

FRIAMAT®

15
31.07.18
12:11

FRIAMAT PRINT eco

29 °C
237 V
50 Hz

Enter barcode
Read



Operating instruction

FRIAMAT print eco



Contents

Page

| | |
|---|----------|
| 1. Preliminary remarks | 4 |
| 1.1 Safety instructions and hints | 4 |
| 1.2 Intended use | 4 |
| 2. Safety | 5 |
| 2.1 Functional reliability | 5 |
| 2.2 The operator's obligations | 5 |
| 2.3 Sources of danger | 6 |
| 2.4 Mains operation | 6 |
| 2.5 Generator operation | 7 |
| 2.6 Extension cable | 8 |
| 2.7 Opening the device | 8 |
| 2.8 Safety measures at the installation site | 8 |
| 2.9 Emergency | 8 |
| 3. Basic information | 9 |
| 3.1 Layout/parts | 9 |
| 3.2 Function keys explained | 10 |
| 3.3 Display | 11 |
| 3.4 Function key symbols explained | 12 |
| 3.5 Function status symbols explained | 12 |
| 3.6 Type plate | 12 |
| 3.7 Reader wand | 13 |
| 3.8 Barcode scanner | 13 |
| 3.9 Protective cap for data interface | 13 |
| 3.10 Temperature probe | 14 |
| 3.11 Fan functionality | 14 |
| 3.12 FRIAMAT preCHECK function | 14 |
| 3.13 Signalling devices | 15 |
| 3.14 Technical details | 15 |
| 3.15 Automatic activation of maintenance interval | 16 |
| 3.16 Transport/storage/dispatch | 16 |

Contents



Page

| | |
|---|-----------|
| 4. “Fusion” sequence | 17 |
| 4.1 Siting, connection, and startup | 17 |
| 4.2 Reading in the barcode | 18 |
| 4.3 Starting the fusion procedure | 19 |
| 5. FRIAMAT print eco | 20 |
| 5.1 “Basic settings” menu | 20 |
| 5.2 “Info” menu | 20 |
| 5.3 “Emergency Input” menu | 21 |
| 5.4 “Data” submenu | 21 |
| 5.4.1 “Transfer” submenu | 21 |
| 5.4.2 “Delete” submenu | 22 |
| 6. Warranty / maintenance / disposal | 23 |
| 6.1 Warranty | 23 |
| 6.2 Maintenance and care | 23 |
| 6.3 Disposal | 23 |
| 7. Error messages / warnings / info | 24 |
| 8. Annex | 27 |
| 8.1 Authorised service stations | 27 |
| 8.2 Updates to these operating instructions | 27 |

1. Preliminary remarks

1.1 Safety instructions and hints

In these operating instructions, the following symbols with warnings are used:

| Symbol | Meaning |
|---|--|
|  WARNING! | Danger to people. Failure to comply can result in death or serious injury. |
|  CAUTION! | Danger to people. Failure to comply can result in minor or moderate injury. |
| NOTE | Danger to objects. Failure to comply can result in objects damage. |
| INFORMATION | Application hints and other useful information. Failure to comply can not result in personal injury or objects damage. |

1.2 Intended use

FRIAMAT fusion units are designed to apply a maximum fusion voltage of 48 V on the following:

- FRIALEN® safety fittings with HDPE pressure pipes (SDR 17-7),
- FRIALEN® XL large pipe installations with HDPE pressure pipes (SDR 17-7), and
- FRIAFIT® sewage fittings with HDPE sewage pipes (SDR 17-33).

FRIAMAT fusion units can also be used on fittings from other manufacturers when these components bear a 24 digit barcode complying with ISO 13950:2007-03. The power ratings and technical data of both the fittings and the FRIAMAT fusion unit must be observed (see also Section 3.14 “Technical data”).

Intended use also includes adherence to:

- all of the instructions in these operating instructions,
- the general and specific processing specifications for electrofusion fittings, and
- the applicable accident prevention regulations, the environmental regulations, the statutory rules, the pertinent safety provisions, and all standards, laws, and directives applying in the country of use.

2. Safety

2.1 Functional reliability

FRIAMAT fusion units are state of the art, built in accordance with the requirements under ISO 12176-2 and the acknowledged safety standards and fitted with the required safety devices. Prior to delivery, FRIAMAT fusion units are tested for correct and safe functioning. Failure to operate or otherwise use the equipment properly will pose a danger to:

- the health of the operator,
- the FRIAMAT fusion unit or other property of the user, or
- the efficiency of work with the FRIAMAT fusion unit.

Safety considerations forbid the following:

- modifications and changes to the FRIAMAT fusion unit and
- working with FRIAMAT fusion units with broken lead seals. Failing to
- observe the above makes all warranty claims void.

2.2 The operator's obligations

Only trained personnel may work with the FRIAMAT fusion unit. In the work area, the operator is responsible for all third parties. The owner is obliged:

- to make the operating instructions accessible to the operator and
- to ensure that these instructions have been read and understood.

The operating instructions must be kept at all times at the device's place of use (ideally in the mesh pocket on the transport box). They must be accessible to the operator at all times.

2.3 Sources of danger



WARNING!

Electric shock from live parts! Danger of death!

- Never leave the FRIAMAT fusion unit unattended.
- Immediately replace damaged housings, connecting lines, and extension cables. Stop using the FRIAMAT fusion unit.
- Before all care and maintenance work, pull out the plug connecting the equipment.
- Maintenance and repair work must be performed by authorised Aliaxis Deutschland service stations only.
- Supply FRIAMAT fusion units only with the operating voltage specified on the ratings plate.
- Fit a residual current protective device (RCD) when this is prescribed.
- Do not remove or otherwise put safety installations out of operation.
- Immediately eliminate identified defects.



WARNING!

Danger of fire and explosion from highly flammable materials and potentially explosive atmospheres!

- Keep away from flammable liquids and gases.
- Do not use in potentially explosive atmospheres (e.g. in areas where flammable gases, solvent vapours, or ignitable dusts can accumulate).
- Never leave the FRIAMAT fusion unit unattended.

2.4 Mains operation

Out of doors (building sites), power outlets must be fitted with residual current protective devices (RCDs). The regulations governing RCDs must be observed here.

NOTE

Before commencing fusion, check the input voltage. The FRIAMAT fusion unit is designed for an input voltage range of 190-250 V!

2.5 Generator operation

NOTE

Only those generators must be used that have been designed for industrial use on building sites. The operating instructions for the generator must be observed!

The use of generators must comply with DVGW work sheet GW308, VDE 0100 Part 728, and the specifications and guidelines applying in the country of use.

INFORMATION

The rated power output required from the generator depends on the level needed for the largest fusion fitting, the connection conditions, the ambient conditions, the generator type, and its control characteristics. Generators from different series exhibit highly diverse control characteristics. The suitability of a specific generator, therefore, cannot be safeguarded even when it provides the required rated power output according to its technical data sheet.

In cases of doubt, e.g. when acquiring new equipment, contact our service hotline +49 (0)621 486-1533!

Use only those generators that operate with frequencies within 44-66 'Hz.

First start the generator, and let it run for half a minute. If necessary, adjust the no-load voltage, limiting it to the voltage specified in the technical data. The generator (mains) fuse must be at least 16 A (slow blow).

NOTE

During fusion, do not operate any other consumer from the same generator!

On finishing fusion work, first pull out the plug connecting the device to the generator, and then switch off the generator.

2.6 Extension cable

When using an extension cable, make sure it has an adequate conductor cross section:

- 2.5 mm² up to 50 m in length or
- 4 mm² up to 100 m in length.

NOTE

Danger of overheating in the extension cable!

The extension cable may be used only when it has been completely unwound and stretched out.

2.7 Opening the device



Electric shock from live parts! Danger of death!

- Never open the FRIAMAT fusion unit when it is supplied with operating voltage!
- FRIAMAT fusion units may be opened only by specialised personnel from an authorised Aliaxis Deutschland service station!

2.8 Safety measures at the installation site

The connecting and fusion cables must be protected against sharp edges. Do not expose the FRIAMAT fusion unit to heavy mechanical loads.

FRIAMAT fusion units are splash proof. They may not, however, be immersed in water.

2.9 Emergency

In emergencies, immediately set the main switch to OFF, and disconnect the FRIAMAT fusion unit from the voltage supply.

3. Basic information

3.1 Layout/parts



1 Main switch

2 Fusion cable with reader wand
or barcode scanner

3 Front foil with display
and function keys

4 Service interface (USB)
with protective cap

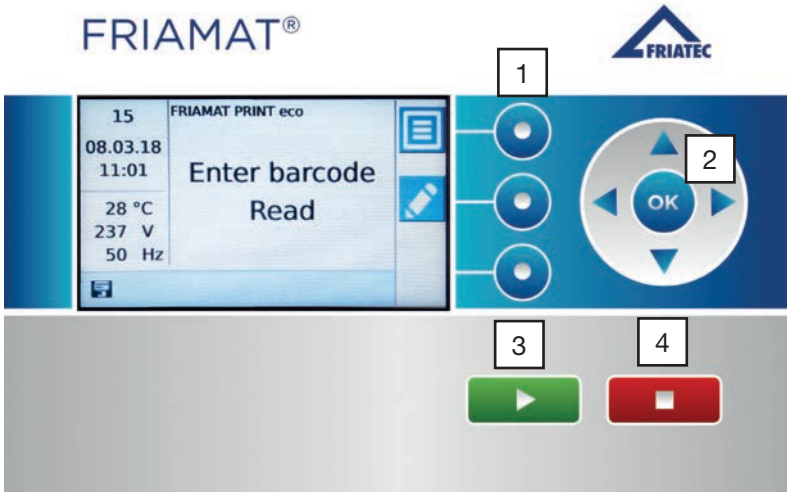
5 Ventilation slots (air outlet)

6 Adapter bag

7 Power cable

8 Ventilation slots (air intake)

3.2 Function keys explained



1 Function keys

The three blue function keys let you access the function key symbols shown on the display.

2 Direction keys

The direction keys (left/right/up/down) let you move the cursor through the menu structure. The selection is confirmed with OK or one of the function keys.

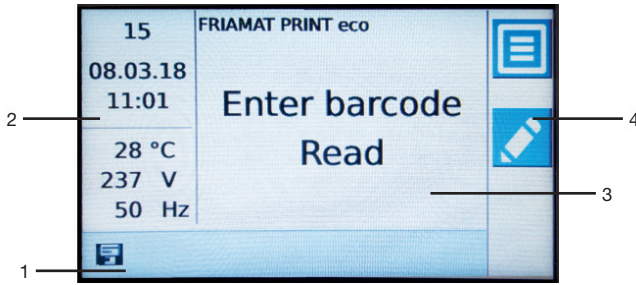
3 START key

The START key is used to start a fusion procedure. This key is also used to confirm messages on the display.

4 STOP key

The STOP key is used to abort a fusion procedure, to close sub- or individual menus, and to cancel an input (without saving).

3.3 Display



1 Function status symbols

Symbols appear representing the functions that can be activated at this time (e.g. documentation switched on, maintenance reminder). See also Section 3.5. Also shown is the next due maintenance (see also Section 6.2).

2 View ambient details / Current number

Key ambient details are shown (current number, date, time, ambient temperature, voltage, and frequency). The current number indicates the number of performed and logged fusions.








3 Main window

The main window presents all inputs and details in each of the menus.


4 Guide key symbols

This presents the functions that are activated at each of the blue guide keys. The symbols shown vary depending on the menu selected (see also Section 3.4).

3.4 Function key symbols explained

| Symbol | Designation | Description |
|---|-----------------------------|---|
|  | Menu key | This opens the main menu |
|  | Input / emergency input key | This lets you input a barcode manually, e.g. when it cannot be read. This opens a virtual keypad. |
|  | Confirm key | Depending on the context: OK, Confirm, Apply, Save, Select (a menu item) |
|  | Cancel key | This ends an input and closes the dialog without saving |
|  | Back key | This takes you one step back in a menu, sequence, or input (without changes) |
|  | Next key | This takes you to the next step in a sequence or input |
|  | Backspace key | This virtual key (emergency inputs) deletes the character to the left of the cursor. |

3.5 Function status symbols explained

| Symbol | Description |
|---|---|
|  | Maintenance date: This is the next due maintenance shown in days. |

3.6 Type plate

The type plate lists the details specific to the FRIAMAT fusion unit and its unique device number.

3.7 Reader wand

To read in fusion barcodes and traceability barcodes, place the reader wand under a slight angle (like a pencil) in front of the barcode on the fitting. Now move the reader wand quickly over the whole label and a little beyond. Barcodes can be read in from right to left or vice versa. When the barcode has been read in correctly, the device emits an acoustic signal to confirm this. If the barcode cannot be read in the first time, repeat the procedure, this time under a different angle or at a different speed.

NOTE

Protect the tip of the reader wand from dirt and damage!

The condition of the reader wand tip has a direct effect on the legibility of barcodes.

3.8 Barcode scanner

The barcode scanner reads in fusion barcodes and traceability barcodes without physical contact. All you need to do is aim at the barcode and press the read button. The barcode is scanned by means of a red light strip that must cross over the whole barcode, whenever possible at the centre. The barcode is not detected properly when the red light strip does not cross the whole barcode.

The optimal read results are obtained when the scanner is positioned at a small distance over the barcode. When the barcode is read in successfully, the device emits an acoustic signal.

NOTE

Protect the reading window from dirt and scratches!

The condition of the reading window has a direct effect on the capabilities of the FRIAMAT barcode scanner.

3.9 Protective cap for data interface

The USB port is found directly behind the protective cap. This data interface functions as a service port. The protective cap for the data interface must be screwed on at all times to prevent contaminants and moisture from reaching it.

3.10 Temperature probe

FRIAMAT fusion units can be used only on electrofusion fittings bearing a barcode. When this is read in, the microprocessor controlled FRIAMAT fusion unit regulates and monitors the supplied energy fully automatically and defines the fusion time as a function of the ambient temperature. This ambient temperature is continuously measured by the temperature probe on the fusion cable.

Make sure that both the temperature probe and the fusion fitting are exposed to the same ambient temperatures. Avoid adverse processing situations, e.g. where the probe is exposed to intense sunlight and the fitting is in the shade. The temperature probe must be protected against damage.

3.11 Fan functionality

How the fans function depends on the temperatures measured at the heat sink inside the FRIAMAT fusion unit. The fans switch ON automatically when the heat sink reaches a certain temperature. And this not only during, but also between fusion sessions, or after reactivation, depending on the load levels. This safeguards reliable operations in continuous duty and during fusion on large dimensions.

INFORMATION

Reduce cooling times!

In particular during series fusion work or work on fittings requiring high power levels, leave the FRIAMAT fusion unit switched ON after each fusion. The fans can then reduce the heat sink temperature.

3.12 FRIAMAT preCHECK function

Before every fusion process, the FRIAMAT calculates from the fitting parameters, the current device status, and the ambient temperature whether this fusion can be executed to the end. Not until then can the fusion be started, and performance related fusion stops are reliably prevented as a result.

3.13 Signalling devices

FRIAMAT fusion units confirm certain sequences of operations by emitting an acoustic signal (1, 2, 3, or 5 beeps). These signals mean the following:

- 1 beep means: Read barcode confirmed.
- 2 beeps mean: Fusion procedure ended.
- 3 beeps mean: Supply voltage too low / too high.
- 5 beeps mean: Error! See display!

INFORMATION

Adjust the volume!

The volume of these signals can be set to “high” or “low” in the “Basic Settings” menu. See also Sections 5.1.

3.14 Technical details

| Technical details* | FRIAMAT print eco |
|--|--|
| Input voltage range | AC 190 V – 250 V |
| Frequency range | 44 Hz...66 Hz |
| Input current | AC 16 A max. |
| Output | 3,5 kW |
| Generator rated output for fittings d 20 – d 160 d 180 – d 900 | ~ AC 2,4 kW ~ AC 5,0 kW |
| Unit fuse | 16 A slow blow |
| Housing | international protection IP 54 DIN EN 60529 protection class I DIN EN 60335-1 |
| Connecting cable | 5 m with contoured plug |
| Fusion cable | 4 m with fittings plug, ø 4 mm |
| Barcode type | code 2/5 interleaved according to ANSI HM 10.8 M-1983 and ISO CD 13950/08.94 |
| Operating temperature range** | -20°C...+50°C** |
| Fusion current monitoring | short circuit 110 A short circuit 1.70 x IN interrupt 0.25 x IN |
| Fusion voltage | max. DC 48V |
| Interface | USB |

| | |
|----------------------------|--|
| Log format | PDF |
| Log memory | 1,000 |
| Languages | Bulgarian, Croatian, Czech, Danish, Dutch, English, Estonian, Finnish, French, German, Hungarian, Italian, Latvian, Lithuanian, Polish, Portuguese, Romanian, Russian, Slovakian, Slovenian, Spanish, Swedish, Turkish |
| Dimensions W x D x H | 260 x 500 x 340 mm |
| Weight | approx. 18 kg |
| Accessories | operating instructions, transport box |
| Overvoltage classification | Category II |
| Certificate/quality | CE, ISO 9001, WEEE Reg. No. DE 49130851, RoHS, REACH |

*: Specifications subject to change.

** : Fusion work on fittings from other manufacturers must comply with their respective working temperature ranges!

3.15 Automatic activation of maintenance interval

The maintenance interval stored in the FRIAMAT fusion unit (default: 12 months, see also Section 7.2) is not activated automatically until after the first fusion.

INFORMATION

The leading maintenance date is always shown on the display and may differ from the details on the service label attached to the FRIAMAT fusion unit!

3.16 Transport/storage/dispatch

The FRIAMAT fusion unit is delivered in a transport box. This transport box keeps it dry and protected against moisture. The box should always be used to transport the device. The temperature range for storage is $-20\text{ }^{\circ}\text{C}$ to $+70\text{ }^{\circ}\text{C}$.

4. “Fusion” sequence

4.1 Siting, connection, and startup

Before every use, you should check that the FRIAMAT fusion unit is not damaged and operates properly within the specifications. All parts must be correctly installed and all conditions fulfilled. Only then can the device operate properly.

The FRIAMAT fusion unit can be sited and operated out of doors when it is protected against rain and moisture.

1. The FRIAMAT fusion unit must be sited on level ground.
2. Prepare the fitting and pipes for fusion in compliance with the assembly instructions.
3. Make sure that the fitting’s contact pins are accessible for connection to the fusion plugs.

NOTE

Danger of overheating in the cables!

Before use, all cables must always be unwound completely. This applies to the device, fusion, and extension cables.

4. Connect the device to the power supply (mains or generator).
To do so, insert the device’s plug into the socket.
5. If necessary, use an extension cable. Make sure that the conductor cross section is adequate (see also Section 2.6).
6. When operating with a generator, make sure that it is fused with at least 16 A (slow blow, see also Section 2.5).
7. When operating with a generator, first start the generator and let it warm up for 30 s.
8. Switch ON the FRIAMAT fusion unit at its main switch.

NOTE

Danger of scorching!

The contact areas on the fusion plugs and fitting must be clean. Soiled contacts can cause the plug to overheat, damaging it.

- If necessary, wipe clean of any contaminants.
- You must always protect the plugs against soiling.
- When a deposit has formed that cannot be removed completely, the fusion plugs must be replaced.
- First examine the fusion plugs and the fitting's insert contacts for soiling, then connect them.



CAUTION

Only original FRIATEC fusion plugs (art. no. 624529) may be used!

9. Connect the fusion plugs to the contact pins on the fitting.
10. The fusion plugs must be attached completely to the fitting's pins, i.e. over their whole internal contact length.

4.2 Reading in the barcode

1. Read in the barcode: use exclusively the barcode affixed to or provided with the contacted fitting.
2. If the barcode label is missing or damaged, you can use the barcode on an identical fitting from the same manufacturer and the same charge. In cases of doubt, contact the fitting manufacturer's hotline.

NOTE

It is forbidden to read in a replacement barcode on a different fitting!

3. Read in the barcode with a reader wand or barcode scanner (see also Sections 3.7 and 3.8).
4. A correctly read barcode is confirmed with an acoustic signal.

INFORMATION

When an acoustic signal is not emitted, examine the reader wand or barcode scanner for soiling or damage. If necessary, you can also perform the fusion in emergency input mode (see Section 5.3)!

4.3 Starting the fusion procedure



Danger of burning injury!

In rare cases, hot PE melt can exit when the fusion sequence malfunctions. A safety distance of at least 1 m must be kept from the fusion site.

NOTE

Do not connect any other consumers during fusion!

You can stop the fusion procedure at any time by pressing the STOP key. Fusion can be resumed after the fusion joint has cooled completely (and all causes of the fault have been eliminated). Observe here the processing instructions from the fitting manufacturer.

INFORMATION

When an acoustic signal is not emitted confirming the read-in process, examine the wand or barcode scanner for soiling or damage. If necessary, you can also perform the fusion in emergency input mode (see Sections 5.5 and 6.3)!

Operating step

1. **“Pipe Processed?”** appears on the display. When applicable, confirm this with the (START) or the (Next) function key.
2. The fitting data then appear again. These must be checked and confirmed by the user.
3. Press the (START) key to initiate the fusion procedure. The ambient temperature is measured, and the resistance of the connected fitting determined (“Check” appears on the display). The connected fitting and the FRIAMAT preCHECK function are now checked. On positive results, fusion starts automatically. The display shows the fusion progress. This shows in seconds the duration of fusion and the fusion time left.
4. “Fusion successful” on the display means: Fusion procedure has ended. “Fusion time nom” and “Fusion time act” mean nominal and actual fusion time and must agree.
5. Note the fusion parameters on the pipe/fitting. This also serves to prevent double fusions.
6. “Fusion successful” with “Fusion time nom” and “Fusion time act” must always be acknowledged with OK or, alternatively, with the START or STOP key. The fusion procedure has ended, and the FRIAMAT fusion unit is ready for the next fusion.

5. FRIAMAT print eco

5.1 “Basic settings” menu

The function key in the main menu opens the submenu “**Basic settings**”. Here you can edit the device settings.

DOCUMENTATION

DATE and TIME

* SYSTEM LANGUAGE *

LOG LANGUAGE

VOLUME

1. Press the (Menu) function key. This opens the main menu.
2. Press the direction keys to open the “Basic Settings” submenu.
3. Press the (Confirm) function key or OK.
4. Use the direction keys to open each menu for documentation, time and date, system language, log language, and volume.
5. Press the (Confirm) function key or OK.
6. Use the function and direction keys to make your changes and edit the settings.
7. Press the (Confirm) function key or OK to save your changes.

INFORMATION

The “Basic settings” menu contains the item “System language” preceded and followed by two asterisks. This lets you find the system language settings menu when the language was changed by accident.

5.2 “Info” menu

The corresponding function key (menu) opens the submenu "Info". Here you can request device information, device features and licenses.

DEVICE INFORMATION

DEVICE FEATURES

LICENSES

1. Press the (Menu) function key. This opens the main menu.
2. Press the direction keys to open the “Info” submenu.
3. Press the (Confirm) function key or OK.
4. Select single menu (device information, device features, licenses) with the direction keys.
5. Press the (Confirm) function key or OK.

Under "device information" the following requests can be displayed:

TYP
UNIT NUMBER
SW-HMI
SW-PU
MAINTENANCE DATE

Under the submenu "device features" function information can be displayed. Here are several functions listed which your FRIAMAT possess and execute. In addition, further functions can be displayed for which your FRIAMAT is prepared.

Under the submenu "Licences" you can check license information.

5.3 "Emergency Input" menu

The "Emergency Input" menu lets you enter the fusion barcode manually.

1. Press the (Input/Emergency Input) function key.
2. Enter each of the numbers from the first to the last in the barcode using the direction keys on the number pad now appearing. When finished, press OK.
3. Press the (Confirm) function key to save the entered numbers, the (Cancel) function key to abort the input, or the (Backspace) function key to delete preceding numbers.
4. If entered correctly, the number on the display is the same as the barcode read in with the wand or scanner.

| |
|---|
| <i>INFORMATION</i> |
| No numbers are shown when this function is used for the first time. Afterwards, the last barcode entered manually is always shown! |

5.4 "Data" submenu

| |
|--|
| <i>INFORMATION</i> |
| The "Data" submenu is first activated and hence shown on the display when documentation has been activated and the first data record saved! |

5.4.1 “Transfer” submenu

The submenu “**Transfer**” serves to transfer the fusion data from the FRIAMAT to a USB stick. The function key in the main menu opens the submenu “**Data**”.

TRANSFER
DELETE

1. Press the (Menu) function key. This opens the main menu.
2. Press the direction keys to open the “Data” submenu.
3. Press the (Confirm) function key or OK.
4. Press the direction keys to open the “Transfer”.
5. The display prompts the operator to plug a USB stick into the USB port.
6. Pressing the (Confirm) function key initiates the data transfer and shows a progress bar.

The data output to the USB stick are written as a PDF file to a subdirectory named as follows: F+device number (e.g. FR 18 67 123): F1867123.

The file names are made up of the current date and a two digit number incremented from 0. For example, the second printout (02) on 01/02/2018 (010218): 01021802.PDF.

The PDF files can be printed out directly with the right software (e.g. Acrobat Reader®) on a PC or laptop.

NOTE

Suitable USB sticks are commercially available FAT 32 compatible models holding up to 256 GB. The USB stick must be formatted to FAT 32 before use.

5.4.2 “Delete” submenu

The “**Delete**” submenu lets you delete all of the saved data.

6. Warranty / maintenance / disposal

6.1 Warranty

FRIAMAT fusion units come with a 24 month warranty.

6.2 Maintenance and care

In accordance with DVS 2208 Part 1 and BGV A3 (“Electrical systems and equipment”), nonstationary electrical equipment must be subjected to repeat tests **at least once a year**. This maintenance can be performed at Aliaxis Deutschland or one of its authorised service stations (see Section 8.1).

Also all connection adapters must be submitted for tests on the maintenance dates.

| What? | When? | Who? |
|---|------------------|---|
| Clean the reader wand or barcode scanner, and check for damage. | Daily | Operator |
| Check function. | Before every use | Operator |
| Check, and, if necessary, clean or exchange contacts. | Before every use | Operator |
| Factory maintenance | Yearly | Aliaxis Deutschland GmbH or authorised service stations |

6.3 Disposal

The European Directive 2002/96/EC on waste electrical and electronic equipment (WEEE) regulates the disposal of used electrical and electronic products. The WEEE Directive 2005 was implemented as the ElektroG on the German disposal sector. Under these laws, waste electrical and electronic equipment must be introduced to a proper disposal or recycling process. FRIAMAT fusion units fall under this European Directive and can be submitted for disposal to Aliaxis Deutschland GmbH or one of its authorised service stations.

Further regulations, standards, and directives applying in the country of use must be observed.

7. Error messages / warnings / info

Irregularities during fusion cause error messages or warnings to appear on the display of the FRIAMAT fusion unit.

INFORMATION

On the FRIAMAT print eco, press the function key to view the displayed error message in plain text!

INFORMATION

Should the FRIAMAT fusion unit output an error message or warning that is not listed in the following and that cannot be explained or remedied despite the plaintext description, contact our service hotline +49 (0)621 486-1533!

| No. | Displayed text | Meaning/causes | Remedy |
|-----|-------------------------------------|---|--|
| 02 | Temperature out of range | Ambient temperature outside of permitted range. | You may have to tent over or shield the fusion area |
| 03 | Resistance outside of tolerance | Fitting's electrical resistance outside of tolerance. | Check that contacts sit firmly and are clean. If necessary, clean contacts and replace the fitting. |
| 04 | Fitting's wire turn short circuited | Short circuit in the fitting's wire turn. | Replace fitting, and send it in for analysis. |
| 05 | Fitting's wire turn interrupted | Current flow interrupted | Check the connection between the fusion plug and the fitting. If OK, replace fitting, and send it in for analysis. |
| 06 | Voltage outside of tolerance | Deviation in fusion voltage too high. | Notify authorised service station. |
| 08 | Operating voltage out of range | Operating voltage outside of permitted range during fusion. | Extension too long, or cross section too small. Check voltage and connection conditions on the generator. |
| 09 | Frequency out of range | Frequency outside of permitted range during fusion. | Check frequency of generator voltage |

| No. | Displayed text | Meaning/causes | Remedy |
|---------------|---------------------------|--|---|
| 10 | Fusion stop | Fusion stopped at STOP key. | – |
| 12 | Device overheated | Protective function that prevents the device from overheating. | Let the device cool down. The fans reduce the temperature of the device when it is switched ON. |
| 13 | Operating voltage failure | Supply voltage interrupted (e.g. power failure during fusion) or too low. | Check connection conditions. |
| 14 | Power too low | Fitting's power input is too low. The FRIAMAT cannot provide such a low power. | Contact the Aliaxis Deutschland service hotline: +49 (0) 621 - 486 1533 |
| 15 | Power exceeded | The fitting's power input exceeds the capacity of the FRIAMAT. | Contact the Aliaxis Deutschland service hotline: +49 (0) 621 - 486 1533 |
| 17 - 19 | System error | | Contact the Aliaxis Deutschland service hotline: +49 (0) 621 - 486 1533 |
| 23 | Generator error | Generator possibly not suitable for fusion. | Contact the Aliaxis Deutschland service hotline: +49 (0) 621 - 486 1533 |
| 30 | Fan blocked or defective | | Contact the Aliaxis Deutschland service hotline: +49 (0) 621 - 486 1533 |

| Displayed text | Tip/remedy |
|------------------------------------|---|
| Attention! Double fusion! | Message is displayed when a fitting has been tried to fuse once again. Nevertheless, if you intend double fusion on a fitting, you must disconnect the fusion unit's pins from the fitting after the first fusion, and let it cool down (see the processing instructions issued by the fitting manufacturer). |
| Defect/incorrect barcode | Use a new barcode on an identical fitting, or correct the entered code manually. |
| Let the device cool down. | Protective function that prevents the device from overheating. Let the device cool down. The fans reduce the temperature of the device when it is switched ON. |
| Fusion stop | Fusion stopped at STOP key. |
| End of fusion | Fusion finished. |
| Checks | Checks on the fitting data and FRIAMAT preCHECK function. |
| Voltage ... V; frequency ... Hz | Adjust generator, and acknowledge at STOP key. |
| Maintenance date exceeded | Have the device serviced by Aliaxis Deutschland GmbH or an authorised service station. |

8. Annex

8.1 Authorised service stations

Please contact the Aliaxis Deutschland GmbH service hotline +49 (0)621 486-1533 for service stations worldwide.

8.2 Updates to these operating instructions

The technical information contained in these operating instructions is examined regularly for currency. The date of the last revision is specified on every page.

The latest operating instructions can be viewed on the internet at www.friatools.de. The download section can be accessed via the navigation bar. This provides our updated operating instructions in the form of PDF documents. We shall also be pleased to send you these.

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