

# INSTRUCTION MANUAL

# RANKOR

PLASTIC TUBE WELDING TOOL

**RPTWT20001**



Made in China 0725-V01

[www.rankortools.com](http://www.rankortools.com)

**READ AND FOLLOW ALL SAFETY PRECAUTIONS IN THE INSTRUCTION MANUAL.**



Thank you for choosing **RANKOR** tools.

**RANKOR** products are renowned for their reliability, high performance, and superior quality. Our team is committed to continuous innovation, providing customers with upgraded tools and a comfortable user experience.

Before operating the tools, please read all warnings, cautions, and instructions on the tool labels and in the owner's manual. Note that the safety information provided does not cover all potential conditions or situations that may arise. Thoroughly review the owner's manual for complete safety guidelines and operating procedures. Failure to follow the instructions and safety information may lead to severe injury or death.

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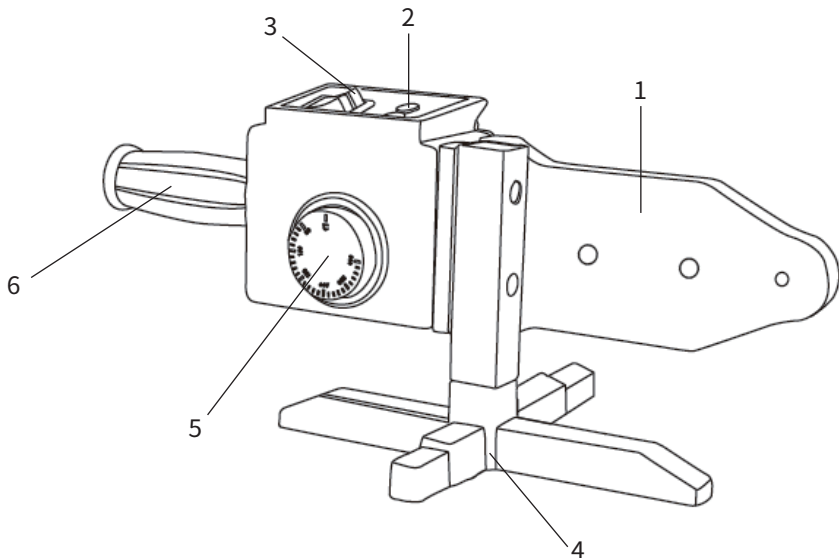
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# 1. Product Overview

## 1.1 Intended use

The machine is used for welding plastic pipes. It features precise temperature control and ensures both safe and convenient operation.

## 1.2 Layout



• The numbers in the diagram correspond to the part names listed in the table below.

1. Heating Plate	2. Indicator light
3. Switch	4. Bracket
5. Adjustment Knob	6. Handle

# 2. Specifications

Model	RPTWT200001
Rated power	1000/2000W
Rated voltage/frequency	220-240V~ 50/60Hz
Temperature	0-300°C
Working range	20-63mm

# 3. Safety Notes



**WARNING: Read all safety warnings and all instructions.** Failure to follow the warnings and instructions may result in electric shock, fire, or severe injury. Save all warnings and instructions for future reference.

The term “power tool” in the safety notes refers to the mains-operated (corded) power tool or battery-operated (cordless) power tool.

## 3.1 General safety notes

### 3.1.1 Work area safety

- DO NOT operate power tools in explosive atmospheres, such as in flammable liquids, gases or dust. Power tools create sparks that may ignite the dust or fumes.
- Keep the work area clean and well-lit. Cluttered or dark areas invite accidents.
- Keep children and bystanders away while operating a power tool. Distractions can cause loss of control.

### 3.1.2 Electrical safety

- DO NOT expose the tool to rain or wet conditions. Moisture entering the tool may increase the risk of electric shock or cause malfunction.
- DO NOT attempt to open or modify the internal electrical components. Unauthorized tampering may lead to electric shock or serious malfunction.
- DO NOT abuse the cord or use it for carrying, pulling, or unplugging the power tool. Keep the cord away from heat, oil, sharp edges, and moving parts. Damaged or entangled cords increase the risk of electric shock.
- DO NOT modify the plug in any way. DO NOT use any adapter plugs with earthed (grounded) power tools. Unmodified plugs and matching outlets will reduce the risk of electric shock. Power tool plugs must match the outlet.
- Use the tool only with compatible power sources as specified by the manufacturer.
- Avoid body contact with earthed or grounded surfaces such as pipes, radiators, ranges, and refrigerators. Contact with such surfaces increases the risk of electric shock.
- Keep the tool clean and dry. Contamination with conductive materials such as dust, metal shavings, or moisture may lead to short circuits.
- If it is unavoidable to operate a power tool in a damp location, use a power supply protected by a residual current device (RCD). Using an RCD reduces the risk of electric shock.
- When operating a power tool outdoors, use an extension cord suitable for outdoor use. Using a cord suitable for outdoor use reduces the risk of electric shock.

### 3.1.3 Personal safety

- DO NOT overreach. Keep proper footing and balance at all times. This enables better control of the power tool in unexpected situations.
- DO NOT use a power tool while the user is tired or under the influence of drugs, alcohol or medication. A moment of inattention while operating power tools may result in serious personal injury.
- DO NOT wear loose clothing or jewellery. Keep hair, clothing and gloves away from moving parts. Loose clothes, jewellery or long hair can be caught in moving parts.
- Use personal protective equipment. Always wear eye protection. Protective equipment such as dust masks, non-skid safety shoes, hard hats, and hearing protection for appropriate conditions will reduce personal injuries.
- Prevent accidental activation. Always verify the power switch is in the OFF position before connecting to a power source, transporting, or handling the device. Never carry the tool with your finger on the switch or operate it while the switch is engaged, as this may lead to hazardous situations.
- Remove all adjustment tools before operation. Ensure any wrenches or keys are detached from the device before powering it on. Leaving tools attached to rotating components can cause serious injury.
- If devices are provided for connecting dust extraction and collection facilities, ensure these are connected and properly used. The use of dust collection can reduce dust-related hazards.

### 3.1.4 Power tool use and care

- DO NOT force the power tool. Use the correct power tool for your application. The correct power tool will do the job better and safer at the rate for which it was designed.
- DO NOT use the power tool if the switch does not turn on and off. Any power tool that cannot be controlled with the switch is dangerous and must be repaired.
- Keep cutting tools sharp and clean. Properly maintained cutting tools with sharp edges are less likely to bind and are easier to control.
- Disconnect the plug from the power source or the battery pack from the power tool before making any adjustments, changing accessories, or storing power tools. Such preventive safety measures reduce the risk of starting the power tool accidentally.
- Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool. Improper use of power tools by untrained individuals may result in serious injury or property damage.
- Maintain power tool. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tool's operation. If damaged, have the power tool repaired before use. Failure to properly maintain power tools can lead to malfunction and increase the risk of accidents.
- Use the power tool, accessories, tool sets, etc., in accordance with these instructions, taking into account the working conditions and the work to be performed. Using the power tool for operations different from those intended could result in a hazardous situation.

### 3.1.5 Service

- Have the power tool serviced by a qualified repair person using only identical replacement parts. This will ensure that the safety of the power tool is maintained.

## 3.2 Additional safety notes for plastic tube welding tool



**WARNING:** Always check the outer cover and cord of the machine before use. Never use this tool if they are damaged.

- DO NOT abuse the cord or use it for carrying, pulling, or unplugging the tool. Keep the cord away from heat, oil, sharp edges, or moving parts.
- Ensure that the power supply matches the tool's rated voltage. Connecting to an improper voltage may result in a risk of electric shock or fire.
- To reduce the risk of electric shock, this tool must be properly grounded. Grounding provides a low-resistance path for the electric current if a malfunction occurs.
- If an extension cord is necessary, ensure that it is rated for outdoor use and has sufficient current capacity. An undersized cord may result in voltage drop and loss of power or overheating.
- When operating a power tool outdoors, use a residual current device (RCD) to reduce the risk of electric shock.
- For safety and optimal performance, only qualified professionals are allowed to open the machine or adjust the temperature.
- If the indicators remain unchanged for a long time, it means the device is in an abnormal working state. Stop using it and turn off the power immediately.

## 4. Assembly And Operation

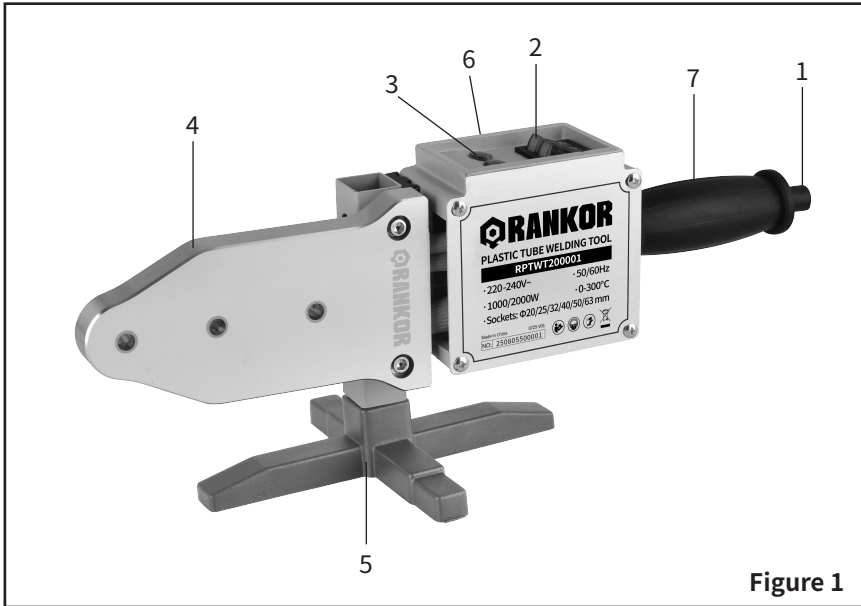


Figure 1

### 4.1 Assembly

- Place the machine on the stand (Figure 1, Item 5) well.
- Install corresponding matrices according to specifications needed.
- Tighten the matrices with a wrench, generally placing the smaller sizes in the front.

### 4.2 Operation



**CAUTION: Power supply must be grounded!**

- Turn on power to start the machine.
- The green indicator light (Figure 1, Item 3) means the machine is heating, while the red indicator light (Figure 1, Item 3) means the machine has stopped heating and is ready for use.
- Before welding, cut the pipe to the required length.
- Then push the pipe or fitting into the heating matrix and hold for the specified time (see the table below). Quickly pull it out, and then steadily insert it to the required depth without twisting or screwing.
- Recommended heating and cooling times for different pipe diameters:

Pipe diameter (mm)	Heating time (s)	Melting depth (mm)	Cooling time (s)
20	5	14	3
25	7	16	3
32	8	20	4
40	12	21	4
50	18	22.5	5
63	24	24	6

**NOTE: If the ambient temperature is below 5°C (41°F), increase the heating time by 50%.**

## 5. Maintenance

- Disconnect the power and let the heating plate cool completely before cleaning.
- Wipe the heating plate and matrices with a soft cloth. Do not use abrasive materials.
- Check the power cord and plug regularly for damage. Replace them if necessary.
- Store the machine in a dry and dust-free environment.

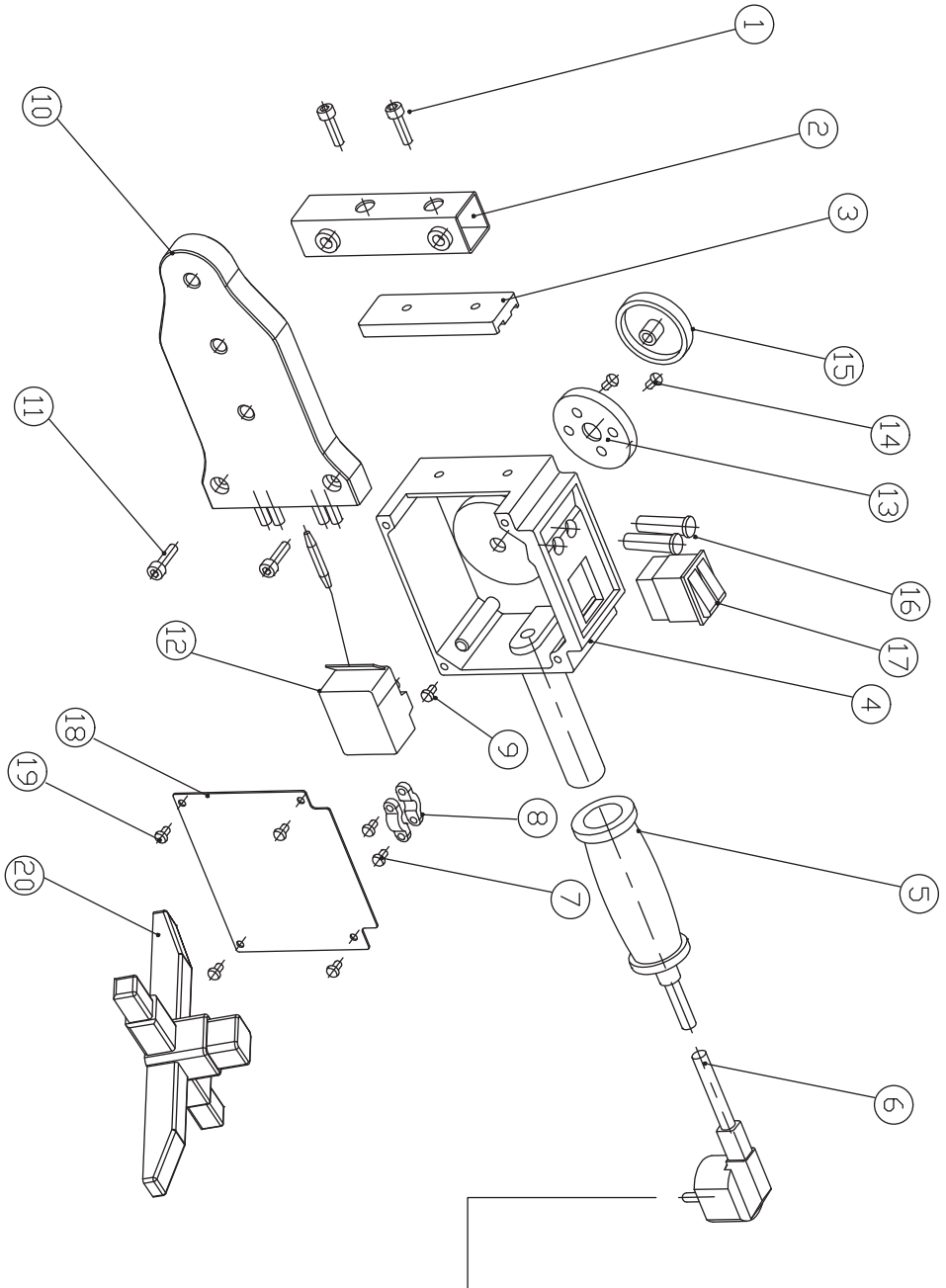
## 6. Disposal And Recycling

- DO NOT dispose of this product with regular household waste.
- Dispose of the product in accordance with local environmental regulations.
- Consult local waste disposal authority for information on proper recycling and disposal.

## 7. RPTWT200001 Plastic Tube Welding Tool Spare Parts List

Exploded View NO.	Part Name	QTY
1	Hex Socket Head Screw	2
2	Square Tube	1
3	Bakelite	1
4	Handle	1
5	Handle Rubber Sleeve	1
6	Power Cord	1
7	Self-tapping Screw	2
8	Tension Plate	2
9	Triangular Screw	1
10	Heating Plate	1
11	Hex Socket Head Screw	2
12	Temperature Controller	1
13	Rubber Pad	1
14	Pan Head Screw	2
15	Adjustment Knob	1
16	LED Light	1
17	Switch	1
18	Panel	1
19	Pan Head Screw	4
20	Bracket	1

# 8. RPTWT200001 Plastic Tube Welding Tool Exploded View



Power cord plug types vary according to regional standards and regulations.  
Please refer to the actual product for the specific configuration.



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