1210	1 ADET
9	AL25031538	HİDROLİK ÜNİTE ROLESİ FINDER 40.52	2 ADET
10	AL25031539	HİDROLİK ÜNİTE TERMİĞİ ALM-T4.5	1 ADET
11	AL25031540	TIRAŞLAYICI TERMİĞİ ALM-T4.5	1 ADET
12	AL25031541	RAY KLAMENSİ	1 ADET
13	AL25031542	BESLEME FİŞİ	1 ADET
14	AL25031543	KUMANDA BUTONU	1 ADET
15	AL25031544	HİDROLİK OTOMATİK REKOR(DIŞI)	1 ADET
16	AL25031545	HİDROLİK POMPA (C036X)	1 ADET
17	AL25031546	YAĞ İLAVE BORUSU	1 ADET
18	AL25031547	BASINÇ SİFİRLAMA KOLU	1 ADET
19	AL25031548	BASINÇ REGÜLATÖRÜ	1 ADET
20	AL25031549	HİDROLİK OTOMATİK REKOR (ERKEK)	1 ADET
21	AL25031550	HİDROLİK KUMANDA SİGORTASI ALMC16	1 ADET
22	AL25031551	İSİTİCİ SİGORTASI ALMC16	1 ADET
23	AL25031552	HİDROLİK ÜNİTE SIGORTASI ALMC10	1 ADET
24	AL25031553	AKÜ	1 ADET
25	AL25031554	MANOMETRE	1 ADET
26	AL25031555	MOTOR (0,55kw) 1400 d/dk	1 ADET
27	AL25031556	HİDROLİK VALF	1 ADET
28	AL25031557	FİRMA ETİKETİ	1 ADET
29	AL25031558	SABİTLİME CİVATASI M6X15	18 ADET
30	AL25031559	YAĞ GÖSTERGESİ	1 ADET
31	AL25031560	HİDROLİK ÜNİTE AYAKLARI	2 ADET
32	AL25031561	HİDROLİK YAĞ TANKI	1 ADET
33	AL25031562	AKÜ BAĞLANTI REKORU (1/4 10)	1 ADET
34	AL25031563	MANOMETRE BAĞLANTI DİRSEĞİ	1 ADET
35	AL25031564	BAĞLANTI HORTUMU	1 ADET
36	AL25031565	KAPLİN	2 ADET
37	AL25031566	DEPO KAPAĞI	1 ADET
38	AL25031567	BASINÇ KİLİTİ	1 ADET
39	AL25031568	BASINÇ AYAR REKORU	1 ADET
40	AL25031569	TIRAŞLAYICI SİGORTASI ALMC10	2 ADET
41	AL25031570	ELEKTRİK PANOSU	1 ADET
42	AL25031571	DK 24 KAPLİN	1 ADET
43	AL25031572	ŞASE ÜST KAPAĞI	1 ADET
44	AL25031573	ŞASE ÖN ALT KAPAĞI	1 ADET
45	AL25031574	ŞASE ÖN ÜST KAPAĞI	1 ADET
46	AL25031575	SOL-SAĞ KAPAKLAR	1 ADET
47	AL25031576	3/8" BAKIR PUL	4 ADET
48	AL25031577	3/8"-3/8" LÜPER	2 ADET
49	AL25031578	3/8" DİŞİ KUIK KAPLİN	1 ADET

AL 250-315

AL 250-315 HİDROLİK ÜNİTE LİSTESİ

Kullanma Kılavuzu
Technical Information

AL 250-315		HİDROLİK ÜNİTE LİSTESİ	
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
50	AL25031579	Ø 10 ALÜMİNYUM BORU	1 ADET
51	AL25031580	1/4" 10 REKOR	3 ADET
52	AL25031581	M6X10 İMBUS CİVATA	4 ADET
53	AL25031582	10 LUK YÜZÜK	3 ADET
54	AL25031583	M10 SOMUN	3 ADET
55	AL25031584	Ø 10 ALÜMİNYUM BORU	1 ADET
56	AL25031585	M8 SOMUN	2 ADET
57	AL25031586	Ø 8 ALÜMİNYUM BORU	1 ADET
58	AL25031587	M10 ŞAPKALI SOMUN	4 ADET
59	AL25031588	M8 SOMUN	4 ADET
60	AL25031589	M8X25 İMBUS CİVATA	4 ADET
61	AL25031590	M6 SOMUN	8 ADET
62	AL25031591	M6X25 İMBUS CİVATA	4 ADET
63	AL25031592	M6X16 İMBUS CİVATA	6 ADET
64	AL25031593	YAĞ FILTRESİ	1 ADET
65	AL25031594	ŞASE ARKA KAPAK	1 ADET
66	AL25031595	POMPA ADAPTÖRÜ	2 ADET
67	AL25031596	M6X20 AKC CİVATA	8 ADET
68	AL25031597	1" O RİNG	1 ADET
69	AL25031598	1" SOMUN	1 ADET
70	AL25031599	Ø 20 O RİNG	1 ADET
71	AL250315100	M6 SOMUN	4 ADET
72	AL250315101	M6 PUL	4 ADET
73	AL250315102	M6X30 AKC CİVATA	4 ADET
74	AL250315103	1/2" 15 mm UZATMA	1 ADET
75	AL250315104	1/2" BAKIR PUL	2 ADET
76	AL250315105	1/2" 10 mm UZATMA	1 ADET
77	AL250315106	1/4" BAKIR PUL	5 ADET

AL 250-315

AL 250-315 HYDRAULIC UNIT LIST

Kullanma Kılavuzu
Technical Information

AL 250-315		HYDRAULIC UNIT LIST	
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL25031530	TRIMMER FAILURE LAMP	1 ITEM
2	AL25031531	HYDRAULIC FAILURE LAMP	1 ITEM
3	AL25031532	HANDLE	2 ITEMS
4	AL25031533	HYDRAULIC SYSTEM LAMP(ON)	1 ITEM
5	AL25031534	TRIMMER SOCKET	1 ITEM
6	AL25031535	HEATER SOCKET	1 ITEM
7	AL25031536	HYDRAULIC UNIT CONTACTOR ALMK 1210	1 ITEM
8	AL25031537	TRIMMER CONTACTOR MTC 1210	1 ITEM
9	AL25031538	HYDRAULIC UNIT ROLE FINDER 40.50	2 ITEMS
10	AL25031539	HYDRAULIC UNIT THERMIC ALM-4.5	1 ITEM
11	AL25031540	TRIMMER THERMIC ALM-T4.5	1 ITEM
12	AL25031541	CONNECTOR	1 ITEM
13	AL25031542	SUPPLY PLUG	1 ITEM
14	AL25031543	CONTROL BUTTON	1 ITEM
15	AL25031544	QUICK COUPLING (FEMALE)	1 ITEM
16	AL25031545	HYDRAULIC PUMP(C036X)	1 ITEM
17	AL25031546	OIL ADDITION TUBE	1 ITEM
18	AL25031547	PRESSURE INITIALIZING HANDLE	1 ITEM
19	AL25031548	PRESSURE REGULATOR	1 ITEM
20	AL25031549	QUICK COUPLING (MALE)	1 ITEM
21	AL25031550	HYDRAULIC CONTROL FUSE ALMC 16	1 ITEM
22	AL25031551	HEATER FUSE ALMC 16	1 ITEM
23	AL25031552	HYDRAULIC UNIT FUSE ALMC 16	1 ITEM
24	AL25031553	ACCUMULATOR	1 ITEM
25	AL25031554	MONOMETER	1 ITEM
26	AL25031555	MOTOR (0,55kw) 1400 d/dk	1 ITEM
27	AL25031556	HYDRAULIC VALVE	1 ITEM
28	AL25031557	COMPANY LABEL	1 ITEM
29	AL25031558	FASTEN JOINT M6X15	18 ITEMS
30	AL25031559	OIL INDICATOR	1 ITEM
31	AL25031560	HYDRAULIC UNIT SUPPORT	2 ITEMS
32	AL25031561	HYDRAULIC OIL TANK	1 ITEM
33	AL25031562	ACCUMULATOR OUT-PUT (1/4 10)	1 ITEM
34	AL25031563	MONOMETER CONNECTOR BEND	1 ITEM
35	AL25031564	HYDRAULIC TANK COVER	1 ITEM
36	AL25031565	COUPLING	2 ITEMS
37	AL25031566	DEPOT COVER	1 ITEM
38	AL25031567	PRESSURE EMERGENCY	1 ITEM
39	AL25031568	PRESSURE REGULATOR	1 ITEM
40	AL25031569	TRIMMER FUSE ALMC 10	2 ITEMS
41	AL25031570	ELEKTRICAL PANEL	1 ITEM
42	AL25031571	DK 24 COUPLING	1 ITEM
43	AL25031572	CHASSIS TOP COVER	1 ITEM
44	AL25031573	CHASSIS FRONT COVER	1 ITEM
45	AL25031574	CHASSIS FRONT UPPER COVER	1 ITEM
46	AL25031575	LEFT - RIGHT COVERS	1 ITEM
47	AL25031576	3/8" COPPER WASHER	4 ITEMS
48	AL25031577	3/8"-3/8" LOOPER	2 ITEMS
49	AL25031578	3/8" FEMALE QUICK COUPLING	1 ITEM

AL 250-315

AL 250-315 HYDRAULIC UNIT LIST

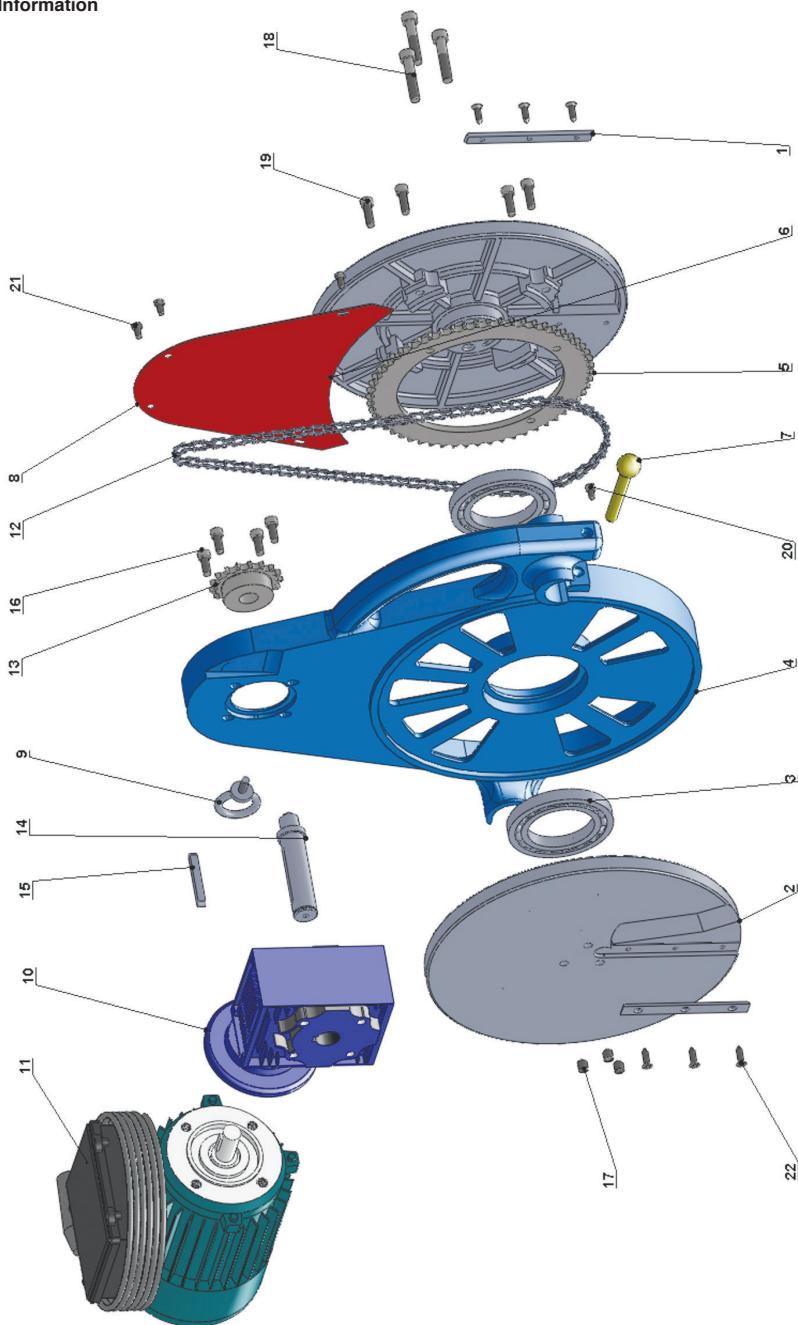
Kullanma Kılavuzu
Technical Information

AL 250-315		HYDRAULIC UNIT LIST	
NO	CODE NUMBER	ITEM ID	QUANTITY
50	AL25031579	Ø 10 ALUMINUM TUBE	1 ITEM
51	AL25031580	1/4" 10 REGULATOR	3 ITEMS
52	AL25031581	M6X10 IMBUS BOLT	4 ITEMS
53	AL25031582	M10 RING	3 ITEMS
54	AL25031583	M10 NUT	3 ITEMS
55	AL25031584	Ø 10 ALUMINUM TUBE	1 ITEM
56	AL25031585	M8 NUT	2 ITEMS
57	AL25031586	Ø 8 ALUMINUM TUBE	1 ITEM
58	AL25031587	M10 CAP NUT	4 ITEMS
59	AL25031588	M8 NUT	4 ITEMS
60	AL25031589	M8X25 IMBUS BOLT	4 ITEMS
61	AL25031590	M6 NUT	8 ITEMS
62	AL25031591	M6X25 IMBUS BOLT	4 ITEMS
63	AL25031592	M6X16 IMBUS BOLT	6 ITEMS
64	AL25031593	OIL FILTER	1 ITEM
65	AL25031594	CHASSIS BACK COVER	1 ITEM
66	AL25031595	PUMP ADAPTER	2 ITEMS
67	AL25031596	M6X20 AKC BOLT	8 ITEMS
68	AL25031597	1" O RING	1 ITEM
69	AL25031598	1" NUT	1 ITEMS
70	AL25031599	Ø 20 O RİNG	1 ITEM
71	AL250315100	M6 NUT	4 ITEMS
72	AL250315101	M6 WASHER	4 ITEMS
73	AL250315102	M6X30 AKC BOLT	4 ITEMS
74	AL250315103	1/2" 15 MM EXTENSION	1 ITEM
75	AL250315104	1/2" COPPER WASHER	2 ITEMS
76	AL250315105	1/2" 10 MM EXTENSION	1 ITEM
77	AL250315106	1/4" COPPER WASHER	5 ITEMS

AL 400-500

AL 400-500 TIRAŞLAYICI / AL 400-500 TRIMMER

Kullanma Kılavuzu
Technical Information



AL 400-500

Kullanma Kılavuzu
Technical Information

AL 400-500 TIRAŞLAYICI LİSTESİ / AL 400-500 TRIMMER LIST

AL 400-500 TIRAŞLAYICI LİSTESİ

PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL500400 69	BIÇAK	2 ADET
2	AL500400 70	TIRAŞLAYICI DÜZ DISK	1 ADET
3	AL500400 71	RULMAN (16014)	2 ADET
4	AL500400 72	TIRAŞLAYICI GÖVDE	1 ADET
5	AL500400 73	ZİNCİR DİŞLİ	1 ADET
6	AL500400 74	TIRAŞLAYICI DİŞLİ DISK	1 ADET
7	AL500400 75	EMНИYET ПІМІ	1 ADET
8	AL500400 76	TIRAŞLAYICI KAPAK	1 ADET
9	AL500400 77	VİNÇ MAPASI	1 ADET
10	AL500400 78	REDÜKTÖR	1 ADET
11	AL500400 79	MOTOR (1,1 Kw) 1400 d/dk	1 ADET
12	AL500400 80	ZİNCİR	1 ADET
13	AL500400 190	ZİNCİR ÜST DİŞLİ	1 ADET
14	AL500400 191	ZİNCİR ÜST DİŞLİ MİLİ	1 ADET
15	AL500400 192	ZİNCİR MİLİ KAMASI	1 ADET
16	AL500400 193	M8x20 İMBUS CİVATA	4 ADET
17	AL500400 194	M10x12 SETUSKUR	3 ADET
18	AL500400 195	M10x50 İMBUS CİVATA	3 ADET
19	AL500400 196	M8x25 İMBUS CİVATA	4 ADET
20	AL500400 197	M6x10 İMBUS	1 ADET
21	AL500400 198	M6x12 AKB CİVATA	4 ADET
22	AL500400 199	M6*15 VİDA	6 ADET

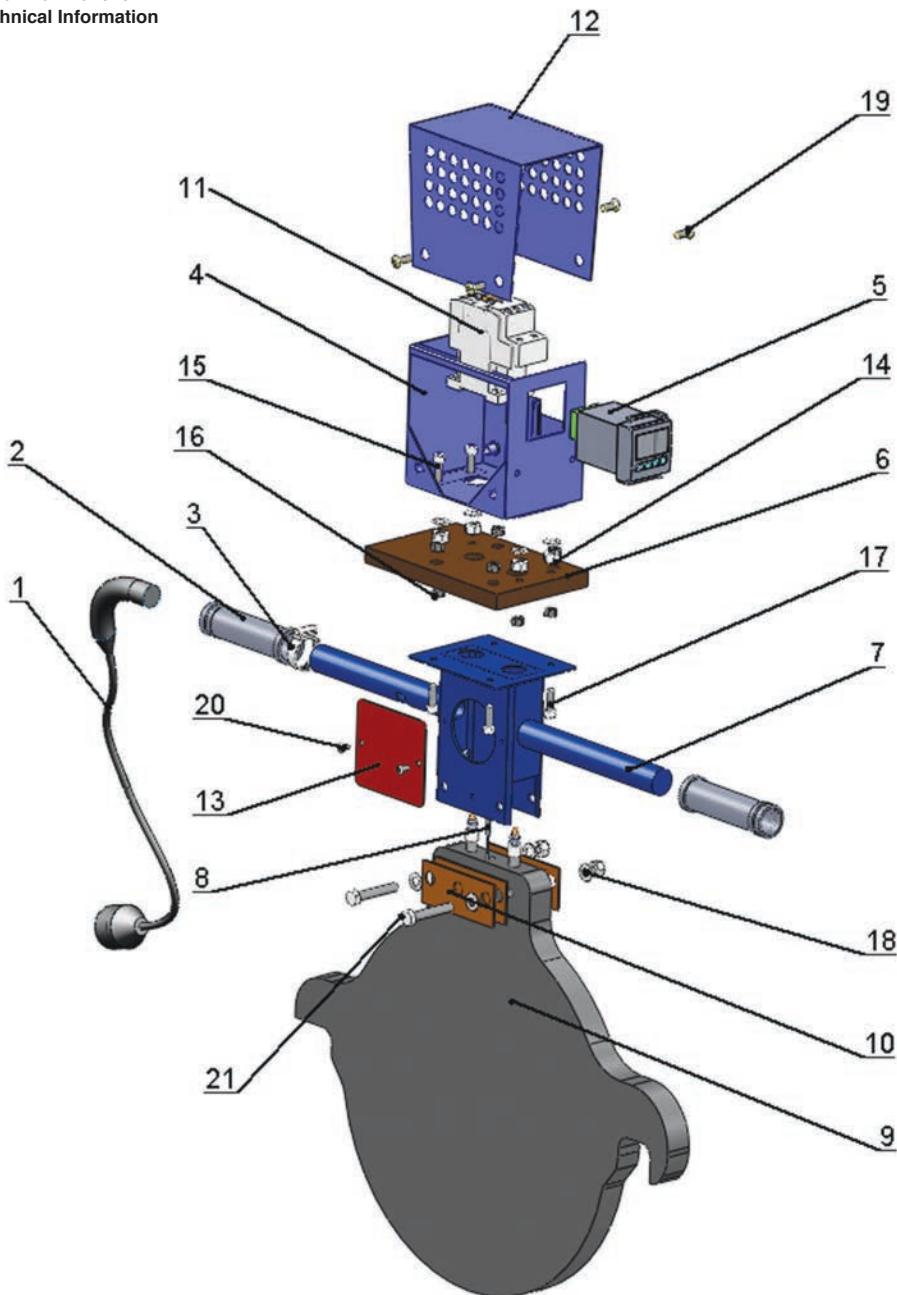
AL 400-500 TRIMMER LIST

NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL500400 69	BLADE	2 ITEMS
2	AL500400 70	TRIMMER PLAIN DISC	1 ITEM
3	AL500400 71	BEARING	2 ITEMS
4	AL500400 72	TRIMMER BODY	1 ITEM
5	AL500400 73	CHAIN BEARING	1 ITEM
6	AL500400 74	TRIMMER SCREW DISC	1 ITEM
7	AL500400 75	SAFETY PIN	1 ITEM
8	AL500400 76	TRIMMER COVER	1 ITEM
9	AL500400 77		1 ITEM
10	AL500400 78	REDUCTOR	1 ITEM
11	AL500400 79	MOTOR	1 ITEM
12	AL500400 80	CHAIN	1 ITEM
13	AL500400 190	CHAIN UPPER GEAR	1 ITEM
14	AL500400 191	CHAIN UPPER GEAR SHAFT	1 ITEM
15	AL500400 192	CHAIN SHAFT PIN	1 ITEM
16	AL500400 193	M8x20 İMBUS BOLT	4 ITEMS
17	AL500400 194	M10X12 SCREW	3 ITEMS
18	AL500400 195	M10x50 İMBUS BOLT	3 ITEMS
19	AL500400 196	M8x25 İMBUS BOLT	4 ITEMS
20	AL500400 197	M6x10 İMBUS BOLT	1 ITEM
21	AL500400 198	M6x12 AKC BOLT	4 ITEMS
22	AL500400 199	M6x15 SCREW	6 ITEMS

AL 400-500

Kullanma Kılavuzu
Technical Information

AL 400-500 ISITICI / AL 400-500 HEATER



AL 400-500

Kullanma Kılavuzu
Technical Information

AL 400-500 ISITICI LİSTESİ / AL 400-500 HEATER LIST

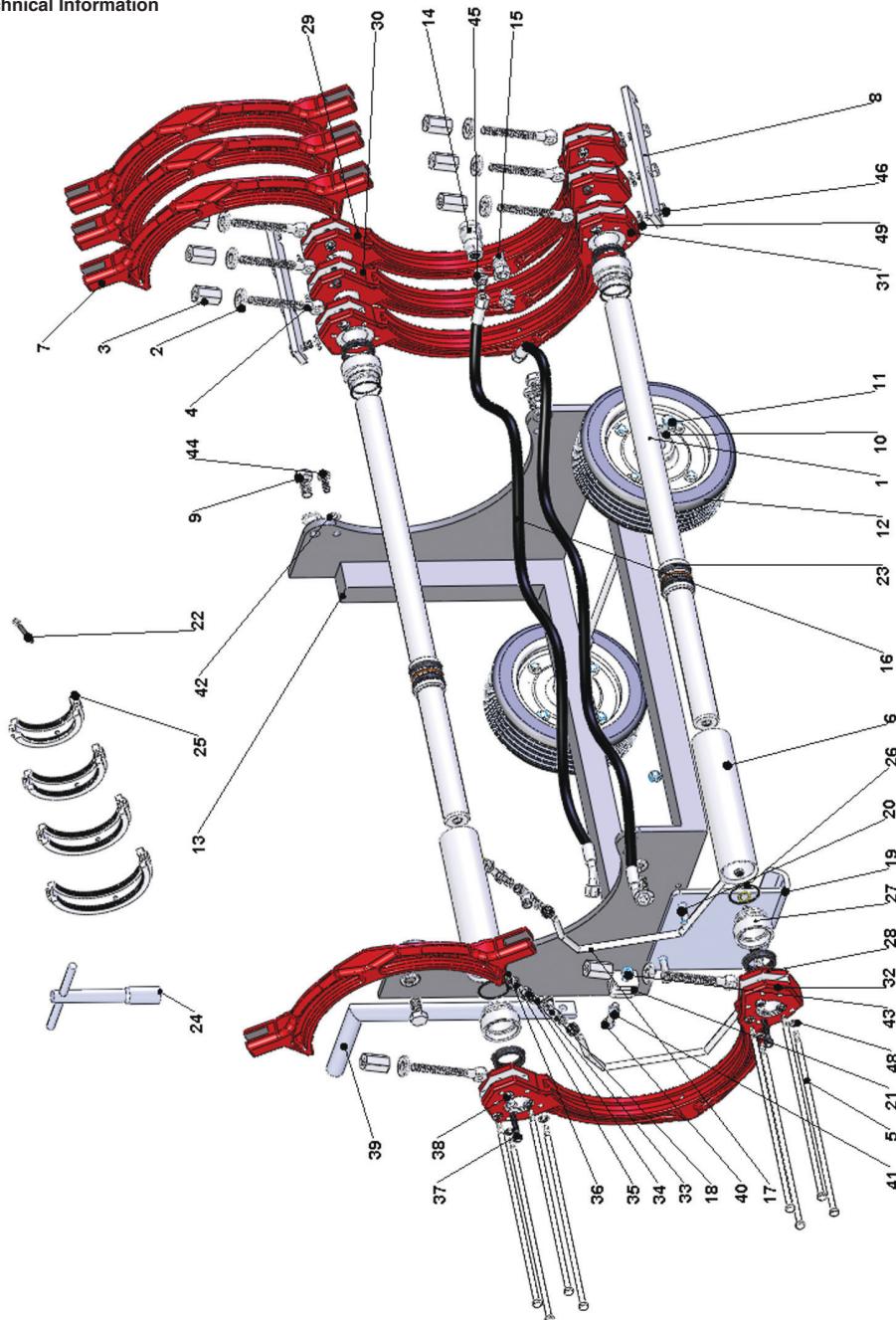
AL 400-500 İSITICI LİSTESİ			
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL500 82	ELEKTRİK KABLOSU	1 ADET
2	AL500 83	TAŞIMA KOLU İZOLESİ	2 ADET
3	AL500 84	KELEPÇE	1 ADET
4	AL500 85	ISITICI KONTROL PANELİ	1 ADET
5	AL500 86	ISI KONTROL CİHAZI	1 ADET
6	AL500 87	ISI YALITIM FİBERİ	1 ADET
7	AL500 88	TAŞIMA KOLU	1 ADET
8	AL500 89	TERMOKULP	1 ADET
9	AL500 90	ISITICI	1 ADET
10	AL500 91	KEÇE	1 ADET
11	AL500 92	KONTAKTÖR	1 ADET
12	AL500 93	ÜST KAPAK	1 ADET
13	AL500 94	KORUYUCU KAPAK(KIRMIZI)	1 ADET
14	AL500 95	M8 SOMUN	4 ADET
15	AL500 96	M6 X 20 İMBUS CİVATA	4 ADET
16	AL500 97	M6 SOMUN	8 ADET
17	AL500 98	M6 X 25 İMBUS CİVATA	4 ADET
18	AL500 99	PUL	8 ADET
19	AL500 100	M6 X 14,5 VİDA	4 ADET
20	AL500 101	M4 VİDA (KORUYUCU KAPAK)	2 ADET
21	AL500 102	M8 X 50 AKB CİVATA	2 ADET

AL 400-500 HEATER LIST			
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL500 82	ELECTRIC CABLE	1 ITEM
2	AL500 83	CARRYING HANDLE ISOLATION	2 ITEMS
3	AL500 84	CLIPS	1 ITEM
4	AL500 85	CONTROL PANNEL	1 ITEM
5	AL500 86	ELECTRIC BOX	1 ITEM
6	AL500 87	HEAT ISOLATION FIBER	1 ITEM
7	AL500 88	CARRYING HANDLE	1 ITEM
8	AL500 89	THERMOCOUPLE	1 ITEM
9	AL500 90	HEATER	1 ITEM
10	AL500 91	BUSH	1 ITEM
11	AL500 92	CONTACTOR	1 ITEM
12	AL500 93	UPPER COVER	1 ITEM
13	AL500 94	PROTECTIVE COVER (RED)	1 ITEM
14	AL500 95	M8 NUT	4 ITEMS
15	AL500 96	M6x20 IMBUS BOLT	4 ITEMS
16	AL500 97	M6 NUT	8 ITEMS
17	AL500 98	M6x25 IMBUS BOLT	4 ITEMS
18	AL500 99	WASHER	8 ITEMS
19	AL500 100	M6x14,5 SCREW	4 ITEMS
20	AL500 101	M4 SCREW (FOR PROTECTIVE COVER)	2 ITEMS
21	AL500 102	M8x50 AKB BOLT	2 ITEMS

AL 400-500

Kullanma Kılavuzu
Technical Information

AL 400-500 GÖVDE / AL 400-500 BASIC MACHINE



AL 400-500

AL 400-500 GÖVDE LİSTESİ

Kullanma Kılavuzu
Technical Information

AL 400-500		GÖVDE LİSTESİ	
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL500400 01	SERT KROMLU MİL 40X1000mm	2 ADET
2	AL500400 02	M16 PUL	8 ADET
3	AL500400 03	BAGLANTI CİVATASI SOMUNU M16	8 ADET
4	AL500400 04	BAĞLANTI CİVATASI SAPLAMASI M16X150 mm	8 ADET
5	AL500400 05	PISTON BAĞLANTI SAPLAMASI M10X400 mm	2 ADET
6	AL500400 06	HONLANMIŞ BORU 50X60X300 mm	2 ADET
7	AL500400 07	BORU BAĞLANTI KELEPÇESİ	4 ADET
8	AL500400 08	ARA BAĞLAMA ADAPTÖRÜ	2 ADET
9	AL500400 09	MİL BAĞLANTI CİVATASI M16X30	4 ADET
10	AL500400 10	TEKER PULU	2 ADET
11	AL500400 11	TEKER CİVATASI M10X20 mm	2 ADET
12	AL500400 12	TEKER 250X80 mm	2 ADET
13	AL500400 13	ANA GÖVDE	1 ADET
14	AL500400 14	HİDROLİK OTOMATİK REKOR (ERKEK)	1 ADET
15	AL500400 15	HİDROLİK OTOMATİK REKOR (DİŞİ)	1 ADET
16	AL500400 16	HİDROLİK HORTUM	1 ADET
17	AL500400 17	HİDROLİK YAĞ BORUSU	2 ADET
18	AL500400 18	T PARÇASI	4 ADET
19	AL500400 19	ANA GÖVDE AYAĞI	1 ADET
20	AL500400 20	ANA GÖVDE AYAĞI BAĞLANTI CİVATASI M10X30 mm	2 ADET
21	AL500400 21	TAŞIMA KOLU YUVASI	1 ADET
22	AL500400 22	PAFTA BAĞLANTI CİVATASI	48 ADET
23	AL500400 23	YAĞ KEÇESİ 50X40X10 mm	2 ADET
24	AL500400 24	24 LOKMA	1 ADET
25	AL500 25 AL400 25	PAFTALAR (180,200,225,250,280-(500-315)-355-400-450) PAFTALAR (160-180,200,225,250,280-315-355-400)	72 ADET 72 ADET
26	AL500400 27	O RİNG 50X46X2 mm	4 ADET
27	AL500400 28	SİFERO BOĞAZ	4 ADET
28	AL500400 29	TOZ KEÇESİ 48X40X7 mm	4 ADET
29	AL500400120	ÇİFT DELİK ALT ÇENE	1 ADET
30	AL500400121	TEK LİK ALT ÇENE	1 ADET
31	AL500400122	KÖR 4 DELİK ALT ÇENE	1 ADET
32	AL500400123	PATLAK 4 DELİK ALT ÇENE	1 ADET
33	AL500400124	10 LUK YÜZÜK	6 ADET
34	AL500400125	M10 SOMUN	6 ADET
35	AL500400126	1/4" 10 LUK TERS REKOR AL 400'DE YOK	4 ADET
36	AL500400127	1/4" BAKIR PUL	4 ADET
37	AL500400128	M8 X 40 İMBUS CİVATA	8 ADET
38	AL500400129	M8 SOMUN	8 ADET
39	AL500400130	TAŞIMA KOLU	1 ADET
40	AL500400131	TAŞIMA KOLU BAĞLANTI CİVATASI	1 ADET
41	AL500400132	TAŞIMA KOLU BAĞLANTI PULU M12	1 ADET
42	AL500400133	MİL BAĞLANTI PULU M10	4 ADET
43	AL500400134	TAŞIMA KOLU SOMUNU M10	1 ADET
44	AL500400135	M10 X 25 AKC CİVATA	2 ADET
45	AL500400136	3/8" 10 REKOR	2 ADET
46	AL500400137	M12 X25 AKC CİVATA	6 ADET
47	AL500400138	ÖN AYAK BAĞLANTI SOMUNU M10	6 ADET
48	AL500400139	PISTON BAĞLANTI SAPLAMASI M10 PULU	16 ADET
49	AL500400140	ARA BAĞLAMA ADAPTÖRÜ PULU M14	6 ADET

AL 400-500

Kullanma Kılavuzu
Technical Information

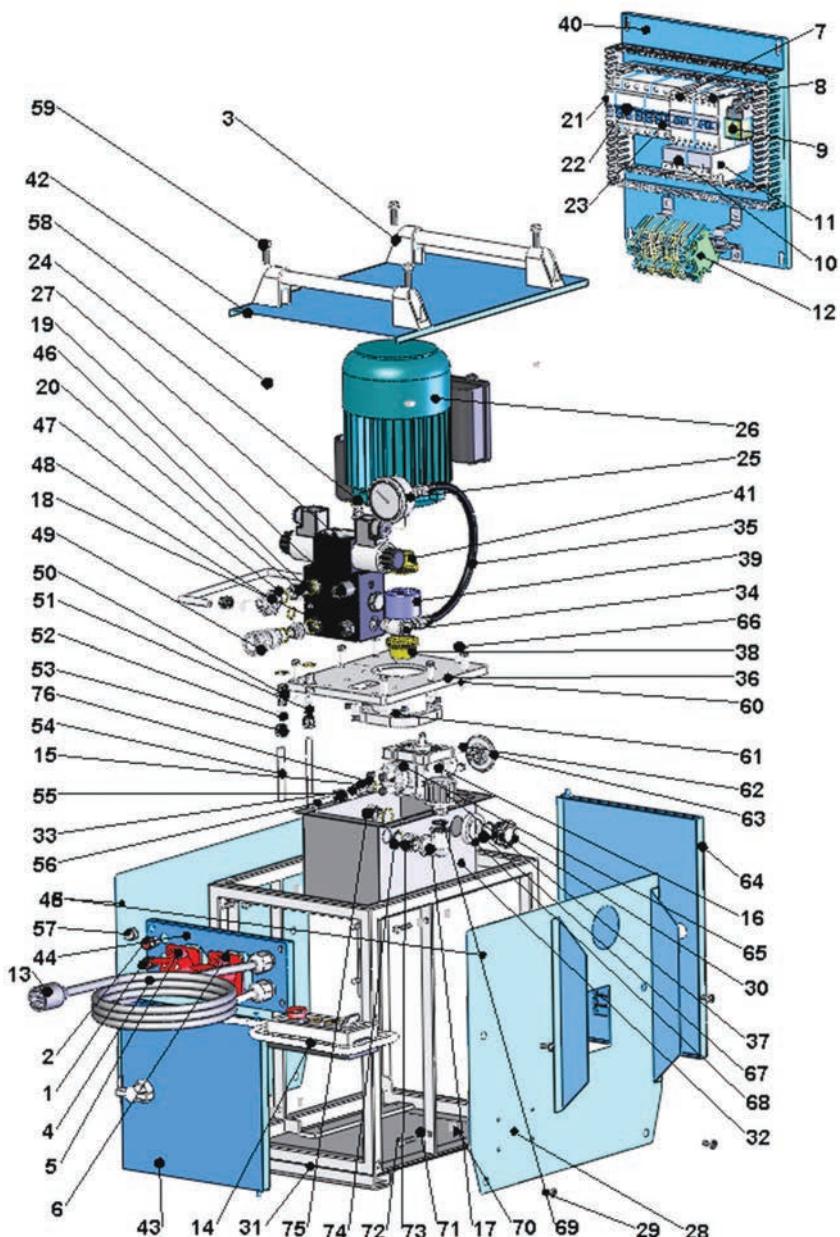
AL 400-500 BASIC MACHINE LIST

AL 400-500			BASIC MACHINE LIST
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL500400 01	CHROME COATED SHAFT (40x800 mm)	2 ITEMS
2	AL500400 02	M12 WASHER	8 ITEMS
3	AL500400 03	M12x40 NUT	8 ITEMS
4	AL500400 04	PIN SCREW (M16x150 mm)	8 ITEMS
5	AL500400 05	PIN (M10x400mm)	2 ITEMS
6	AL500400 06	POLISHED PIPE (50x60x300 mm)	2 ITEMS
7	AL500400 07	UPPER CLAMP	4 ITEMS
8	AL500400 08	PLATE ROD	2 ITEMS
9	AL500400 09	AKC BOLT M16X30	4 ITEMS
10	AL500400 10	M8 WASHER	2 ITEMS
11	AL500400 11	WHEEL BOLT (M10x20)	2 ITEMS
12	AL500400 12	WHEEL (250x80 mm)	2 ITEMS
13	AL500400 13	FRAME	1 ITEM
14	AL500400 14	3/8" MALE QUICK COUPLING	1 ITEM
15	AL500400 15	3/8" FEMALE QUICK COUPLING	1 ITEM
16	AL500400 16	5/16" HYDRAULIC HOSE	1 ITEM
17	AL500400 17	M10 ALUMINUM PIPE	2 ITEMS
18	AL500400 18	M10 TE PIECE	4 ITEMS
19	AL500400 19	FORE LEG	1 ITEM
20	AL500400 20	FORE LEG BOLT (M10x30 mm)	2 ITEMS
21	AL500400 21	CARRYING HANDLE HOUSING	1 ITEM
22	AL500400 22	BOLT CONNECTION	48 ITEM
23	AL500400 23	OIL BUSH (50x40x10 mm)	2 ITEMS
24	AL500400 24	KEY 24	1 ITEM
25	AL500 25	CLAMP (180,200,225,250,280-(500-315)-355-400-450)	72 ITEMS
	AL400 25	CLAMP (160-180,200,225,250,280-315-355-400)	72 ITEMS
26	AL500400 27	O RING (50x46x2 mm)	4 ITEMS
27	AL500400 28	SIFERO NECK	4 ITEMS
28	AL500400 29	DUST FELT 48*40*7	4 ITEMS
29	AL500400120	DOUBLE HOLE LOWER CLAMP	1 ITEM
30	AL500400121	SINGLE HOLE LOWER CLAMP	1 ITEM
31	AL500400122	4 HOLE BLIND LOWER CLAMP	1 ITEM
32	AL500400123	4 HOLE LOWER CLAMP	1 ITEM
33	AL500400124	M10 RING	6 ITEMS
34	AL500400125	M10 NUT	6 ITEMS
35	AL500400126	1/4" 10 REVERSE ADAPTOR NOT IN AL 400	4 ITEMS
36	AL500400127	1/4" COPPER WASHER	4 ITEMS
37	AL500400128	M8x 40 IMBUS BOLT	8 ITEMS
38	AL500400129	M8 NUT	8 ITEMS
39	AL500400130	CARRYING HANDLE	1 ITEM
40	AL500400131	CARRYING HANDLE BOLT CONNECTOR	1 ITEM
41	AL500400132	CARRYING HANDLE WASHER CONNECTOR M12	1 ITEM
42	AL500400133	M10 WASHER	4 ITEMS
43	AL500400134	CARRYING HANDLE NUT M12	1 ITEM
44	AL500400135	M10 x25 AKC BOLT	2 ITEMS
45	AL500400136	3/8" 10 ADAPTOR	2 ITEMS
46	AL500400137	M12 x25 AKC BOLT	6 ITEMS
47	AL500400138	M10 NUT	6 ITEMS
48	AL500400139	M10 WASHER	16 ITEMS
49	AL500400140	M14 WASHER	6 ITEMS

AL 400-500

Kullanma Kılavuzu
Technical Information

AL 400-500 HİDROLİK ÜNİTE / AL 400-500 HYDRAULIC UNIT



AL 400-500

Kullanma Kılavuzu
Technical Information

AL 400-500 HİDROLİK ÜNİTE LİSTESİ

AL 400-500		HİDROLİK ÜNİTE LİSTESİ	
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL500400 30	TIRAŞLAYICI ARIZA LAMBASI	1 ADET
2	AL500400 31	HİDROLİK ARIZA LAMBASI	1 ADET
3	AL500400 32	TAŞIMA KOLU	2 ADET
4	AL500400 33	HİDROLİK SİSTEM DEVREDE LAMBASI	1 ADET
5	AL500400 34	TIRAŞLAYICI PRİZİ	1 ADET
6	AL500400 35	İSİTİCİ PRİZİ	1 ADET
7	AL500400 36	HİDROLİK ÜNİTE KONTAKTORU ALMK 1210	1 ADET
8	AL500400 37	TIRAŞLAYICI KONTAKTORU MTC 1810	1 ADET
9	AL500400 38	HİDROLİK ÜNİTE ROLESİ FINDER 40.52	2 ADET
10	AL500400 39	HİDROLİK ÜNİTE TERMİĞİ ALM-T2.1	1 ADET
11	AL500400 40	TIRAŞLAYICI TERMİĞİ ALM-T3.5	1 ADET
12	AL500400 41	RAY KLAMENSİ	1 ADET
13	AL500400 42	BESLEME FİŞİ	1 ADET
14	AL500400 43	KUMANDA BUTONU	1 ADET
15	AL500400 44	HİDROLİK OTOMATİK REKOR(DİŞİ)	1 ADET
16	AL500400 45	HİDROLİK POMPA (C036X)	1 ADET
17	AL500400 46	YAĞ İLAVE BORUSU	1 ADET
18	AL500400 47	BASINÇ SİFIRLAMA KOLU	1 ADET
19	AL500400 48	BASINÇ REGÜLATÖRÜ	1 ADET
20	AL500400 49	HİDROLİK OTOMATİK REKOR (ERKEK)	1 ADET
21	AL500400 50	HİDROLİK KUMANDA SİGORTASI ALMC16	1 ADET
22	AL500400 51	İSİTİCİ SİGORTASI ALMC25	1 ADET
23	AL500400 52	HİDROLİK ÜNİTE SİGORTASI ALMC10	1 ADET
24	AL500400 53	AKÜ	1 ADET
25	AL500400 54	MANOMETRE	1 ADET
26	AL500400 55	MOTOR (0,55kw) 1400 d/dk	1 ADET
27	AL500400 56	HİDROLİK VALF	1 ADET
28	AL500400 57	FİRMA ETİKETİ	1 ADET
29	AL500400 58	SABİTLEME CİVATASI M6X15	18 ADET
30	AL500400 59	YAĞ GÖSTERGESİ	1 ADET
31	AL500400 60	HİDROLİK ÜNİTE AYAKLARI	2 ADET
32	AL500400 61	HİDROLİK YAĞ TANKI	1 ADET
33	AL500400 62	AKÜ BAĞLANTI REKORU (1/4 10)	1 ADET
34	AL500400 63	MANOMETRE BAĞLANTI DİRSEĞİ	1 ADET
35	AL500400 64	BAĞLANTI HORTUMU	1 ADET
36	AL500400 65	KAPLİN	2 ADET
37	AL500400 66	DEPO KAPAĞI	1 ADET
38	AL500400 67	BASINÇ KİLİTİ	1 ADET
39	AL500400 68	BASINÇ AYAR REKORU	1 ADET
40	AL500400 150	ELEKTRİK PANOSU	1 ADET
41	AL500400 151	DK 24 KAPLİN	1 ADET
42	AL500400 152	ŞASE ÜST KAPAĞI	1 ADET
43	AL500400 153	ŞASE ÖN ALT KAPAĞI	1 ADET
44	AL500400 154	ŞASE ÖN ÜST KAPAĞI	1 ADET
45	AL500400 155	SOL-Sağ KAPAKLAR	1 ADET
46	AL500400 156	3/8" BAKIR PUL	4 ADET
47	AL500400 157	3/8"-3/8" LÜPER	2 ADET
48	AL500400 158	3/8" DIŞI KUIK KAPLİN	1 ADET
49	AL500400 159	Ø 10 ALÜMİNYUM BORU	1 ADET

AL 400-500

Kullanma Kılavuzu
Technical Information

AL 400-500 HİDROLİK ÜNİTE LİSTESİ

AL 400-500		HİDROLİK ÜNİTE LİSTESİ	
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
50	AL500400 160	1/4" 10 REKOR	3 ADET
51	AL500400 161	M6X10 İMBUS CİVATA	4 ADET
52	AL500400 162	10 LUK YÜZÜK	3 ADET
53	AL500400 163	M10 SOMUN	3 ADET
54	AL500400 164	Ø 10 ALÜMİNYUM BORU	1 ADET
55	AL500400 165	M8 SOMUN	2 ADET
56	AL500400 166	Ø 8 ALÜMİNYUM BORU	1 ADET
57	AL500400 167	M10 ŞAPKALI SOMUN	4 ADET
58	AL500400 168	M8 SÖMÜN	4 ADET
59	AL500400 169	M8X25 İMBUS CİVATA	4 ADET
60	AL500400 170	M6 SÖMÜN	8 ADET
61	AL500400 171	M6X25 İMBUS CİVATA	4 ADET
62	AL500400 172	M6X16 İMBUS CİVATA	6 ADET
63	AL500400 173	YAG FİLTRESİ	1 ADET
64	AL500400 174	ŞASE ARKA KAPAK	1 ADET
65	AL500400 175	POMPA ADAPTÖRÜ	2 ADET
66	AL500400 176	M6X20 AKC CİVATA	8 ADET
67	AL500400 177	1" O RİNG	1 ADET
68	AL500400 178	1" SOMUN	1 ADET
69	AL500400 179	Ø 20 O RİNG	1 ADET
70	AL500400 180	M6 SÖMÜN	4 ADET
71	AL500400 181	M6 PUL	4 ADET
72	AL500400 182	M6X30 AKC CİVATA	4 ADET
73	AL500400 183	1/2" 15 mm UZATMA	1 ADET
74	AL500400 184	1/2" BAKIR PUL	2 ADET
75	AL500400 185	1/2" 10 mm UZATMA	1 ADET
76	AL500400 186	1/4" BAKIR PUL	5 ADET

AL 400-500

Kullanma Kılavuzu
Technical Information

AL 400-500 HYDRAULIC UNIT LIST

AL 400-500		HYDRAULIC UNIT LIST	
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL500400 30	TRIMMER FAILURE LAMP	1 ITEM
2	AL500400 31	HYDRAULIC FAILURE LAMP	1 ITEM
3	AL500400 32	HANDLE	2 ITEMS
4	AL500400 33	HYDRAULIC SYSTEM LAMP(ON)	1 ITEM
5	AL500400 34	TRIMMER SOCKET	1 ITEM
6	AL500400 35	HEATER SOCKET	1 ITEM
7	AL500400 36	HYDRAULIC UNIT CONTACTOR ALMK 1210	1 ITEM
8	AL500400 37	TRIMMER CONTACTOR MTC 1210	1 ITEM
9	AL500400 38	HYDRAULIC UNIT ROLE FINDER 40.50	2 ITEMS
10	AL500400 39	HYDRAULIC UNIT THERMIC ALM-4.5	1 ITEM
11	AL500400 40	TRIMMER THERMIC ALM-T4.5	1 ITEM
12	AL500400 41	CONNECTOR	1 ITEM
13	AL500400 42	SUPPLY PLUG	1 ITEM
14	AL500400 43	CONTROL BUTTON	1 ITEM
15	AL500400 44	QUICK COUPLING (FEMALE)	1 ITEM
16	AL500400 45	HYDRAULIC PUMP(C036X)	1 ITEM
17	AL500400 46	OIL ADDITION TUBE	1 ITEM
18	AL500400 47	PRESSURE INITIALIZING HANDLE	1 ITEM
19	AL500400 48	PRESSURE REGULATOR	1 ITEM
20	AL500400 49	QUICK COUPLING (MALE)	1 ITEM
21	AL500400 50	HYDRAULIC CONTROL FUSE ALMC 16	1 ITEM
22	AL500400 51	HEATER FUSE ALMC 16	1 ITEM
23	AL500400 52	HYDRAULIC UNIT FUSE ALMC 16	1 ITEM
24	AL500400 53	ACCUMULATOR	1 ITEM
25	AL500400 54	MONOMETER	1 ITEM
26	AL500400 55	MOTOR (0,55kw) 1400 d/dk	1 ITEM
27	AL500400 56	HYDRAULIC VALVE	1 ITEM
28	AL500400 57	COMPANY LABEL	1 ITEM
29	AL500400 58	FASTEN JOINT M6X15	18 ITEMS
30	AL500400 59	OIL INDICATOR	1 ITEM
31	AL500400 60	HYDRAULIC UNIT SUPPORT	2 ITEMS
32	AL500400 61	HYDRAULIC OIL TANK	1 ITEM
33	AL500400 62	ACCUMULATOR OUT-PUT (1/4 10)	1 ITEM
34	AL500400 63	MONOMETER CONNECTOR BEND	1 ITEM
35	AL500400 64	CONNECTION HOSE	1 ITEM
36	AL500400 65	COUPLING	2 ITEMS
37	AL500400 66	DEPOT COVER	1 ITEM
38	AL500400 67	PRESSURE EMERGENCY	1 ITEM
39	AL500400 68	PRESSURE REGULATOR	1 ITEM
40	AL500400 150	ELEKTRICAL PANEL	1 ITEM
41	AL500400 151	DK 24 COUPLING	1 ITEM
42	AL500400 152	CHASSIS TOP COVER	1 ITEM
43	AL500400 153	CHASSIS FRONT COVER	1 ITEM
44	AL500400 154	CHASSIS FRONT UPPER COVER	1 ITEM
45	AL500400 155	LEFT - RIGHT COVERS	1 ITEM
46	AL500400 156	3/8" COPPER WASHER	4 ITEMS
47	AL500400 157	3/8"-3/8" LOOPER	2 ITEMS
48	AL500400 158	3/8" FEMALE QUICK COUPLING	1 ITEM
49	AL500400 159	Ø 10 ALUMINUM TUBE	1 ITEM

AL 400-500

Kullanma Kılavuzu
Technical Information

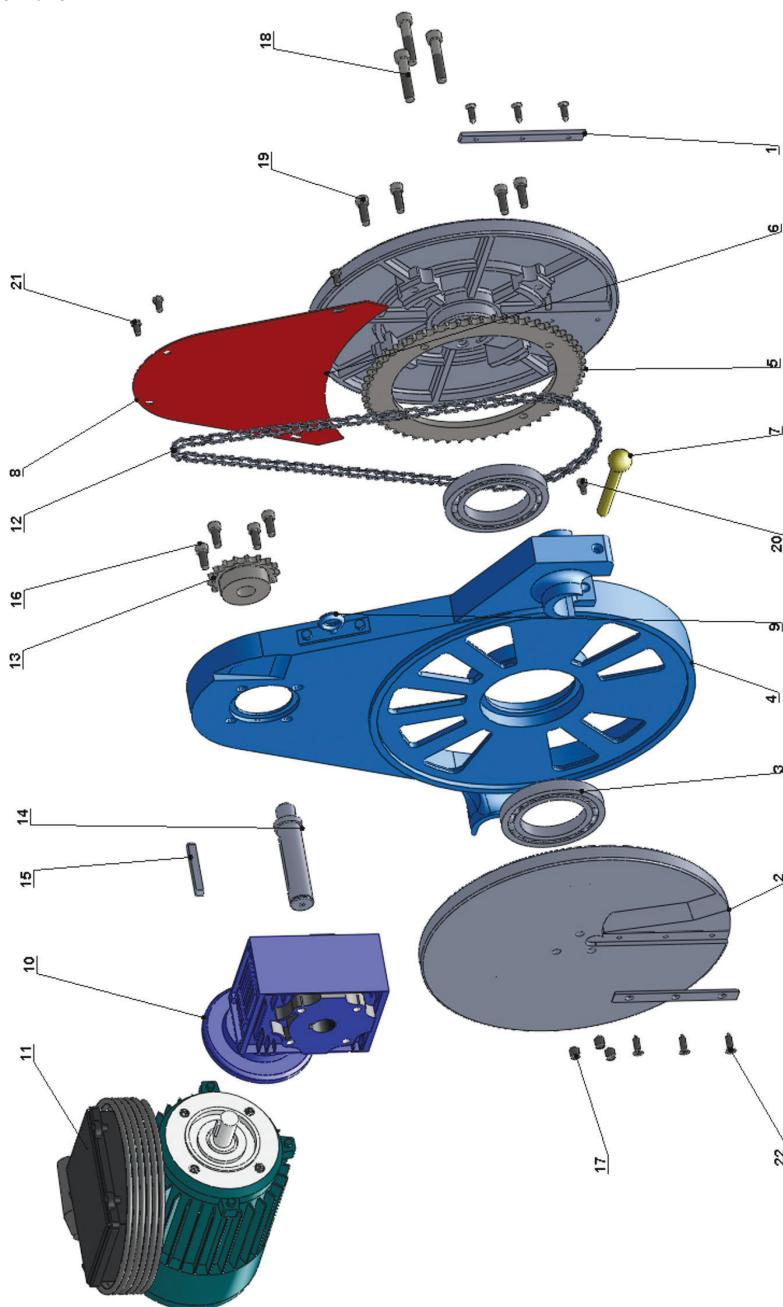
AL 400-500 HYDRAULIC UNIT LIST

AL 400-500		HYDRAULIC UNIT LIST	
NO	CODE NUMBER	ITEM ID	QUANTITY
50	AL500400 160	1/4" 10 REGULATOR	3 ITEMS
51	AL500400 161	M6X10 IMBUS BOLT	4 ITEMS
52	AL500400 162	M10 RING	3 ITEMS
53	AL500400 163	M10 NUT	3 ITEMS
54	AL500400 164	Ø 10 ALUMINUM TUBE	1 ITEM
55	AL500400 165	M8 NUT	2 ITEMS
56	AL500400 166	Ø 8 ALUMINUM TUBE	1 ITEM
57	AL500400 167	M10 CAP NUT	4 ITEMS
58	AL500400 168	M8 NUT	4 ITEMS
59	AL500400 169	M8X25 IMBUS BOLT	4 ITEMS
60	AL500400 170	M6 NUT	8 ITEMS
61	AL500400 171	M6X25 IMBUS BOLT	4 ITEMS
62	AL500400 172	M6X16 IMBUS BOLT	6 ITEMS
63	AL500400 173	OIL FILTER	1 ITEM
64	AL500400 174	CHASSIS BACK COVER	1 ITEM
65	AL500400 175	PUMP ADAPTER	2 ITEMS
66	AL500400 176	M6X20 AKC BOLT	8 ITEMS
67	AL500400 177	1" O RING	1 ITEM
68	AL500400 178	1" NUT	1 ITEM
69	AL500400 179	Ø 20 O RING	1 ITEM
70	AL500400 180	M6 NUT	4 ITEMS
71	AL500400 181	M6 WASHER	4 ITEMS
72	AL500400 182	M6X30 AKC BOLT	4 ITEMS
73	AL500400 183	1/2" 15 MM EXTENSION	1 ITEM
74	AL500400 184	1/2" COPPER WASHER	2 ITEMS
75	AL500400 185	1/2" 10 MM EXTENSION	1 ITEM
76	AL500400 186	1/4" COPPER WASHER	5 ITEMS

AL 630

AL 630 TIRAŞLAYICI / AL 630 TRIMMER

Kullanma Kılavuzu
Technical Information



AL 630

Kullanma Kılavuzu
Technical Information

AL 630 TIRAŞLAYICI LİSTESİ / AL 630 TRIMMER LIST

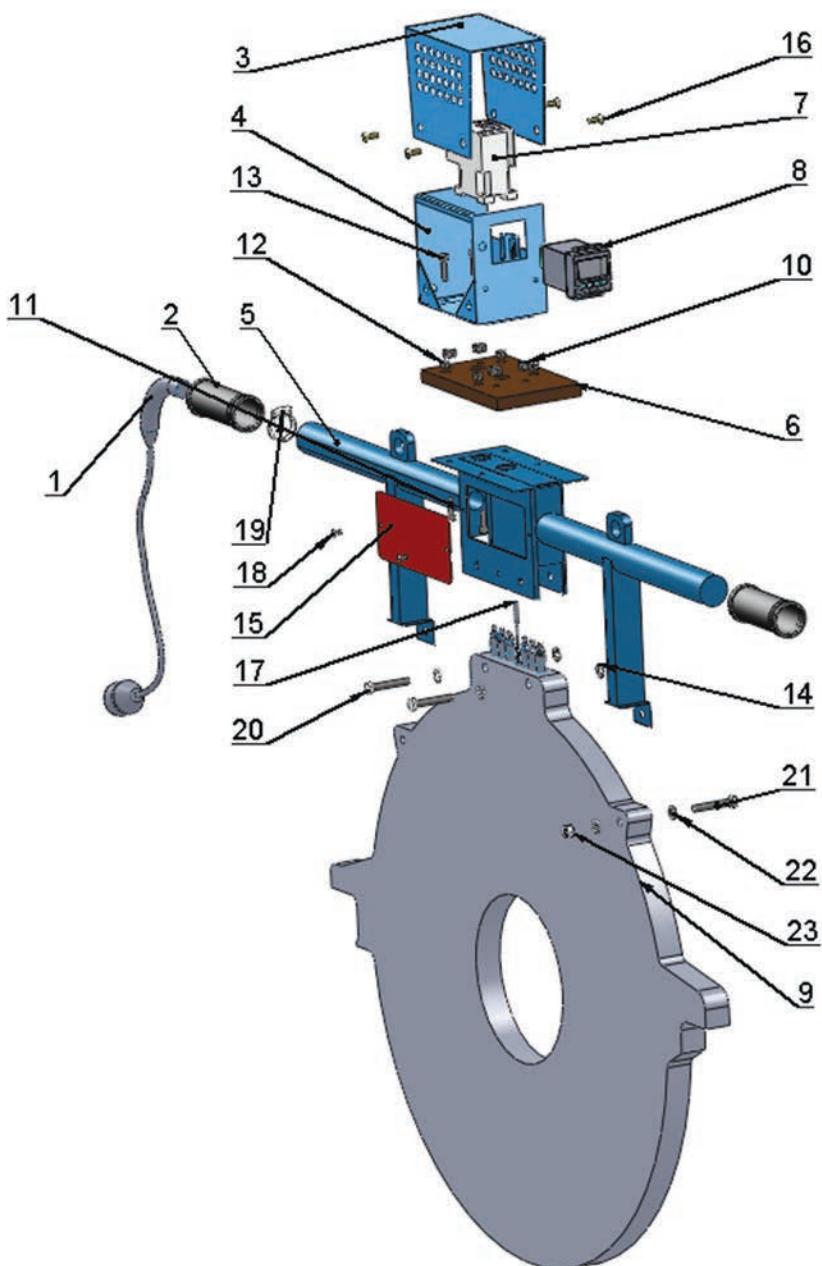
AL 630 TIRAŞLAYICI LİSTESİ			
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL630 72	BIÇAK	2 ADET
2	AL630 73	TIRAŞLAYICI DÜZ DISK	1 ADET
3	AL630 74	RULMAN (16014)	2 ADET
4	AL630 75	TIRAŞLAYICI GÖVDE	1 ADET
5	AL630 76	ZİNCİR DİŞLİ	1 ADET
6	AL630 77	TIRAŞLAYICI DİŞLİ DISK	1 ADET
7	AL630 78	EMNİYET PİMİ	1 ADET
8	AL630 79	TIRAŞLAYICI KAPAK	1 ADET
9	AL630 80	VİNÇ MAPASI	1 ADET
10	AL630 81	REDÜKTÖR	1 ADET
11	AL630 82	MOTOR (1,5 Kw) 1400 d/dk	1 ADET
12	AL630 83	ZİNCİR	1 ADET
13	AL630190	ZİNCİR ÜST DİŞLİ	1 ADET
14	AL630191	ZİNCİR ÜST DİŞLİ MİLİ	1 ADET
15	AL630192	ZİNCİR MİLİ KAMASI	1 ADET
16	AL630193	M8X20 İMBUS CİVATA	4 ADET
17	AL630194	M10X12 SETUSKUR	3 ADET
18	AL630195	M10X50 İMBUS CİVATA	3 ADET
19	AL630196	M8X25 İMBUS CİVATA	4 ADET
20	AL630197	M6X10 İMBUS	1 ADET
21	AL630198	M6X12 AKB CİVATA	4 ADET
22	AL630199	M6 X10 VİDA	6 ADET

AL 630 TRIMMER LIST			
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL630 72	BLADE	2 ITEMS
2	AL630 73	TRIMMER PLAIN DISC	1 ITEM
3	AL630 74	BEARING (6032)	2 ITEMS
4	AL630 75	TRIMMER BODY	1 ITEM
5	AL630 76	CHAIN BEARING (76 CAVITY)	1 ITEM
6	AL630 77	TRIMMER SCREW DISC	1 ITEM
7	AL630 78	SAFETY PIN	1 ITEM
8	AL630 79	TRIMMER COVER	1 ITEM
9	AL630 80	MAPA CRANE	1 ITEM
10	AL630 81	REDUCTOR	1 ITEM
11	AL630 82	MOTOR	1 ITEM
12	AL630 83	CHAIN	1 ITEM
13	AL630190	CHAIN UPPER GEAR	1 ITEM
14	AL630191	CHAIN UPPER GEAR SHAFT	1 ITEM
15	AL630192	CHAIN SHAFT PIN	1 ITEM
16	AL630193	M8x20 İMBUS BOLT	4 ITEMS
17	AL630194	M10X12 NUT (WITH FIBER)	3 ITEMS
18	AL630195	M10x50 İMBUS BOLT	3 ITEMS
19	AL630196	M8x25 İMBUS BOLT	4 ITEMS
20	AL630197	M6x10 İMBUS BOLT	1 ITEM
21	AL630198	M6x12 AKC BOLT	4 ITEMS
22	AL630199	M6x10 SCREW	6 ITEMS

AL 630

AL 630 ISITICI / AL 630 HEATER

Kullanma Kılavuzu
Technical Information



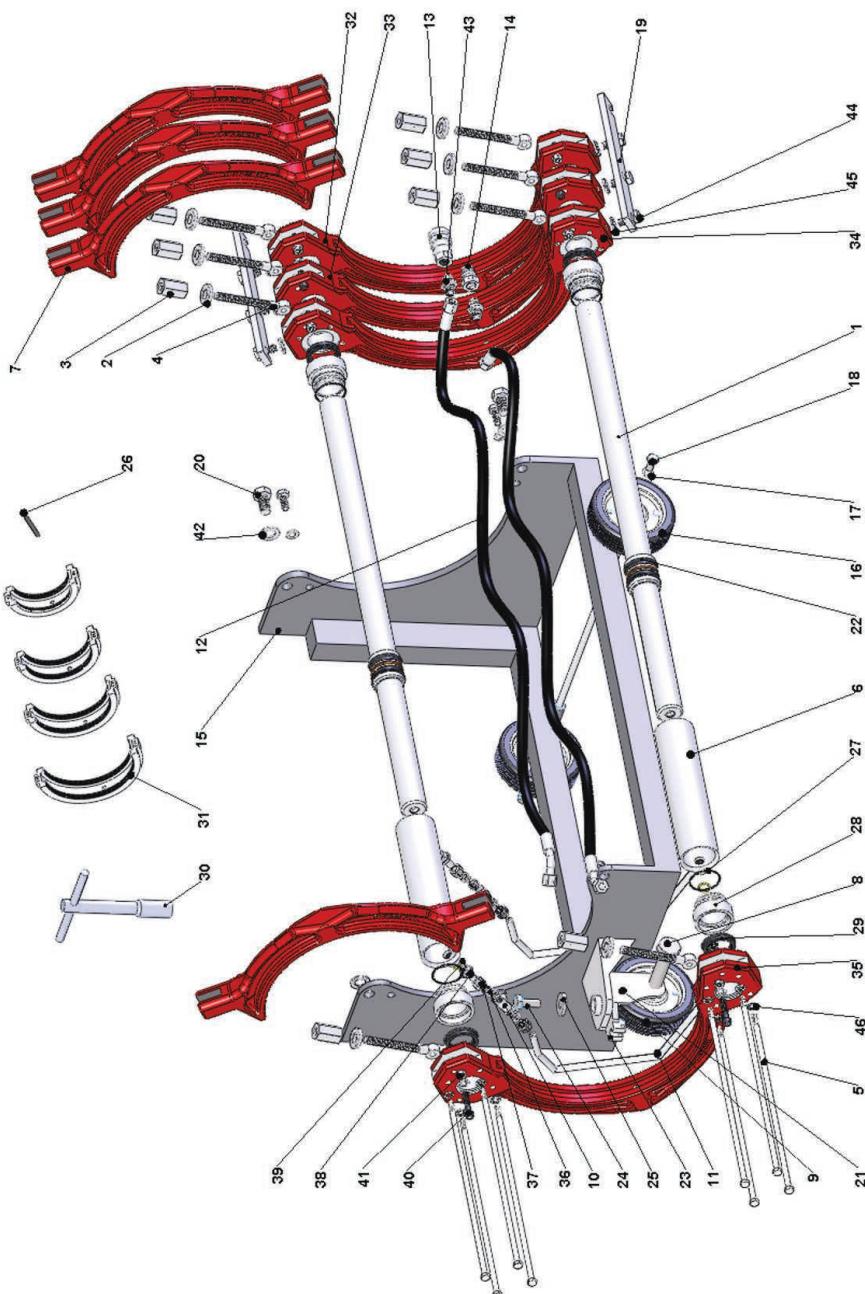
AL 630 İSİTİCİ LİSTESİ			
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL 630 84	ELEKTRİK KABLOSU	1 ADET
2	AL 630 85	TAŞIMA KOLU İZOLESİ	1 ADET
3	AL 630 86	ÜST KAPAK	1 ADET
4	AL 630 87	ELEKTRİK KUTUSU	1 ADET
5	AL 630 88	TAŞIMA KOLU İZOLESİ	2 ADET
6	AL 630 89	İSİ YALITIM FİBERİ	1 ADET
7	AL 630 90	KONTAKTÖR	1 ADET
8	AL 630 91	KONTROL PANELİ	1 ADET
9	AL 630 92	İSİTİCİ	1 ADET
10	AL 630 93	M8 SOMUN (FİBER)	4 ADET
11	AL 630 94	M6 X 25 İMBUS CİVATA	3 ADET
12	AL 630 95	M6 X 30 İMBUS CİVATA	1 ADET
13	AL 630 96	M10 SOMUN	8 ADET
14	AL 630 97	M6 X 25 İMBUS CİVATA	4 ADET
15	AL 630 98	M10 PUL	8 ADET
16	AL 630 99	KORUYUCU KAPAK(KIRMIZI)	1 ADET
17	AL 630 100	M6 X 15 YSB VİDA	4 ADET
18	AL 630 101	TERMOKULP	1 ADET
19	AL 630 102	M4 VİDA (KORUYUCU KAPAK)	2 ADET
20	AL 630 103	KELEPÇE	1 ADET
21	AL 630 104	M10 X 50 AKC CİVATA	2 ADET
22	AL 630 105	M8 X 50 AKC CİVATA	2 ADET
23	AL 630 106	M8 PUL	4 ADET
24	AL 630 107	M8 SOMUN (TAŞIMA KOLU)	2 ADET

AL 630 HEATER LIST			
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL 630 84	ELECTRIC CABLE	1 ITEM
2	AL 630 85	CARRYING HANDLE ISOLATION	1 ITEM
3	AL 630 86	UPPER COVER	1 ITEM
4	AL 630 87	ELECTRIC BOX	1 ITEM
5	AL 630 88	CARRYING HANDLE ISOLATION	2 ITEMS
6	AL 630 89	HEAT ISOLATION FIBER	1 ITEM
7	AL 630 90	CONTACTOR	1 ITEM
8	AL 630 91	CONTROL PANNEL	1 ITEM
9	AL 630 92	HEATER	1 ITEM
10	AL 630 93	M8 NUT (FIBER)	4 ITEMS
11	AL 630 94	M6x25 IMBUS BOLT	3 ITEMS
12	AL 630 95	M6x30 IMBUS BOLT	1 ITEM
13	AL 630 96	M10 NUT	8 ITEMS
14	AL 630 97	M6x25 IMBUS BOLT	4 ITEMS
15	AL 630 98	M10 WASHER	8 ITEMS
16	AL 630 99	PROTECTIVE COVER (RED)	1 ITEM
17	AL 630 100	M6x15 BOLT	4 ITEMS
18	AL 630 101	THERMOCOUPLE	1 ITEM
19	AL 630 102	M4 SCREW (FOR PROTECTIVE COVER)	2 ITEMS
20	AL 630 103	CLIPS	1 ITEM
21	AL 630 104	M10x50 AKC BOLT	2 ITEMS
22	AL 630 105	M8x50 AKC BOLT	2 ITEMS
23	AL 630 106	M8 WASHER	4 ITEMS
24	AL 630 107	M8 NUT (FOR CARRYING HANDLE)	2 ITEMS

AL 630

Kullanma Kılavuzu
Technical Information

AL 630 GÖVDE / AL 630 BASIC MACHINE



AL 630		GÖVDE LİSTESİ	
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL630 01	SERT KROMLU MİL 50X1242mm	2 ADET
2	AL630 02	BAĞLANTI CİVATASI SOMUNU M20	8 ADET
3	AL630 03	M20 PUL	8 ADET
4	AL630 04	BAĞLANTI CİVATASI SAĞLAMASI M20X135 mm	8 ADET
5	AL630 05	PISTON BAĞLANTI SAPLAMASI M10X465 mm	2 ADET
6	AL630 06	HONLANMIŞ BORU 50X60X300 mm	2 ADET
7	AL630 07	BORU BAĞLANTI KELEPÇESİ	4 ADET
8	AL630 08	ÖN TEKER BAĞLANTI CİVATASI M20X150 mm	1 ADET
9	AL630 09	TEKER 250X80 mm	1 ADET
10	AL630 10	M10 T PARÇASI	2 ADET
11	AL630 11	HİDROLİK YAĞ BORUSU	2 ADET
12	AL630 12	5/16" HİDROLİK HORTUM	1 ADET
13	AL630 13	3/8" HİDROLİK OTOMATİK REKOR (DİŞI)	1 ADET
14	AL630 14	3/8" HİDROLİK OTOMATİK REKOR (ERKEK)	1 ADET
15	AL630 15	ANA GÖVDE	1 ADET
16	AL630 16	TEKER 300X80 mm	2 ADET
17	AL630 17	TEKER PULU M12	4 ADET
18	AL630 18	TEKER CİVATASI M10X20 mm	4 ADET
19	AL630 19	ARA BAĞLAMA ADAPTÖRÜ	2 ADET
20	AL630 20	MİL BAĞLANTI CİVATASI M20X30 mm	2 ADET
21	AL630 21	ÖN TEKER BAĞLANTI AYAĞI	1 ADET
22	AL630 22	YAĞ KEÇESİ 63X80X8 mm	8 ADET
23	AL630 23	TAŞIMA KOLU YUVASI	1 ADET
24	AL630 24	ÖN TEKER CİVATASI M12X30 mm	1 ADET
25	AL630 25	ÖN TEKER SABİTLEME M12 PUL	1 ADET
26	AL630 26	PAFTA BAĞLANTI CİVATASI	48 ADET
27	AL630 27	O RİNG 58X63X3 mm	4 ADET
28	AL630 28	SİFERO BOĞAZ	4 ADET
29	AL630 29	TOZ KEÇESİ 50X60X7 mm	4 ADET
30	AL630 30	32 LOKMA	1 ADET
31	AL630 31	PAFTALAR (315,355,400,450,500,560)	48 ADET
32	AL630 120	ÇİFT DELİK ALT ÇENE	1 ADET
33	AL630 121	TEK LİK ALT ÇENE	1 ADET
34	AL630 122	KÖR 4 DELİK ALT ÇENE	1 ADET
35	AL630 123	PATLAK 4 DELİK ALT ÇENE	1 ADET
36	AL630 124	10 LUK YÜZÜK	6 ADET
37	AL630 125	M10 SOMUN	6 ADET
38	AL630 126	1/4" 10 TERS REKOR	4 ADET
39	AL630 127	1/4" BAKIR PUL	4 ADET
40	AL630 128	M8 X 40 İMBUS CİVATA	8 ADET
41	AL630 129	M8 SOMUN	8 ADET
42	AL630 130	MİL BAĞLANTI PULU M10	4 ADET
43	AL630 131	3/8" 10 REKOR	2 ADET
44	AL630 132	ARA ADAPTÖR BAĞLANTI CİVATASI M12 X25 AKC	6 ADET
45	AL630 133	ARA BAĞLAMA ADAPTÖRÜ PULU M14	6 ADET
46	AL630 134	PISTON BAĞLANTI SAPLAMASI PULU M10	8 ADET

AL 630

AL 630 BASIC MACHINE LIST

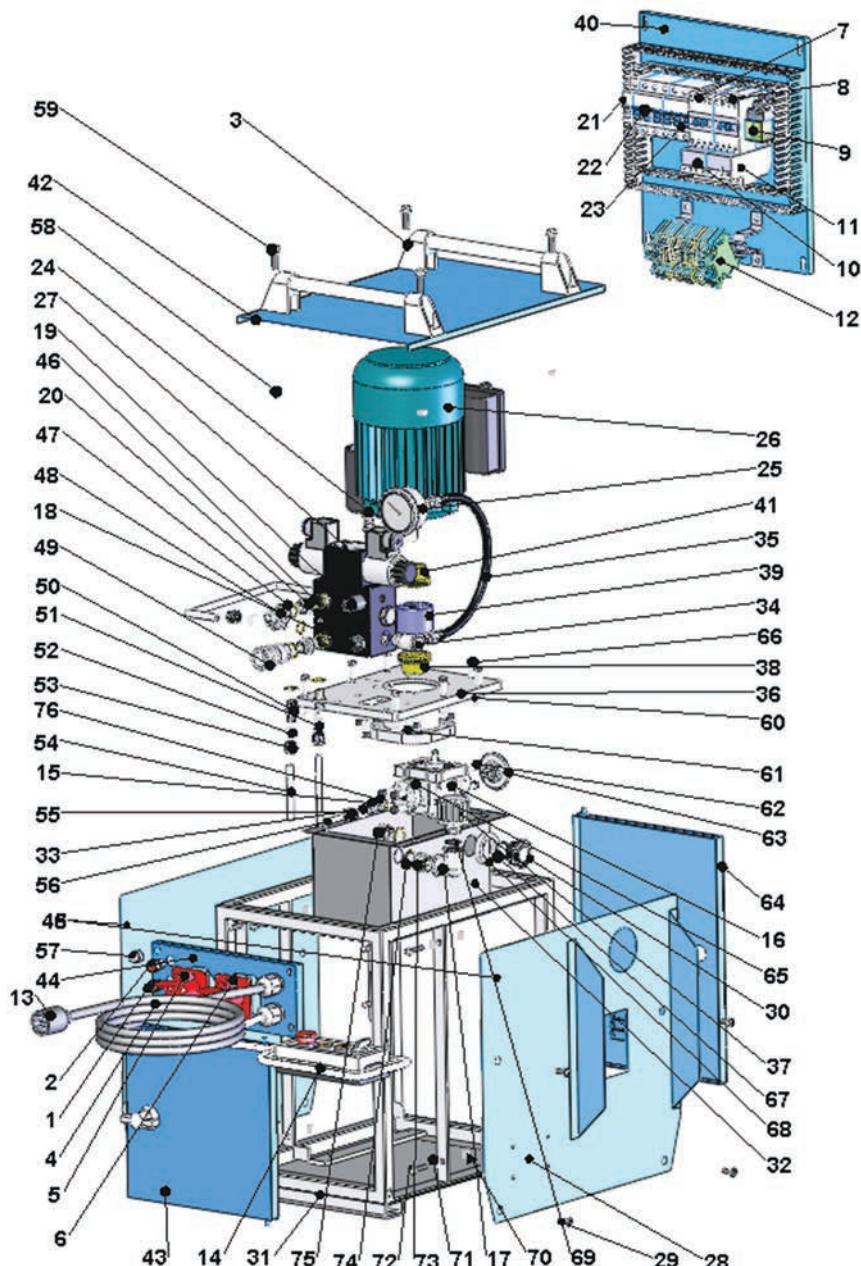
Kullanma Kılavuzu
Technical Information

AL 630			BASIC MACHINE LIST
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL630 01	CHROME COATED SHAFT(50x1242)	2 ITEMS
2	AL630 02	CONNECTING JOINT NUT M20	8 ITEMS
3	AL630 03	M20 WASHER	8 ITEMS
4	AL630 04	CONNECTING JOINT NUT M20X135 mm	8 ITEMS
5	AL630 05	PISTON CONNECTING HANDLE M10X465 mmmm)	2 ITEMS
6	AL630 06	POLISHED PIPE (50x60x300 mm)	2 ITEMS
7	AL630 07	PIPE CONNECTING CLIP	4 ITEMS
8	AL630 08	FORE WHEEL POSITIONING BOLT (M20X150 mm)	1 ITEM
9	AL630 09	FORE WHEEL (250X80 mm)	1 ITEM
10	AL630 10	M10 TE PIECE	2 ITEMS
11	AL630 11	HYDRAULIC OIL TUBE	2 ITEMS
12	AL630 12	5/16" HYDRAULIC HOSE	1 ITEM
13	AL630 13	3/8" FEMALE QUICK COUPLING	1 ITEM
14	AL630 14	3/8" MALE QUICK COUPLING	1 ITEM
15	AL630 15	BASIC MACHINE	1 ITEM
16	AL630 16	WHEEL (300x80 mm)	2 ITEMS
17	AL630 17	WHEEL WASHER M12	4 ITEMS
18	AL630 18	WHEEL BOLT (M10x20)	4 ITEMS
19	AL630 19	CONNECTING ADAPTOR	2 ITEMS
20	AL630 20	FLAT BAR JOINT M20X30 mm	2 ITEMS
21	AL630 21	FORE WHEEL CONNECTION LEG	1 ITEM
22	AL630 22	OIL BUSH (65x50x80)	8 ITEMS
23	AL630 23	CARRYING HANDLE BED	1 ITEM
24	AL630 24	WHEEL BOLT (M12x30mm)	1 ITEM
25	AL630 25	FORE WHEEL POSITIONING WASHER (M12)	1 ITEM
26	AL630 26	BOLD CONNECTING JOINT	48 ITEMS
27	AL630 27	O RING (58x63x3 mm)	4 ITEMS
28	AL630 28	SIFERO NECK	4 ITEMS
29	AL630 29	DUST FELT 50X60X7 mm	4 ITEMS
30	AL630 30	KEY 32	1 ITEM
31	AL630 31	BOLTS (315,355,400,450,500,560)	48 ITEMS
32	AL630 120	DOUBLE HOLE LOWER CLAMP	1 ITEM
33	AL630 121	SINGLE HOLE LOWER CLAMP	1 ITEM
34	AL630 122	4 HOLE BLIND LOWER CLAMP	1 ITEM
35	AL630 123	4 HOLE LOWER CLAMP	1 ITEM
36	AL630 124	M10 RING	6 ITEMS
37	AL630 125	M10 NUT	6 ITEMS
38	AL630 126	1/4" 10 REVERSE SCREW ADAPTOR	4 ITEMS
39	AL630 127	1/4" COPPER WASHER	4 ITEMS
40	AL630 128	M8x40 IMBUS BOLT	8 ITEMS
41	AL630 129	M8 NUT	8 ITEMS
42	AL630 130	SHAFT CONNECTING WASHER M10	4 ITEMS
43	AL630 131	3/8" 10 ADAPTOR	2 ITEMS
44	AL630 132	CONNECTING ADAPTOR BOLT M14X35	6 ITEMS
45	AL630 133	CONNECTING ADAPTOR WASHER M12	6 ITEMS
46	AL630 134	PISTONS CONNECTING STUD WASHER M10	8 ITEMS

AL 630

AL 630 HİDROLİK ÜNİTE / AL 630 HYDRAULIC UNIT

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AL 630 HİDROLİK ÜNİTE LİSTESİ

AL 630		HİDROLİK ÜNİTE LİSTESİ	
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL630 33	TIRAŞLAYICI ARIZA LAMBASI	1 ADET
2	AL630 34	HİDROLİK ARIZA LAMBASI	1 ADET
3	AL630 35	TAŞIMA KOLU	2 ADET
4	AL630 36	HİDROLİK SİSTEM DEVREDE LAMBASI	1 ADET
5	AL630 37	TIRAŞLAYICI PRİZİ	1 ADET
6	AL630 38	İSİTİCİ PRİZİ	1 ADET
7	AL630 39	HİDROLİK ÜNİTE KONTAKTORU ALMK 1210	1 ADET
8	AL630 40	TIRAŞLAYICI KONTAKTORU MTC 1810	1 ADET
9	AL630 41	HİDROLİK ÜNİTE ROLESİ FINDER 40.52	2 ADET
10	AL630 42	HİDROLİK ÜNİTE TERMİĞİ ALM-T2.1	1 ADET
11	AL630 43	TIRAŞLAYICI TERMİĞİ ALM-T3.5	1 ADET
12	AL630 44	RAY KLAMENSİ	1 ADET
13	AL630 45	BESLEME FİŞİ	1 ADET
14	AL630 46	KUMANDA BUTONU	1 ADET
15	AL630 47	HİDROLİK OTOMATİK REKOR(DIŞI)	1 ADET
16	AL630 48	HİDROLİK POMPA (C036X)	1 ADET
17	AL630 49	YAĞ İLAVE BORUSU	1 ADET
18	AL630 50	BASINÇ SİFIRLAMA KOLU	1 ADET
19	AL630 51	BASINÇ REGÜLATÖRÜ	1 ADET
20	AL630 52	HİDROLİK OTOMATİK REKOR (ERKEK)	1 ADET
21	AL630 53	HİDROLİK KUMANDA SİGORTASI ALMC16	1 ADET
22	AL630 54	İSİTİCİ SİGORTASI ALMC25	1 ADET
23	AL630 55	HİDROLİK ÜNİTE SIGORTASI ALMC10	1 ADET
24	AL630 56	AKÜ	1 ADET
25	AL630 57	MANOMETRE	1 ADET
26	AL630 58	MOTOR (0,75kw) 1400 d/dk	1 ADET
27	AL630 59	HİDROLİK VALF	1 ADET
28	AL630 60	FİRMA ETİKETİ	1 ADET
29	AL630 61	SABİTLEME CİVATASI M6X15	18 ADET
30	AL630 62	YAĞ GÖSTERGESİ	1 ADET
31	AL630 63	HİDROLİK ÜNİTE AYAKLARI	2 ADET
32	AL630 64	HİDROLİK YAĞ TANKI	1 ADET
33	AL630 65	AKÜ BAĞLANTI REKORU (1/4 10)	1 ADET
34	AL630 66	MANOMETRE BAĞLANTI DİRSEĞİ (1/4 10)	1 ADET
35	AL630 67	BAĞLANTI HORTUMU	1 ADET
36	AL630 68	KAPLİN	2 ADET
37	AL630 69	DEPO KAPAĞI	1 ADET
38	AL630 70	BASINÇ KİLİTİ	1 ADET
39	AL630 71	BASINÇ AYAR REKORU	1 ADET
40	AL630150	ELEKTRİK PANOSU	1 ADET
41	AL630151	DK 24 KAPLİN	1 ADET
42	AL630152	ŞASE ÜST KAPAĞI	1 ADET
43	AL630153	ŞASE ÖN ALT KAPAĞI	1 ADET
44	AL630154	ŞASE ÖN ÜST KAPAĞI	1 ADET
45	AL630155	SOL-SAĞ KAPAKLAR	1 ADET
46	AL630156	3/8"-3/8" BAKIR PUL	4 ADET
47	AL630157	3/8"-3/8" LÜPER	2 ADET
48	AL630158	3/8" DIŞI KUIK KAPLİN	1 ADET
49	AL630159	Ø 10 ALÜMİNYUM BORU	1 ADET

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Kullanma Kılavuzu
Technical Information

AL 630 HİDROLİK ÜNİTE LİSTESİ

AL 630		HİDROLİK ÜNİTE LİSTESİ	
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
50	AL630160	1/4" 10 REKOR	3 ADET
51	AL630161	M6X10 İMBUS CİVATA	4 ADET
52	AL630162	10 LUK YÜZÜK	3 ADET
53	AL630163	M10 SOMUN	3 ADET
54	AL630164	Ø 10 ALÜMİNYUM BORU	1 ADET
55	AL630165	M8 SOMUN	2 ADET
56	AL630166	Ø 8 ALÜMİNYUM BORU	1 ADET
57	AL630167	M10 ŞAPKALI SOMUN	4 ADET
58	AL630168	M8 SÖMÜN	4 ADET
59	AL630169	M8X25 İMBUS CİVATA	4 ADET
60	AL630170	M6 SÖMÜN	8 ADET
61	AL630171	M6X25 İMBUS CİVATA	4 ADET
62	AL630172	M6X16 İMBUS CİVATA	6 ADET
63	AL630173	YAG FİLTRESİ	1 ADET
64	AL630174	ŞASE ARKA KAPAK	1 ADET
65	AL630175	POMPA ADAPTÖRÜ	2 ADET
66	AL630176	M6X20 AKC CİVATA	8 ADET
67	AL630177	1" O RİNG	1 ADET
68	AL630178	1" SOMUN	1 ADET
69	AL630179	Ø 20 O RİNG	1 ADET
70	AL630180	M6 SÖMÜN	4 ADET
71	AL630181	M6 PUL	4 ADET
72	AL630182	M6X30 AKC CİVATA	4 ADET
73	AL630183	1/2" 15 mm UZATMA	1 ADET
74	AL630184	1/2" BAKIR PUL	2 ADET
75	AL630185	1/2" 10 mm UZATMA	1 ADET
76	AL630186	1/4" BAKIR PUL	5 ADET

AL 630

Kullanma Kılavuzu
Technical Information

AL 630 HYDRAULIC UNIT LIST

AL 630 HYDRAULIC UNIT LIST			
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL630 33	TRIMMER FAILURE LAMP	1 ITEM
2	AL630 34	HYDRAULIC FAILURE LAMP	1 ITEM
3	AL630 35	HANDLE	2 ITEMS
4	AL630 36	HYDRAULIC SYSTEM LAMP(ON)	1 ITEM
5	AL630 37	TRIMMER SOCKET	1 ITEM
6	AL630 38	HEATER SOCKET	1 ITEM
7	AL630 39	HYDRAULIC UNIT CONTACTOR ALMK 1210	1 ITEM
8	AL630 40	TRIMMER CONTACTOR MTC 1210	1 ITEM
9	AL630 41	HYDRAULIC UNIT ROLE FINDER 40.55	2 ITEMS
10	AL630 42	HYDRAULIC UNIT THERMIC ALM-2.1	1 ITEM
11	AL630 43	TRIMMER THERMIC ALM-T3.5	1 ITEM
12	AL630 44	CONNECTOR	1 ITEM
13	AL630 45	SUPPLY PLUG	1 ITEM
14	AL630 46	CONTROL BUTTON	1 ITEM
15	AL630 47	QUICK COUPLING (FEMALE)	1 ITEM
16	AL630 48	HYDRAULIC PUMP(C036X)	1 ITEM
17	AL630 49	OIL ADDITION TUBE	1 ITEM
18	AL630 50	PRESSURE INITIALIZING HANDLE	1 ITEM
19	AL630 51	PRESSURE REGULATOR	1 ITEM
20	AL630 52	QUICK COUPLING (MALE)	1 ITEM
21	AL630 53	HYDRAULIC CONTROL FUSE ALMC 16	1 ITEM
22	AL630 54	HEATER FUSE ALMC 25	1 ITEM
23	AL630 55	HYDRAULIC UNIT FUSE ALMC 10	1 ITEM
24	AL630 56	ACCUMULATOR	1 ITEM
25	AL630 57	MONOMETER	1 ITEM
26	AL630 58	MOTOR (1,5kw) 1400 d/dk	1 ITEM
27	AL630 59	HYDRAULIC VALVE	1 ITEM
28	AL630 60	COMPANY LABEL	1 ITEM
29	AL630 61	FASTEN JOINT M6X15	18 ITEMS
30	AL630 62	OIL INDICATOR	1 ITEM
31	AL630 63	HYDRAULIC UNIT SUPPORT	2 ITEMS
32	AL630 64	HYDRAULIC OIL TANK	1 ITEM
33	AL630 65	ACCUMULATOR OUT-PUT (1/4 10)	1 ITEM
34	AL630 66	MONOMETER CONNECTOR BEND	1 ITEM
35	AL630 67	CONNECTION HOSE	1 ITEM
36	AL630 68	COUPLING	2 ITEMS
37	AL630 69	DEPOT COVER	1 ITEM
38	AL630 70	PRESSURE EMERGENCY	1 ITEM
39	AL630 71	PRESSURE REGULATOR	1 ITEM
40	AL630150	ELEKTRICAL PANEL	1 ITEM
41	AL630151	DK 24 COUPLING	1 ITEM
42	AL630152	CHASSIS TOP COVER	1 ITEM
43	AL630153	CHASSIS FRONT COVER	1 ITEM
44	AL630154	CHASSIS FRONT UPPER COVER	1 ITEM
45	AL630155	LEFT - RIGHT COVERS	1 ITEM
46	AL630156	3/8" COPPER WASHER	4 ITEMS
47	AL630157	3/8"-3/8" LOOPER	2 ITEMS
48	AL630158	3/8" FEMALE QUICK COUPLING	1 ITEM
49	AL630159	Ø 10 ALUMINUM TUBE	1 ITEM

AL 630

Kullanma Kılavuzu
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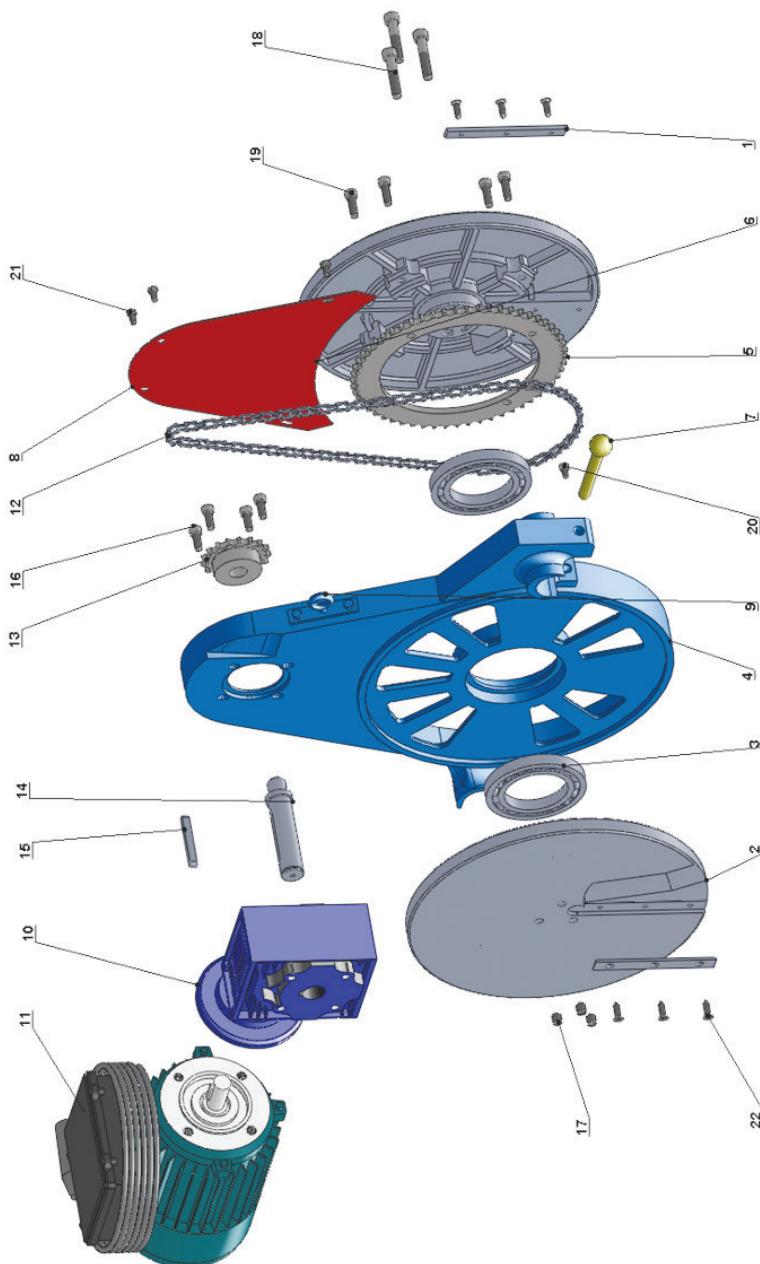
AL 630 HYDRAULIC UNIT LIST

AL 630		HYDRAULIC UNIT LIST	
NO	CODE NUMBER	ITEM ID	QUANTITY
50	AL630160	1/4" 10 REGULATOR	3 ITEMS
51	AL630161	M6X10 IMBUS BOLT	4 ITEMS
52	AL630162	M10 RING	3 ITEMS
53	AL630163	M10 NUT	3 ITEMS
54	AL630164	Ø 10 ALUMINUM TUBE	1 ITEM
55	AL630165	M8 NUT	2 ITEMS
56	AL630166	Ø 8 ALUMINUM TUBE	1 ITEM
57	AL630167	M10 CAP NUT	4 ITEMS
58	AL630168	M8 NUT	4 ITEMS
59	AL630169	M8X25 IMBUS BOLT	4 ITEMS
60	AL630170	M6 NUT	8 ITEMS
61	AL630171	M6X25 IMBUS BOLT	4 ITEMS
62	AL630172	M6X16 IMBUS BOLT	6 ITEMS
63	AL630173	OIL FILTER	1 ITEM
64	AL630174	CHASSIS BACK COVER	1 ITEM
65	AL630175	PUMP ADAPTER	2 ITEMS
66	AL630176	M6X20 AKC BOLT	8 ITEMS
67	AL630177	1" O RING	1 ITEM
68	AL630178	1" NUT	1 ITEM
69	AL630179	Ø 20 O RING	1 ITEM
70	AL630180	M6 NUT	4 ITEMS
71	AL630181	M6 WASHER	4 ITEMS
72	AL630182	M6X30 AKC BOLT	4 ITEMS
73	AL630183	1/2" 15 MM EXTENSION	1 ITEM
74	AL630184	1/2" COPPER WASHER	2 ITEMS
75	AL630185	1/2" 10 MM EXTENSION	1 ITEM
76	AL630186	1/4" COPPER WASHER	5 ITEMS

AL 800

Kullanma Kılavuzu
Technical Information

AL 800 TIRAŞLAYICI / AL 800 TRIMMER



AL 800

Kullanma Kılavuzu
Technical Information

AL 800 TIRAŞLAYICI LİSTESİ / AL 800 TRIMMER LIST

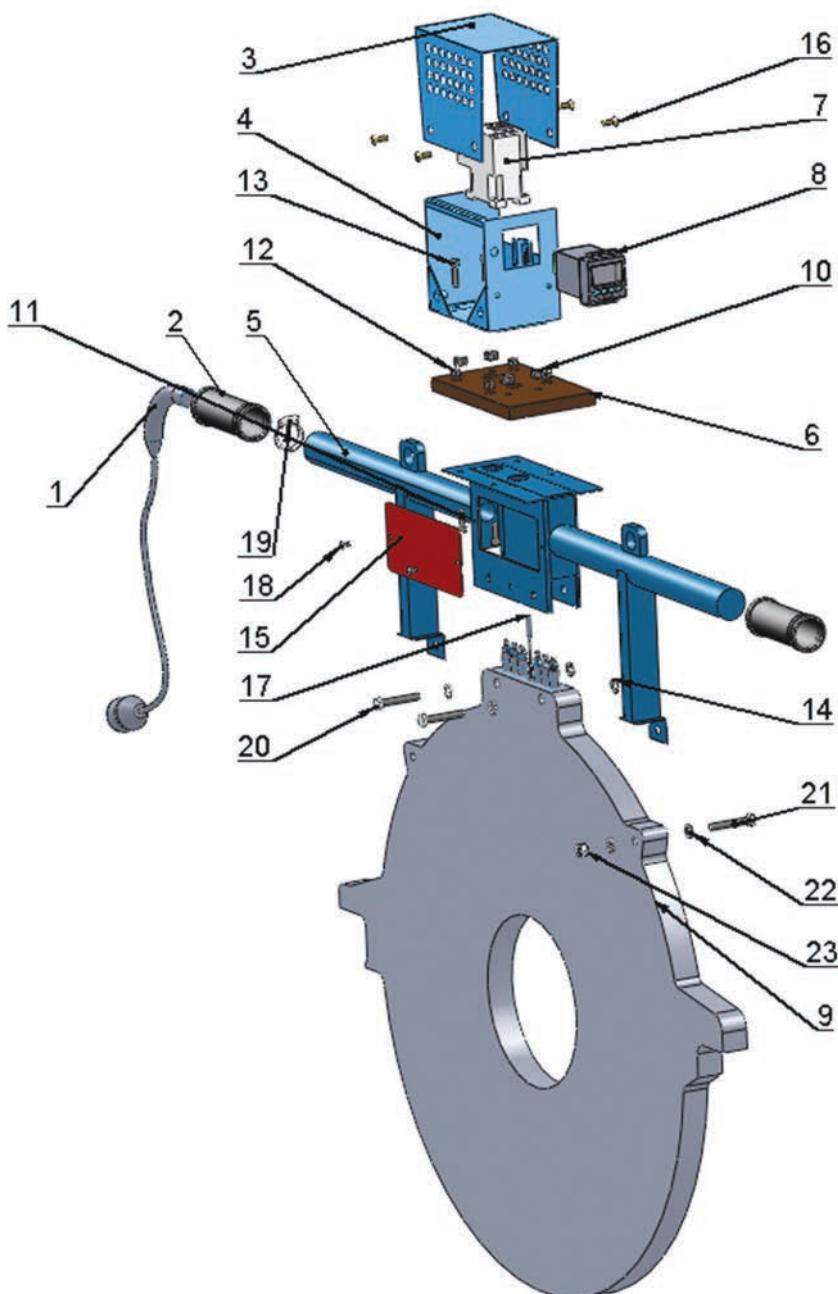
AL 800				TIRAŞLAYICI LİSTESİ
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET	
1	AL800 72	BIÇAK	2 ADET	
2	AL800 73	TRAŞLAYICI DÜZ DISK	1 ADET	
3	AL800 74	RULMAN (16014)	2 ADET	
4	AL800 75	TRAŞLAYICI GÖVDE	1 ADET	
5	AL800 76	ZİNCİR DİŞLİ	1 ADET	
6	AL800 77	TRAŞLAYICI DİŞLİ DISK	1 ADET	
7	AL800 78	EMNİYET PİMİ	1 ADET	
8	AL800 79	TRAŞLAYICI KAPAK	1 ADET	
9	AL800 80	VİNÇ MAPASI	1 ADET	
10	AL800 81	REDÜKTÖR	1 ADET	
11	AL800 82	MOTOR (1,5 Kw) 1400 d/dk	1 ADET	
12	AL800 83	ZİNCİR	1 ADET	
13	AL800 190	ZİNCİR ÜST DİŞLİ	1 ADET	
14	AL800 191	ZİNCİR ÜST DİŞLİ MİLİ	1 ADET	
15	AL800 192	ZİNCİR MİLİ KAMASI	1 ADET	
16	AL800 193	M8X35 İMBUS CİVATA	4 ADET	
17	AL800 194	M10X12 SETUSKUR	3 ADET	
18	AL800 195	M10X50 İMBUS CİVATA	3 ADET	
19	AL800 196	M8X25 İMBUS CİVATA	4 ADET	
20	AL800 197	M6X10 İMBUS	1 ADET	
21	AL800 198	M6X12 AKB CİVATA	4 ADET	
22	AL800 199	M6X10 VİDA	6 ADET	

AL 800				TRIMMER LIST
NO	CODE NUMBER	ITEM ID	QUANTITY	
1	AL800 72	BLADE	2 ITEMS	
2	AL800 73	TRIMMER PLAIN DISC	1 ITEM	
3	AL800 74	BEARING (6032)	2 ITEMS	
4	AL800 75	TRIMMER BODY	1 ITEM	
5	AL800 76	CHAIN BEARING	1 ITEM	
6	AL800 77	TRIMMER SCREW DISC	1 ITEM	
7	AL800 78	SAFETY PIN	1 ITEM	
8	AL800 79	TRIMMER COVER	1 ITEM	
9	AL800 80		1 ITEM	
10	AL800 81	REDUCTOR	1 ITEM	
11	AL800 82	MOTOR	1 ITEM	
12	AL800 83	CHAIN	1 ITEM	
13	AL800 190	CHAIN UPPER GEAR	1 ITEM	
14	AL800 191	CHAIN UPPER GEAR SHAFT	1 ITEM	
15	AL800 192	CHAIN SHAFT PIN	1 ITEM	
16	AL800 193	M8x35 İMBUS BOLT_M12 NUT (WITH FIBER)	4 ITEMS	
17	AL800 194	M10x12 İMBUS BOLT	3 ITEMS	
18	AL800 195	M10x50 İMBUS BOLT	3 ITEMS	
19	AL800 196	M8x25 İMBUS BOLT	4 ITEMS	
20	AL800 197	M6x10 İMBUS BOLT	1 ITEM	
21	AL800 198	M6x12 AKC BOLT	4 ITEMS	
22	AL800 199	M6x10 SCREW	6 ITEMS	

AL 800

AL 800 ISITICI / AL 800 HEATER

Kullanma Kılavuzu
Technical Information



AL 800

Kullanma Kılavuzu
Technical Information

AL 800 İSİTİCİ LİSTESİ / AL 800 HEATER LIST

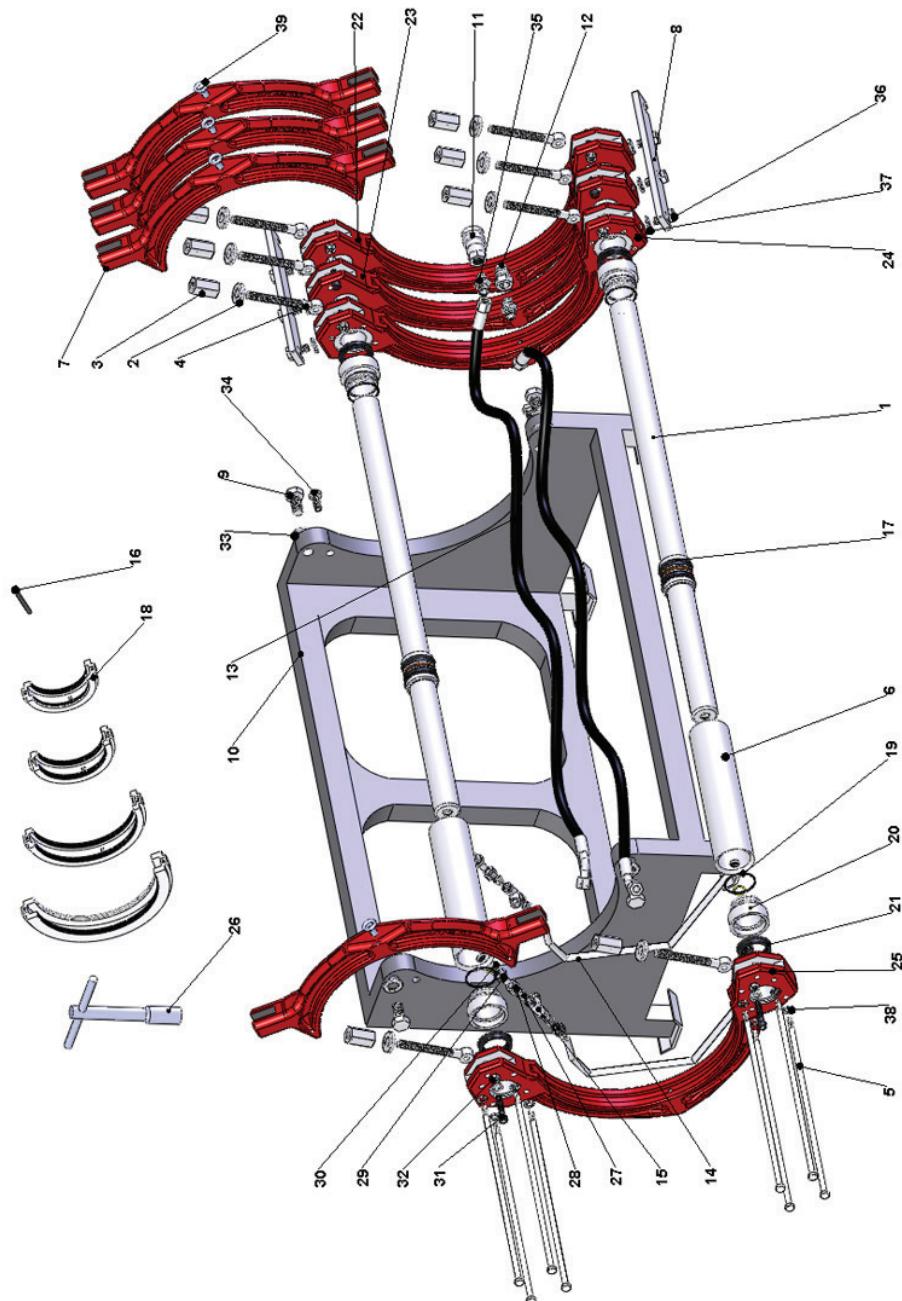
AL 800 İSİTİCİ LİSTESİ			
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL800 92	ELEKTRİK KABLOSU	1 ADET
2	AL800 93	TAŞIMA KOLU İZOLESİ	1 ADET
3	AL800 94	ÜST KAPAK	1 ADET
4	AL800 95	ELEKTRİK KUTUSU	1 ADET
5	AL800 96	TAŞIMA KOLU İZOLESİ	2 ADET
6	AL800 97	İSİ YALITIM FİBERİ	1 ADET
7	AL800 98	KONTAKTÖR	1 ADET
8	AL800 99	KONTROL PANELİ	1 ADET
9	AL800 100	İSİTİCİ	1 ADET
10	AL800 101	M8 SOMUN (FİBER)	4 ADET
11	AL800 102	M6 X 25 İMBUS CİVATA	3 ADET
12	AL800 95	M6 X 30 İMBUS CİVATA	1 ADET
13	AL800 96	M10 SOMUN	8 ADET
14	AL800 97	M6 X 25 İMBUS CİVATA	4 ADET
15	AL800 98	M10 PUL	8 ADET
16	AL800 99	KORUYUCU KAPAK(KIRMIZI)	1 ADET
17	AL800 100	M6 X 15 YSB VİDA	4 ADET
18	AL800 101	TERMOKULP	1 ADET
19	AL800 102	M4 VİDA (KORUYUCU KAPAK)	2 ADET
20	AL800 103	KELEPÇE	1 ADET
21	AL800 104	M10 X 50 AKC CİVATA	2 ADET
22	AL800 105	M8 X 50 AKC CİVATA	2 ADET
23	AL800 106	M8 PUL	4 ADET
24	AL800 107	M8 SOMUN (TAŞIMA KOLU)	2 ADET

AL 800 HEATER LIST			
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL800 92	ELECTRIC CABLE	1 ITEM
2	AL800 93	CARRYING HANDLE ISOLATION	1 ITEM
3	AL800 94	UPPER COVER	1 ITEM
4	AL800 95	ELECTRIC BOX	1 ITEM
5	AL800 96	CARRYING HANDLE ISOLATION	2 ITEMS
6	AL800 97	HEAT ISOLATION FIBER	1 ITEM
7	AL800 98	CONTACTOR	1 ITEM
8	AL800 99	CONTROL PANNEL	1 ITEM
9	AL800 100	HEATER	1 ITEM
10	AL800 101	M8 NUT (FIBER)	4 ITEM S
11	AL800 102	M6x25 IMBUS BOLT	3 ITEMS
12	AL800 95	M6x30 IMBUS BOLT	1 ITEM
13	AL800 96	M10 NUT	8 ITEMS
14	AL800 97	M6x25 IMBUS BOLT	4 ITEMS
15	AL800 98	M10 WASHER	8 ITEMS
16	AL800 99	PROTECTIVE COVER (RED)	1ITEM
17	AL800 100	M6x15 BOLT	4ITEM S
18	AL800 101	THERMOCOUPLE	1ITEM
19	AL800 102	M4 SCREW (FOR PROTECTIVE COVER)	2 ITEM S
20	AL800 103	CLIPS	1 ITEM
21	AL800 104	M10x50 AKC BOLT	2 ITEMS
22	AL800 105	M8x50 AKC BOLT	2 ITEMS
23	AL800 106	M8 WASHER	4 ITEMS
24	AL800 107	M8 NUT (FOR CARRYING HANDLE)	2 ITEMS

AL 800

AL 800 GÖVDE / AL 800 BASIC MACHINE

Kullanma Kılavuzu
Technical Information



AL 800

Kullanma Kılavuzu
Technical Information

AL 800 GÖVDE LİSTESİ

AL 800		GÖVDE LİSTESİ	
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL80001	SERT KROMLU MİL 50X1242mm	2 ADET
2	AL80002	M20PUL	8 ADET
3	AL80003	BAĞLANTI CİVATASI SOMUNU M20	8 ADET
4	AL80004	BAĞLANTI CİVATASI SAPLAMASI	8 ADET
5	AL80005	PISTON BAĞLANTI SAPLAMASI M10X465 mm	2 ADET
6	AL80006	HONLANMIŞ BORU 50X60X300 mm	2 ADET
7	AL80007	BORU BAĞLANTI KELEPÇESİ	4 ADET
8	AL80008	ARA BAĞLAMA ADAPTÖRÜ	2 ADET
9	AL80009	MIL BAĞLANTI CİVATASI M20X30 mm	4 ADET
10	AL80010	ANA GÖVDE	1 ADET
11	AL80011	3/8" HIDROLİK OTOMATİK REKOR (ERKEK)	1 ADET
12	AL80012	3/8" HIDROLİK OTOMATİK REKOR (DİŞİ)	1 ADET
13	AL80013	5/16 "HİDROLİK HORTUM	1 ADET
14	AL80014	HİDROLİK YAĞ BORUSU	2 ADET
15	AL80015	10 LUK T PARÇASI	4 ADET
16	AL80016	PAFTA BAĞLANTI CİVATASI	48 ADET
17	AL80017	YAĞ KEÇESİ 65X50X8 mm	2 ADET
18	AL80018	PAFTALAR (500-560-630-710)	80 ADET
19	AL80019	O RİNG 58X63X3 mm	4 ADET
20	AL80020	SİFERO BOĞAZ	4 ADET
21	AL80021	TOZ KEÇESİ 51X60X4,5 mm	4 ADET
22	AL80022	ÇİFT DELİK ALT ÇENE	1 ADET
23	AL80023	TEK LİK ALT ÇENE	1 ADET
24	AL80024	KÖR 4 DELİK ALT ÇENE	1 ADET
25	AL80025	PATLAK 4 DELİK ALT ÇENE	1 ADET
26	AL80026	32 LOKMA	1 ADET
27	AL80027	10 LUK YÜZÜK	6 ADET
28	AL80028	M10 SOMUN	6 ADET
29	AL80029	10 LUK TERS REKOR	4 ADET
30	AL80030	1/4" BAKIR PUL	4 ADET
31	AL80031	M8 X 40 İMBUS CİVATA	8 ADET
32	AL80032	M8 SOMUN	8 ADET
33	AL80033	MİL BAĞLANTI PULU M20	4 ADET
34	AL80034	M12 X 30 AKC CİVATA	2 ADET
35	AL80035	3/8" 10 TERS REKOR	2 ADET
36	AL80036	ARA ADAPTÖR BAĞLANTI CİVATASI M14X35 AKC	6 ADET
37	AL80037	ARA ADAPTÖR BAĞLANTI PULU M14	6 ADET
38	AL80038	PISTON BAĞLANTI SAPLAMASI PULU M10	16 ADET
39	AL80039	VİNÇ MAPASI	1 ADET

AL 800

Kullanma Kılavuzu
Technical Information

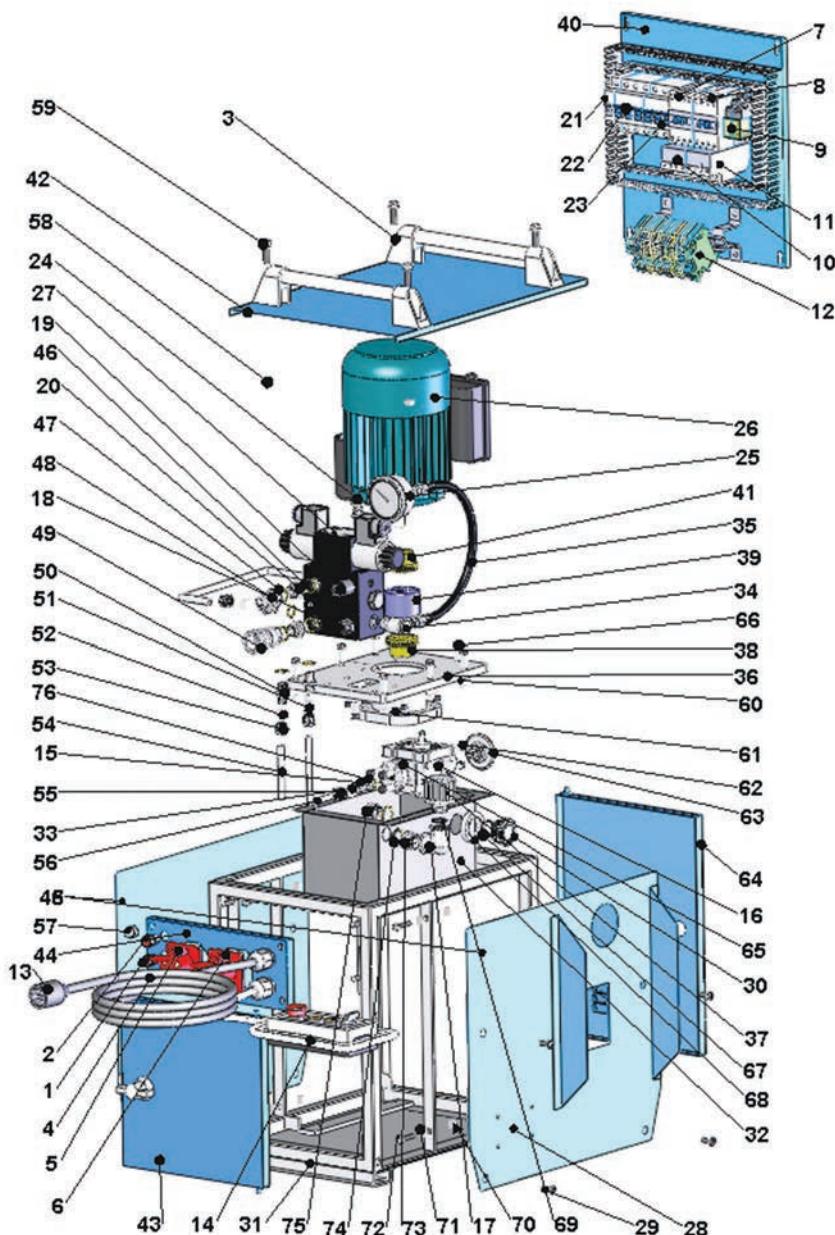
AL 800 BASIC MACHINE LIST

AL 800			BASIC MACHINE LIST
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL80001	CHROME COATED SHAFT 50x1242	2 ITEMS
2	AL80002	M20 WASHER	8 ITEMS
3	AL80003	CONNECTING JOINT NUT M20	8 ITEMS
4	AL80004	CONNECTING JOINT SHAFT	8 ITEMS
5	AL80005	PISTON CONNECTING HANDLE M10X465 mm(m)	2 ITEMS
6	AL80006	POLISHED PIPE (50x60x300 mm)	2 ITEMS
7	AL80007	PIPE CONNECTING CLIP	4 ITEMS
8	AL80008	CONNECTING ADAPTOR	2 ITEMS
9	AL80009	FLAT BAR JOINT M20X30 mm	4 ITEMS
10	AL80010	BASIC MACHINE	1 ITEM
11	AL80011	3/8" MALE QUICK COUPLING	1 ITEM
12	AL80012	3/8" FEMALE QUICK COUPLING	1 ITEM
13	AL80013	5/16" HYDRAULIC HOSE	1 ITEM
14	AL80014	HYDRAULIC OIL TUBE	2 ITEMS
15	AL80015	M10 TE PIECE	4 ITEMS
16	AL80016	BOLD CONNECTING JOINT	48 ITEMS
17	AL80017	OIL BUSH (65x50x8)	2 ITEMS
18	AL80018	BOLTS (500-560-630-710)	80 ITEMS
19	AL80019	O RING (58x63x3 mm)	4 ITEMS
20	AL80020	FORE NECK	4 ITEMS
21	AL80021	BEDDING BUSH (51X60X4,5 mm)	4 ITEMS
22	AL80022	DOUBLE HOLE LOWER CLAMP	1 ITEM
23	AL80023	SINGLE HOLE LOWER CLAMP	1 ITEM
24	AL80024	4 HOLE BLIND LOWER CLAMP	1 ITEM
25	AL80025	4 HOLE LOWER CLAMP	1 ITEM
26	AL80026	KEY 32	1 ITEM
27	AL80027	M10 RING	6 ITEMS
28	AL80028	M10 NUT	6 ITEMS
29	AL80029	M10 REVERSE SCREW ADAPTOR	4 ITEMS
30	AL80030	1/4" COPPER WASHER	4 ITEMS
31	AL80031	M8x40 IMBUS BOLT	8 ITEMS
32	AL80032	M8 NUT	8 ITEMS
33	AL80033	SHAFT CONNECTING WASHER M20	4 ITEMS
34	AL80034	M12X30 AKC BOLT	2 ITEMS
35	AL80035	3/8" 10 ADAPTOR	2 ITEMS
36	AL80036	CONNECTING ADAPTOR BOLT M14X35	6 ITEMS
37	AL80037	CONNECTING ADAPTOR WASHER M14	6 ITEMS
38	AL80038	PISTONS CONNECTINGS STUD WASHER M10	16 ITEMS
39	AL80039	WINCH EYEBOLT	1 ITEMS

AL 800

AL 800 HİDROLİK ÜNİTE / AL 800 HYDRAULIC UNIT

Kullanma Kılavuzu
Technical Information



AL 800 HİDROLİK ÜNİTE LİSTESİ			
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL800 33	TIRAŞLAYICI ARIZA LAMBASI	1 ADET
2	AL800 34	HİDROLİK ARIZA LAMBASI	1 ADET
3	AL800 35	TAŞIMA KOLU	2 ADET
4	AL800 36	HİDROLİK SİSTEM DEVREDE LAMBASI	1 ADET
5	AL800 37	TIRAŞLAYICI PRİZİ	1 ADET
6	AL800 38	ISİTİCİ PRİZİ	1 ADET
7	AL800 39	HİDROLİK ÜNİTE KONTAKTÖRÜ ALMK 1210	1 ADET
8	AL800 40	TIRAŞLAYICI KONTAKTÖRÜ MTC 1810	1 ADET
9	AL800 41	HİDROLİK ÜNİTE ROLESİ FİNDER 40.52	2 ADET
10	AL800 42	HİDROLİK ÜNİTE TERMİĞİ ALM-T2.1	1 ADET
11	AL800 43	TIRAŞLAYICI TERMİĞİ ALM-T3.5	1 ADET
12	AL800 44	RAY KLAMENSİ	1 ADET
13	AL800 45	BESLEME FİŞİ	1 ADET
14	AL800 46	KUMANDA BUTONU	1 ADET
15	AL800 47	HİDROLİK OTOMATİK REKOR(DIŞI)	1 ADET
16	AL800 48	HİDROLİK POMPA (C036X)	1 ADET
17	AL800 49	YAĞ İLAVE BORUSU	1 ADET
18	AL800 50	BASINÇ SİFIRLAMA KOLU	1 ADET
19	AL800 51	BASINÇ REGÜLATÖRÜ	1 ADET
20	AL800 52	HİDROLİK OTOMATİK REKOR (ERKEK)	1 ADET
21	AL800 53	HİDROLİK KUMANDA SIGORTASI ALMC16	1 ADET
22	AL800 54	ISİTİCİ SIGORTASI ALMC25	1 ADET
23	AL800 55	HİDROLİK ÜNİTE SIGORTASI ALMC10	1 ADET
24	AL800 56	AKÜ	1 ADET
25	AL800 57	MANOMETRE	1 ADET
26	AL800 58	MOTOR (0,55kw) 1400 d/dk	1 ADET
27	AL800 59	HİDROLİK VALF	1 ADET
28	AL800 60	FİRMA ETİKETİ	1 ADET
29	AL800 61	SABİTLEME CİVATASI M6X15	18 ADET
30	AL800 62	YAĞ GÖSTERGESİ	1 ADET
31	AL800 63	HİDROLİK ÜNİTE AYAKLARI	2 ADET
32	AL800 64	HİDROLİK YAĞ TANKI	1 ADET
33	AL800 65	AKÜ BAĞLANTı REKORU (1/4 10)	1 ADET
34	AL800 66	MANOMETRE BAĞLANTı DIRSEĞİ (1/4 10)	1 ADET
35	AL800 67	BAĞLANTı HORTUMU	1 ADET
36	AL800 68	KAPLİN	2 ADET
37	AL800 69	DEPO KAPAĞI	1 ADET
38	AL800 70	BASINÇ KİLİTİ	1 ADET
39	AL800 71	BASINÇ AYAR REKORU	1 ADET
40	AL800150	ELEKTRİK PANOSU	1 ADET
41	AL800 151	DK 24 KAPLİN	1 ADET
42	AL800 152	ŞASE ÜST KAPAĞI	1 ADET
43	AL800 153	ŞASE ÖN ALT KAPAĞI	1 ADET
44	AL800 154	ŞASE ÖN ÜST KAPAĞI	1 ADET
45	AL800 155	SOL-SAĞ KAPAKLAR	1 ADET
46	AL800 156	3/8" BAKIR PUL	4 ADET
47	AL800 157	3/8"-3/8" LÜPER	2 ADET
48	AL800 158	3/8" DİSİ KÜİK KAPLİN	1 ADET
49	AL800 159	Ø 10 ALÜMİNYUM BORU	1 ADET

AL 800

AL 800 HİDROLİK ÜNİTE LİSTESİ

Kullanma Kılavuzu
Technical Information

AL 800		HİDROLİK ÜNİTE LİSTESİ	
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
50	AL800 160	1/4" 10 REKOR	3 ADET
51	AL800 161	M6X10 İMBUS CİVATA	4 ADET
52	AL800 162	10 LUK YÜZÜK	3 ADET
53	AL800 163	M10 SOMUN	3 ADET
54	AL800 164	Ø 10 ALÜMİNYUM BORU	1 ADET
55	AL800 165	M8 SOMUN	2 ADET
56	AL800 166	Ø 8 ALÜMİNYUM BORU	1 ADET
57	AL800 167	M10 ŞAPKALI SOMUN	4 ADET
58	AL800 168	M8 SOMUN	4 ADET
59	AL800 169	M8X25 İMBUS CİVATA	4 ADET
60	AL800 170	M6 SOMUN	8 ADET
61	AL800 171	M6X25 İMBUS CİVATA	4 ADET
62	AL800 172	M6X16 İMBUS CİVATA	6 ADET
63	AL800 173	YAĞ FILTRESİ	1 ADET
64	AL800 174	ŞASE ARKA KAPAK	1 ADET
65	AL800 175	POMPA ADAPTÖRÜ	2 ADET
66	AL800 176	M6X20 AKC CİVATA	8 ADET
67	AL800 177	1" O RİNG	1 ADET
68	AL800 178	1" SOMUN	1 ADET
69	AL800 179	Ø 20 O RİNG	1 ADET
70	AL800 180	M6 SOMUN	4 ADET
71	AL800 181	M6 PUL	4 ADET
72	AL800 182	M6X30 AKC CİVATA	4 ADET
73	AL800 183	1/2" 15 mm UZATMA	1 ADET
74	AL800 184	1/2" BAKIR PUL	2 ADET
75	AL800 185	1/2" 10 mm UZATMA	1 ADET
76	AL800 186	1/4" BAKIR PUL	5 ADET

AL 800

Kullanma Kılavuzu
Technical Information

AL 800 HYDRAULIC UNIT LIST

AL 800		HYDRAULIC UNIT LIST	
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL800 33	TRIMMER FAILURE LAMP	1 ITEM
2	AL800 34	HYDRAULIC FAILURE LAMP	1 ITEM
3	AL800 35	HANDLE	2 ITEMS
4	AL800 36	HYDRAULIC SYSTEM LAMP(ON)	1 ITEM
5	AL800 37	TRIMMER SOCKET	1 ITEM
6	AL800 38	HEATER SOCKET	1 ITEM
7	AL800 39	HYDRAULIC UNIT CONTACTOR ALMK 1210	1 ITEM
8	AL800 40	TRIMMER CONTACTOR MTC 1810	1 ITEM
9	AL800 41	HYDRAULIC UNIT ROLE FINDER 40.52	2 ITEMS
10	AL800 42	HYDRAULIC UNIT THERMIC ALM-2.1	1 ITEM
11	AL800 43	TRIMMER THERMIC ALM-T3.5	1 ITEM
12	AL800 44	CONNECTOR	1 ITEM
13	AL800 45	SUPPLY PLUG	1 ITEM
14	AL800 46	CONTROL BUTTON	1 ITEM
15	AL800 47	QUICK COUPLING (FEMALE)	1 ITEM
16	AL800 48	HYDRAULIC PUMP(C036X)	1 ITEM
17	AL800 49	OIL ADDITION TUBE	1 ITEM
18	AL800 50	PRESSURE INITIALIZING HANDLE	1 ITEM
19	AL800 51	PRESSURE REGULATOR	1 ITEM
20	AL800 52	QUICK COUPLING (MALE)	1 ITEM
21	AL800 53	HYDRAULIC CONTROL FUSE ALMC 16	1 ITEM
22	AL800 54	HEATER FUSE ALMC 25	1 ITEM
23	AL800 55	HYDRAULIC UNIT FUSE ALMC 10	1 ITEM
24	AL800 56	ACCUMULATOR	1 ITEM
25	AL800 57	MONOMETER	1 ITEM
26	AL800 58	MOTOR (1,5kw) 1400 d/dk	1 ITEM
27	AL800 59	HYDRAULIC VALVE	1 ITEM
28	AL800 60	COMPANY LABEL	1 ITEM
29	AL800 61	FASTEN JOINT M6X15	18 ITEMS
30	AL800 62	OIL INDICATOR	1 ITEM
31	AL800 63	HYDRAULIC UNIT SUPPORT	2 ITEMS
32	AL800 64	HYDRAULIC OIL TANK	1 ITEM
33	AL800 65	ACCUMULATOR OUT-PUT (1/4 10)	1 ITEM
34	AL800 66	MONOMETER CONNECTOR BEND	1 ITEM
35	AL800 67	CONNECTION HOSE	1 ITEM
36	AL800 68	COUPLING	2 ITEMS
37	AL800 69	DEPOT COVER	1 ITEM
38	AL800 70	PRESSURE EMERGENCY	1 ITEM
39	AL800 71	PRESSURE REGULATOR	1 ITEM
40	AL800150	ELEKTRICAL PANEL	1 ITEM
41	AL800 151	DK 24 COUPLING	1 ITEM
42	AL800 152	CHASSIS TOP COVER	1 ITEM
43	AL800 153	CHASSIS FRONT COVER	1 ITEM
44	AL800 154	CHASSIS FRONT UPPER COVER	1 ITEM
45	AL800 155	LEFT - RIGHT COVERS	1 ITEM
46	AL800 156	3/8" COPPER WASHER	4 ITEMS
47	AL800 157	3/8"-3/8" LOOPER	2 ITEMS
48	AL800 158	3/8" FEMALE QUICK COUPLING	1 ITEM
49	AL800 159	Ø 10 ALUMINUM TUBE	1 ITEM

AL 800

AL 800 HYDRAULIC UNIT LIST

Kullanma Kılavuzu
Technical Information

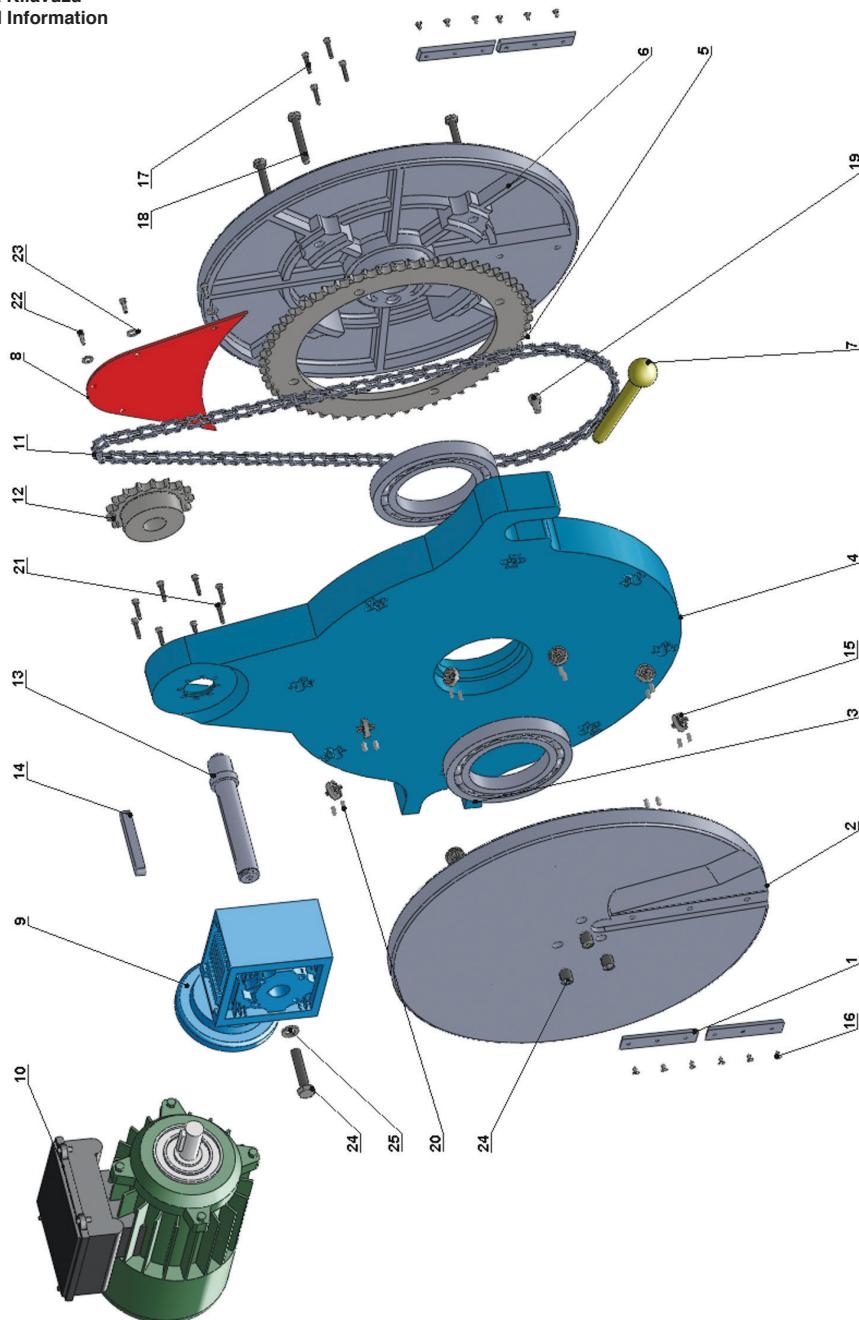
AL 800 HYDRAULIC UNIT LIST

NO	CODE NUMBER	ITEM ID	QUANTITY
50	AL800 160	1/4" 10 REGULATOR	3 ITEMS
51	AL800 161	M6X10 IMBUS BOLT	4 ITEMS
52	AL800 162	M10 RING	3 ITEMS
53	AL800 163	M10 NUT	3 ITEMS
54	AL800 164	Ø 10 ALUMINUM TUBE	1 ITEM
55	AL800 165	M8 NUT	2 ITEMS
56	AL800 166	Ø 8 ALUMINUM TUBE	1 ITEM
57	AL800 167	M10 CAP NUT	4 ITEMS
58	AL800 168	M8 NUT	4 ITEMS
59	AL800 169	M8X25 IMBUS BOLT	4 ITEMS
60	AL800 170	M6 NUT	8 ITEMS
61	AL800 171	M6X25 IMBUS BOLT	4 ITEMS
62	AL800 172	M6X16 IMBUS BOLT	6 ITEMS
63	AL800 173	OIL FILTER	1 ITEM
64	AL800 174	CHASSIS BACK COVER	1 ITEM
65	AL800 175	PUMP ADAPTER	2 ITEMS
66	AL800 176	M6X20 AKC BOLT	8 ITEMS
67	AL800 177	1" O RING	1 ITEM
68	AL800 178	1" NUT	1 ITEM
69	AL800 179	Ø 20 O RİNG	1 ITEM
70	AL800 180	M6 NUT	4 ITEMS
71	AL800 181	M6 WASHER	4 ITEMS
72	AL800 182	M6X30 AKC BOLT	4 ITEMS
73	AL800 183	1/2" 15 MM EXTENSION	1 ITEM
74	AL800 184	1/2" COPPER WASHER	2 ITEMS
75	AL800 185	1/2" 10 MM EXTENSION	1 ITEM
76	AL800 186	1/4" COPPER WASHER	5 ITEMS

AL 1000-1200

AL 1000-1200 TIRAŞLAYICI / AL 1000-1200 TRIMMER

Kullanma Kılavuzu
Technical Information



AL 1000-1200

AL 1000-1200 TIRAŞLAYICI LİSTESİ / AL 1000-1200 TRIMMER LIST

Kullanma Kılavuzu
Technical Information

AL 1000-1200

TIRAŞLAYICI LİSTESİ

PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL1000120070	BIÇAK	12 ADET
2	AL1000120071	TIRAŞLAYICI DÜZ DISK	1 ADET
3	AL1000120072	RULMAN (16014)	2 ADET
4	AL1000120073	TIRAŞLAYICI GÖVDE	1 ADET
5	AL1000120074	ZİNCİR DİŞLİ	1 ADET
6	AL1000120075	TIRAŞLAYICI DİŞLİ DISK	1 ADET
7	AL1000120076	EMНИYET PİMİ	1 ADET
8	AL1000120077	TIRAŞLAYICI KAPAK	1 ADET
9	AL1000120078	REDÜKTÖR	1 ADET
10	AL1000120079	MOTOR (4 Kw) MONOFAZE 1400 d/dk	1 ADET
11	AL1000120080	ZİNCİR	1 ADET
12	AL1000120081	ZİNCİR ÜST DİŞLİ	1 ADET
13	AL1000120082	ZİNCİR ÜST DİŞLİ MİLİ	1 ADET
14	AL1000120083	ZİNCİR MİLİ KAMASI	1 ADET
15	AL1000120084	RULMAN (62303)	8 ADET
16	AL1000120085	M6x15 VİDA	18 ADET
17	AL1000120086	M10x55 İMBUS CİVATA	4 ADET
18	AL1000120087	M12x140 İMBUS CİVATA	6 ADET
19	AL1000120088	M6x20 İMBUS CİVATA	1 ADET
20	AL1000120089	M6x25 İMBUS CİVATA	16 ADET
21	AL1000120090	M10x40 İMBUS CİVATA	8 ADET
22	AL1000120091	M6x20 İMBUS CİVATA	5 ADET
23	AL1000120092	M6 PUL	5 ADET
24	AL1000120093	M12 X25 AKC CİVATA	1 ADET
25	AL1000120094	M 12 PUL	1 ADET

AL 1000-1200

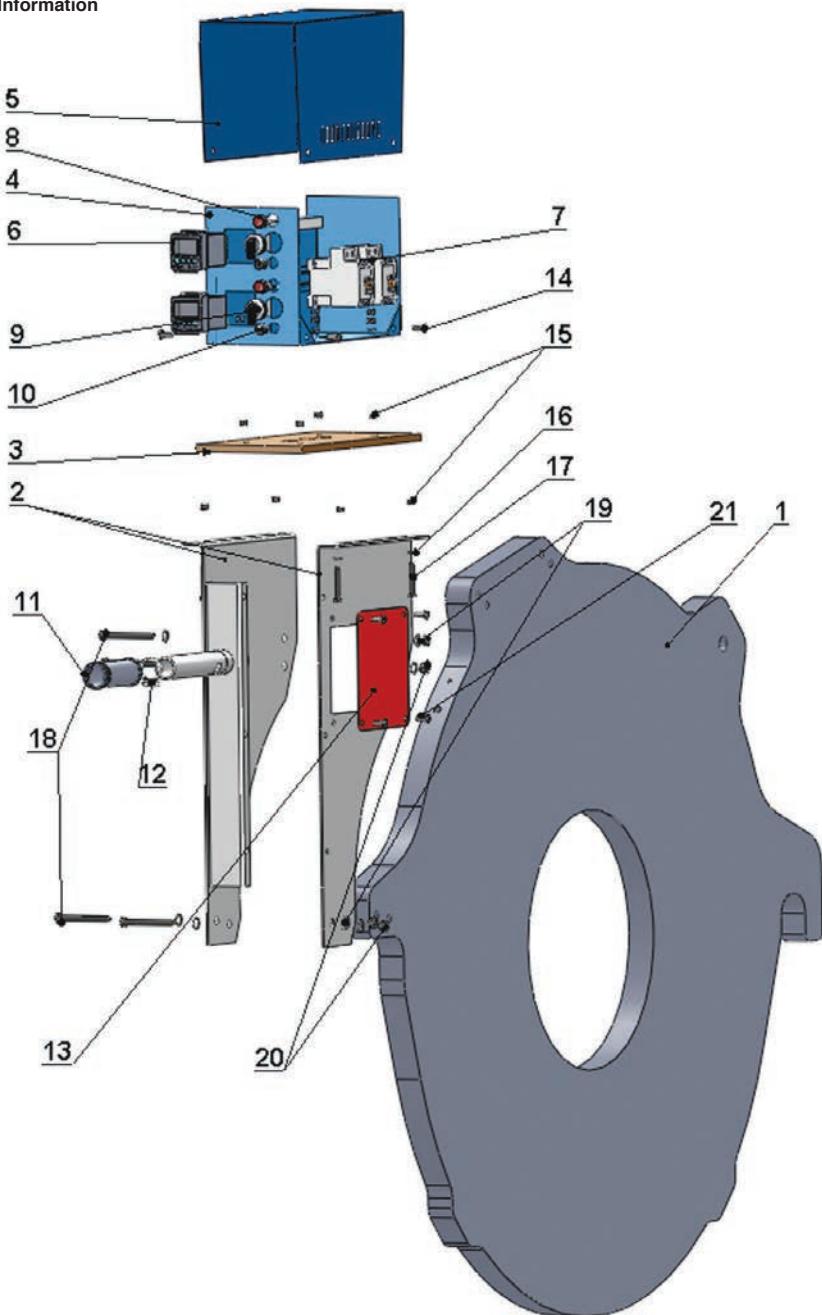
TRIMMER LIST

NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL1000120070	BLADE	12 ITEMS
2	AL1000120071	TRIMMER PLAIN DISC	1 ITEM
3	AL1000120072	BEARING	2 ITEMS
4	AL1000120073	TRIMMER BODY	1 ITEM
5	AL1000120074	CHAIN BEARING	1 ITEM
6	AL1000120075	TRIMMER SCREW DISC	1 ITEM
7	AL1000120076	SAFETY PIN	1 ITEM
8	AL1000120077	TRIMMER COVER	1 ITEM
9	AL1000120078	REDUCTOR	1 ITEM
10	AL1000120079	MOTOR (4 KW)	1 ITEM
11	AL1000120080	CHAIN	1 ITEM
12	AL1000120081	CHAIN UPPER GEAR	1 ITEM
13	AL1000120082	CHAIN UPPER GEAR SHAFT	1 ITEM
14	AL1000120083	CHAIN SHAFT PIN	1 ITEM
15	AL1000120084	BEARING	8 ITEMS
16	AL1000120085	M6x15 SCREW	18 ITEMS
17	AL1000120086	M10x55 IMBUS BOLT	4 ITEMS
18	AL1000120087	M12x140 IMBUS BOLT	6 ITEMS
19	AL1000120088	M6x20 IMBUS BOLT	1 ITEM
20	AL1000120089	M6x25 IMBUS BOLT	16 ITEMS
21	AL1000120090	M6x40 IMBUS BOLT	8 ITEMS
22	AL1000120091	M6x20 IMBUS BOLT	5 ITEMS
23	AL1000120092	M6 WASHER	5 ITEMS
24	AL1000120093	M12X25 IMBUS BOLT	1 ITEM
25	AL1000120094	M 12 WASHER	1 ITEM

AL 1000-1200-1600

AL 1000-1200-1600 ISITICI / AL 1000-1200-1600 HEATER

Kullanma Kılavuzu
Technical Information



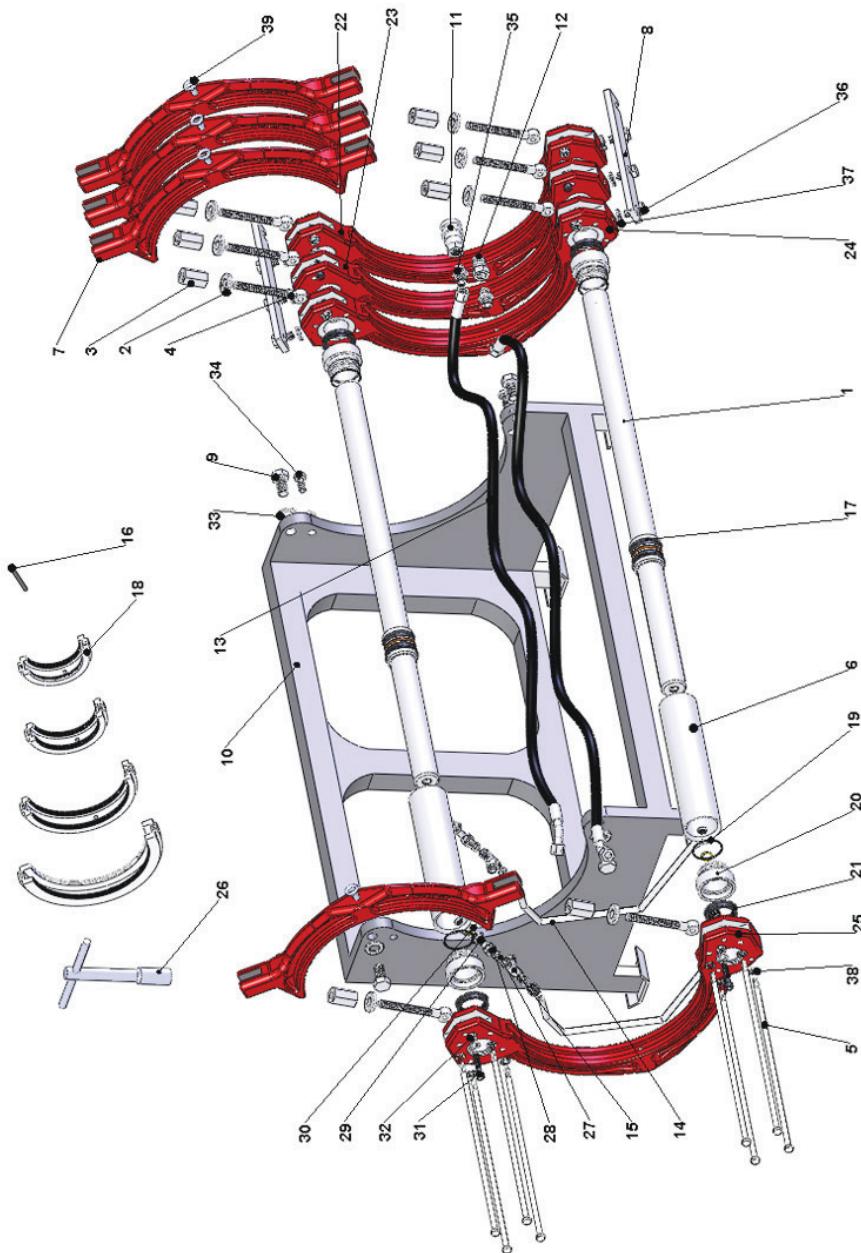
AL 1000-1200-1600

AL 1000-1200-1600 ISITICI LİSTESİ / AL 1000-1200-1600 HEATER LIST

Kullanma Kılavuzu
Technical Information

AL 1000-1200-1600 ISITICI LİSTESİ			
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL10001200160001	ISITICI	1 ADET
2	AL10001200160002	ISITICI KABİN	1 ADET
3	AL10001200160003	ISI YALITIM FİBERİ	1 ADET
4	AL10001200160004	ELEKTRİK KUTUSU	1 ADET
5	AL10001200160005	ELEKTRİK KUTUSU ÜST KAPAĞI	1 ADET
6	AL10001200160006	KONTROL PANELİ	2 ADET
7	AL10001200160007	KONTAKTÖR	2 ADET
8	AL10001200160008	GÖSTERGE LAMBAŞI	2 ADET
9	AL10001200160009	ACMA / KAPAMA	2 ADET
10	AL100012001600010	SİGORTA	2 ADET
11	AL100012001600011	TAŞIMA KOLU İZOLESİ	1 ADET
12	AL100012001600012	KELEPCE	2 ADET
13	AL100012001600013	KORUYUCU KAPAK	1 ADET
14	AL100012001600014	ELEKTRİK KABLOSU	1 ADET
15	AL100012001600015	M6 SOMUN	8 ADET
16	AL100012001600016	M6 PUL	4 ADET
17	AL100012001600017	M6 X 45 AKC CİVATA	3 ADET
		M6 X 50 AKC CİVATA	1 ADET
18	AL100012001600018	M8 X 90 AKC CİVATA	4 ADET
19	AL100012001600019	M8 PUL	8 ADET
20	AL100012001600020	M8 SOMUN	4 ADET
21	AL100012001600021	M6 X 15 YHB VİDA	8 ADET
22	AL1000	REZİSTANS 7500*2 WATT 380 VOLT	1 ADET
23	AL1200	REZİSTANS 8000*2 WATT 380 VOLT	1 ADET
24	AL1600	REZİSTANS12000*2 WATT 380 VOLT	1 ADET

AL 1000-1200-1600 HEATER LIST			
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL10001200160001	HEATER	1 ITEM
2	AL10001200160002	HEATER BOX	1 ITEM
3	AL10001200160003	HEAT ISOLATION FIBER	1 ITEM
4	AL10001200160004	ELECTRIC BOX	1 ITEM
5	AL10001200160005	ELECTRIC BOX UPPER COVER	1 ITEM
6	AL10001200160006	CONTROL PANNEL	2 ITEM
7	AL10001200160007	CONTACTOR	2 ITEM
8	AL10001200160008	INDICATOR LAMP	2 ITEM
9	AL10001200160009	ON/OFF	2 ITEM
10	AL100012001600010	FUSE	2 ITEM
11	AL100012001600011	CARRYING HANDLE ISOLATION	1 ITEM
12	AL100012001600012	CLIPS	2 ITEM
13	AL100012001600013	PROTECTIVE COVER	1 ITEM
14	AL100012001600014	ELECTRIC CABLE	1 ITEM
15	AL100012001600015	M6 NUT	8 ITEM
16	AL100012001600016	M6 WASHER	4 ITEM
17	AL100012001600017	M6x45 AKC BOLT	3 ITEM
		M6x50 AKC BOLT	1 ITEM
18	AL100012001600018	M8x90 AKC BOLT	4 ITEM
19	AL100012001600019	M8 WASHER	8 ITEM
20	AL100012001600020	M8NUT	4 ITEM
21	AL100012001600021	M6X15 SCREW	8 ITEM
22	AL1000	REZİSTANS 7500*2 WATT 380 VOLT	1 ITEM
23	AL1200	REZİSTANS 8000*2 WATT 380 VOLT	1 ITEM
24	AL1600	REZİSTANS12000*2 WATT 380 VOLT	1 ITEM



AL 1000 GÖVDE LİSTESİ			
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL100001	SERT KROMLU MİL 70X1768mm	2 ADET
2	AL100002	M30 PUL	8 ADET
3	AL100003	BAĞLANTI CİVATASI SOMUNU M30X60 mmn	8 ADET
4	AL100004	BAĞLANTI CİVATASI SAĞLAMASI M30X200 mm	8 ADET
5	AL100005	PIŞTON BAĞLANTI SAPLAMASI M12X680 mm	8 ADET
6	AL100006	HONLANMIŞ BORU 90X110X478 mm	2 ADET
7	AL100007	BORU BAĞLANTI KELEPÇESİ	4 ADET
8	AL100008	ARA BAĞLAMA ADAPTÖRÜ	2 ADET
9	AL100009	MİL BAĞLANTI CİVATASI M30X60 mm	4 ADET
10	AL100010	ANA GÖVDE	1 ADET
11	AL100011	HİDROLİK OTOMATİK REKOR (ERKEK)	1 ADET
12	AL100012	HİDROLİK OTOMATİK REKOR (DİŞİ)	1 ADET
13	AL100013	HİDROLİK HORTUM	1 ADET
14	AL100014	HİDROLİK YAĞ BORUSU	2 ADET
15	AL100015	T PARÇASI	4 ADET
16	AL100016	PAFTA BAĞLANTI CİVATASI	48 ADET
17	AL100017	YAĞ KEÇESİ 70X90X12 mm	2 ADET
18	AL100018	PAFTALAR (710-800-900)	24 ADET
19	AL100019	O RİNG 79X50X3 mm	4 ADET
20	AL100020	SİFERO BOĞAZ	4 ADET
21	AL100021	TOZ KEÇESİ 70X80X5 mm	4 ADET
22	AL100022	ÇİFT DELİK ALT ÇENE	1 ADET
23	AL100023	TEKLIK ALT ÇENE	1 ADET
24	AL100024	KÖR 4 DELİK ALT ÇENE	1 ADET
25	AL100025	PATLAK 4 DELİK ALT ÇENE	1 ADET
26	AL100026	46 LOKMA	1 ADET
27	AL100027	10 LUK YÜZÜK	6 ADET
28	AL100028	M10 SOMUN	6 ADET
29	AL100029	1/4" BAKIR PUL	4 ADET
30	AL100030	M12 X 30 İMBUS CİVATA	8 ADET
31	AL100031	M12 SOMUN	8 ADET
32	AL100032	MİL BAĞLANTI PULU M30	4 ADET
33	AL100033	M12 X 30 AKC CİVATA	2 ADET
34	AL100034	3/8" 10 REKOR	2 ADET
35	AL100035	ARA ADAPTÖR BAĞLANTI CİVATASI M20X60 AKC	6 ADET
36	AL100036	ARA ADAPTÖR BAĞLANTI PULU M20	6 ADET
37	AL100037	PISTON BAĞLANTI SAPLAMASI PULU M12	16 ADET
38	AL100038	VİNÇ MAPASI	4 ADET

AL 1000

AL 1000 BASIC MACHINE LIST

Kullanma Kılavuzu
Technical Information

AL 1000		BASIC MACHINE LIST	
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL100001	CHROME COATED SHAFT 70x1768 mm	2 ITEMS
2	AL100002	M30 WASHER	8 ITEM S
3	AL100003	CONNECTING JOINT NUT M30X60 mm	8 ITEMS
4	AL100004	CONNECTING JOINT SHAFT M30X200 mm	8 ITEMS
5	AL100005	PISTON CONNECTING HANDLE M12X680 mm	8 ITEMS
6	AL100006	POLISHED PIPE (90X110X478 mm)	2 ITEMS
7	AL100007	PIPE CONNECTING CLIP	4 ITEM S
8	AL100008	CONNECTING ADAPTOR	2 ITEMS
9	AL100009	FLAT BAR JOINT M30X60 mm	4 ITEMS
10	AL100010	BASIC MACHINE	1 ITEM
11	AL100011	MALE QUICK COUPLING	1 ITEM
12	AL100012	FEMALE QUICK COUPLING	1 ITEM
13	AL100013	HYDRAULIC HOSE	1 ITEM
14	AL100014	HYDRAULIC OIL TUBE	2 ITEMS
15	AL100015	TE PIECE	4 ITEMS
16	AL100016	BOLD CONNECTING JOINT	48 ITEMS
17	AL100017	OIL BUSH (70X90X12 mm)	2 ITEMS
18	AL100018	BOLTS (800-900-1000)	24 ITEMS
19	AL100019	O RING (79X50X3 mm)	4 ITEMS
20	AL100020	FORE NECK	4 ITEMS
21	AL100021	BEDDING BUSH (70X80X5 mm)	4 ITEMS
22	AL100022	DOUBLE HOLE LOWER CLAMP	1 ITEM
23	AL100023	SINGLE HOLE LOWER CLAMP	1 ITEM
24	AL100024	4 HOLE BLIND LOWER CLAMP	1 ITEM
25	AL100025	4 HOLE LOWER CLAMP	1 ITEM
26	AL100026	KEY 46	1 ITEM
27	AL100027	M10 RING	6 ITEMS
28	AL100028	M10 NUT	6 ITEMS
29	AL100029	1/4" COPPER WASHER	4 ITEMS
30	AL100030	M12X30 IMBUS BOLT	8 ITEMS
31	AL100031	M12 NUT	8 ITEMS
32	AL100032	SHAFT CONNECTING WASHER M30	4 ITEMS
33	AL100033	M12X30 AKC BOLT	2 ITEMS
34	AL100034	3/8" 10 ADAPTOR	2 ITEMS
35	AL100035	CONNECTING ADAPTOR BOLT M20X60 mm	6 ITEMS
36	AL100036	CONNECTING ADAPTOR WASHER M20	6 ITEMS
37	AL100037	PISTONS CONNECTING STUD WASHER M12	16 ITEMS
38	AL100038	WINCH EYEBOLT	4 ITEMS

AL 1200 GÖVDE LİSTESİ			
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL120001	SERT KROMLU MİL 70X1768mm	2 ADET
2	AL120002	M30 PUL	8 ADET
3	AL120003	BAĞLANTI CİVATASI SOMUNU M30X60 mmn	8 ADET
4	AL120004	BAĞLANTI CİVATASI SAĞLAMASI M30X200 mm	8 ADET
5	AL120005	PIŞTON BAĞLANTI SAPLAMASI M12X680 mm	8 ADET
6	AL120006	HONLANMIŞ BORU 90X110X478 mm	2 ADET
7	AL120007	BORU BAĞLANTI KELEPÇESİ	4 ADET
8	AL120008	ARA BAĞLAMA ADAPTÖRÜ	2 ADET
9	AL120009	MİL BAĞLANTI CİVATASI M30X60 mm	4 ADET
10	AL120010	ANA GÖVDE	1 ADET
11	AL120011	HİDROLİK OTOMATİK REKOR (ERKEK)	1 ADET
12	AL120012	HİDROLİK OTOMATİK REKOR (DİŞİ)	1 ADET
13	AL120013	HİDROLİK HORTUM	1 ADET
14	AL120014	HİDROLİK YAĞ BORUSU	2 ADET
15	AL120015	T PARÇASI	4 ADET
16	AL120016	PAFTA BAĞLANTI CİVATASI	48 ADET
17	AL120017	YAĞ KEÇESİ 70X90X12 mm	2 ADET
18	AL120018	PAFTALAR (800-900-1000)	24 ADET
19	AL120019	O RİNG 79X50X3 mm	4 ADET
20	AL120020	SİFERO BOĞAZ	4 ADET
21	AL120021	TOZ KEÇESİ 70X80X5 mm	4 ADET
22	AL120022	ÇİFT DELİK ALT ÇENE	1 ADET
23	AL120023	TEKLIK ALT ÇENE	1 ADET
24	AL120024	KÖR 4 DELİK ALT ÇENE	1 ADET
25	AL120025	PATLAK 4 DELİK ALT ÇENE	1 ADET
26	AL120026	46 LOKMA	1 ADET
27	AL120027	10 LUK YÜZÜK	6 ADET
28	AL120028	M10 SOMUN	6 ADET
29	AL120029	1/4" BAKIR PUL	4 ADET
30	AL120030	M12 X 30 İMBUS CİVATA	8 ADET
31	AL120031	M12 SOMUN	8 ADET
32	AL120032	MİL BAĞLANTI PULU M30	4 ADET
33	AL120033	M12 X 30 AKC CİVATA	2 ADET
34	AL120034	3/8" 10 REKOR	2 ADET
35	AL120035	ARA ADAPTÖR BAĞLANTI CİVATASI M20 X60 AKC	6 ADET
36	AL120036	ARA ADAPTÖR BAĞLANTI PULU M20	6 ADET
37	AL120037	PISTON BAĞLANTI SAPLAMASI PULU M12	16 ADET
38	AL120038	VİNÇ MAPASI	4 ADET

AL 1200

AL 1200 BASIC MACHINE LIST

Kullanma Kılavuzu
Technical Information

AL 1200		BASIC MACHINE LIST	
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL120001	CHROME COATED SHAFT 70x1768 mm	2 ITEMS
2	AL120002	M30 WASHER	8 ITEMS
3	AL120003	CONNECTING JOINT NUT M30X60 mm	8 ITEMS
4	AL120004	CONNECTING JOINT SHAFT M30X200 mm	8 ITEMS
5	AL120005	PISTON CONNECTING HANDLE M12X680 mm	8 ITEMS
6	AL120006	POLISHED PIPE (90X110X478 mm)	2 ITEMS
7	AL120007	PIPE CONNECTING CLIP	4 ITEMS
8	AL120008	CONNECTING ADAPTOR	2 ITEMS
9	AL120009	FLAT BAR JOINT M30X60 mm	4 ITEMS
10	AL120010	BASIC MACHINE	1 ITEM
11	AL120011	MALE QUICK COUPLING	1 ITEM
12	AL120012	FEMALE QUICK COUPLING	1 ITEM
13	AL120013	HYDRAULIC HOSE	1 ITEM
14	AL120014	HYDRAULIC OIL TUBE	2 ITEMS
15	AL120015	TE PIECE	4 ITEMS
16	AL120016	BOLD CONNECTING JOINT	48 ITEMS
17	AL120017	OIL BUSH (70X90X12 mm)	2 ITEMS
18	AL120018	BOLTS (800-900-1000)	24 ITEMS
19	AL120019	O RING (79X50X3 mm)	4 ITEMS
20	AL120020	FORE NECK	4 ITEMS
21	AL120021	BEDDING BUSH (70X80X5 mm)	4 ITEMS
22	AL120022	DOUBLE HOLE LOWER CLAMP	1 ITEM
23	AL120023	SINGLE HOLE LOWER CLAMP	1 ITEM
24	AL120024	4 HOLE BLIND LOWER CLAMP	1 ITEM
25	AL120025	4 HOLE LOWER CLAMP	1 ITEM
26	AL120026	KEY 46	1 ITEM
27	AL120027	M10 RING	6 ITEMS
28	AL120028	M10 NUT	6 ITEMS
29	AL120029	1/4" COPPER WASHER	4 ITEMS
30	AL120030	M12X30 IMBUS BOLT	8 ITEMS
31	AL120031	M12 NUT	8 ITEMS
32	AL120032	SHAFT CONNECTING WASHER M30	4 ITEMS
33	AL120033	M12X30 AKC BOLT	2 ITEMS
34	AL120034	3/8" 10 ADAPTOR	2 ITEMS
35	AL120035	CONNECTING ADAPTOR BOLT M20X60 mm	6 ITEMS
36	AL120036	CONNECTING ADAPTOR WASHER M20	6 ITEMS
37	AL120037	PISTONS CONNECTING STUD WASHER M12	16 ITEMS
38	AL120038	WINCH EYEBOLT	4 ITEMS

AL 1600

AL 1600 GÖVDE LİSTESİ

Kullanma Kılavuzu
Technical Information

AL 1600 GÖVDE LİSTESİ			
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL160001	SERT KROMLU MİL 70X2000mm	2 ADET
2	AL160002	M30 PUL	8 ADET
3	AL160003	BAĞLANTI CİVATASI SOMUNU M30X60 mmn	8 ADET
4	AL160004	BAĞLANTI CİVATASI SAPLAMASI M30X280 mm	8 ADET
5	AL160005	PIŞTON BAĞLANTI SAPLAMASI M12X680 mm	8 ADET
6	AL160006	HONLANMIŞ BORU 90X110X478 mm	2 ADET
7	AL160007	BORU BAĞLANTI KELEPÇESİ	4 ADET
8	AL160008	ARA BAĞLAMA ADAPTÖRÜ	2 ADET
9	AL160009	MİL BAĞLANTI CİVATASI M30X60 mm	4 ADET
10	AL160010	ANA GÖVDE	1 ADET
11	AL160011	HİDROLİK OTOMATİK REKOR (ERKEK)	1 ADET
12	AL160012	HİDROLİK OTOMATİK REKOR (DİŞİ)	1 ADET
13	AL160013	HİDROLİK HORTUM	1 ADET
14	AL160014	HİDROLİK YAĞ BORUSU	2 ADET
15	AL160015	T PARÇASI	4 ADET
16	AL160016	PAFTA BAĞLANTI CİVATASI	48 ADET
17	AL160017	YAĞ KEÇESİ 70X90X12 mm	2 ADET
18	AL160018	PAFTALAR (1200-1400)	16 ADET
19	AL160019	O RİNG 79X50X3 mm	4 ADET
20	AL160020	SİFERO BOĞAZ	4 ADET
21	AL160021	TOZ KEÇESİ 70X80X5 mm	4 ADET
22	AL160022	ÇİFT DELİK ALT ÇENE	1 ADET
23	AL160023	TEK LİK ALT ÇENE	1 ADET
24	AL160024	KÖR 4 DELİK ALT ÇENE	1 ADET
25	AL160025	PATLAK 4 DELİK ALT ÇENE	1 ADET
26	AL160026	46 LOKMA	1 ADET
27	AL160027	10 LUK YÜZÜK	6 ADET
28	AL160028	M10 SOMUN	6 ADET
29	AL160029	1/4" BAKIR PUL	4 ADET
30	AL160030	M12 X 30 İMBUS CİVATA	8 ADET
31	AL160031	M12 SOMUN	8 ADET
32	AL160032	MİL BAĞLANTI PULU M30	4 ADET
33	AL160033	M12 X 30 AKC CİVATA	2 ADET
34	AL160034	3/8" 10 REKOR	2 ADET
35	AL160035	ARA ADAPTÖR BAĞLANTI CİVATASI M20 X60 AKC	6 ADET
36	AL160036	ARA ADAPTÖR BAĞLANTI PULU M20	6 ADET
37	AL160037	PISTON BAĞLANTI SAPLAMASI PULU M12	16 ADET
38	AL160038	VİNÇ MAPASI	4 ADET
39	AL160039	SERT KROMLU MİL 60X2000 mm	1 ADET

AL 1600

AL 1600 BASIC MACHINE LIST

Kullanma Kılavuzu
Technical Information

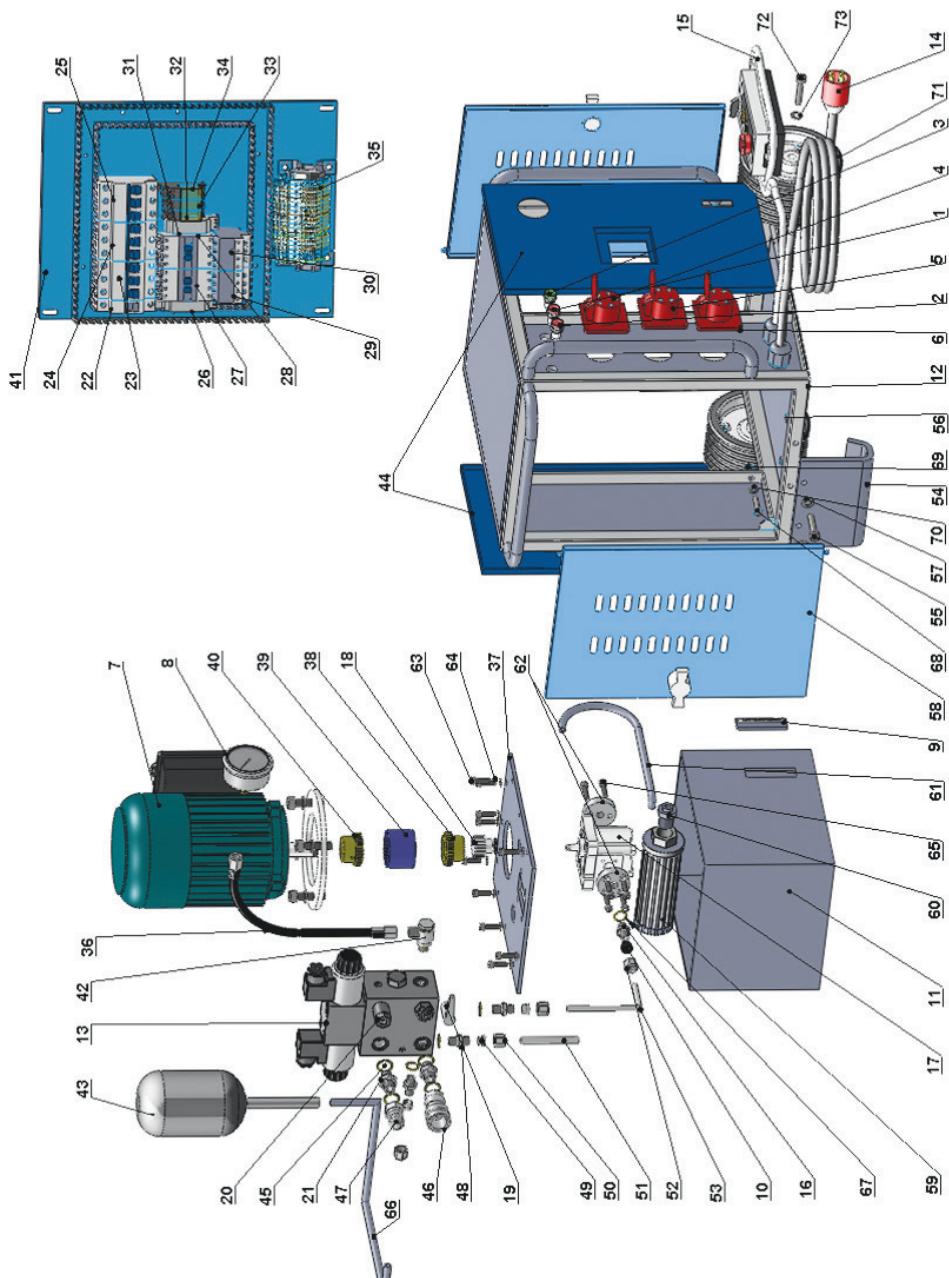
AL 1600		BASIC MACHINE LIST	
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL160001	CHROME COATED SHAFT 70x2000 mm	2 ITEMS
2	AL160002	M30 WASHER	8 ITEMS
3	AL160003	CONNECTING JOINT NUT M30X60 mm	8 ITEMS
4	AL160004	CONNECTING JOINT SHAFT M30X280 mm	8 ITEMS
5	AL160005	PISTON CONNECTING HANDLE M12X680 mm	8 ITEMS
6	AL160006	POLISHED PIPE (90X110X478 mm)	2 ITEMS
7	AL160007	PIPE CONNECTING CLIP	4 ITEMS
8	AL160008	CONNECTING ADAPTOR	2 ITEMS
9	AL160009	FLAT BAR JOINT M30X60 mm	4 ITEMS
10	AL160010	BASIC MACHINE	1 ITEM
11	AL160011	MALE QUICK COUPLING	1 ITEM
12	AL160012	FEMALE QUICK COUPLING	1 ITEM
13	AL160013	HYDRAULIC HOSE	1 ITEM
14	AL160014	HYDRAULIC OIL TUBE	2 ITEMS
15	AL160015	TE PIECE	4 ITEMS
16	AL160016	BOLD CONNECTING JOINT	48 ITEMS
17	AL160017	OIL BUSH (70X90X12 mm)	2 ITEMS
18	AL160018	BOLTS (12001400)	16 ITEMS
19	AL160019	O RING (79X50X3 mm)	4 ITEMS
20	AL160020	FORE NECK	4 ITEMS
21	AL160021	BEDDING BUSH (70X80X5 mm)	4 ITEMS
22	AL160022	DOUBLE HOLE LOWER CLAMP	1 ITEM
23	AL160023	SINGLE HOLE LOWER CLAMP	1 ITEM
24	AL160024	4 HOLE BLIND LOWER CLAMP	1 ITEM
25	AL160025	4 HOLE LOWER CLAMP	1 ITEM
26	AL160026	KEY 46	1 ITEM
27	AL160027	M10 RING	6 ITEMS
28	AL160028	M10 NUT	6 ITEMS
29	AL160029	1/4" COPPER WASHER	4 ITEMS
30	AL160030	M12X30 IMBUS BOLT	8 ITEMS
31	AL160031	M12 NUT	8 ITEMS
32	AL160032	SHAFT CONNECTING WASHER M30	4 ITEMS
33	AL160033	M12X30 AKC BOLT	2 ITEMS
34	AL160034	3/8" 10 REKOR	2 ITEMS
35	AL160035	CONNECTING ADAPTOR BOLT M20X60 mm	6 ITEMS
36	AL160036	CONNECTING ADAPTOR WASHER M20	6 ITEMS
37	AL160037	PISTONS CONNECTING STUD WASHER M12	16 ITEMS
38	AL160038	WINCH EYEBOLT	4 ITEMS
39	AL160039	CHROME COATED SHAFT 60X2000 mm	1 ITEM

AL 1000-1200-1600

AL 1000-1200-1600 HİDROLİK ÜNİTE

AL 1000-1200-1600 HYDRAULIC UNIT

Kullanma Kılavuzu
Technical Information



AL 1000-1200-1600

AL 1000-1200-1600 HİDROLİK ÜNİTE LİSTESİ

Kullanma Kılavuzu
Technical Information

AL 1000-1200-1600 HİDROLİK ÜNİTE LİSTESİ

PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL001	TIRAŞLAYICI ARIZA LAMBASI	1 ADET
2	AL002	HİDROLİK ARIZA LAMBASI	1 ADET
3	AL003	HİDROLİK SİSTEM DEVREDE LAMBASI	1 ADET
4	AL004	TIRAŞLAYICI PRİZİ	1 ADET
5	AL005	İSİTİCİ PRİZİ	1 ADET
6	AL006	YEDEK PRİZ	1 ADET
7	AL007	MOTOR (3 kw) 1400 d/dk	1 ADET
8	AL008	MANOMETRE	1 ADET
9	AL009	YAG GÖSTERGESİ	1 ADET
10	AL010	AKÜ BAĞLANTI REKORU (1/4 10)	1 ADET
11	AL011	HİDROLİK YAĞ TANKI	1 ADET
12	AL012	ŞASE	1 ADET
13	AL013	HİDROLİK VALF	1 ADET
14	AL014	BESLEME FİŞİ	1 ADET
15	AL015	KUMANDA BUTONU	1 ADET
16	AL016	HİDROLİK OTOMATİK REKOR(DIŞI)	1 ADET
17	AL017	HİDROLİK POMPA (C036X)	1 ADET
18	AL018	YAĞ İLAVE BORUSU	1 ADET
19	AL019	BASINÇ SİFRILLAŞMA KOLU	1 ADET
20	AL020	BASINÇ REGÜLATÖRÜ	1 ADET
21	AL021	HİDROLİK OTOMATİK REKOR (ERKEK)	1 ADET
22	AL022	HİDROLİK KUMANDA SİGORTASI ALMC16	1 ADET
23	AL023	HİDROLİK VE TRAŞLAYICI SIGORTASI	1 ADET
24	AL024	YEDEK SİGORTA	1 ADET
25	AL025	İSİTİCİ SIGORTASI	1 ADET
26	AL026	FAZ SIRA ROLESİ	1 ADET
27	AL027	HİDROLİK ÜNİTE KONTAKTÖRÜ	1 ADET
28	AL028	TRAŞLAYICI KONTAKTÖRÜ	1 ADET
29	AL029	HİDROLİK TERMİĞİ	1 ADET
30	AL030	TIRAŞLAYICI TERMİĞİ	1 ADET
31	AL031	ZAMAN ROLESİ	1 ADET
32	AL032	İLERİ ROLESİ	1 ADET
33	AL033	GERİ ROLESİ	1 ADET
34	AL034	MÜHÜRLEME ROLESİ	1 ADET
35	AL035	RAY KLAMENSI	1 ADET
36	AL036	BAĞLANTI HORTUMU	1 ADET
37	AL037	YAĞ DEPOSU ÜST KAPAĞI	1 ADET
38	AL038	BASINÇ KİLİDİ	1 ADET
39	AL039	BASINÇ AYAR REKORU	1 ADET
40	AL040	DK 24 KAPLİN	1 ADET
41	AL041	ELEKTRİK PANOSU	1 ADET
42	AL042	MONOMETRE BAĞLANTI DİRSEĞİ	1 ADET
43	AL043	AKÜ	1 ADET
44	AL044	SOL-SAĞ KAPAKLAR	1 ADET
45	AL045	3/8" BAKIR PÜL	4 ADET
46	AL046	3/8" DİSİ KUIK KAPLİN	1 ADET
47	AL047	3/8" ERKEK KUIK KAPLİN	1 ADET
48	AL048	1/4" 10 REKOR	3 ADET
49	AL049	10 LUK YÜZÜK	3 ADET

AL 1000-1200-1600

AL 1000-1200-1600 HİDROLİK ÜNİTE LİSTESİ

Kullanma Kılavuzu
Technical Information

AL 1000-1200-1600 HİDROLİK ÜNİTE LİSTESİ

PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
50	AL050	M10 SOMUN	3 ADET
51	AL051	Ø 10 ALÜMİNYUM BORU	1 ADET
52	AL052	M10 SOMUN	2 ADET
53	AL053	Ø 10 ALÜMİNYUM BORU	1 ADET
54	AL054	ÖN AYAK	1 ADET
55	AL055	ÖN AYAK BAĞLANTI CİVATASI M8X40 mm	2 ADET
56	AL056	ÖN AYAK BAĞLANTI SOMUNU M8	2 ADET
57	AL057	ÖN AYAK BAĞLANTI PUL M8	2 ADET
58	AL058	ÖN ARKA KAPAK	1 ADET
59	AL059	YAĞ FILTRESİ	1 ADET
60	AL060	REKOR	
61	AL061	Ø 10 ALÜMİNYUM BORU	1 ADET
62	AL062	POMPA ADAPTÖRÜ	2 ADET
63	AL063	ÜST KAPAK BAĞLANTI CİVATASI M6X20 İMBUS	
64	AL064	ÜST KAPAK BAĞLANTI PUL M6	
65	AL065	POMPA ADAPTÖRÜ BAĞLANTI CİVATASI	
66	AL066	Ø 10 ALÜMİNYUM BORU	1 ADET
67	AL067	3/8" BAKIR PUL	5 ADET
68	AL068	PANO BAĞLANTI CİVATASI M6X40 AKC	4 ADET
69	AL069	PANO BAĞLANTI SOMUNU M6	4 ADET
70	AL070	PANO BAĞLANTI PUL M6	4 ADET
71	AL071	TEKERLEK	2 ADET
72	AL072	TEKERLEK BAĞLANTI CİVATASI M10X15 mm	2 ADET
73	AL073	TEKERLEK BAĞLANTI PUL M10	2 ADET

AL 1000-1200-1600

AL 1000-1200-1600 HYDRAULIC UNIT LIST

Kullanma Kılavuzu
Technical Information

AL 1000-1200-1600 HYDRAULIC UNIT LIST			
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL001	TRIMMER FAILURE LAMP	1 ITEM
2	AL002	HYDRAULIC FAILURE LAMP	1 ITEM
3	AL003	HYDRAULIC SYSTEM LAMP(ON)	1 ITEM
4	AL004	TRIMMER SOCKET	1 ITEM
5	AL005	HEATER SOCKET	1 ITEM
6	AL006	AUXILIARY SECKET	1 ITEM
7	AL007	MOTOR (3 kw) 1400 d/dk	1 ITEM
8	AL008	MONOMETER	1 ITEM
9	AL009	OIL INDICATOR	1 ITEM
10	AL010	ACCUMULATOR OUT-PUT (1/4 10)	1 ITEM
11	AL011	HYDRAULIC OIL TANK	1 ITEM
12	AL012	CHASSIS	1 ITEM
13	AL013	HYDRAULIC VALVE	1 ITEM
14	AL014	SUPPLY PLUG	1 ITEM
15	AL015	CONTROL BUTTON	1 ITEM
16	AL016	QUICK COUPLING (FEMALE)	1 ITEM
17	AL017	HYDRAULIC PUMP(C036X)	1 ITEM
18	AL018	OIL ADDITION TUBE	1 ITEM
19	AL019	PRESSURE INITIALIZING HANDLE	1 ITEM
20	AL020	PRESSURE REGULATOR	1 ITEM
21	AL021	QUICK COUPLING (MALE)	1 ITEM
22	AL022	HYDRAULIC CONTROL FUSE ALMC 16	1 ITEM
23	AL023	HYDRAULIC AND TRIMMER FUSE	1 ITEM
24	AL024	AUXILIARY FUSE	1 ITEM
25	AL025	HEATER FUSE	1 ITEM
26	AL026	PHASE ROLE	1 ITEM
27	AL027	HYDRAULIC UNIT CONTACTOR	1 ITEM
28	AL028	TRIMMER CONTACTOR	1 ITEM
29	AL029	HYDRAULIC UNIT THERMIC	1 ITEM
30	AL030	TRIMMER THERMIC	1 ITEM
31	AL031	TIME ROLE	1 ITEM
32	AL032	NEXT ROLE	1 ITEM
33	AL033	BACK ROLE	1 ITEM
34	AL034	SEAL ROLE	1 ITEM
35	AL035	CONNECTOR	1 ITEM
36	AL036	CONNECTION HOSE	1 ITEM
37	AL037	OIL UPPER COVER	1 ITEM
38	AL038	PRESSURE EMERGENCY	1 ITEM
39	AL039	PRESSURE REGULATOR	1 ITEM
40	AL040	DK 24 COUPLING	1 ITEM
41	AL041	ELEKTRICAL PANEL	1 ITEM
42	AL042	MONOMETER CONNECTOR BEND	1 ITEM
43	AL043	ACCUMULATOR	1 ITEM
44	AL044	LEFT - RIGHT COVERS	1 ITEM
45	AL045	3/8" COPPER WASHER	4 ITEMS
46	AL046	3/8" FEMALE QUICK COUPLING	1 ITEM
47	AL047	3/8" MALE QUICK COUPLING	1 ITEM
48	AL048	1/4" 10 REGULATOR	3 ITEMS
49	AL049	M10 RING	3 ITEMS

AL 1000-1200-1600

AL 1000-1200-1600 HYDRAULIC UNIT LIST

Kullanma Kılavuzu
Technical Information

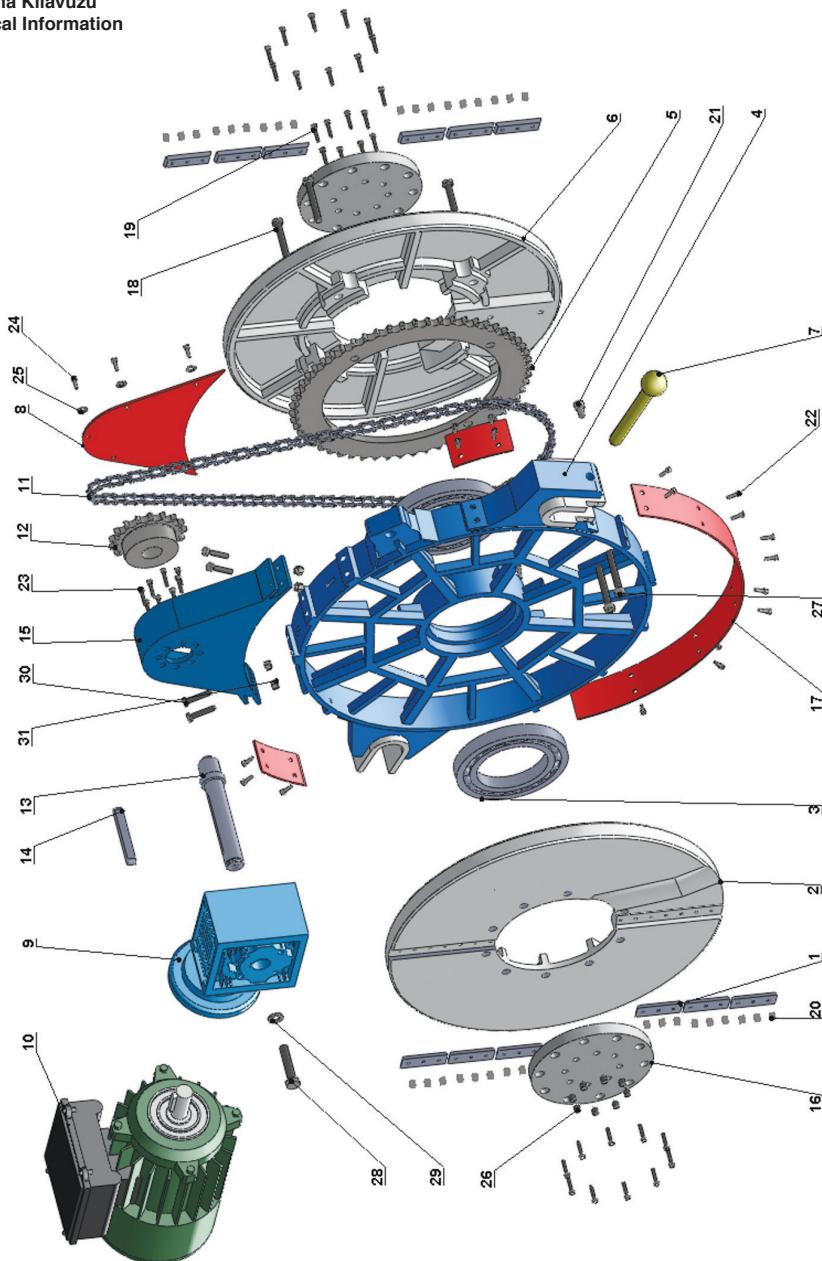
AL 1000-1200-1600 HYDRAULIC UNIT LIST

NO	CODE NUMBER	ITEM ID	QUANTITY
50	AL050	M10 NUT	3 ITEMS
51	AL051	Ø 10 ALUMINUM TUBE	1 ITEM
52	AL052	M10 NUT	2 ITEMS
53	AL053	Ø 10 ALUMINUM TUBE	1 ITEM
54	AL054	FRONT LEG	1 ITEM
55	AL055	FRONT LEG CONNECTING BOLT M8X40 mm	2 ITEMS
56	AL056	FRONT LEG CONNECTING NUT M8	2 ITEMS
57	AL057	FRONT LEG CONNECTING WASHER M8	2 ITEMS
58	AL058	FRONT COVER	1 ITEM
59	AL059	OIL FILTER	1 ITEM
60	AL060	REGULATOR	
61	AL061	Ø 10 ALUMINUM TUBE	1 ITEM
62	AL062	PUMP ADAPTER	2 ITEMS
63	AL063	TOP COVER CONNECTING IMBUS BOLT M6X20 mm	
64	AL064	TOP COVER CONNECTING WASHER M6	
65	AL065	PUMP ADAPTER CONNECTING IMBUS BOLT	
66	AL066	Ø 10 ALUMINUM TUBE	1 ITEM
67	AL067	3/8" COPPER WASHER	5 ITEMS
68	AL068	PANEL CONNECTING AKC BOLT M6X40 mm	4 ITEMS
69	AL069	PANEL CONNECTING NUT M6	4 ITEMS
70	AL070	PANEL CONNECTING WASHER M6	4 ITEMS
71	AL071	HEEL	2 ITEMS
72	AL072	WHEEL CONNECTING BOLT M10X25 mm	2 ITEMS
73	AL073	WHEEL CONNECTING WAHER M10	2 ITEMS

AL 1600

AL 1600 TIRAŞLAYICI / AL 1600 TRIMMER

Kullanma Kılavuzu
Technical Information



AL 1600

AL 1600 TIRAŞLAYICI LİSTESİ

Kullanma Kılavuzu
Technical Information

AL 1600

TIRAŞLAYICI LİSTESİ

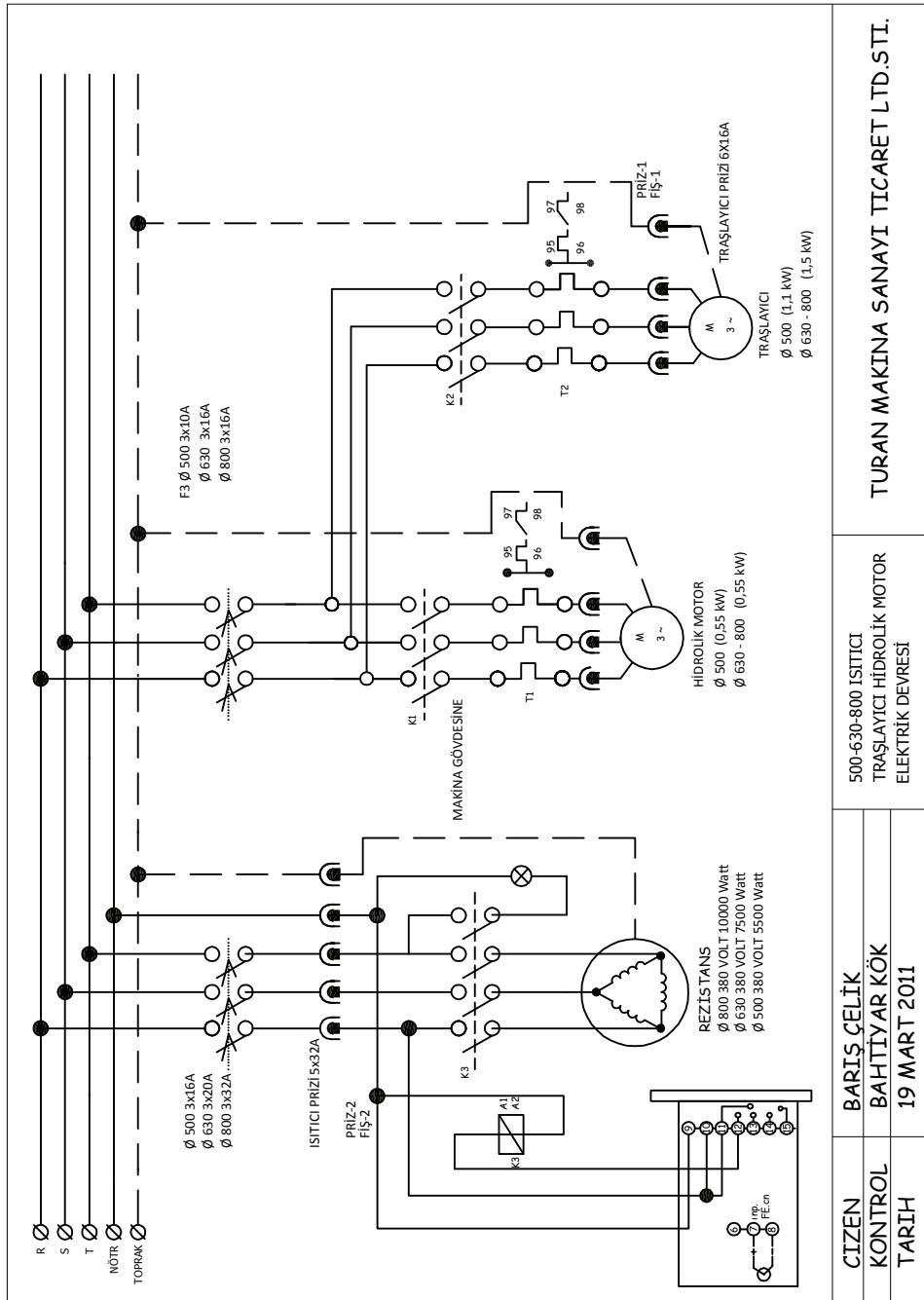
PARÇA NO	ÜRÜN KODU	ÜRÜN ADI	ADET
1	AL160070	BIÇAK	12 ADET
2	AL160071	TIRAŞLAYICI DÜZ DISK	1 ADET
3	AL160072	RULMAN (16014)	2 ADET
4	AL160073	TIRAŞLAYICI GÖVDE	1 ADET
5	AL160074	ZİNCİR DİŞLİ	1 ADET
6	AL160075	TIRAŞLAYICI DİŞLİ DISK	1 ADET
7	AL160076	EMNİYET PİMİ	1 ADET
8	AL160077	TIRAŞLAYICI KAPAK	1 ADET
9	AL160078	REDÜKTÖR	1 ADET
10	AL160079	MOTOR (4 Kw) MONOFAZE 1400 d/dk	1 ADET
11	AL160080	ZİNCİR	1 ADET
12	AL160081	ZİNCİR ÜST DİŞLİ	1 ADET
13	AL160082	ZİNCİR ÜST DİŞLİ MİLİ	1 ADET
14	AL160083	ZİNCİR MİLİ KAMASI	1 ADET
15	AL160084	ÜST GÖVDE	1 ADET
16	AL160085	FLANŞ	2 ADET
17	AL160086	GÖVDE LAMASI	3 ADET
18	AL160087	M14X90 AKC CİVATA	4 ADET
19	AL160088	M10X40 İMBUS	10 ADET
20	AL160089	M6X15 YHB VİDA	36 ADET
21	AL160090	M6X25 İMBUS CİVATA	1 ADET
22	AL160091	LAMA BAĞLANTı VİDASI M6X15 YHB	20 ADET
23	AL160092	REDÜKTÖR BAĞLANTı CİVATASI M10X30 AKC	8 ADET
24	AL160093	KORUYUCU KAPAK BAĞLANTı CİVATASI M6X20 AKC	5 ADET
25	AL160094	KORUYUCU KAPAK BAĞLANTı PUL M6	5 ADET
26	AL160095	DİKS BAĞLANTISI SETİSKUR M14X20	8 ADET
27	AL160096	GÖVDE CİVATASI M10X20	4 ADET
28	AL160097	DİŞLİ MİLİ BAĞLANTı CİVATASI M12X25	1 ADET
29	AL160098	DİŞLİ MİLİ BAĞLANTı PUL M12	1 ADET
30	AL160099	ÜST GÖVDE BAĞLANTı CİVATASI M12X35	6 ADET
31	AL160100	ÜST GÖVDE BAĞLANTı SOMUN M12	6 ADET

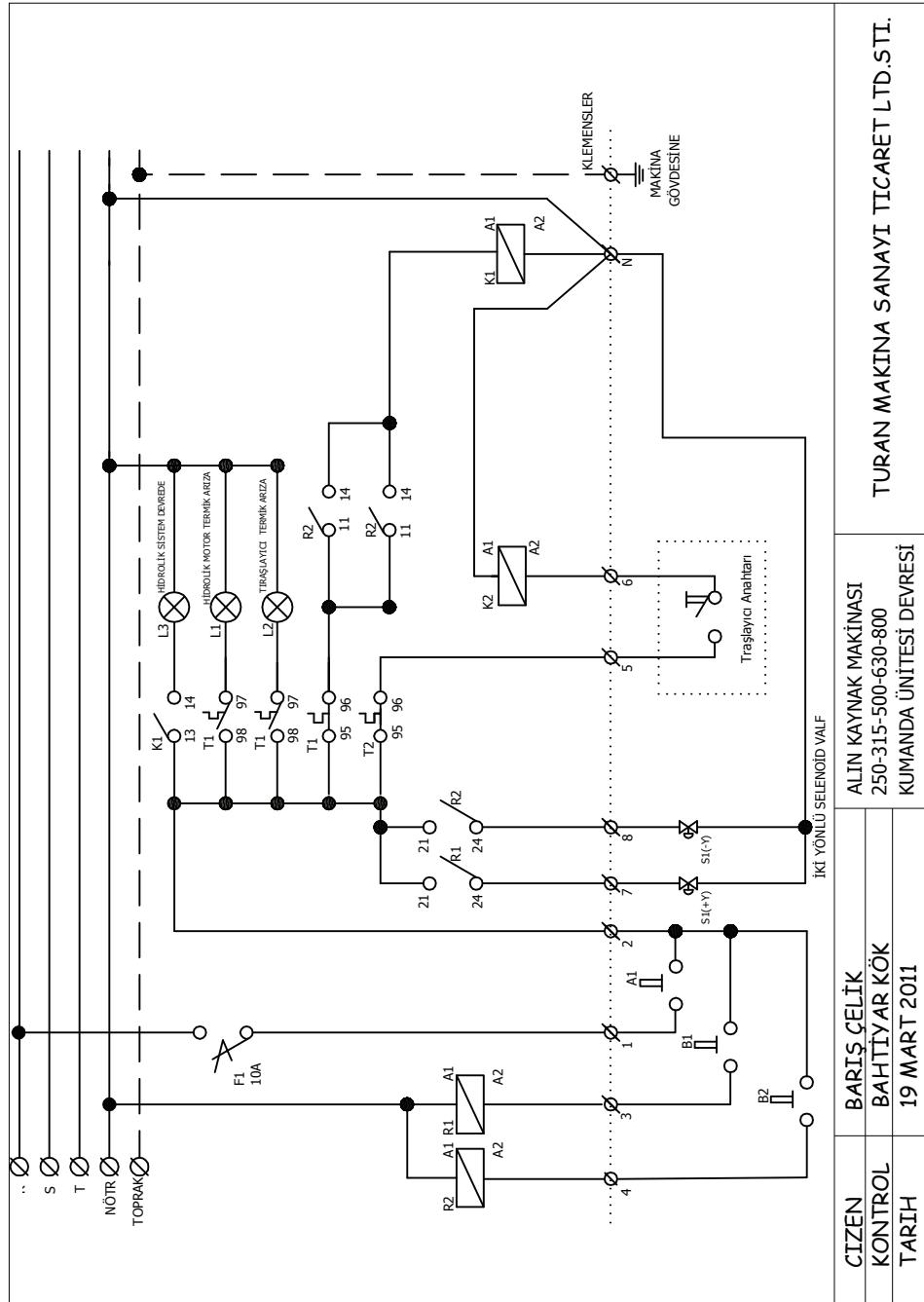
AL 1600

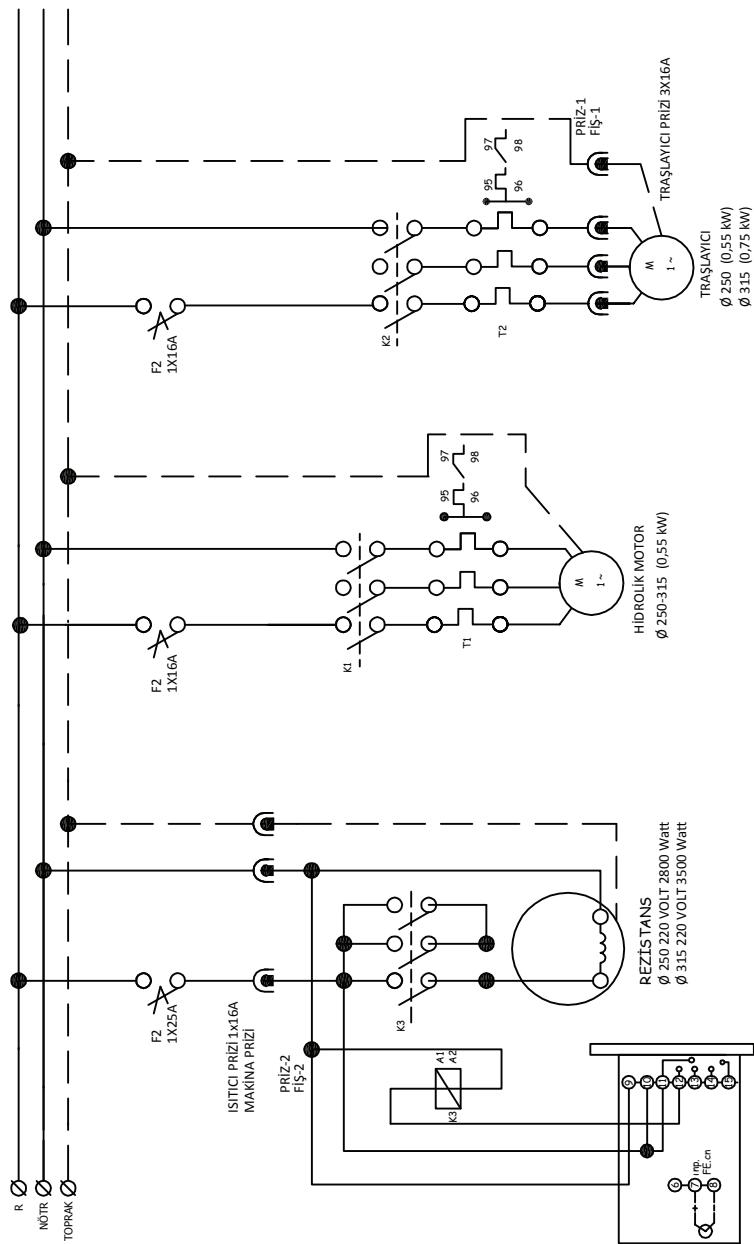
AL 1600 TRIMMER LIST

Kullanma Kılavuzu
Technical Information

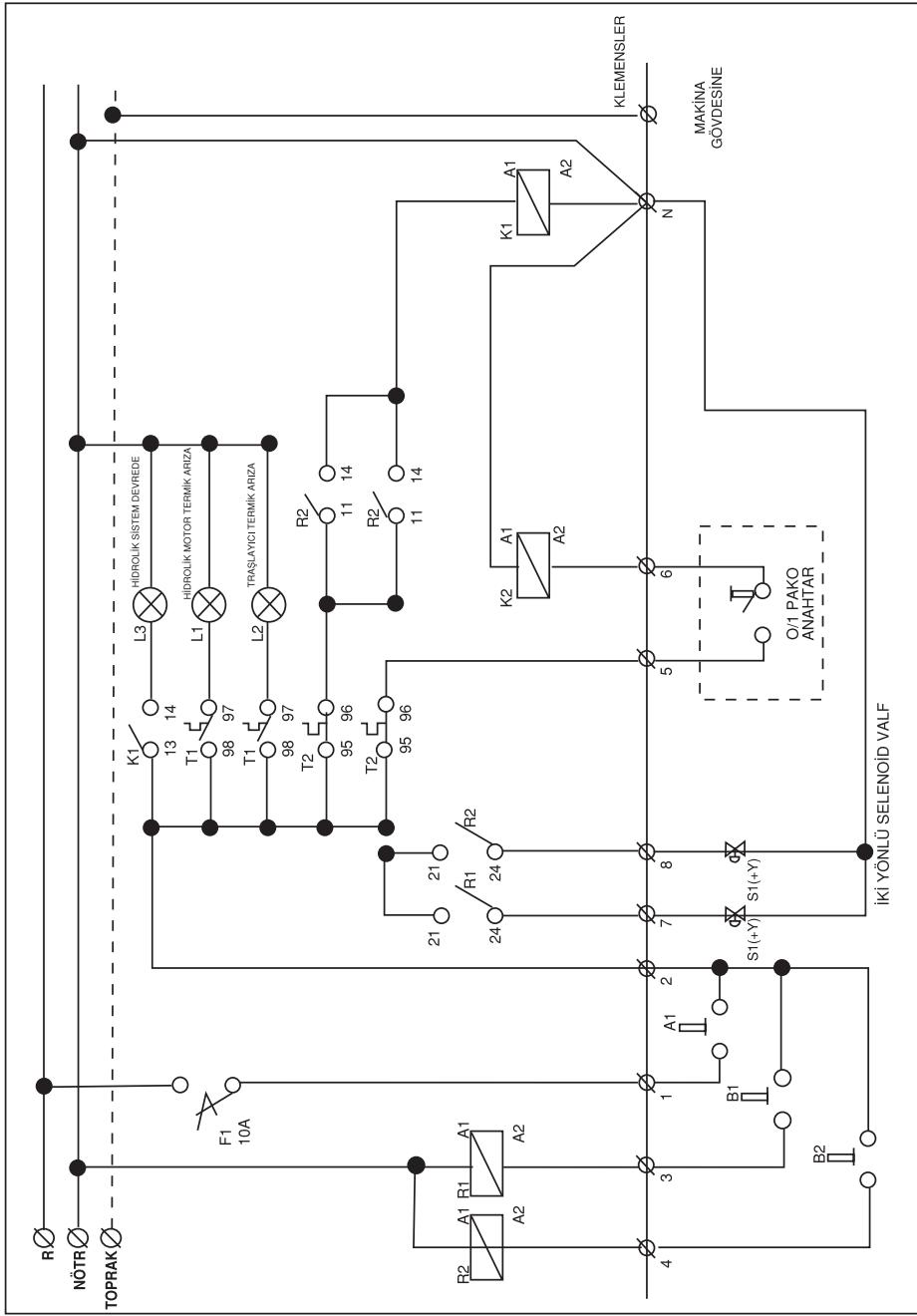
AL 1600		TRIMMER LIST	
NO	CODE NUMBER	ITEM ID	QUANTITY
1	AL160070	BLADE	12 ITEMS
2	AL160071	TRIMMER PLAIN DISC	1 ITEM
3	AL160072	BEARING	2 ITEMS
4	AL160073	TRIMMER BODY	1 ITEM
5	AL160074	CHAIN BEARING	1 ITEM
6	AL160075	TRIMMER SCREW DISC	1 ITEM
7	AL160076	SAFETY PIN	1 ITEM
8	AL160077	TRIMMER COVER	1 ITEM
9	AL160078	REDUCTOR	1 ITEM
10	AL160079	MOTOR	1 ITEM
11	AL160080	CHAIN	1 ITEM
12	AL160081	CHAIN UPPER GEAR	1 ITEM
13	AL160082	CHAIN UPPER GEAR SHAFT	1 ITEM
14	AL160083	CHAIN SHAFT PIN	1 ITEM
15	AL160084	TOP BASIC	1 ITEM
16	AL160085	FLANGE	2 ITEMS
17	AL160086	LAMA	3 ITEMS
18	AL160087	M14X90 AKC BOLT	4 ITEMS
19	AL160088	M10X40 IMBUS BOLT	10 ITEMS
20	AL160089	M6x15 YHB SCREW	36 ITEMS
21	AL160090	M6x25 IMBUS BOLT	1 ITEM
22	AL160091	LAMA CONNECTING BOLD M6X20 AKC	20 ITEMS
23	AL160092	REDUCTOR CONNECTING BOLD M10X30 AKC	8 ITEMS
24	AL160093	PROTECTING COVER CONNECTING BOLT M6X20 AKC	5 ITEMS
25	AL160094	PROTECTING COVER CONNECTING WASHER M6	5 ITEMS
26	AL160095	DISC CONNECTING SETİSKUR M14X20	8 ITEMS
27	AL160096	BASIC BOLT M10X20	4 ITEMS
28	AL160097	GEAR SHAFT CONNECTING BOLT M12X25	1 ITEM
29	AL160098	GEAR SHAFT CONNECTING WASHER M12	1 ITEM
30	AL160099	TOP BASIC CONNECTING BOLT M12X35	6 ITEMS
31	AL160100	TOP BASIC CONNECTING WASHER M12	6 ITEMS



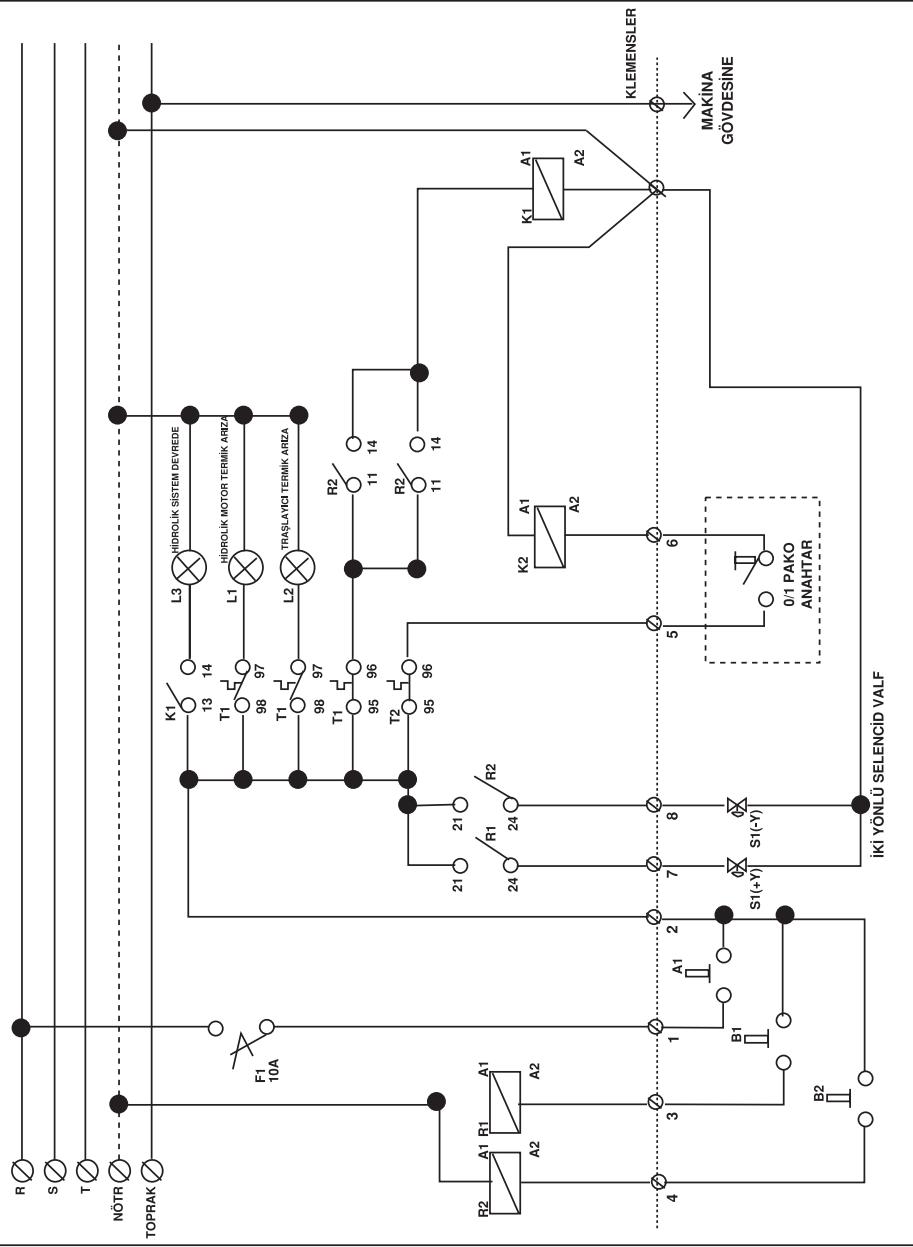


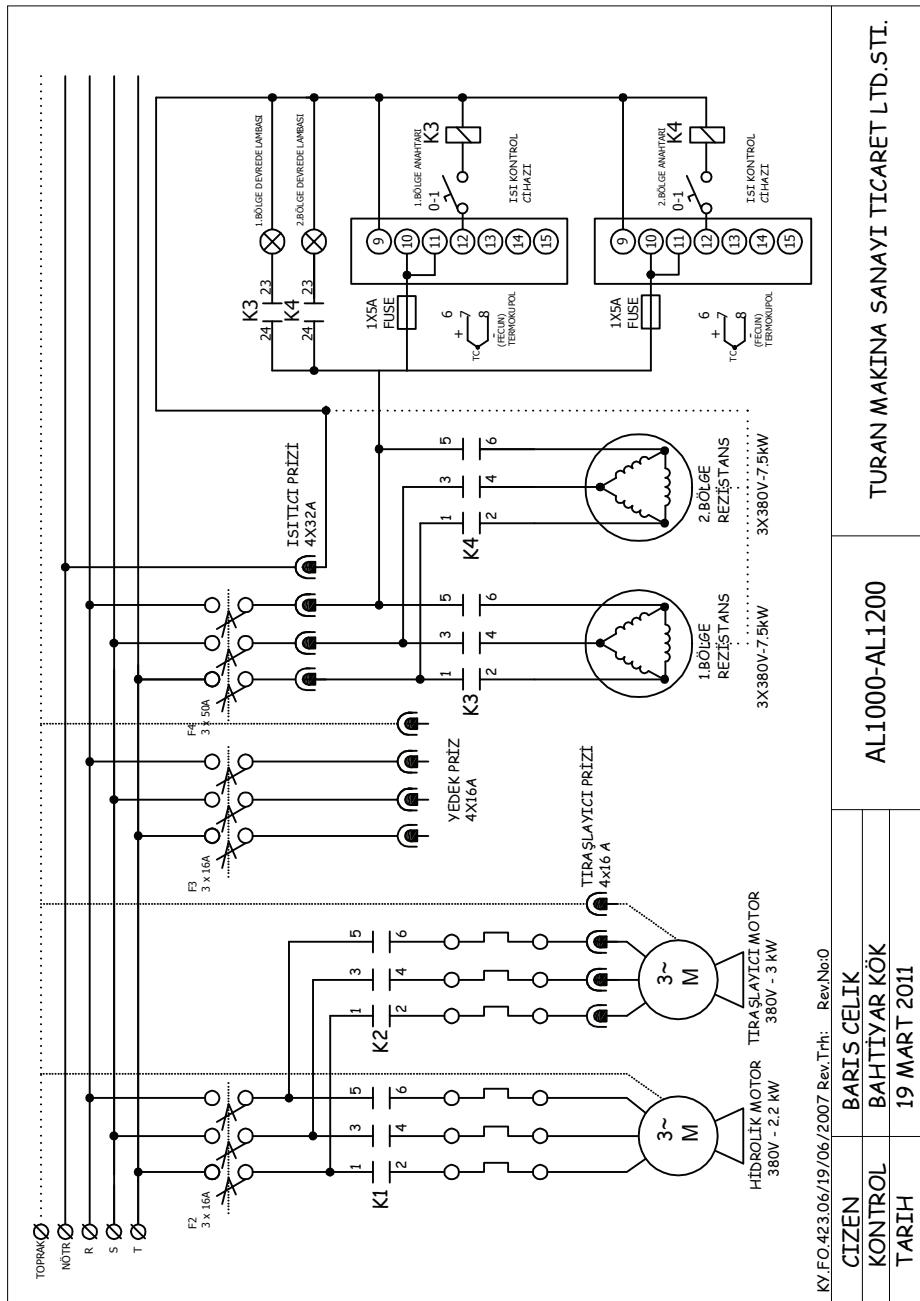


ALIN KAYNAK MAKİNASI 250-315 KUMANDA ÜNİTESİ DEVRESİ



ALIN KAYNAK MAKİNASI 250-315-500-630-800 KUMANDA ÜNİTESİ DEVRESİ

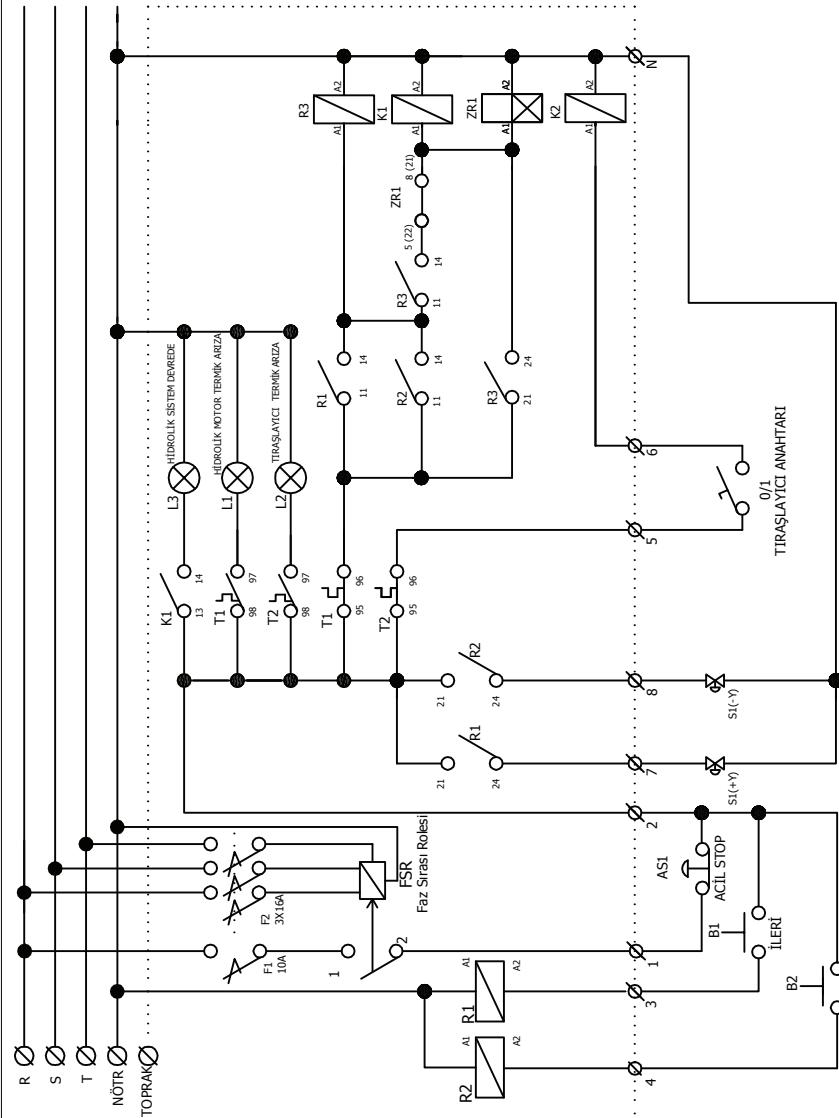




KY.FO.423.06/19/06/2007 Rev.Trh: Rev.No:0

CIZEN BARIŞ CELİK

KONIKUL TARIH BAHARIIYAR KUK 19 MART 2011



K.FO.423.06/19/06 Rev.Trh: Rev.No:0

İKİ YÖNLÜ SELENOİD VALF

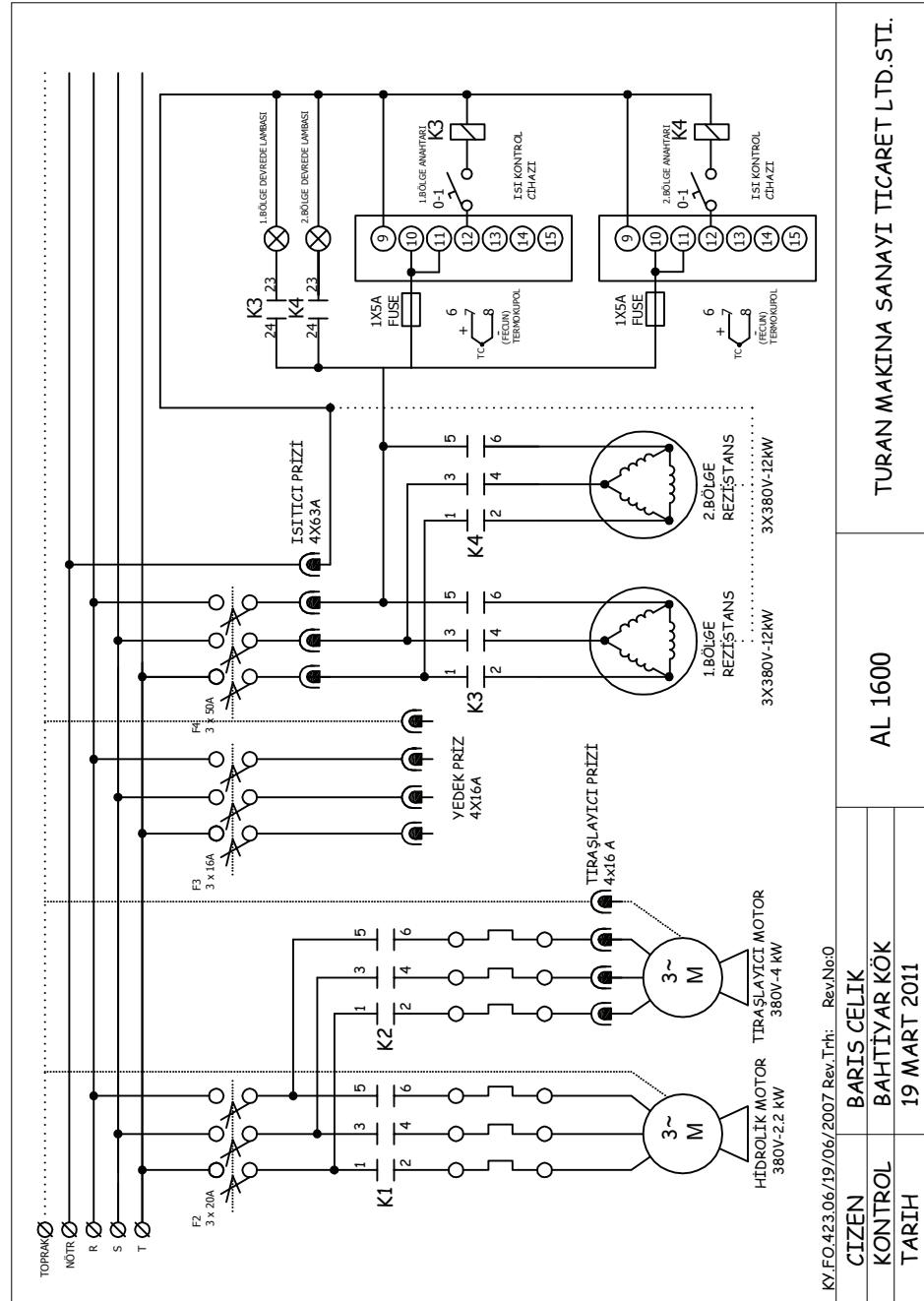
TURAN MAKİNA SANAYİ TİCARET LTD.ŞTİ

ALIN KAYNAK MAKİNASI 1000-1200	KUMANDA ÜNİTESİ DEVRESİ
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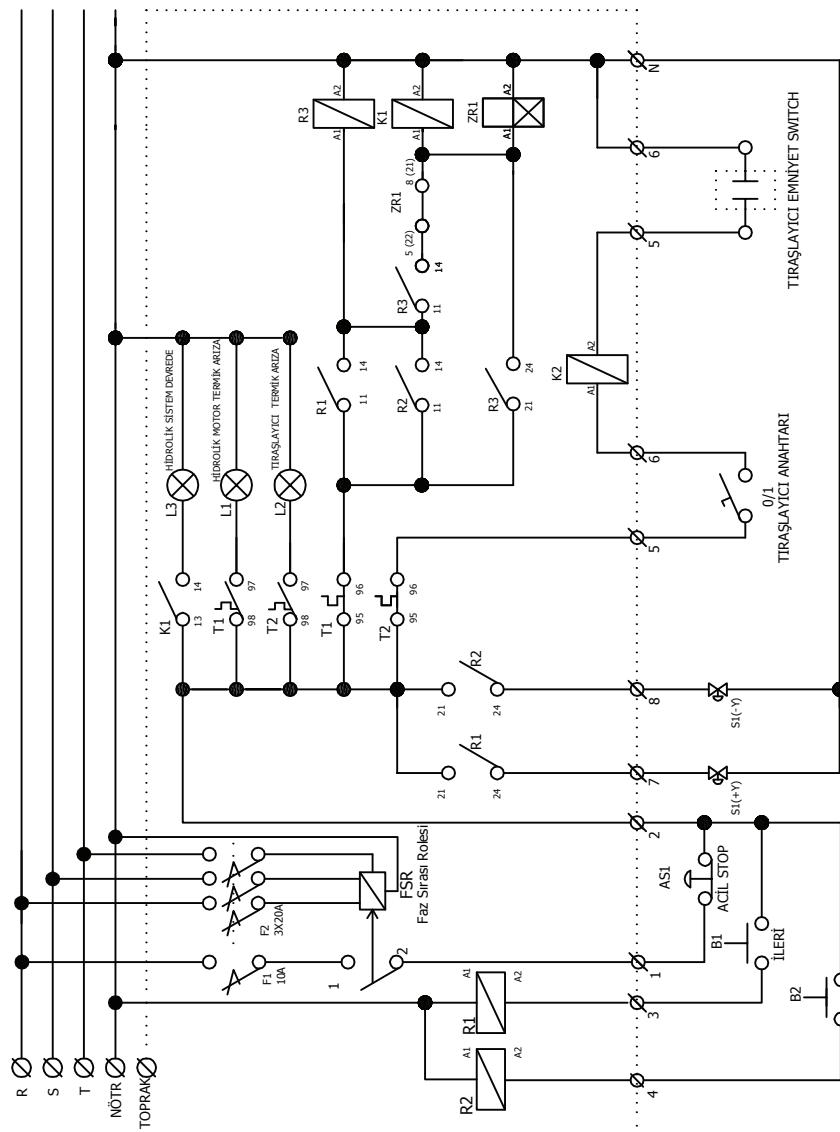
CİZEN	BARİS CELİK
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KONTROL	BAHTİYAR KÖK
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TARIH	19 MART 2011
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KY.FO.423.06/19/06/2007 Rev.Trh.: Rev.Nr:0





Uygunluk Deklarasyonu

ÜRETİCİ: TURAN MAKİNA METAL İNŞ. SAN. TİC. LTD. ŞTİ

ADRES : Sanayi Mah.Orhanlı Yolu Cad.Mezarlık Sok.No:6 Kurtköy /

Pendik İSTANBUL TÜRKİYE

Aşağıda adı tipi veya modeli verilen mamullerin belirtilen standartlara uygun olarak belirtilen direktiflerin gereklerini karşılayacak şekilde üretiğimizi beyan ederiz.

ÜRÜNLER : PLASTİK BORU ALIN KAYNAK MAKİNALARI

MARKA:TAL-KA

MODEL:40-160/75-250/90-315/160-400/180-500/315-630/500-800/710-1000/800-1200/1200-1600

İLGİLİ YÖNETMELİKLER :

ELEKTROMANYETİK UYUMLULUK YÖNETMELİĞİ (2004/108/AT)

MAKİNA EMNİYETİ YÖNETMELİĞİ 2006/42/AT

BELİRLİ GERİLİM SINIRLARI DAHİLİNDE KULLANILMAK ÜZERE TASARLANMIŞ ELEKTRİKLİ TEÇHİZAT İLE İLGİLİ YÖNETMELİK (2006/95/AT)

İLGİLİ HARMONİZE STANDARTLAR :

EN ISO 12100:2010, EN ISO13850:2006, EN 55011:2010, EN 55014-1:2007, EN 61000-6-2:2006, TS EN 61000-4-2:2009, TS EN 61000-4-3:2006; EN 61000-4-4:2013, EN 61000-4-5:2007, TS EN 61000-4-6:2011; EN 60204-1

YETKİLİ İMZASI:

: SUNAY TURAN
: GENEL MÜDÜR
: 13.08.2013

TURAN MAKİNA METAL

İNSAAT SAN. TİC. LTD. ŞTİ.
Sanayi Mahallesi Orhanlı Yolu Caddesi
Mezarlık Sk. No:5 Kurtköy-İSTANBUL
Tel: 0216 595 07 51 Pta Fax: 595 07 52
Anadolu Kurumsal VD: 909 006 3892

İŞİM

POZİSYON

YER/TARİH

İMZA



C E R T I F I C A T E

ATTESTATION CERTIFICATE OF MACHINERY DIRECTIVE

Technical file of the company mentioned below has been inspected and audit has been completed successfully.

2006/42/EC Machinery Directive has been taken as references for these processes.

Company Name : **Turan Makina Plastik Boru Sistemleri Anonim Şirketi**

Company Address : Kurtköy Sanayi Sitesi Adıgüzeli Sok. No:6 Kurtköy Pendik
ISTANBUL / TURKEY

Related Directives and Annex : **Machinery Directive 2006/42/EC / Annex VIII**

Related Standards : EN ISO 12100, EN ISO 13850, EN 60204-1, EN 55014-1, EN 61000-6-2,
EN 61000-6-4, EN 61000-3-2, EN 61000-3-3, EN 61000-3-11,
EN 61000-4-2, EN 61000-4-3, EN 61000-4-4, EN 61000-4-5,
EN 61000-4-6, EN 61000-4-8, EN 61000-4-11

Product Name : **Plastic Pipe Butt Welding Machine**

Product Model/Type : **TAL-KA**
40mm-160mm, 75mm-250mm, 90mm-315mm, 160mm-400mm,
180mm-500mm, 315mm-630mm, 500mm-800mm, 710mm-1000mm,
800mm-1200mm, 1200mm-1600mm

Certificate Number : **M.2013.103.2275**

Initial Assessment Date : **12.08.2013**

Registration Date : **15.08.2013**

Reissue Date/No : **29.06.2016**

Expiry Date : **14.08.2017**

APB
UDEM
UDEM International Certification
Auditing Training Centre Industry
and Trade Co. Ltd.

The validity of the certificate can be checked through www.udemltd.com.tr. The CE mark shown on the right can only be used under the responsibility of the manufacturer with the conformation of EC Declaration of Conformity for all the requirements of Directive. This certificate requires the responsibility of UDEM International Certification Auditing Training Centre Industry and Trade Co. Ltd. to whom it must be returned upon request. The above named firm must keep a copy of this certificate for 15 years from the date of issue of certificate. This certificate only covers the product(s) stated above and UDEM must be notified in case of any changes on the products.

Address: Muttukem Mahallesi 2073 Sokak (Eski 93 Sokak) No:10 Çankaya - Ankara - TURKEY
Phone: +90 0312 443 03 90 **Fax:** +90 0312 443 03 76
E-mail: info@udemltd.com.tr www.udemltd.com.tr







DigiCert

**TURAN MAKİNA PLASTİK BORU SİSTEMLERİ
ANONİM ŞİRKETİ**

KURTÖK SANAYİ MAHALLESİ ADIGÜZEL SOKAK NO:6
PENDİK / İSTANBUL

Plastik boru bağlantı parçaları, plastik boru alın kaynak makinaları imalatı ve satışı ile bu hizmetlere ilişkin lojistik, depolama, muhasebe, finans ve bilgi işlem gibi faaliyetlerinin elektronik bilgi varlıklarını ile bu varlıklarını korumak amacıyla kullandığı bilişim güvenliği

kapsamında

TS EN ISO 27001:2013

Uluslararası sistem standardına uygun bir *Bilgi Güvenliği Yönetim Sistemi* dokümantasyonu kurmuş ve yönetmektedir.

Belge No	:	154.621.829
Yayın Tarihi	:	27.10.2016
Revizyon No	:	00
Revizyon Tarihi	:	..
Geçerlilik Tarihi	:	26.10.2017
Geçerlilik Periyodu	:	3 Yıl
<i>Uygulanabilirlik Bildirgesi</i>		
Doküman No	:	TURAN.00
Yayın Tarihi	:	09.06.2016
Revizyon No/Tarihi	:	00/09.06.2016

Bu sertifika yukarıda adı geçen firma , adresler) ile kapsam için tescil edilmiştir. DigiCert Belgelendirme Ltd. Şti. ile yapılan sisteme belgelendirme hizmet sözleşmesinin şartlarına uygun olarak verilmiştir. Bu sertifikanın geçerliliği www.digicert.com.tr adresinde "Belge Sorğulama" bölümünden ya da satılık keyde bulunan QR Kodunun aktif telefon uygulamalarına okutulması ile sorgulanabilir. Bu belge , kuruluşun DigiCert Belgelendirme Kurallarına uyması ve yılda en az bir defa yapılacak gözetim denetimlerinde başarılı olması durumunda yayın tarihinden itibaren 3 yıl geçerlidir. Doküman No/Rev.No: 05.01.2015 / REV.02



ONAY
AHMET ÖZDAY
GENEL MÜDÜR




DigiCert Belgelendirme Ltd.Şti.
A.Oveçler Mah. 1293.Sok. No:7/14 ÇANKAYA / ANKARA
Tel: 0 312 386 12 47 - Faks: 0 312 386 12 48
www.digicert.com.tr · bilgi@digicert.com.tr



DigiCert

BORFİT BORU VE EK PARÇALARI SANAYİ TİCARET LİMİTED ŞİRKETİ

KURTKÖY SANAYİ MAHALLESİ ADIGÜZEL SOKAK NO:6
PENDİK / İSTANBUL

Plastik boru bağlantı parçaları, plastik boru alın kaynak makinaları ihracatı ile bu hizmetlere ilişkin lojistik, depolama, muhasebe, finans ve bilgi işlem gibi faaliyetlerinin elektronik bilgi varlıklarını ile bu varlıklarını korumak amacıyla kullandığı bilişim güvenliği

kapsamında

TS EN ISO 27001:2013

Uluslararası sistem standardına uygun bir *Bilgi Güvenliği Yönetim Sistemi* dokümantasyonu kurmuş ve yönetmektedir.

Belge No	: 515.164.329
Yayın Tarihi	: 27.10.2016
Revizyon No	: 00
Revizyon Tarihi	: --
Geçerlilik Tarihi	: 26.10.2017
Geçerlilik Periyodu	: 3 Yıl
Uygulanabilirlik Bildirgesi	
Doküman No	: BORFIT.00
Yayın Tarihi	: 09.06.2016
Revizyon No/Tarihi	: 00/09.06.2016

Bu sertifika yukarıda adı geçen firma, adres(ler) ve kapsam için tescil edilmiştir. DigiCert Belgelendirme Ltd. Şti. ile yapılan sistem belgelendirme hizmet sözleşmesinin şartlarına uygun olarak verilmiştir. Bu sertifikatanın geçerliliği www.digicert.com.tr adresinde "Belge Sorgulama" bölümünden ya da sol üst köşede bulunan QR Kodunun akıllı telefon uygulamalarına okutulması ile sorgulanabilir. Bu belge, kuruluşun DigiCert Belgelendirme Kurallarına uyması ve yılda en az bir defa yapılacak gözetim denetimlerinde başarılı olması durumunda yayın tarihinden itibaren 3 yıl geçerlidir. Doküman No/Rev No: 05.03.2015 / REV.02

ONAY

AHMET ÖZADAY

GENEL MUDÜR



Bilgi Güvenliği Yönetim Sistemi
TS EN ISO/IEC 17021
AB-0117-YS



DigiCert Belgelendirme Ltd.Şti.
A.Ovaçlı Mah. 1293.Sok. No:7/14 ÇANKAYA / ANKARA
Tel: 0 312 386 12 47 - Faks: 0 312 386 12 48
www.digicert.com.tr - bilgi@digicert.com.tr

TÜRK STANDARDLARI ENSTİTÜSÜ
TÜRK STANDARDLARINA UYGUNLUK BELGESİ
TURKISH STANDARDS INSTITUTION
CERTIFICATE OF CONFORMITY TO TURKISH STANDARDS



Markamın Tanımı Description of the Mark
TSE veya/or veya/or

BELGE NUMARASI REFERENCE NUMBER OF LICENCE	010972-TSE-01/01
BELGENİN İLK VERİLİŞ TARİHİ DATE OF FIRST ISSUE OF LICENCE	26.03.2015
BELGENİN SON GEÇERLİLİK TARİHİ LICENCE VALID UNTIL	26.03.2017
BELGE SAHİBİ KURULUSUN ADI NAME OF THE LICENCE HOLDER	TURAN MAKINA PLASTİK BORU SİSTEMLERİ ANONİM ŞİRKETİ
BELGE SAHİBİ KURULUSUN ADRESİ ADDRESS OF THE LICENCE HOLDER	SANAYİ MAH. ORHANLI YOLU CAD. ADIGÜZEL SOK. NO:6 34912 KURTKOY-PENDİK İSTANBUL/TÜRKİYE
ÜRETİM YERİ ADI NAME OF THE MANUFACTURING PLACE	TURAN MAKINA PLASTİK BORU SİSTEMLERİ ANONİM ŞİRKETİ
ÜRETİM YERİ ADRESİ ADDRESS OF THE MANUFACTURING PLACE	SANAYİ MAH. ORHANLI YOLU CAD. ADIGÜZEL SOK. NO:6 34912 KURTKOY-PENDİK İSTANBUL / TÜRKİYE
İPTAL EDİLEN BELGE NUMARASI (Varsa) INDICATION OF SUPERSEDED LICENCE (if any)	14.03.04.34.00/TSE-66679
TESCİLLİ TİCARİ MARKASI REGISTERED TRADE MARK	BORFIT
İLGİLİ TÜRK STANDARTI RELATED TURKISH STANDARD	TS EN ISO 15494 / Plastics piping systems for industrial applications - Polybutene (PB), polyethylene (PE) and polypropylene (PP) - Specifications for components and the system - Metric series (ISO 15494:2003) / 28.01.2004
BELGE KAPSAMI SCOPE OF LICENCE	POLYETHYLENE (PE) FITTINGS FOR INDUSTRIAL APPLICATIONS -ELECTROFUSION FITTINGS USED UNDERGROUND BLACK , POLYETHYLENE (PE) 100 SDR 11, SDR 17 Ø 16MM (INCLUDING) UNTIL Ø710MM (INCLUDING)



23/05/2016

AHMET NURSİ KARTAL
MANAGER OF THE TSE ISTANBUL
CERTIFICATION DEPT

*Bu belge, belgelerdenin grubun, getirilen yerinin Enstitüsünün belirttiği şartlar karşıladığı da gösterir.
 *Bu belge bir surette tahrif edilemez, kriyem veya okunmasının zorlaştırılacak şekilde yapılmamaz, kazanı ve silinir yapılabilir.
 *TSE İSTANBUL CERTIFICATION DEPT. Adres: Çarşeva Tren İstasyonu Yarıç ÇAYIROVA/İZMİR * Tel: 2627231273* Faks: 2627231606
 *TSE BELGELENDİRME MERKEZİ BAŞKANLIĞI: Adres: Necatibey Cad. No:112 06100 Bahçelievler/ANKARA * Tel: 0 312 416 64 81 / 416 64 27, Faks: 0 312 416 66 17
 e-posta : tmb@tse.org.tr , web : www.tse.org.tr

1 / 1



TÜRK STANDARDLARI ENSTİTÜSÜ
TÜRK STANDARDLARINA UYGUNLUK BELGESİ
TURKISH STANDARDS INSTITUTION
CERTIFICATE OF CONFORMITY TO TURKISH STANDARDS

Markanın Tanımı Description of the Mark
TSE veya/or veya/or **トルコ**

BELGE NUMARASI
 REFERENCE NUMBER OF LICENCE

14.0.30.4.34.00/TSE-67249

BELGENİN İLK VERİLİŞ TARİHİ
 DATE OF FIRST ISSUE OF LICENCE

13.04.2006

BELGENİN SON GEÇERLİLİK TARİHİ
 LICENCE VALID UNTIL

15.12.2016

BELGE SAHİBİ KURULUSUN ADI
 NAME OF THE LICENCE HOLDER

TURAN MAKİNA PLASTİK BORU SİSTEMLERİ ANONİM ŞİRKETİ

BELGE SAHİBİ KURULUSUN ADRESİ
 ADDRESS OF THE LICENCE HOLDER

SANAYİ MAH. ORHANLI YOLU CAD. ADIGÜZEL SOK. NO:6 34912 KURTKOY-PENDİK İSTANBUL/TÜRKİYE

ÜRETİM YERİ ADI
 NAME OF THE MANUFACTURING PLACE

TURAN MAKİNA PLASTİK BORU SİSTEMLERİ A.Ş.

ÜRETİM YERİ ADRESİ
 ADDRESS OF THE MANUFACTURING PLACE

Kurtköy Sanayi Mah. ADIGÜZEL SOK. No:6 Pendik/İstanbul İSTANBUL / TÜRKİYE

İPTAL EDİLEN BELGE NUMARASI (Varsa)
 INDICATION OF SUPERSEDED LICENCE (if any)

14.0.30.4.34.00/TSE-65593

TESCİLLİ TİCARİ MARKASI
 REGISTERED TRADE MARK

BORFIT

İLGİLİ TÜRK STANDARTI
 RELATED TURKISH STANDARD

TS EN 12201-3+A1 / Plastics piping systems for water supply, and for drainage and sewerage under pressure - Polyethylene (PE) - Part 3: Fittings / 21.02.2012

BELGE KAPSAMI
 SCOPE OF LICENCE

PLASTICS PIPING SYSTEMS FOR WATER SUPPLY, AND FOR DRAINAGE AND SEWERAGE UNDER PRESSURE-

PART-3 FITTINGS

* FITTINGS FROM POLYETHYLENE (PE) 100 BLACK SDR 11, SDR 17
 GROUP SIZE : 1,2,3
 90°, 45° ELBOW, PIERCING T, CAP, REDUCER, COUPLER, FLANGE ADAPTER
 "BUTT WELDED FITTINGS"

Ø 20MM (INCLUDING) UNTIL Ø710MM (INCLUDING) (K.D : 18.11.2015)



23/05/2016

AHMET NURSİ KARTAL
 MANAGER OF THE TSE İSTANBUL
 CERTIFICATION DEPT

*Bu belge, İstişaredeki Gruplar, Gruplar *yeni* Erstellenmaları belirlediği şartları karşıladığı da gösteri.

*Bu belge bir hizmetle tescil edilmesi, istenilen veya olumsuz zorlaştırmakla şartsız olmalıdır. Kazanç ve şantiye yapılışması.

*TSE İSTANBUL BELEĞELENDİRME MUDURLUĞU * Adres: Gayriova Tren İstasyonu Yarı ÇAYIROVA/AGEBEZE * Tel: 2627231273 Faks: 2627231606

*TSE BELEĞELENDİRME MERKEZİ BAŞKANLIĞI: Adres: Necatibey Cad. No:112 06100 Bakanlıklar/ANKARA – Tel: 0 312 416 64 27, Faks: 0 312 416 66 17

e-posta : tmb@tse.org.tr , web : www.tse.org.tr

1/2





**NARODOWY INSTYTUT ZDROWIA PUBLICZNEGO
- PAŃSTOWY ZAKŁAD HIGIENY**

**NATIONAL INSTITUTE OF PUBLIC HEALTH
- NATIONAL INSTITUTE OF HYGIENE**

**ZAKŁAD HIGIENY ŚRODOWISKA
DEPARTMENT OF ENVIRONMENTAL HYGIENE**

24 Chocimska 00-791 Warsaw • Phone (22) 5421354; (22) 5421349 • Fax (22) 5421287 • e-mail: sek-zhk@pzh.gov.pl

ATEST HIGIENICZNY HK/W/0014/01/2015
HYGIENIC CERTIFICATE

ORYGINAL

Wyrób / product: Kształtki elektrooporowe i doczolowe - kolano, trójnik równoprzelotowy i redukcyjny, redukcja, zaślepkę; elektrooporowe -odejście śiodłowe, trójnik śiodłowy z zaworem i bez; doczolowe-tuleje kohnierzowe, czwórnik, adaptör z przejściem PE/metal gwint zewn. i wewn.

Zawierający / containing: polietilen Borsafe HE3490-LS

Przeznaczony do / destined: montażu w instalacjach służących do przesyłania wody przeznaczonej do spożycia przez ludzi i instalacjach gazowych

Wymieniony wyżej produkt odpowiada wymaganiom higienicznym przy spełnieniu następujących warunków / is acceptable according to hygiene criteria with the following conditions:

Instalację przeznaczoną do przesyłania wody przeznaczonej do spożycia przez ludzi, przed oddaniem do użytku, należy przepływać woda.

Atest higieniczny nie obejmuje oceny podatności materiału na tworzenie biofilmu (brak badań).

Atest nie dotyczy parametrów technicznych wyrobu/Hygienic certificate does not apply to technical parameters of the product.

Wytwarzca / producer:

Turan Makina Plastik Boru Sistemleri A.S.
Sanayi Mahallesi Adıguzel Sokak No 6

Kurtköy Pendik, İstanbul, Turcja

Niniejszy dokument wydano na wniosek / this certificate issued for:

Turan Makina Plastik Boru Sistemleri A.S.
Sanayi Mahallesi Adıguzel Sokak No 6
Kurtköy Pendik, İstanbul, Turcja

Atest może być zmieniony lub unieważniony po przedstawieniu stosownych dowodów przez którąkolwiek stronę. Niniejszy atest traci ważność po 2020-02-20 lub w przypadku zmian w recepturze albo w technologii wytwarzania wyrobu.

The certificate may be corrected or cancelled after appropriate motivation. The certificate loses its validity after 2020-02-20 or in the case of changes in composition or in technology of production.

Data wydania atestu higienicznego: 20 lutego 2015

The date of issue of the certificate: 20th February 2015

Reprodukcja, kopowanie, fotorytualizacja, skanowanie, digitalizacja Atestu Higienicznego w celach marketingowych bez zgody NIZP-PZH jest zabronione.

Kierownik
Zakładu Higieny Środowiska

[Signature]
dr Bożena Króglewska

www.pzh.gov.pl



CERTIFICATE

81242

This certificate was given to the below stated company by UDEM International Certification
Audit Training Cent. Ind. Co. Ltd.

Turan Makina Plastik Boru Sistemleri A.Ş.

Kurtköy Sanayi Mahallesi Adıgüzel Sokak No:6 Pendik
ISTANBUL / TURKEY

O H S A S - 1 8 0 0 1

Scope: Manufacturing of fittings and plastic pipe welding machines

EA Code: 14-19

Certification Audit Date

: 17.08.2015

Decision Date

: 19.08.2015

Reissue Date

: 01.07.2016

Expiry Date

: 18.08.2017



UDEM International Certification
Audit Training Cent. Ind. Co. Ltd.



Hereby, UDEM International Certification Audit Training Cent. Ind. Co. Ltd, certifies that the above stated company have the appropriate management system according to the requirements of the above standard. This certificate is valid for 3 years since the decision date as long as the system is effectively maintained and surveillance audits are carried out. The validity of the certificate can be checked through www.udemilt.com.tr. The certificate is the property of UDEM International Certification Audit Training Cent. Ind. Co. Ltd and shall be returned if requested.

Address: Mutlukent Mahallesi 2073 Sekak (Eski 93 Sokak) No:10 Çankaya – Ankara - TURKEY

Tel: +90 312 443 03 90 (pbx) Fax: +90 312 443 03 76

E-mail: info@udemilt.com.tr Web: www.udemilt.com.tr



CERTIFICATE

58638

This certificate was given to the below stated company by UDEM International Certification
Audit Training Cent. Ind. Co. Ltd.

Turan Makina Plastik Boru Sistemleri A.Ş.

Kurtköy Sanayi Mahallesi Adıgüzel Sokak No:6 Pendik
ISTANBUL / TURKEY

ISO 9001:2008

Scope: Manufacturing and sales of plastic pipe butt-welding machine and plastic pipe
connection parts (spigot, EF, outfit metal transition)

EA Code: 14-19

Certification Audit Date	: 05.11.2016
Decision Date	: 09.11.2016
Reissue Date	: -
Expiry Date	: 08.11.2017



UDEM International Certification
Audit Training Cent. Ind. Co. Ltd.



Hereby, UDEM International Certification Audit Training Cent. Ind. Co. Ltd. certifies that the above stated company have the appropriate management system according to the requirements of the above standard. This certificate is valid for 3 years since the decision date as long as the system is effectively maintained and surveillance audits are carried out. The validity of the certificate can be checked through www.udemltd.com.tr, www.jas-anz.org/register. The certificate is the property of UDEM International Certification Audit Training Cent. Ind. Co. Ltd and shall be returned if requested.

Address: Mutlukent Mahallesi 2073 Sokak (Eski 93 Sokak) No:10 Çankaya – Ankara - TURKEY
Tel: +90 312 443 03 90 (pbox) Fax: +90 312 443 03 76
E-mail: info@udemltd.com.tr Web: www.udemltd.com.tr



CERTIFICATE

61126

This certificate was given to the below stated company by UDEM International Certification
Audit Training Cent. Ind. Co. Ltd

Turan Makina Plastik Boru Sistemleri A.Ş.

Kurtkoy Sanayi Mahallesi Adiguzel Sokak No:6 Pendik
ISTANBUL / TURKEY

ISO 14001:2004

Scope: Manufacturing of fittings and plastic pipe welding machines

EA Code: 14-19

Certification Audit Date	:	06.09.2014
Decision Date	:	10.09.2014
Reissue Date	:	11.09.2015
Expiry Date	:	09.09.2016

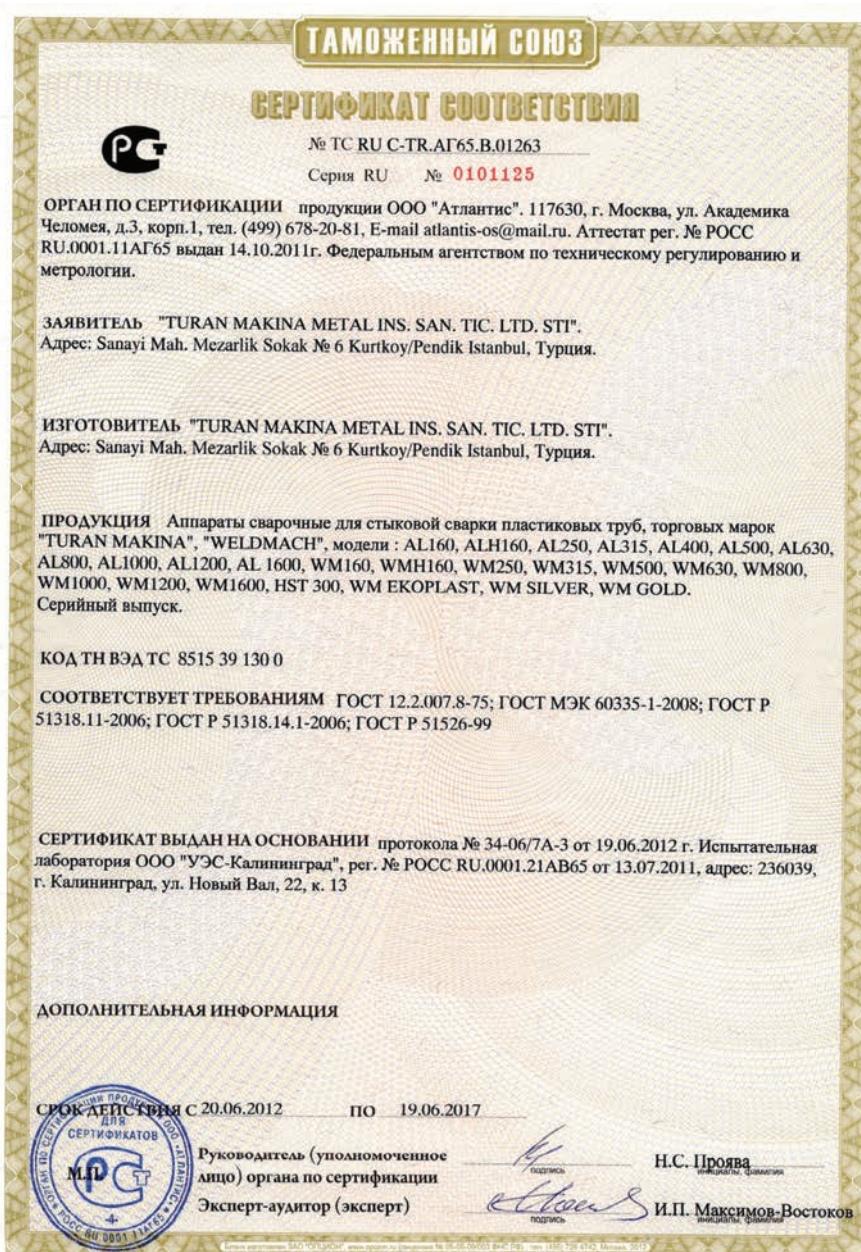


UDEM International Certification
Audit Training Cent. Ind. Co. Ltd.



Hereby, UDEM International Certification Audit Training Cent. Ind. Co. Ltd, certifies that the above stated company have the appropriate management system according to the requirements of the above standard. This certificate is valid for 3 years since the decision date as long as the system is effectively maintained and surveillance audits are carried out. The validity of the certificate can be checked through www.udemtld.com.tr, <http://www.jas-anz.com.au>. The certificate is the property of UDEM International Certification Audit Training Cent. Ind. Co. Ltd and shall be returned if requested.

Address: Mutlukent Mahallesi 2073 Sokak (Eski 93 Sokak) No:10 Çankaya – Ankara - TURKEY
Tel: +90 312 443 03 90 (pbx) **Fax:** +90 312 443 03 76
E-mail: info@udemtld.com.tr **Web:** www.udemtld.com.tr





AENOR

Asociación Española de
Normalización y Certificación

CERTIFICADO AENOR DE PRODUCTO N° 001 / 006318

AENOR PRODUCT CERTIFICATE N°

Pg. 1/3
2014-12-16

La Asociación Española de Normalización y Certificación (AENOR) certifica que el producto
The Spanish Association for Standardisation and Certification (AENOR) certifies that the product

ACCESORIOS DE POLIETILENO (PE)
PARA CONDUCCIÓN DE AGUA PARA CONSUMO HUMANO

POLYETHYLENE (PE) FITTINGS FOR WATER SUPPLY FOR HUMAN CONSUMPTION

detallado en la(s) página(s) siguiente(s),

detailed in the following page(s),

suministrado por

supplied by

TURAN MAKINA PLASTIK BORU SİSTEMLERİ A.S.
SANAYİ MAHALLESİ ADIGÜZEL SOKAK, NO: 6
KURTKÖY PENDİK İSTANBUL (Turquía)

y elaborado en

and manufactured in

SANAYİ MAHALLESİ ADIGÜZEL SOKAK, NO: 6
KURTKÖY PENDİK İSTANBUL (Turquía)

es conforme con

complies with

UNE-EN 12201-1:2012 (EN 12201-1:2011)

UNE-EN 12201-3:2012+A1:2013 (EN 12201-3:2011+A1:2012)

Para conceder este Certificado, AENOR ha ensayado el producto y ha comprobado el sistema de la calidad aplicado para su elaboración. AENOR realiza estas actividades periódicamente mientras el Certificado no haya sido anulado, según se establece en el Reglamento Particular RP 01.70.

In order to grant this Certificate, AENOR has tested the product and has verified the quality system used in its manufacture. AENOR performs these tasks periodically while the Certificate has not been cancelled, in accordance with the stipulations of the Specific Rules RP 01.70.

Fecha de concesión: 2014-12-16
First issued on:

Fecha de caducidad: 2019-06-03
Expires on:



Avelino BRITO MARQUINA
Director General de AENOR
Chief Executive Officer

Este certificado anula y sustituye al certificado 001/006229, de fecha 2014-06-03.
No está autorizada la reproducción parcial de este documento.

This certificate supersedes certificate 001/006229, dated 2014-06-03.
The partial reproduction of this document is not permitted.

AENOR - Génova, 6 - 28004 MADRID - Teléfono 914 32 60 00 - Telefax 913 10 46 83

Approval Number: 1604526
Test Report: M 106143



27th June 2016

Turan Makina Plastik Boru Sistemleri A.Ş.
Sanayi Mah. Adıgizel Sok. 6,
Kurtköy Pendik,
İstanbul,
Turkey

Water Regulations Advisory Scheme Ltd.
Unit 13,
Willow Road,
Pen y Fan Industrial Estate,
Crumlin,
Gwent,
NP11 4EG

**WATER REGULATIONS ADVISORY SCHEME LTD. (WRAS)
MATERIAL APPROVAL**

The material referred to in this letter is suitable for contact with wholesome water for domestic purposes having met the requirements of BS6920-1:2000 and/or 2014 'Suitability of non-metallic products for use in contact with water intended for human consumption with regard to their effect on the quality of the water'.

The reference relates solely to its effect on the quality of the water with which it may come into contact and does not signify the approval of its mechanical or physical properties for any use.

POLYETHYLENE - MATERIAL ONLY.

5245

'BORFIT'. Black coloured, injection moulded polyethylene sheet material. For use with water up to 23°C.

APPROVAL NUMBER: 1604526

APPROVAL HOLDER: TURAN MAKINA PLASTIK BORU SISTEMLERİ A.Ş.

The Scheme reserves the right to review approval.

Approval 1604526 is valid between April 2016 and April 2021

An entry, as above, will accordingly be included in the Water Fittings Directory on-line under the section headed, "Materials which have passed full tests of effect on water quality".

The Directory may be found at: www.wrás.co.uk/directory

Yours faithfully

Jason Furnival
Approvals & Enquiries Manager
Water Regulations Advisory Scheme

GARANTİ BELGESİ

1. Garanti süresi, malın teslim tarihinden başlar ve 1 yıldır.
2. Malın bütün parçaları dahil olmak üzere tamamı firmamızın garantisini kapsamındadır.
3. Malın garanti süresi içerisinde, gerek malzeme ve işçilik, gerekse montaj hatalarından dolayı arızalanması halinde, işçilik masrafı, değiştirilen parça bedeli yada başka herhangi bir ad altında hiçbir ücret talep etmeksiz tamiri yapılacaktır.
4. Malın kullanma kılavuzunda yer alan hususlara aykırı kullanılmasından kaynaklanan arızalar garanti kapsamı dışındadır.

**MALIN
CİNSİ** :
MARKASI :
MODELİ :
BANDROL VE SERİ NO :
TESLİM TARİHİ VE YERİ :

Kaşe



BUTT WELDING MACHINES GUARANTEE CONDITIONS

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2. The warranty claims covered during the guarantee period only relate to the replacement of defect parts arising from the production.

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PURCHASER DETAILS:

Company name:

Legal address:

PRODUCT DETAILS:

Description:
BUTT WELDING MACHINE
for HDPE PIPES

Code: AL250

Brand: TALKA

Model:

Serial No.:

Gross weight: 256 KG

Packing size: 100*102 *79 CM

Packing quantity: 1 WOODEN BOX
Trimmer: 220V – 0,75 kW MOTOR
Heater: 220V – 3000W RESISTANCE

Generator required: 6,5 KVA

Delivery date:

Guarantee period: 1 YEAR

Stamp / Sign:

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BORFIT Boru ve Ek Parçaları San. Tic.Ltd.Şti

Sanayi Mah. Orhanlı Yolu Cd. Mezarlık Sk. No: 6 Kurköy / Pendik

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	<p>BUTT WELDING MACHINES GUARANTEE CONDITIONS</p> <p>1. BORFIT guarantees you, the initial purchaser, a guarantee period of 1 year from the date of purchase.</p> <p>2. The warranty claims covered during the guarantee period only relate to the replacement of defect parts arising from the production.</p> <p>3. In order to file a claim under the terms of the guarantee, it is mandatory that the defect parts will be handed over to BORFIT when required.</p> <p>4. Guarantee claims cannot be considered, if the model number and/or the serial number has been altered, deleted, duplicated, removed or is unrecognisable.</p> <p>5. This guarantee excludes damage through misuse, inappropriate usage, negligence, lack of care and, in addition, damage caused by modifications or repairs carried out by unauthorised persons.</p> <p>6. Should you require to repair the product after the legal guarantee period has expired, which is not covered by the guarantee, then BORFIT maintains the right to charge a fee for the repair at its own discretion, or to refer these repairs to an authorised third party.</p>	<p>PURCHASER DETAILS:</p> <p>Company name: _____</p> <p>Legal address: _____</p> <p>Stamp / Sign: _____</p>	<p>PRODUCT DETAILS:</p> <p>Description: BUTT WELDING MACHINE for HDPE PIPES</p> <p>Code: AL315 Brand: TALKA Model: _____</p> <p>Serial No.: _____</p> <p>Gross weight: 296 KG Packing size: 100 *112 *90 CM Packing quantity: 1 WOODEN BOX Trimmer: 220V - 0,75 kW MOTOR Heater: 220V - 3500W RESISTANCE Generator required: 8 KVA</p> <p>Delivery date: : _____ Guarantee period: 1 YEAR</p> <p>www.turannmak.com TURAN Mak. Met. San.Tic.Ltd.Şti. BORFIT Boru ve Ek Parçaları San. Tic.Ltd.Şti Sanayi Mah. Orhanlı Yolu Cd. Mezarlık Sk. No: 6 Kurköy / Pendik İstanbul - TÜRKİYE Tel :+90 216 595 07 51 Fax :+90 216 595 07 52 E-mail: info@turannmak.com</p> 
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	BUTT WELDING MACHINES GUARANTEE CONDITIONS	<u>PRODUCT DETAILS:</u>
		<p>Description: BUTT WELDING MACHINE for HDPE PIPES</p> <p>Code: AL400 Brand: TALKA Model:</p> <p>Serial No.: Gross weight: 365 KG Packing size: 117,5 * 156,5 * 98,5 CM Packing quantity: 1 WOODEN BOX Trimmer: 380V - 1,1 kW MOTOR Heater: 380V - 4500W RESISTANCE Generator required: 10 KVA</p> <p>Delivery date: : Guarantee period: 1 YEAR</p> <p>Stamp / Sign:</p>
	<p>1. BORFIT guarantees you, the initial purchaser, a guarantee period of 1 year from the date of purchase.</p> <p>2. The warranty claims covered during the guarantee period only relate to the replacement of defect parts arising from the production.</p> <p>3. In order to file a claim under the terms of the guarantee, it is mandatory that the defect parts will be handed over to BORFIT when required.</p> <p>4. Guarantee claims cannot be considered, if the model number and/or the serial number has been altered, deleted, duplicated, removed or is unrecognisable.</p> <p>5. This guarantee excludes damage through misuse, inappropriate usage, negligence, lack of care and, in addition, damage caused by modifications or repairs carried out by unauthorised persons.</p> <p>6. Should you require to repair the product after the legal guarantee period has expired, which is not covered by the guarantee, then BORFIT maintains the right to charge a fee for the repair at its own discretion, or to refer these repairs to an authorised third party.</p>	<p><u>PURCHASER DETAILS:</u></p> <p>Company name: <input type="text"/></p> <p>Legal address: <input type="text"/></p> <p>www.turannmak.com TURAN Mak. Met. San.Tic.Ltd.Şti. BORFIT Boru ve Ek Parçaları San. Tic.Ltd.Şti Sanayi Mah. Orhanlı Yolu Cd. Mezarlık Sk. No: 6 Kurkoy / Pendik İstanbul - TÜRKİYE Tel :+90 216 595 07 51 Fax :+90 216 595 07 52 E-mail: info@turannmak.com</p> 



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PURCHASER DETAILS:

Company name:

Legal address:

PRODUCT DETAILS:

Description:
BUTT WELDING MACHINE
for HDPE PIPES

Code: AL500

Brand: TALKA

Model:

Serial No.:

Gross weight: 492 KG

Packing size: 97 * 155 * 105 CM

Packing quantity: 1 WOODEN BOX

Trimmer: 380V - 1,1 kW MOTOR

Heater: 380V - 5500 W RESISTANCE

Generator required: 12 KVA

Delivery date: :

Guarantee period: 1 YEAR

Stamp / Sign:

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PURCHASER DETAILS:

Company name:

Legal address:

PRODUCT DETAILS:

Description:
BUTT WELDING MACHINE
for HDPE PIPES

Code: AL630

Brand: TALKA

Model:

Serial No.:

Gross weight: 479 KG

Gross weight: 304 KG

Packing size: 105 * 167 * 123 CM

Packing size: 77 * 127 * 149 CM

Packing quantity: 2 WOODEN BOX

Trimmer: 380V - 1,5 KW MOTOR

Heater: 380V - 7500W RESISTANCE

Generator required: 16 KVA

Delivery date: :

Guarantee period: 1 YEAR

Stamp / Sign:

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PURCHASER DETAILS:

Company name:

Legal address:

PRODUCT DETAILS:

Description:
BUTT WELDING MACHINE
for HDPE PIPES

Code: AL800

Brand: TALKA

Model:

Serial No.:

Gross weight: 480 KG

Gross weight: 459 KG

Gross weight: 250 KG

Packing size: 114*120*120 CM

Packing size: 162*80*142 CM

Packing size: 62*92*92 CM

Packing quantity: 3 WOODEN BOX

Trimmer: 380V - 1,5 kW MOTOR

Heater: 380V - 10000W RESISTANCE

Generator required: 21 KVA

Delivery date: :

Guarantee period: 1 YEAR

Stamp / Sign:

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PURCHASER DETAILS:

Company name:

Legal address:

PRODUCT DETAILS:

Description:
BUTT WELDING MACHINE
for HDPE PIPES

Code: AL1000

Brand: TALKA

Model:

Serial No.:

Gross weight: 1195 KG

Gross weight: 608 KG

Gross weight: 170 KG

Gross weight: 313 KG

Packing size: 137*180*153 CM

Packing size: 88*164*180 CM

Packing size: 75*94*104 CM

Packing size: 60*112*66 CM

Packing quantity: 4 WOODEN BOX

Trimmer: 380V - 3 KW MOTOR

Heater: 380V - 15000W RESISTANCE

Generator required: 32 KVA

Delivery date: :

Guarantee period: 1 YEAR

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PURCHASER DETAILS:

Company name:

Legal address:

PRODUCT DETAILS:

Description:
BUTT WELDING MACHINE
for HDPE PIPES

Code: AL1200

Brand: TALKA

Model:

Serial No.:

Gross weight: 1263 KG

Gross weight: 681 KG

Gross weight: 193 KG

Gross weight: 468 KG

Packing size: 150*180*150 CM

Packing size: 80*180*180 CM

Packing size: 66*76*82 CM

Packing size: 70*130*70 CM

Packing quantity: 4 WOODEN BOX

Trimmer: 380V - 3 KW MOTOR

Heater: 380V - 15000W RESISTANCE

Generator required: 32 KVA

Delivery date: :

Guarantee period: 1 YEAR

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PURCHASER DETAILS:

Company name:

Legal address:

PRODUCT DETAILS:

Description:
BUTT WELDING MACHINE
for HDPE PIPES

Code: AL1600

Brand: TALKA

Model:

Serial No.:

Gross weight: 1791 KG

Gross weight: 887 KG

Gross weight: 193 KG

Gross weight: 622 KG

Packing size: 225*218*235 CM

Packing size: 100*185*207 CM

Packing size: 66*76*82 CM

Packing size: 165*145*45 CM

Packing quantity: 4 WOODEN BOX

Trimmer: 380V - 3 KW MOTOR

Heater: 380V - 24000W RESISTANCE

Generator required: 50 KVA

Delivery date: :

Guarantee period: 1 YEAR

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TURAN BORFİT

TURAN MAKİNA PLASTİK BORU SİSTEMLERİ A.Ş.

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