



TURBO HP SERIES

High Pressure
Hydraulic Butt Fusion Machines

DATASHEET



4901 Whiskey Rd. Aiken, South Carolina 29803, United States

www.hayesweldingsolutions.com

About Hayes

Hayes specializes in providing world-class butt fusion machines that weld thermoplastic pipes such as polyethylene HDPE and polypropylene PPR. This in turn, gives consumers high quality, exceptional durability and commercial-grade butt fusion machines that deliver a superior weld with ease of use, which will maximize thermoplastic pipe fusion procedures while reducing costs.

We offer a variety of options for each pipe size that you need to weld.

Our welding equipment is designed and manufactured according to the American international standard ASTM F2620 and they also meet European International guidelines DVS2207.

We have a specialized team with knowledge in both pipe fusion and maintenance to offer full support.

We inspect all our products before shipping to ensure quality control. We stand behind our product line through our manufacture warranty policy.



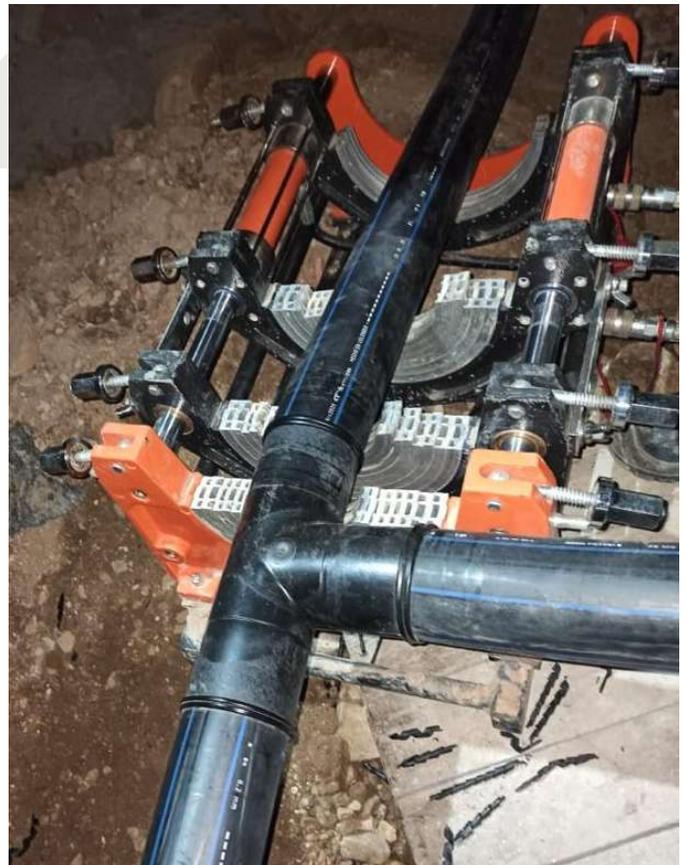
Fusion Procedures



Obtain a copy of the pipe manufacturer's fusion procedures or appropriate joining standard for the pipe being fused.

Follow the procedure carefully and adhere to all specified parameters.

NOTICE: Failure to follow the pipe manufacturer's fusion procedures or appropriate joining standard could result in a bad fusion joint.



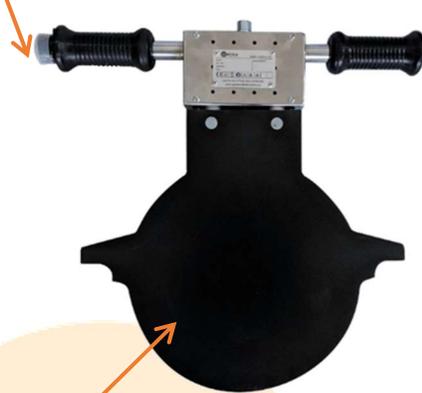
MODEL	TURBO 18-8HP	TURBO 24-12HP	TURBO 36-24HP
Welding range (inches ips)	8" 10" 12" 14" 16" 18" IPS	12" 14" 16" 18" 20" 22" 24" IPS	24" 26" 28" 30" 32" 34" 36" IPS
What is included?	*Pipe alignment *Inserts for inch pipe 8" 10" 12" 14" 16" 18" IPS *Hydraulic power unit *Heater and Trimmer *Crane with hoist (Not included)	*Pipe alignment *Inserts for inch pipe 12" 14" 16" 18" 20" 22" 24" IPS *Hydraulic power unit *Heater and Trimmer *Crane with hoist (Not included)	*Pipe alignment *Inserts for inch pipe 24,26,28,30,32,34,36" IPS *Hydraulic power unit *Heater and Trimmer *Crane with hoist
Max. Pipe wall thickness	SDR11	SDR11	SDR11
Cylinder area	5.84 In ² 37.7 cm ²	10.05 In ² 64.9 cm ²	24.3 In ² 157 cm ²
Pressure adjustable ranges	913.7 PSI 63 Bar 6.3 Mpa	913.7 PSI 63 Bar 6.3 Mpa	2320.6 PSI 160 Bar 16 Mpa
Oil tank capacity	3 L	3 L	20 L
Oil requirement	46# Hydraulic oil (kinematic viscosity) mm ² /s	46# Hydraulic oil (kinematic viscosity) mm ² /s	46# Hydraulic oil (kinematic viscosity) mm ² /s
Plug	Nema L14-30	Nema L14-30	Nema L14-30
Heating plate max. Temp.	518 °F 270 °C	518 °F 270 °C	518 °F 270 °C
Temp. Deviation in Surface	≤ ± 5°F ≤ ± 5°C	≤ ± 5°F ≤ ± 5°C	≤ ± 5°F ≤ ± 5°C
Working voltage	220V ± 10% 3 phases	220V ± 10% 3 phases	220V ± 10% 3 phases
Frequency	50/60 HZ	50/60 HZ	50/60 HZ
Total power	13.5 KW	16.35 KW	36.3 KW
Heating plate power	6.5 KW	9.35 KW	17.5 KW
Trimmer tool power	1.5 KW	1.5 KW	3 KW
Hydraulic unit power	5.5 KW	5.5 KW	15 KW
Crane hoist	0.8 KW (Optional)	0.8 KW (Optional)	0.8 KW
Packing / weight	1294 LBS 118 CFT	1892 LBS 156 CFT	5701 LBS 568 CFT (2586 KG 16.087 CBM) 20' Container
Alignment with inserts	683 Lbs	1137Lbs	3108 Lbs
Heating plate and trimmer	451 Lbs	595 Lbs	808 Lbs
Hydraulic unit	160 Lbs	160 Lbs	188 Lbs
Crane with hoist	Optional	Optional	597 Lbs

What is included?

Heater

The heater is coated to reduce polymer adhesion. The heater temperature is controlled by a microprocessor installed in the hydraulic unit.

Socket for cable connection



Heater plate

Trimmer

This is a heavy-duty trimmer with a robust electric motor. It will establish clean, parallel mating surfaces perpendicular to the centerline of the pipes.

Trimmer motor



Socket for cable connection

Blades

Pipe support stands alignment

Pipe support stands are used to support the pipe at both ends of the butt fusion machine to assist with pipe loading and alignment.

Inserts/Clamps

Main Clamp



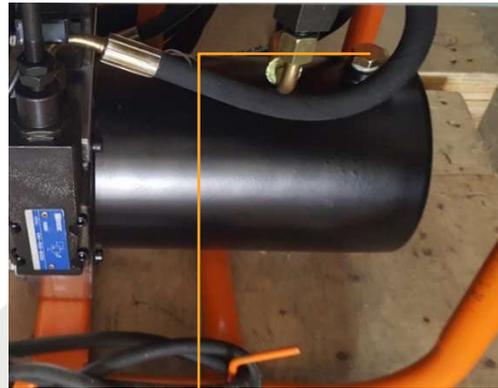
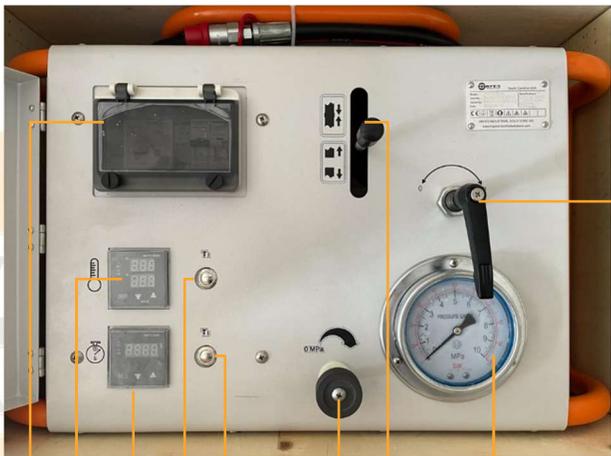
Cylinder

Heater and trimmer stand

This stand is not only to hold the heater and the trimmer, the main purpose is to keep the heater away from you when it is hot to avoid injury and to keep your tools organized and in a good condition for the next use.



Hydraulic unit



Replace metal screw on oil tank with the red dipstick cap. The metal screw is not meant to be used when operating the hydraulic unit.



Warranty

LIMITED WARRANTY

Hayes warrants all products distributed. All products have 12 months warranty against manufacturer's defects from the date of purchase directly from Hayes or Hayes authorized dealers. Furthermore, this warranty only covers factory defects.

RETURN OF GOODS

Buyer must receive written authorization directly from Hayes or Hayes authorized dealer before any returns. The goods must be in the same condition as received. The buyer has 15 days to request a return of goods after the date of the purchase. Buyer is responsible for return freight for any reason other than manufacturer's defects.

IMPROVEMENT

Hayes reserves the right to make any changes in or improvements on its products without incurring any liability or obligation to update or change previously sold machines and/or the accessories.

PROPRIETARY RIGHTS

All proprietary rights pertaining to the design, colors, and branding, are exclusively the property of Hayes.

DISCLAIMER OF LIABILITY

Hayes accepts no responsibility of liability for fusion joints. Operation and maintenance of the product is the responsibility of operators. We recommend qualified joining procedures to be followed when using Hayes fusion equipment. Hayes makes no further warranty of any kind whatever, express or implied; and all implied warranties of merchantability and fitness for a particular purpose which exceed the aforesaid obligation are hereby disclaimed by Hayes.

