

: **MINI-Xtruder**
230

K03969
K04354

K04326
K04355



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1	4
2	4
2.1	5
2.2	5
2.3	5
2.4	5
2.5	5
2.6	7
2.7	7
3	7
3.1	7
3.2	7
3.3	7
4	8
4.1	8
4.2	8
4.3	8
4.4	9
4.5	9
5	10
5.1	10
5.2	10
5.3	11
5.4	11
5.4.1	11
5.4.2	12
5.4.3	12
5.4.4	13
5.4.5	13
5.4.6	14
5.4.7	15
5.4.8	15
5.5	16
5.5.1	16
5.5.2	17
5.5.3	17
5.5.4	17
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6	/	18
6.1	/	18
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7	-	19
8	20
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Konformitätserklärung des Herstellers
im Sinne der EG-Maschinenrichtlinie 98/37/EG Anhang II B,



EU machinery directive 98/37/EEC, Annex II B

MUNSCH Kunststoff-Schweißtechnik GmbH
Im Staudchen
D-56235 Ransbach-Baumbach

:
: MINI-Xtruder

- | | |
|--------------------------------------|-------------------------------|
| √ EU Machinery Directive 98/37/EC | √ EU EMC Directive 89/336/EEC |
| √ EN 61029-1 (VDE 0740 Part 500) | √ DIN EN 55014-1 |
| √ VDE 0701 Part 1 | √ DIN EN 55014-2 |
| √ VDE 0702 Part 1 | √ DIN EN ISO 12100-1 |
| √ EU Low Voltage Directive 73/23/EEC | √ DIN EN ISO 12100-2 |
| √ EN 60204-1 (VDE 0113 Part 1) | |

Ransbach-Baumbach, 2006

Stefan Munsch
Dipl.-Ing. Stefan Munsch,

1



Внимание

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Внимание

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2

EMC (),

(,)

2.1



Внимание (

DIN 4844-W 9).



(
DIN 4844-W 8).



2.2

2.3

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-
-
-

2.4

2.5

±5%

/ 2%
VDE°0100 §55,



()

230 (

230).

	MIN
19	4,0 ¹⁾
20-50	6,0 ¹⁾

¹⁾ 230

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-
-
-
-



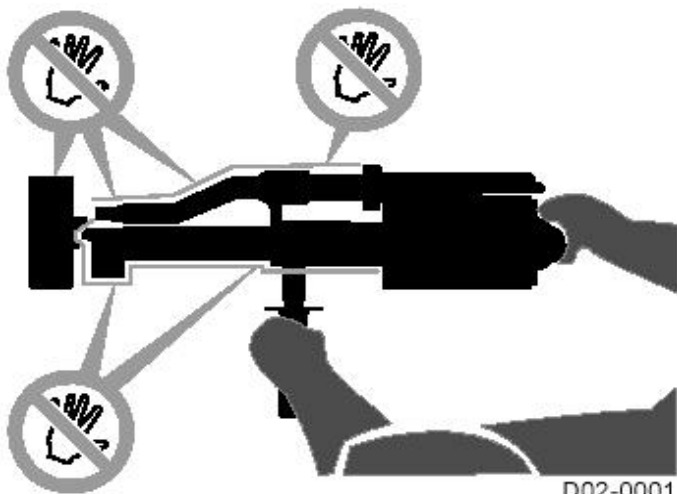
4-



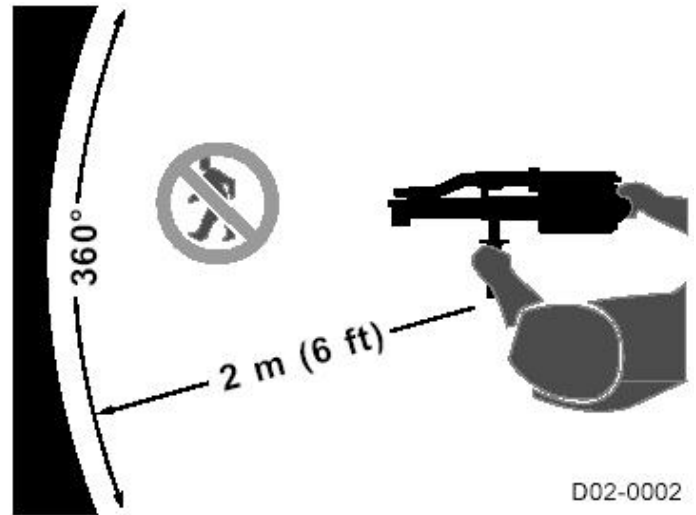


()

350°



D02-0001



D02-0002



() ()

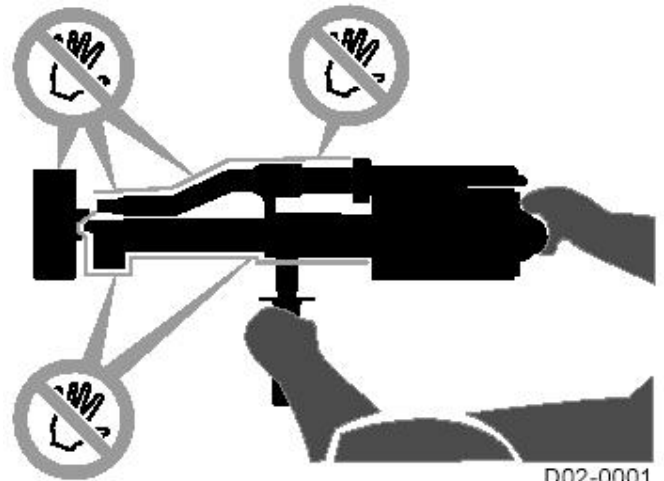


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2.6

VDE 0701 (IEC 335),



2.7

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3.2

3

3.1

3.3



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350°

4

4.1

MINI-Xtruder

PP (), PE-HD (), PVC-U (), PVC-C (), PVDF ()

100%.

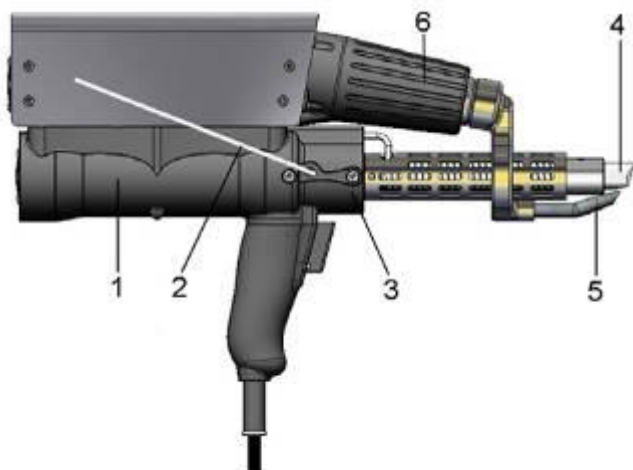
4%.

4.2



4.3

MINI-Xtruder – (Autoair).



(2) (3), (1) (4), (5) (6).



4.4

	MINI-Xtruder
	, , ,
	Ø3
. , /	0,6
.	1-10 ,
,	3,4
	230
	875
	2100
()	300 / 0,4
	- ;
	- ;
	-

4.5

	:		
-	MINI-Xtruder	1 .	- 1 .
-		1 .	- 1 .
-		1 .	- 1 .
-		3 .	

5

5.1

5.2

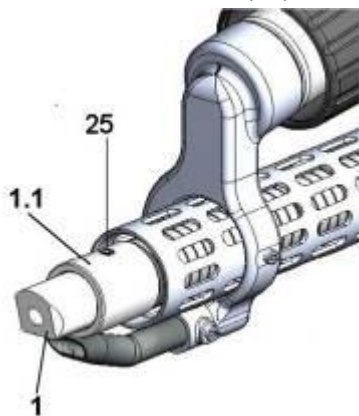


DVS 2207 (4).

(1.1)

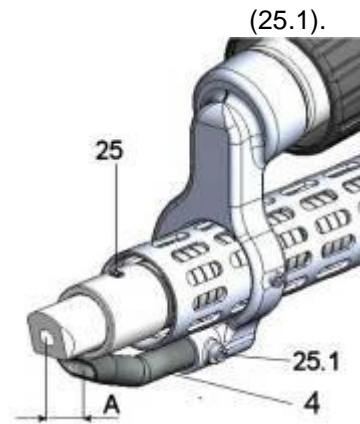
(1)

(25).

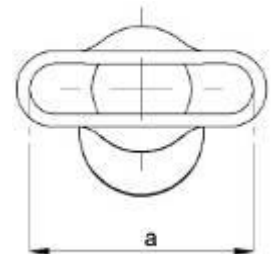


-
- =5
-

(4),

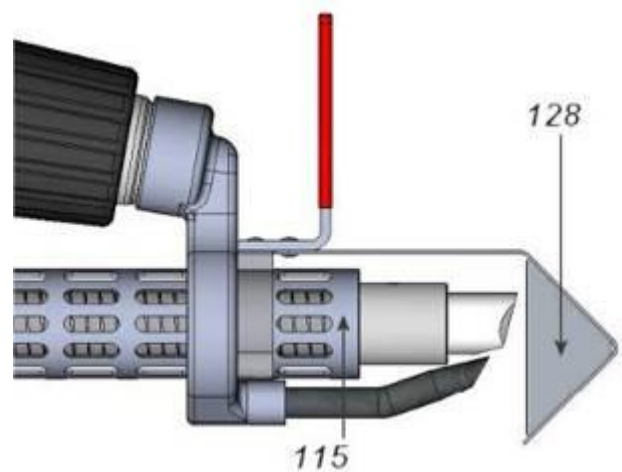


12
18



(115)

(128)



5.3

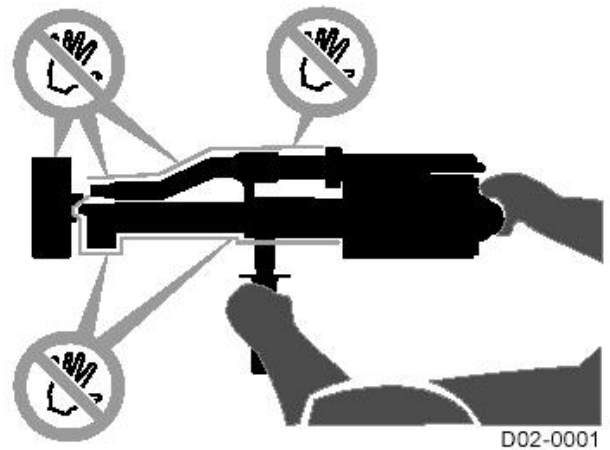


.5.4.2 « ».

.5.4.1. « ».

5-10

. 5.4.1. «



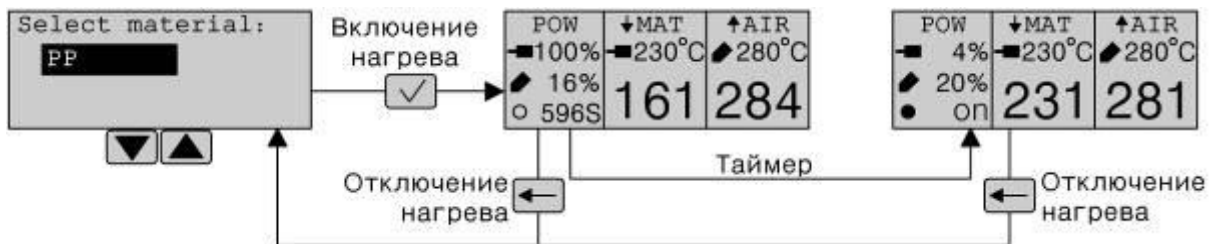
5.4

5.4.1

[]

[] « ».

[]



(. .5.4.8.):

TAir;

TAir ±.

TAir (. .).

TMat;

TMat ±.

TMat (. .).

[] « »

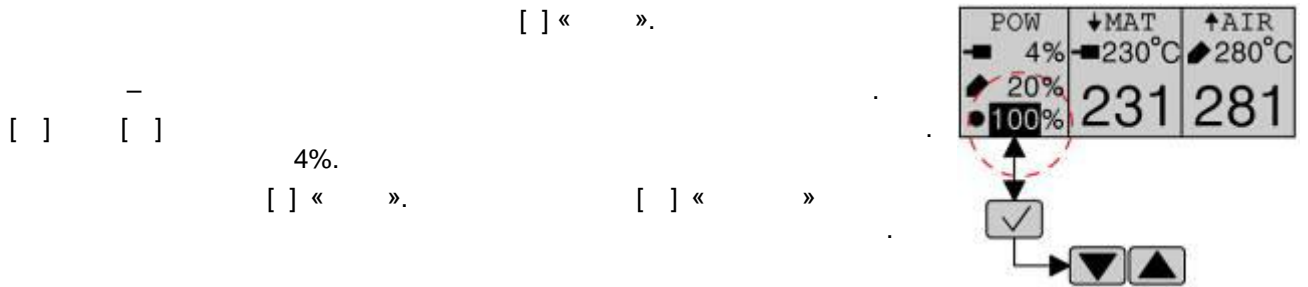
(.1),

1

	TMat, °	TMat ±, °	TAir, °	TAir ±, °
PP –	230	±20	280	±70
PE-HD –	230	±20	280	±70
PVC-U –	190	±20	300	±70
PVDF –	250	±20	300	±70

[] « »
(« »).

5.4.2



5.4.3

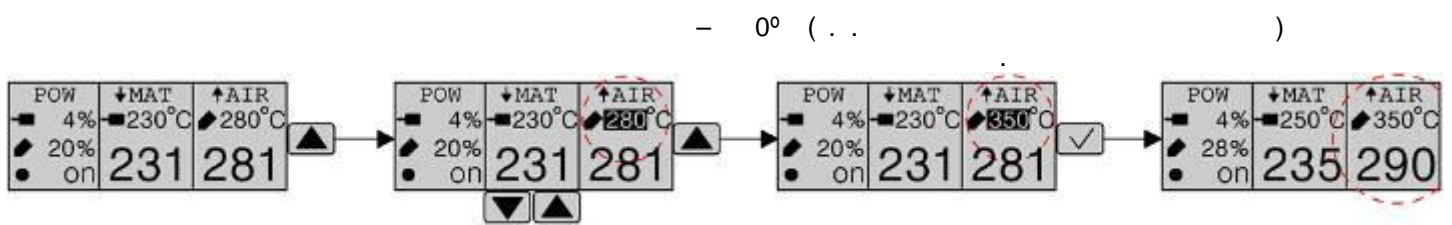
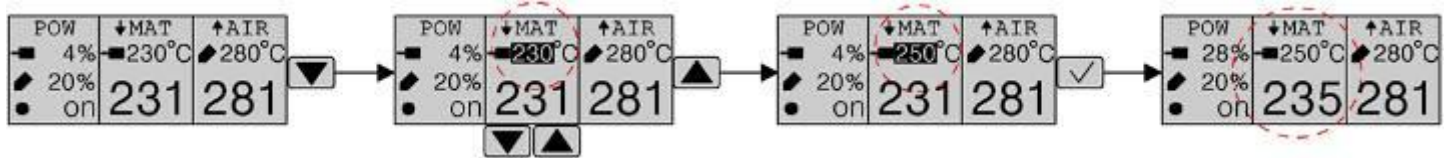
(,)

[] .

[] []

(.1, .5.4.1).

[] « »



5.4.4

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- [] « ».
- [] « », [].
- 3 .
- [] [] [] « ».

POW	↓MAT	↑AIR
■ 4%	■ 230°C	◆ 280°C
◆ 20%	231	281
● on		

✓ Короткое нажатие

POW	↓MAT	↑AIR
■ 4%	■ 230°C	◆ 280°C
◆ 20%	231	281
● 100%		

✓ ▾ Нажать и удерживать ~3 сек.

POW	↓MAT	↑AIR
■ 4%	■ 230°C	◆ 280°C
◆ 20%	231	281
● on		

POW	↓MAT	↑AIR
■ 4%	■ 245°C	◆ 280°C
◆ 20%	231	281
● on		

POW	↓MAT	↑AIR
■ 0%	■ 230°C	◆ 280°C
◆ 20%	245	281
● on		



« .5.4.8).

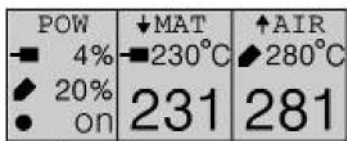
TMat » (.

(PP, PE, PVC-U PVDF)
TAir TMat .

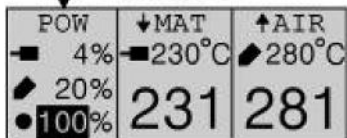
5.4.5

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-

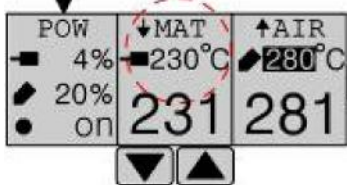
-
-
- [] « ».
- [] « », []
- 3
- [] [] [] « ».



✓ Короткое нажатие



✓ ▲ Нажать и удерживать ~3 сек.



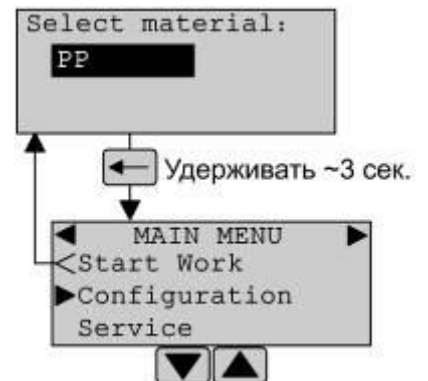
5.4.8). « TAir » (.

(PP, PE, PVC-U PVDF)
TAir TMat .

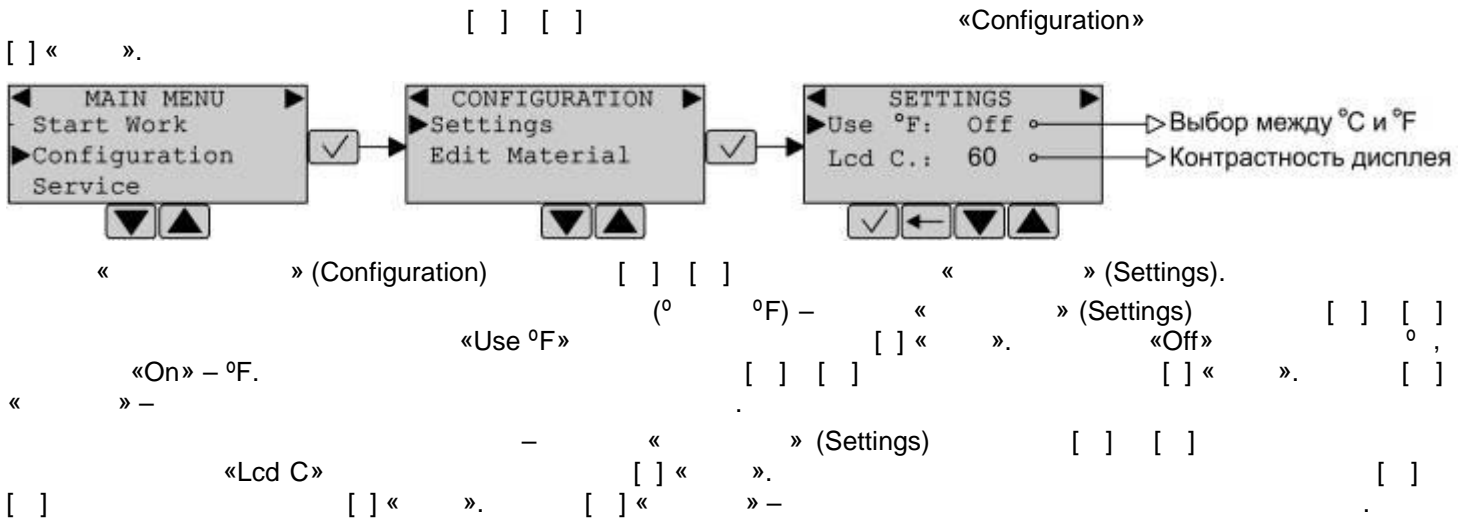
5.4.6

3 [] « ».

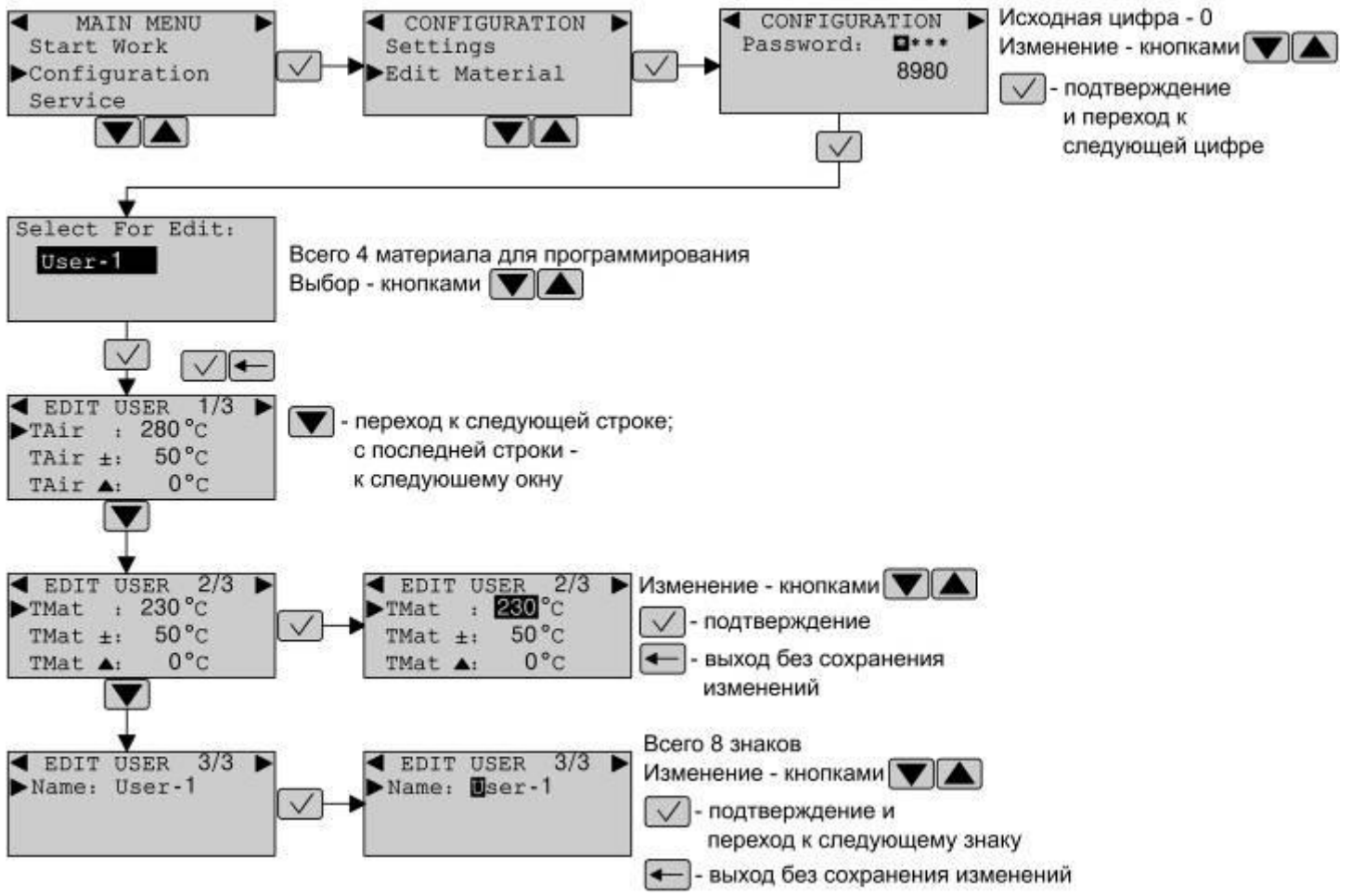
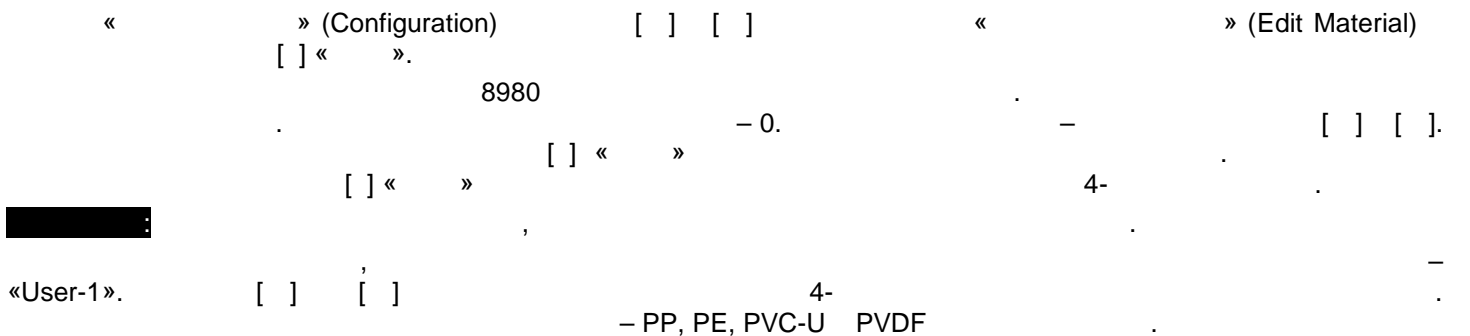
- « » (Start Work).
- « » (Configuration).
- « » (Service).



5.4.7



5.4.8



[] [] - , [] « ». 3- [] « ».

[] « ». [] « » - [] []

3 :

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- **TAir;**
- **TAir ±.** (. . 5.4.3).

2

- **TAir** (. .).
- **TMat;**
- **TMat ±.** (. . 5.4.3).

3

- **TMat** (. .).
- **User 1.** [] []. 8 [] « » [] « »

TAir TMat


5° , **TMat** -5° .

20° , **TMat** +20° . (. . _____) ,

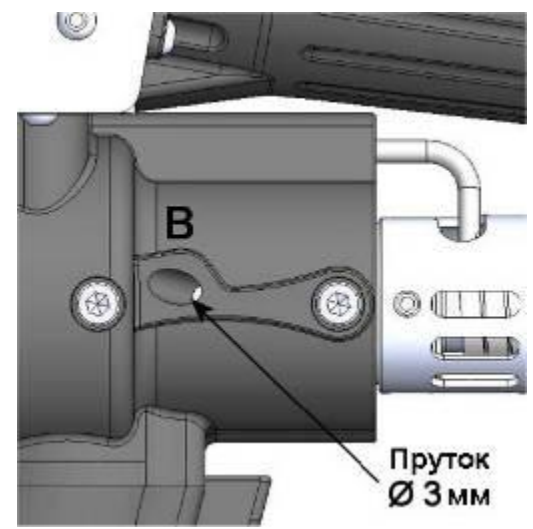
TAir TMat

5.5

5.5.1


Внимание

(Deutscher Verband für Schweißtechnik DVS).



Ø3 .

5.5.2

DVS



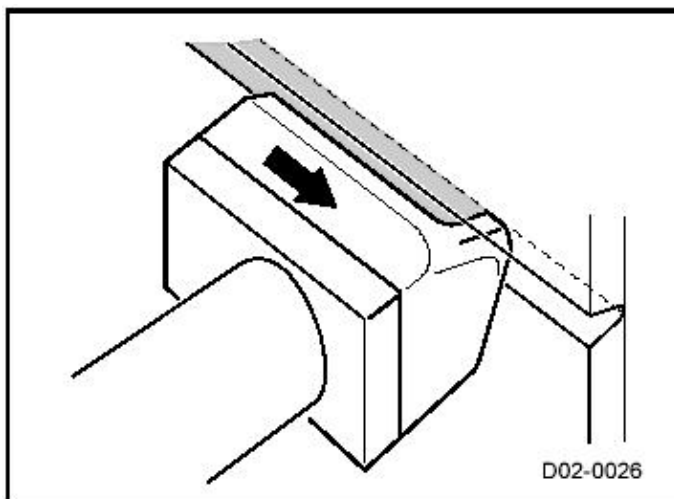
5.5.3

()

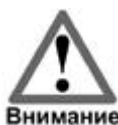
– DVS.

30-40 /

– 0,5



5.5.4



« ».



5.5.5

[] « ».

(5).



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6.1

MINI-Xtruder /



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3

(

VBG4);

6.2

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» « — «
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MUNSCH.

	4, 5, 6, 7, 8, 9, 11, 14, 15, 16, 17, 18, 20
	4, 5, 6, 7, 8, 9, 11, 14, 15, 16, 17, 18, 20
	1, 13, 14, 17
	1, 14, 17
	1, 11, 13
	13
	19, 4
	2, 3, 4, 15, 19
	2, 3, 6, 7, 11, 15, 19
	2, 3, 8, 11
	2, 3, 9, 19
	2, 3, 15, 16
	3, 10, 16

1		
2		1)
3		1)
4		
5		
6		
7		
8		
9		1)
10		1)
11	-	
12		- ; «)
13		; !
14		1)
15		1)
16		1)
17		. . .5.4.1, 5.4.2
18		
19	2)	1)
20		
21		

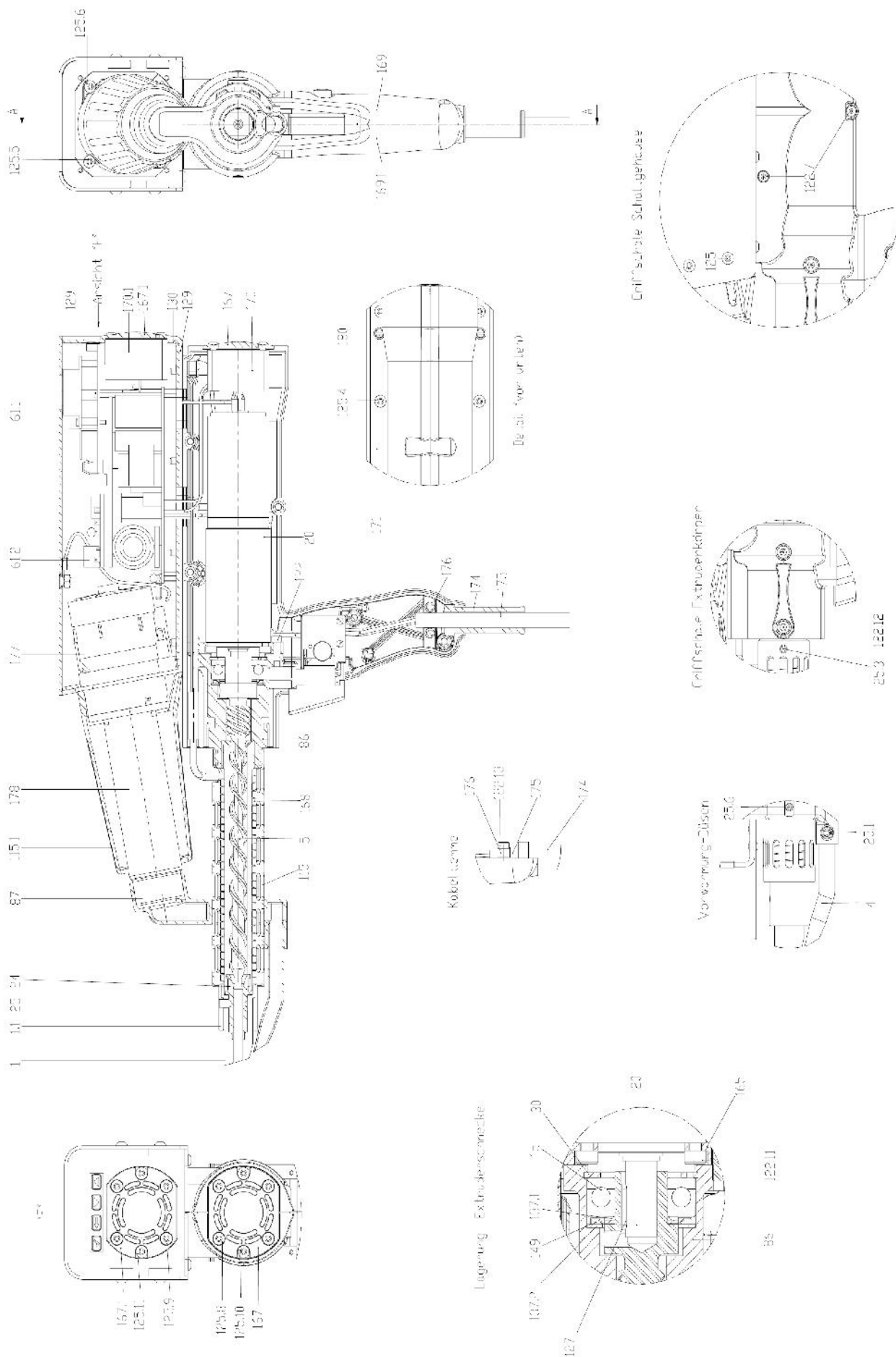
1) MUNSCH

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1.		4.
2.	12	5.
3.		5.1.
3.1.		5.2.
3.2.		5.3.
3.3.		5.4.
3.4.		5.5.
		5.6.
		5.7.
		6.
		7.
		.1.

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MINI-Xtruder, . K03969 K04180

1	K03884	
1.1	K03885	
4	K03898	
5	K03879	
15	K02669	-
20	K03890	
24	K03883	
25	K03956	
25.1	K03474	
25.3	K03474	
25.6	K03474	
30	K00657	
61.1	K03962	230
61.1	K04195	120
61.2	K03975	
86	K03880	
87	K03891	
115	K03886	
115.1	K03906	
122	K03477	
122.7	K00656	
122.11	K01454	
122.12	K03957	
122.13	K03477	
124.1	K04110	EBM13
125	K03411	
125.4	K03411	
125.5	K03411	
125.6	K03411	
125.7	K03411	
125.8	K03411	
125.9	K03411	
125.10	K03411	
125.11	K03411	
127	K00625	
128	K04199	
129	K03895	
130	K03896	
137.1	K03959	
137.2	K03958	
149	K03960	
155	K04152	
165	K03881	
166	K03882	
167	K03887	
167.1	K03887	
168	K03889	
169	K03892	,
169.1	K03892	,
170	K03894	
170.1	K03894	
171	K03897	
173	K03336	
174	K04137	
175	K04135	
176	K04136	
177	K03964	
178	K03965	230
178	K04179	120
180	K03283	
	K04153	