

# V64SHP Butt Fusion Machine

RIYANG V64SHP manual or CNC controlled hydraulic operated butt fusion welding

machine is suitable for PE and PP pipes from 36" to 64" OD. It is featured:

- ◎Consists of basic frame, hydraulic unit, planing tool, heating plate, basket
  - ◎Standard welding range 64" DR 17 to 36" DR 11 with optional clamp inserts
  - ◎According to high pressure standard ASTM F2620 and ISO21307 single high pressure
  - ◎Reductions included: 60"x54", 54"x48", 48"x42", 42"x36"
  - ◎Electro hydraulic pump with controls and accumulator are mounted on the main frame.
- Includes countdown timers for heating and cooling phases
- ◎Aluminium PTFE coated heating plate with electronic temperature control.
  - ◎Welding can be carried out between clamps 3 & 4 for tees, bends and manifold work
  - ◎2years warranty
  - ◎Options: PLC control(CNC type), data logger, hydraulic operated clamps, hydraulic locking, stub end holder, other reductions size etc.

Model	V64SHP
Applicable material	PE, PP
Pipe size (OD)	36", 42", 48", 54", 60"
Ambient temperature	—5~45℃
Power supply	~380 V±10 %
Frequency	50 Hz
Total current	144 A
Total power	55 KW
Include: Heater plate	42 kW
Milling cutter motor	8 kW IP54
Hydraulic unit motor	5 kW IP54
Insulation resistance	>1MΩ
Max.working pressure	25 MPa
Cylinder area	135 cm <sup>2</sup>

Cylinder capacity		130 L
Hydraulic oil		40～50 (viscosity mm <sup>2</sup> /s, 40℃)
Noise level		<70 dB
Max.temperature of heating plate		270℃
Temperature deviation of heating plate		±7℃
Basic frame	Dimension,mm	3540X2600X2500
	Weight,kg	8600
Milling cutter	Dimension,mm	2490X280X2500
	Weight,kg	1500
Heater	Dimension,mm	2600X90X2250
	Weight,kg	600
Support for milling cutter and heater	Dimension,mm	2340X1700X2000
	Weight,kg	800
Total weight (kg)		≈ 11500

**Featured by:**

- \*Machine carriage designed "3+1" specially weld short spigot fittings
- \*Quick coupling origins from Italy
- \*Oil seal kit origin from Germany or Japan
- \*Newly designed control panel with all function buttons integrated
- \*Pressure valves origin from USA
- \*Electricity brand: Schneider
- \*Stable pressure performance and robust frame
- \*etc.....

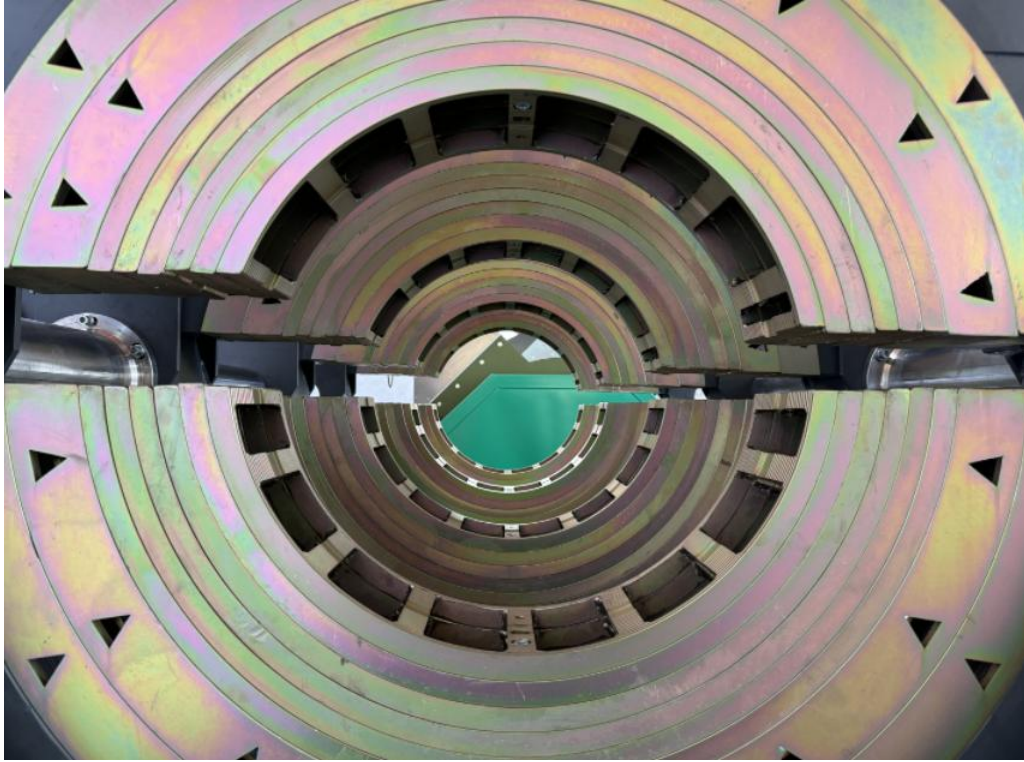
## Overview of RIYANG V64SHP Butt Fusion Machine



(With hydraulic clamps and hydraulic locking)



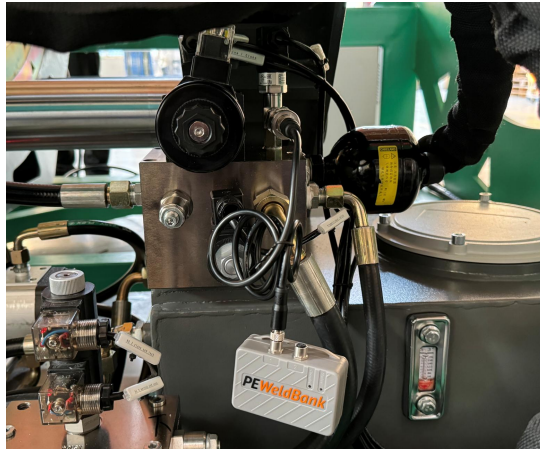
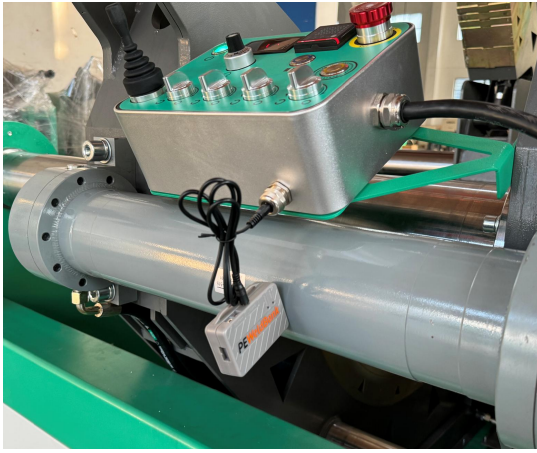




(Galvanized Reducing Inserts )

**Compatible with PEWELDBANK data logging device**

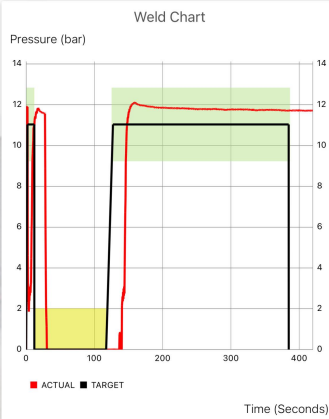




Date	Weld Number
19-08-2023	202308191416111338
Start Time	Ambient Temp
14:19	117.84 °F
Welding Standard	
ASTM F2620	
Custom Weld Number	
3	

Weld Details	Required	Actual	
Bead-up pressure	9.2-12.8	1.9-11.9	bar
Bead-up size	Until indication of bead	28	Seconds
Heat soak pressure	0.0-2.0	0.0-0.2	bar
Heat soak time	105	105	Seconds
Heater plate removal time	≤ 10	10	Seconds
Fusion jointing pressure	9.2-12.8	11.7-12.0	bar
Cooling time in machine under	≥ 04:17	04:17	Min:Sec

\*\* Manual override has been enabled by the user



#### Welding Company Details

Name	Contact	Phone
Riyang Fusion Manufacturing		

#### Operator Details

Operator	ID number	DOB	Last Accredit...

#### GPS Coordinates at Time of Completed Weld

Latitude	Longitude
31.70121	120.26813

#### GPS Coordinates for Current Location

Latitude	Longitude

UPDATE WELD WITH CURRENT LOCATION

#### Heater Plate Details (°F)

	FRONT	BACK
Zone 1	407.30	424.85

#### Heater Plate Details (°F)

	FRONT	BACK
Zone 1	407.30	424.85
Zone 2	420.35	436.55
Zone 3	417.20	440.60
Zone 4	425.75	426.65
Heater plate target	399 - 450	
Average	424.91	
Fixed Point Sensor	432.61-439.21	

#### Quality / Process Checklist

Is weld area protected?	Yes
Have the pipes been cleaned before placing in machine	Yes
Are pipe ends covered?	Yes
Is pipe faced correctly?	Yes
Have pipe faces been cleaned?	Yes
Have pipe ends been checked for gap?	Yes
Is pipe aligned within 10% of wall thickness?	Yes

#### OH&S Take 5

Am I aware of crushing points? (hydraulic movement)	Yes
Am I aware of sharp objects? (facing blades)	Yes
Am I aware of burning (heating plate)	Yes