



SDF-250 STATIONARY SUBMERGED ARC WELDING POWDER DRYING OVEN

0700 100 000 THREE PHASE 400V AC 50/60Hz
0700 100 001 ONE PHASE 110V AC 50/60Hz

INSTRUCTION MANUAL FOR SUBMERGED ARC WELDING POWDER DRYING OVEN

USAGE PURPOSE

This product is designed to dry and hold the submerged arc welding powders at a certain temperature. Welding powders can be dried for the period recommended by the manufacturer, depending on the conditions. It should only be used in the intended use direction to avoid possible damage to property and injuries.

BEFORE USING

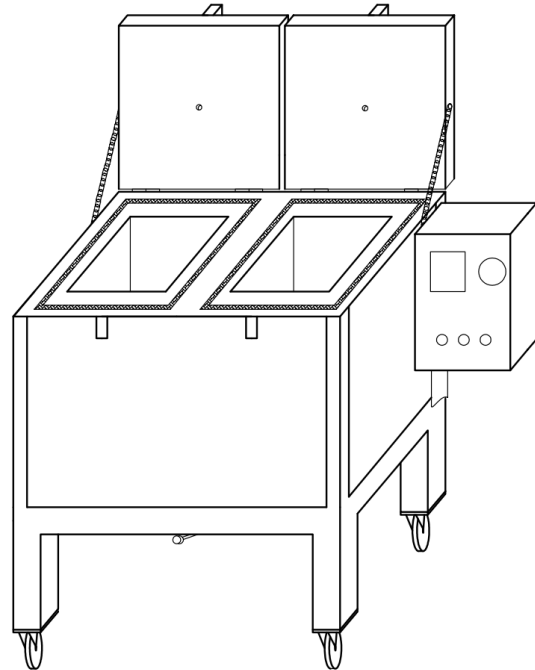
Make sure that the technical specification on the product corresponds to the electrical supply in your network. Check the voltage and frequency information. Check that there are no fault that will affect the operation of the product.

USAGE ENVIRONMENT

Flammable and explosive materials should not be around the device. The device it should not be covered. It should be run in a dry place. Never use it in the rain and wet ground.

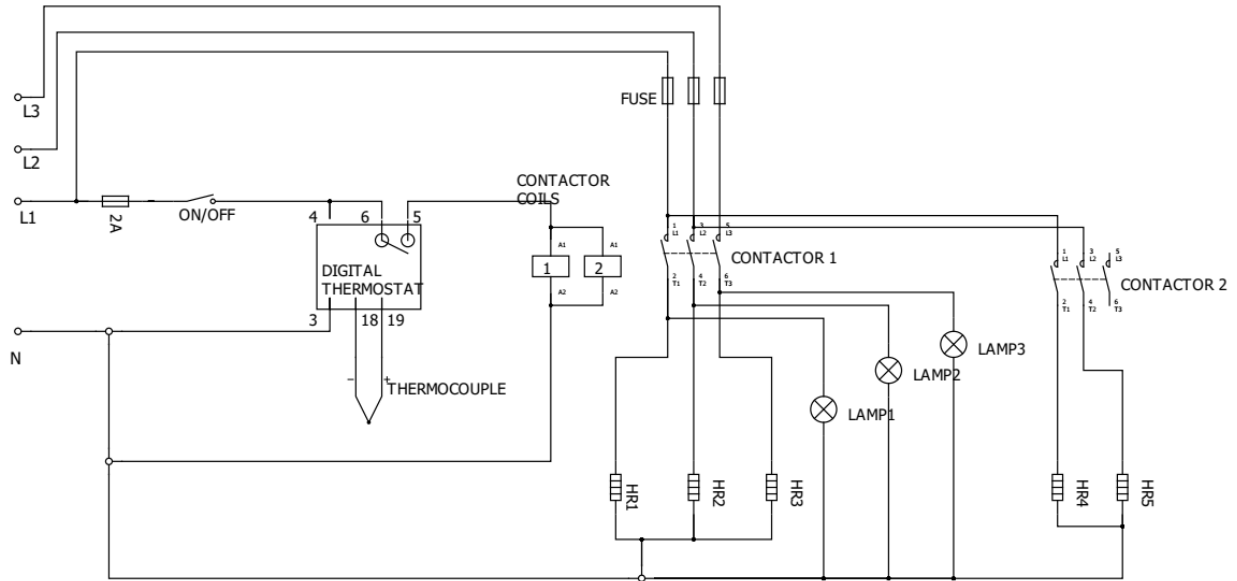
USING

Connect the appliance plug to the power supply by attaching a socket. Turn the switch to position (1) on the top of the main panel. To set the temperature above the Digital Controller; Press and hold the SET key for 2 seconds. Select the temperature with the Up and Down keys and press the SET key again. The device will automatically switch off the heating when it reaches the desired temperature. The three pilot lamps (side-by-side) on the panel show three electrical phases. If one or two does not, there is a problem with your electricity line. 3 light should blink at the same moment. The lamps turn on during heating. If the oven has reached the desired temperature, the lamps will turn off. Charge of the welding powders into the top cover, do not put any other material, package, etc. from the welding powder into the chamber. Leave a little high to hard to close the door. The lock will be fully seated. When you want to use the welding powders, pull the lower arm than powder will discharge into a bucket. When the bucket is full push back the arm. If you are not using the oven, turn the switch to position (0) and unplug it. Some surfaces may be hot to the touch, use heat resistant fireproof gloves. Do not touch live parts with electrical shock hazard.



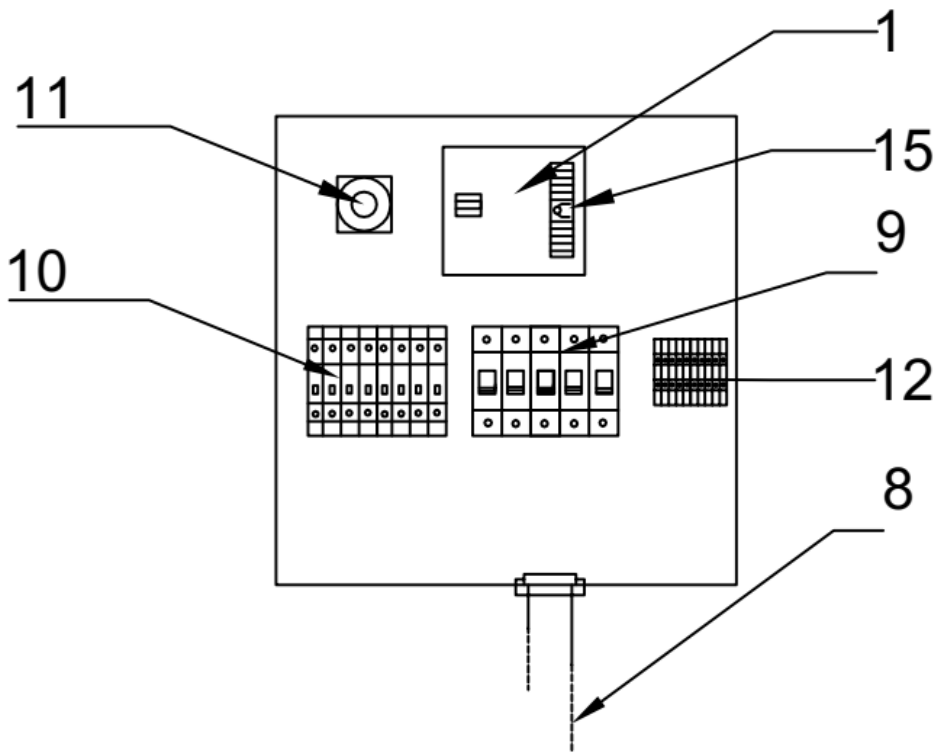
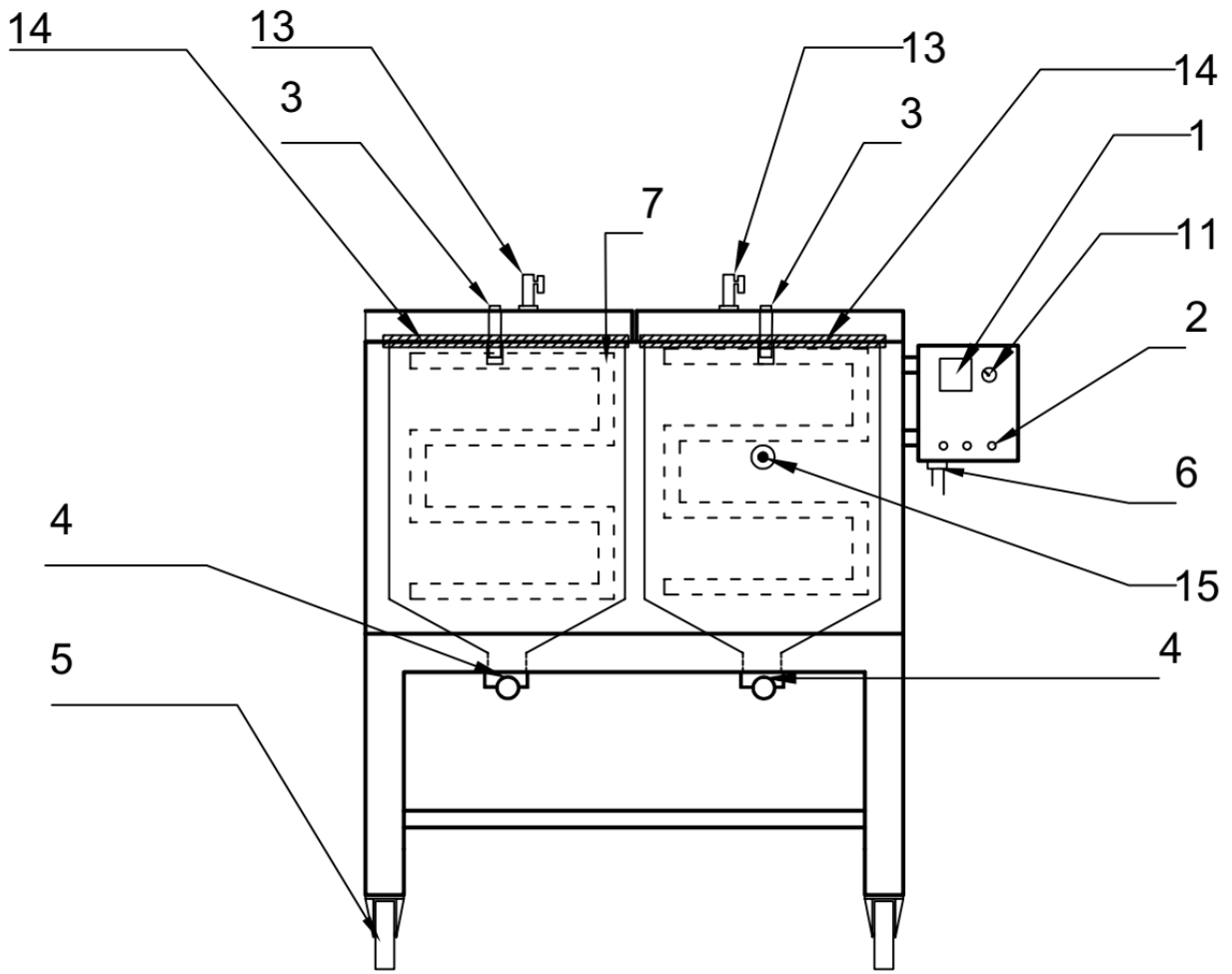
SDF-250 Technical Information	
Capacity	250 Kg (551 lb) Flux
Voltage	3 ph 400V, 3ph 230V 50/60Hz
Power	7.500 W
Temperature	0-400 °C (32-752 °F) Digital Thermostate
Storage Size L-W-H	2 pcs 45x51x60 cm, 17,71x20,07x23,62 in
Outer Dimensions	162x82x145 cm, 63.77x32,28x57,08 in
Weight	230 kg (507 lb)

SCHEMATIC DIAGRAM OF SDF-250



SPARE PARTS LIST

ITEM NO	QTY	ORDERING NO	DESCRIPTION	NOTES
1	1	0700 100 002	Digital Thermostate	DT-109A
2	3	0700 100 003	Signal Lamp	220V
2	3	0700 100 004	Signal Lamp	110V
3	1	0700 100 006	Door Handle	
4	1	0700 100 007	Puller Arm	
5	2	0700 100 008	Castors without Brake	Back
5	2	0700 100 009	Castors with Brake	Front
6	1	0700 100 031	Cable Gland	
7	2	0700 100 011	Heating Element	220V
7	2	0700 100 012	Heating Element	110V
8	1	0700 100 013	Power cable with plug	CEE 5x32A 400V plug
8	1	0700 100 014	Power cable with plug	110V
9	1	0700 100 015	Fuse (automatic)	10A
9	1	0700 100 016	Fuse (automatic)	2A
10	2	0700 100 017	Contactor 220V UNI	220V
10	2	0700 100 023	Contactor 110V UNI	110V
11	1	0700 100 018	Power Switch	
12	1	0700 100 019	Terminal	set
13	1	0700 100 020	Air Valve	
14	1	0700 100 164	Fiberglass Wick	SDF-250
15	1	0700 100 165	Thermocouples	



CONTROL PANEL