



OPERATING INSTRUCTIONS **FRIAMAT PRIME ECO**

www.friatools.com

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1. Preliminary remarks

1.1 Safety instructions and hints

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

Symbol	Meaning
	Danger to people. Failure to comply can result in death or serious injury.
	Danger to people. Failure to comply can result in minor or moderate injury.
	Danger to objects. Failure to comply can result in objects damage.
	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 have 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 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.

1.3 Important note on the restricted Bluetooth® usability in certain countries

The FRIAMAT fusion unit is equipped with a Bluetooth® interface. At present, the use of the Bluetooth function is only permitted in the following countries:

Belgium	France	Croatia	the Netherlands	Sweden	Hungary
Bulgaria	Greece	Latvia	Norway	Switzerland	Cyprus
Denmark	Great Britain	Liechtenstein	Austria	Slovakia	
Germany	Ireland	Lithuania	Poland	Slovenia	
Estonia	Iceland	Luxembourg	Portugal	Spain	
Finland	Italy	Malta	Romania	Czech Republic	

In all other countries the use of the Bluetooth® function is not permitted.

The operator must ensure that the country set in the FRIAMAT fusion unit (see chapter 5.1) corresponds to the current country of use during operation.

Furthermore, the operator must ensure that all users of the FRIAMAT fusion unit are informed of the country-specific restrictions on the usability of the Bluetooth® function before using the fusion unit. The operating manual of the fusion unit must always be carried with the fusion unit. In particular (but not exclusively) the user must be informed if the fusion unit is used or transported to countries in which the use of the Bluetooth® function is not permitted.

INFORMATION

Failure to observe the above may be deemed a violation of the law, which may entail penalties.

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 with the FRIAMAT Fusion Unit (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 FRIATEC 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 protection 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 where 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.

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 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 of the generator. 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 must only be used 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 FRIATEC 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

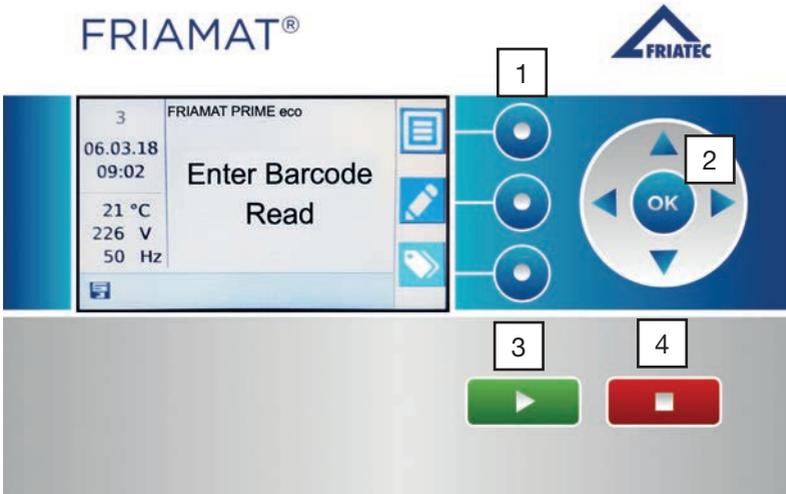
3.1 Layout/parts



- 1 Main switch
- 2 Fusion cable with reader wand or barcode scanner
- 3 Front with display and function keys
- 4 USB interface 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 key symbols shown on the display (see section 3.4).

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.

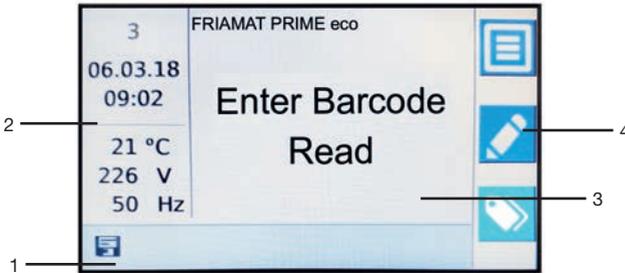
3 START key

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 any input (without saving).

3.3 Display



1 Function status symbols

Symbols appear representing the functions that can be activated at this time. See also Section 3.5. Also shown is the next due maintenance (see also Section 6.2).

2 View ambient details

Key ambient details are shown (date, time, ambient temperature, voltage, and frequency).

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.
	ID Data key	This opens the “ID” Data input dialog for taking Commission number, Seam number, and GPS Data
	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.
	OK key	Depending on the context: OK, Confirm, Apply, Save, Select (a menu item)
	Recycle Bin key	This removes/deletes commission numbers
	Info Data key	This opens the Info Data dialog for taking Info Text, Comment, and Subcontractor
	Details / Search	To call up detailed information or for search words (e.g. country of operation)

3.5 Function status symbols explained

Symbol	Description
	Documentation is active.
	Seam numbers can be entered.
	Traceability barcodes can be entered.
	Pipe numbers can be entered.
	Pipe lengths can be entered.
	USB has been connected.
	Maintenance date: Indication of the next maintenance.
	Bluetooth pairing active

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 Scanner

The scanner reads fusion barcodes and traceability without physical contact. Aim the scanner at the barcode and press the read button. The barcode is then scanned by a red light strip that must cross over the whole barcode; ideally across the centre; otherwise the barcode will not be detected properly.

The optimal results are obtained when the scanner is positioned a small distance over the barcode and successful, when 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 scanner.

3.9 Protective cap for data interface

The USB port is found directly behind the protective cap and this interface is also used as a service port. The protective cap for the data interface must be screwed on at all times to prevent contaminants and moisture ingress.

3.10 Temperature probe

FRIAMAT fusion units can be used only on electrofusion fittings with a barcode. When the barcode is scanned in the microprocessor controlled FRIAMAT fusion unit regulates and monitors the supplied energy fully automatically and defines the fusion time based on 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. This is not only during the fusion process but also between fusion sessions, or after reactivation. This ensures reliable operations for continuous operation and during fusion on large dimensions.

INFORMATION

Reduce cooling times!

In particular during multiple fusion work or 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, the ambient temperature and whether this fusion can be executed to the end. Not until then can the fusion be started and any performance related fusion issues will be prevented.

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: Read barcode confirmed.
- 2 beeps: Fusion procedure ended.
- 3 beeps: Supply voltage too low / too high.
- 5 beeps: 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 Section 5.1.

3.14 Technical details

Technical details*	FRIAMAT prime cco
Input voltage range	AC 190 V – 250 V
Frequency range	44 Hz...66 Hz
Current consumption	AC 16 A max.
Input current	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 acting
Housing	international protection IP 54 DIN EN 60529 protection class I DIN EN 60335-1
Connecting cable	5 m with shaped plug
Fusion cable	4 m with fitting connector, ø 4 mm
Barcode type	code 2/5 interleaved according to ANSI HM 10.8 M-1983 and ISO CD 13950/08.94 code 128 as defined under ISO 12176-4
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
Data transfer interface	USB / Bluetooth Low Energy V4.2 (CE, FCC, IC certified)
Protocol format	PDF, CSV, FTD
Protocol memory	20.000
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
Approval/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 6.2) 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 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 acting, see also Section 2.5).
7. When operating with a generator, first start the generator and let it warm up for 30 seconds.
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 any contaminants.
- You must always protect the plugs against contamination.
- 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 contamination, 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 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 batch. 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 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 scanner for contamination or damage. If necessary, you can also perform the fusion in emergency input mode (see Section 5.3)!

4.3 Starting the fusion procedure

CAUTION!

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 scanner for contamination 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 appears again. These must then 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 confirmed. On a positive result the fusion starts automatically and display shows the fusion progress. This shows the time in seconds of 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 prime eco

5.1 Initial set-up

When starting up the FRIAMAT fusion unit for the first time, the display language, the protocol language and the country of operation must be set once. These settings can be changed at any time via the corresponding function in the “Basic settings” menu (see Chapter 5.2.).

INFORMATION

Some functions, such as the Bluetooth® interface, are only available in some countries (see chapter 1.3). By selecting a country of operation, these specific functions are activated, provided they are permitted for that country.

5.2 “Basic settings” menu

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

INFORMATION

The Bluetooth® function of the FRIAMAT fusion unit cannot be used in every country (see chapter 1.3). If this function is not available for a country of operation, the submenus “Bluetooth” and “Paired Bluetooth devices” will not be displayed.

Documentation
Date and time
* System language *
Protocol language
Country of operation
Volume
Bluetooth
Update
Factory Settings

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 the menu for Documentation, Time and Date, System language, Protocol language, Country of Operation, Volume, Bluetooth®, Update, and Factory Settings
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, for instance, the language was changed by accident.

5.2.1 Bluetooth® Function

The FRIAMAT fusion unit is equipped with a Bluetooth® module. This allows the connection to the FRIAMAT APP on a smartphone.

INFORMATION

The Bluetooth® function of the FRIAMAT fusion unit cannot be used in every country (see chapter 1.3). If this function is not available for a country of operation, the submenu will not be displayed.

INFORMATION

The operating instructions of the FRIAMAT APP must be observed!

NOTE

When using the FRIAMAT APP, observe the indications and messages in the display of the FRIAMAT fusion unit!

Error messages which may not be displayed in the FRIAMAT APP must be confirmed on the FRIAMAT fusion unit.

5.2.1.1 Activate Bluetooth®

The function key in the main menu opens the submenu “Bluetooth” under “Basic Settings”.

INFORMATION

The Bluetooth® function is deactivated on delivery.

The Bluetooth function can be activated or deactivated via this menu.

The submenu menu “Paired Bluetooth Devices” is only visible when the Bluetooth function is activated (see Chapter 5.2.1).

5.2.1.2 Pairing with smartphone

If the FRIAMAT fusion unit is to be used with the FRIAMAT APP, the FRIAMAT fusion unit must be in input mode, “Please scan barcode” is displayed. The pairing must always be initiated via the FRIAMAT APP.



When the FRIAMAT fusion unit and the FRIAMAT APP are paired for the first time, the FRIAMAT fusion unit displays a coupling window with a 6-digit PIN number



INFORMATION

The PIN entry is only required when the FRIAMAT fusion unit is coupled with a new smartphone for the first time.

The 6-digit PIN number must be entered on the smartphone within 30 seconds. After successful pairing, the function status symbol for Bluetooth® appears in the main window of the FRIAMAT fusion unit. In addition, the successful pairing is confirmed acoustically by two short tones.

5.2.1.3 Disconnect pairing with smartphone

The function key in the main menu opens the submenu “Paired Bluetooth Devices” under “Basic Settings”.

All smartphones paired with the FRIAMAT fusion unit with its Bluetooth® address are displayed here.

In this submenu the pairing with a smartphone can be disconnected.

5.2.2 Update

Software updates can be imported via USB stick in the “Update” sub-menu.

5.2.3 Factory settings

In the submenu “Factory settings” the FRIAMAT fusion unit can be reset to factory settings. Afterwards, the display language, protocol language and country of operation must be set again (see also Chapter 5.1).

INFORMATION

No fusion data is deleted from the memory by resetting to the factory settings.

5.3 “Fusion Sequence” menu

INFORMATION

The “Fusion Sequence” submenu is first activated and hence shown on the display when documentation has been activated and the first data record saved! Default is documentation OFF.

5.3.1 “Operator pass” submenu

INFORMATION

The “Operator pass” submenu is first activated and shown on the display when a operators pass is read in for the first time (and documentation is activated)!

INFORMATION

Personal data are handled in compliance with the EU GDPR

If, for example, the operator’s name is encrypted as user code, this will also be transferred as such to the FRIAMAT fusion log for further processing! The specifications under the EU GDPR must be followed with respect to personal data!

After a operators pass has been read in for the first time, all fusions performed from this time on will be stored under the code for this operator. The FRIAMAT prime eco is reconfigured accordingly when another operator is logged on.

After reading in the operator pass, the system opens the “**ID Data**” submenu (see also Section 5.2.4) and the operator can use the direction keys to scroll through the settings activated on the FRIAMAT prime eco.

The operator pass can be used to lock the FRIAMAT prime eco as protection against unauthorised use. A locked FRIAMAT prime eco shows on its display the request “**!!! PLEASE ENTER VALID OPERATOR PASS !!!**”.

Locking the device:

1. Read in the current operator pass.
2. Press the function (confirmation) key to acknowledge the prompt “**LOCK UNIT?**”. Alternatively, you can abort the procedure at the CANCEL function key.
3. The FRIAMAT prime eco is also locked automatically when a operator pass has been read in and the date changes, i.e. the FRIAMAT prime eco is locked on the next day. In both of these cases (manual or automatic locking), the display shows the prompt “**!!! PLEASE ENTER VALID OPERATOR PASS !!!**”.

Unlocking the device:

1. Read in an operator pass.
2. The valid operator pass appears on the display and must be confirmed with the function (confirmation) key.

5.3.2 “Traceability” menu

The “**Traceability**” submenu lets you read, process and store traceability barcodes and data.

5.3.2.1 Traceability Active

The “**Traceability Active**” sub menu activates and deactivates the traceability function. In addition, the “**Traceability**” submenu lets you activate the functions “**Pipe Number**” and “**Pipe Length**”.

5.3.2.2 Pipe Number

The “**Pipe Number**” function lets you decide whether an individual pipe number can be entered for the fusion operation on each pipe.

5.3.2.3 Pipe Length

The “**Pipe Length**” function lets you decide whether the length can be entered for the fusion operation on each of the pipes.

5.3.2.4 “Fitting-ID”

Function is currently inactive.

5.3.3 “Info Data” submenu

The “**Info Data**” submenu lets you enter additional information relevant to each of the fusion operations.

5.3.3.1 Info Text

The “**Info Text**” function lets you decide whether additional text information can be entered for a fusion operation.

5.3.3.2 Comment

The “**Comment**” function lets you decide whether additional text information can be entered for a fusion.

5.3.3.3 Scraper Tool

The “**Scraper Tool**” function lets you decide whether the data (e.g. device number) of the scraper tool used to prepare for fusion can be entered for a fusion operation. The scraper tool then requires a corresponding barcode.

5.3.3.4 Subcontractor

The “**Subcontractor**” function lets you decide whether additional text information can be entered for a fusion.

5.3.4 “ID Data” submenu

The “**ID Data**” submenu presents data that you can select and that must be assigned directly to the pending fusion: Order Number, Fusion Joint Number, and GPS Data. When this function is “activated”, the inputs are prompted during the fusion process; these data can also be entered directly in the “ID Data” menu before each fusion operation (see Section 5.5.1).

5.3.4.1 Commission Number

The “**Commission Number**” function lets you activate or deactivate work with order numbers. With Commission Number activated, the ID Data menu (ID Data key) lets you select a Commission Number or enter a new number either manually or in the form of a barcode. The selected order number then appears in the display’s main window.

5.3.4.2 Seam number

The “**Seam number**” function lets you decide whether an additional seam number can be entered for a fusion operation.

5.3.4.3 GPS Data

The “**GPS Data**” function lets you decide whether the coordinates/location of the fusion fitting can be entered manually.

INFORMATION

An additional GPS device is needed to determine the GPS data!

5.4 “Data” submenu

INFORMATION

The “Data” submenu is first activated and shown on the display when documentation has been activated and the first data record has been saved!

The function key in the main menu opens the submenu “**Data**”.

5.4.1 “Transfer” submenu

The submenu “**Transfer**” serves to transfer the fusion data from the FRIAMAT to a USB stick.

An “Export Filter” dialog lets you select the data you want to output.

Filters can be configured here for the data to be output. Options:

- Commission Number
- Date
- Operator
- Data not transferred yet

After selecting, you can then choose the output format for the fusion and/or traceability data. The data can be output as PDF, CSV, and/or FTD (FRIATRACE) files.

1. Press the (Menu) function key. This opens the main menu.
2. Press the direction keys to open the “Data” submenu.
3. Open the “Transfer” submenu.
4. Configure the output filter in the “Export Filter” dialog.
5. Press the function (Next) key to select the output format dialog “Transfer Data”.
6. In the menu “Transfer Data”, define the output formats (CSV, PDF, and/or FTD).
7. The display prompts the operator to plug a USB stick into the USB port.
8. Pressing the (Confirm) function key initiates the data transfer and shows a progress bar.

The data output to the USB stick are written in the selected output format to a file in 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 04/09/2018 (2018_09_04 N02): 2018_09_04 N02.PDF

The PDF or CSV files can then be viewed and edited with the right software (e.g. Acrobat Reader® / Microsoft® Excel) on a PC or laptop.

Editing FTD data requires the FRIATRACE database software.

INFORMATION

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 a selection or all of the saved data.

5.5 Fusion options

5.5.1 “ID Data” menu

INFORMATION

The “ID Data” option is first activated and shown on the display when documentation has been activated.

The “**ID Data**” menu lets you enter data you want assigned to the pending fusion operation: Commission Number, Serial Number, Seam Number, and GPS Data.

INFORMATION

Commission and seam numbers can be entered only when documentation and the functions “Commission Number” (see Section 5.2.4.1) and “Seam Number” (see Section 5.2.4.2) have been activated

5.5.1.1 Commission Number

1. Press the (ID DATA) function key . The ID Data dialog opens.
2. Press the “Down” direction key to open the Commission number window.
3. Press the (Input/Emergency Input) function key. Use the direction keys to select a number (if assigned) on the virtual keypad, or press the (Input/Emergency Input) function key to enter a new “Alphanumeric Commission number”. You must press the (confirmation) function key to confirm the new number you have entered.
4. Press the (recycle bin) function key to remove previously stored commission numbers (available in this selection menu only).
5. Press the (cancel) function key or the STOP key to close the menu.

5.5.1.2 Operator pass

The main window shows the registered operator, at the bottom right. If no operator pass has been activated, the window remains unchanged.

The operator cannot be edited manually. To register a new operator, you must read in a new operator pass (see Section 5.2.1).

5.5.1.3 Serial number

Press the (ID DATA) function key. The serial number of the executed fusions appear on the display. This number is assigned automatically by the device and cannot be changed. This serial number is assigned to each of the activated commission numbers.

5.5.1.4 Seam Number

1. Press the (ID DATA) function key .
2. Use the “Down” direction key to select “Seam Number”.
3. Press the (Input/Emergency Input) function key.
4. Enter each of the numbers from the first to the last using the direction keys on the virtual keypad. When finished, press OK.
5. 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.
6. A previously assigned seam number can be edited on the virtual keypad.
7. Press the (OK) function key or the STOP key to close the menu.

5.5.1.5 GPS 1 - 3

The coordinates/location of the fusion (GPS 1, GPS 2, GPS 3) can be entered in the menu “GPS 1–3”. The GPS data are made up of three input fields: GPS 1 for the geographical longitude, GPS 2 for the geographical latitude, and GPS 3 for the altitude above sea level. GPS 1 can take a string of thirteen user definable alphanumeric, GPS 2 twelve, and GPS 3 ten.

INFORMATION

An additional GPS Device device is needed to determine the GPS data!

1. Press the (ID DATA) function key .
2. Use the direction keys to select “GPS 1–3”.
3. Press the (Input/Emergency Input) function key.
4. Enter each of the numbers from the first to the last using the direction keys on the virtual keypad. When finished, press OK.
5. 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.
6. Previously assigned GPS coordinates can be edited on the virtual keypad.
7. Press the (OK) function key or the STOP key to close the menu.

5.5.2 Traceability Barcodes / Pipe Number / Pipe Length

Traceability Barcodes is activated when the fusion barcode on the fusion fitting is read.

 The main window prompts you to enter the traceability barcode on the fitting.

 When this is being read, you are prompted to enter the traceability barcode on Component 1. When Pipe Number and/or Pipe Length has been activated, these are also shown and can be entered accordingly.

 Now you are prompted to enter the traceability barcode on Component 2. The pipe number and/or pipe length is entered as above.

Press the (confirmation) function key to acknowledge the prompt **“Pipe Processed?”** when the fusion pipe has been processed properly. Press the START key to initiate fusion.

INFORMATION

The display presents the entered data in succession until fusion can be started. You can use the (back/next) function key to switch at any time between the separate prompts “Fitting” / “Component 1” / “Component 2” / “Pipe Processed” / “Start”. Use the direction keys to navigate inside the separate prompts.

5.5.3 Info Data: Info Text, Comment, Subcontractor

After the fusion barcode has been read, the prompt “START” appears on the display.

1. Press the (Info Data) function key.
2. Use the direction keys to select “INFO TEXT”, “COMMENT”, and/or “Subcontractor”.
3. Press the (Input/Emergency Input) function key.
4. Enter each of the numbers from the first to the last using the direction keys on the virtual keypad. When finished, press OK.
5. 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
6. Press the (OK) function key or the STOP key to close the menu.

5.5.4 Scraper Tool

When the data is being entered to start the fusion, the prompt “**PIPE PROCESSED?**” is followed by the prompt to enter a scraper tool code.

When the scraper tool is equipped with a barcode, this can be read in and the data is then assigned to the fusion in the log.

Also the (Input/Emergency Input) function key can be used to enter the scraper tool code manually on the virtual keypad.

5.6 “Info” menu

The (Menu) function key in the main menu opens the submenu “Info”. Here you can view the device details.

Type

Device number

SW version

HW version

Maintenance Date

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. All device details are shown.
5. Press OK or the START key to close the menu.

5.7 “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 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. The (Back) function key deletes the last input.
5. If entered correctly, the number on the display is the same as the barcode read in with the reader wand or scanner.

INFORMATION

No numbers are shown when this function is used for the first time. Afterwards, the last barcode entered manually is always shown!

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 FRIATEC 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	FRIATEC 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 FRIATEC 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 prime 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
01	Wrong barcode	Faulty / Wrong barcode	Use a new barcode of the same batch or enter it manually.
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

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 FRIATEC service hotline: +49 (0) 621 - 486 1533
15	Power exceeded	The fitting's power input exceeds the capacity of the FRIAMAT.	Contact the FRIATEC service hotline: +49 (0) 621 - 486 1533
17 - 19	System error		Contact the FRIATEC service hotline: +49 (0) 621 - 486 1533
23	Generator error	Generator possibly not suitable for fusion.	Contact the FRIATEC service hotline: +49 (0) 621 - 486 1533
30	Fan blocked or defective		Contact the FRIATEC service hotline: +49 (0) 621 - 486 1533
32	Temperature sensor fault	One of the temperature sensors defective in the device	Contact the FRIATEC service hotline: +49 (0) 621 - 486 1533
34	Temperature limit reached	A temperature sensor signals high heating levels in the device	Let the device cool down. The fans reduce the temperature of the device when it is switched ON.
50	USB interface fault	USB transfer not possible	Contact the FRIATEC service hotline: +49 (0) 621 - 486 1533
70	Communication fault	Data transfer has been disrupted inside the device.	Contact the FRIATEC 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.
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 FRIATEC GmbH or an authorised service station.

8. Annex

8.1 Authorised service stations

Please contact the FRIATEC 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 are reviewed regularly and updated. 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 and this provides our updated operating instructions in the form of PDF documents.

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