

Operating manual for BARY

Plastic welding tool

”BARY” Swiss Made

Federal Inspectorate for Heavy Current Installations

Swiss Certification

Electrosuisse Swiss Certification Body ESTI

Switzerland (NEV / VEMV) and EU / EWR

**Application: for all plastics plastic
pipes and fittings of
PP / PE / PE-HD**



D

Wichtig !

Lesen Sie diese Bedienungsanleitung, bevor Sie mit dem “BARY” Schweissapparat arbeiten.

FR

Remarque !

Lisez ces instructions d’utilisation avant de travailler avec le poste de soudage “BARY”.

EN

Note!

Read this operating manual before using the “BARY” welding device.

IT

Avvertenza!

Leggere il presente manuale di istruzioni prima di utilizzare l’apparecchio per saldatura “BARY”.

Manufacturer's warranty 2 years

The Teflon coating on the plate and cable breakage due to improper handling of the welding apparatus "BARY" not covered by the liability the manufacturer's warranty.

Proper use

Proper use also includes observing the user guide and safety instructions as well as implementation of maintenance work. Therefore, always keep this user guide together with the welding tool and make sure that it is read and used by anyone who works with the tool.

If the tool is used for another purpose, any liability claims for damage to persons and property are excluded. In like manner, structural changes to the tool as well as improper use are forbidden.

1. Safety / warning information

This tool may be used by children from the age of 14 and in addition also by anyone with reduced physical, sensory or mental capabilities or a lack of experience and knowledge if they are supervised or have been instructed in connection with safe use of the tool and the danger resulting from it. Children may not play with the unit. Cleaning and user maintenance must not be carried out by children without supervision.

The tool was developed and manufactured according to the state of the art and has also been examined in accordance with accident prevention and electrical regulations. Nevertheless there is still a danger for your life and health in the event of mishandling, carelessness, inattentiveness and misuse. Therefore, always observe the given safety and warning information.

If the power cord of this tool is damaged, it must be replaced by the manufacturer or its customer service or a similarly qualified person in order to avoid any danger.

- 1.1 Only use the tool in a technically flawless condition, in accordance with its purpose and with safety and potential risks in mind.
- 1.2 Replace a damaged tool with a new one.
- 1.3 Only use the tool in ventilated rooms.
- 1.4 Make sure that children and unauthorised persons keep away from the workplace.

2. Attention!

- 2.1 This tool must be placed on its stand when not in use, and must be connected to a power outlet with protective earthing (protective earth connector).
- 2.2 Pull the power plug for all manipulations that are not part of the work (not in use, maintenance, ...).

3. Risk of burns! Risk of fire!

- 3.1 The tool must be always placed on the stand for safety reasons.
- 3.2 When putting the hot tool down, make sure that the heating element does not come into contact with combustible materials.
- 3.3 Only put the tool down on a fire-retarding underlay.
- 3.4 Do not touch the tool when it is in operation or in the cooling phase.
- 3.5 Guide the power cord so that contact with the heating surface is not possible.

4. Danger to life!

- 4.1 Wet, water-bearing lines must not be welded.
- 4.2 Only use the welding tool when it is dry.

5. Cleaning! Explosion hazard! Only clean outdoors!

- 5.1 Pull the power plug for all manipulations that are not part of the work (not in use, maintenance / cleaning).
- 5.2 Do not use any chemicals because of residues that can be deposited in the weld seam. Never use steel wool or the like.
- 5.3 Dirty tools
Only clean the face (Teflon coating) with a clean cloth.
Warning, risk of fire!
Observe section 5. Clean when it is cold with a clean cloth with light gasoline. Afterwards grease lightly with a cloth.
(This is how to remove soot particles.)
Do not inhale any vapours when cleaning or starting the tool.

6. Operation and process description

- 6.1 Preheating the welding tool
When the power cord of the welding tool is connected to an outlet, the tool starts heating up. The tool requires ca. 5 - 10 minutes to heat up. When the target temperature is reached, the temperature regulator integrated in the tool cuts off the power supply (click). The thermostat regulates the set temperature with a tolerance of 2.5°C. The welding process can begin.
- 6.2 For butt welding, the bonding surfaces of the parts to be welded are evened out under pressure on the heating element. Afterwards, they are heated to the welding temperature with reduced pressure and joined together under pressure after removal of the heating element.

7. Preparation for welding

If you are working outdoors, make sure that the welding is not adversely effected by unfavourable ambient conditions. The welding point must be covered in the event of bad weather or strong sunlight. Set-up a welding tent if necessary. To prevent uncontrolled cooling of the weld point from draughts, seal the ends of the pipe. Pipe ends that are not round must be aligned before welding by heating them up carefully (hot air device). Only weld pipes and fittings of the same material and same wall thickness.

8. Processing the pipe ends

The pipe ends to be welded must be processed immediately before welding. The pipe ends must be cut at right angles and must be flat. If necessary, clean the end faces that are to be welded with a knife or scraper. The processed surfaces to be welded must not be touched again before welding.

9. Process steps for butt welding

For butt welding, the surfaces are heated up to the welding temperature by the heating element and then welded together under pressure after the heating element is removed. The heating element must be cleaned after each welding.

(Clean plastic residue off the Teflon with a clean cloth.)

10. Matching

During matching, the surfaces to be welded are pressed onto the heating element for as long as it takes to form a bead. When adjusting, for PE for example, a fusing pressure of 0.15 N/mm² must be applied. Matching has been completed when one bead has been formed around the entire circumference. The bead must project over the pipe circumference on all sides.

11. Conduct in the event of a malfunction

11.1 Heating element dirty (See cleaning in section 5)

11.2 Coating damaged

Electrical cause

11.3 Welding tool not plugged into the power outlet

11.4 Power cord defective

11.5 Power outlet defective

11.6 Tool defective (Return to the retailer or manufacturer)

Werner Riesen
Dittingerstrasse 45
4053 Basel

11.7 Service and warranty provision from manufacturer

11.8 Professional disposal

Technische Daten und Hinweise

Kunststoff - Schweissapparat

Handelsmarke: **“BARY”**

Protection class:	I	Schutzgrad:	IPX0	Certificate	ESTI	Netzstecker	CH
Handelsmarke	Durchmesser	Spannung	Leistung	Ausführung	Gewicht		
“BARY” A-6 abgewinkelt	120 mm	230 V, 50 Hz	400 W	Teflon aufgesintert	1,5 kg		
“BARY” A-1	190 mm	230 V, 50 Hz	500 W	Teflon aufgesintert	2,0 kg		
“BARY” A-1 abgewinkelt	190 mm	230 V, 50 Hz	500 W	Teflon aufgesintert	2,0 kg		
“BARY” A-1	190 mm	230 V, 50 Hz	500 W	Folie mit Rahmen	2,0 kg		
“BARY” A-1	190 mm	230 V, 50 Hz	500 W	Alu blank	2,0 kg		
“BARY” A-2	280 mm	230 V, 50 Hz	900 W	Teflon aufgesintert	3,2 kg		
“BARY” A-3	350 mm	230 V, 50 Hz	1600 W	Teflon aufgesintert			
“BARY” A R							Netzstecher CH oder D / I möglich

Zubehör:Gerätekoffer aus Holz: A -1 / A - 6 siehe Seite 1



Geräteständer

A -1 / A - 2 / A - 6 / AR



Halterung für Werkbank

A -1 / A - 2 / A - 6 / AR



Universal Halterung:

A -1

Sicherung:

Eingebauter Temperaturregler;
Werkseitig auf 220° C eingestellt. Toleranz 2° C
Um eine optimale Schweissung zu
garantieren, darf die Stellschraube (Temperaturregler)
an dem Werkzeug nicht verstellt werden !
Zulässige Umgebungstemperatur: ca. - 10°C bis + 40°C

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