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LI-Line Manual 250-315-355

HÜRNER LI-Line, the 4-3-2 Machine Manual Hydraulic

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Stand-alone in Butt-Welding

Technical Specs	250 mm	315 mm	355 mm
P/N 200-731-...	-251	-315	-355
Welding range O.D. (mm)	(63) 75 - 250	90 - 315	90 - 355
Power Supply	230 V 50 Hz	230 V 50 Hz	230 V 50 Hz
Rated power (kW)	3.65	4.65	5.4
Overall weight with all components (kg)	89	119	142
Weight basic machine (kg)	19 - 41	40 - 66	50 - 95
Reducer inserts	(63)*, 75, 90, 110, 125, 140, 160, 180, 200, 225	90, 110, 125, 140, 160, 180, 200, 225, 250, 280	90, 110, 125, 140, 160, 180, 200, 225, 250, 280, 315
Included standard delivery			
Hydraulic controller for Manual with centralized controls	■	■	■
Basic machine chassis	■	■	■
Facing tool with micro-switch	■	■	■
PTFE-coated heating element	■	■	■
Carrying rack	■	■	■
HÜRNER aluminium reducers	■	■	■
Accessories optional:			
Welding neck support	■	■	■
HÜRNER flightcase for reducers and machine	■	■	■

The Manual Hydraulic Series of butt-welding machines in the new LI-Line generation makes a statement by its superior manufacturing quality and its scalability in the form of an easy upgrade to a data logging-enabled machine with the installation of an SPG 2.0 data logger for welding report generation.

- The machine ships with a hydraulic unit that features, as a unique first, a totally integrated enclosure that also is a splash and dirt shield for all components on the inside. The front panel controls, too, are included in the ingress protection according to the IP 54 rating (where IP 64 is possible upon request).
- All connections, including an additional power socket free to use for the operator's convenience, are located at the back of the controller. Both the facing tool and the heating element are also connected at the back panel of the hydraulic controller. Therefore, no additional power distribution unit is needed.
- The hydraulic unit also doubles as the central control panel of the machine with which the user performs all relevant settings and process steps. The front panel features a GT keypad, the critical process controls,

and also the digital temperature control for the heating element and the extra-large and conveniently readable pressure gauge.

- All HÜRNER Manual Hydraulic butt-welding machines can easily be upgraded with the HÜRNER data logger SPG 2.0 for welding parameter viewing, monitoring, and recording. As a consequence the model version "Manual + SPG" of the butt-welding machine complies with mains gas distributors' specification requirements, which state that data recording and report generation is mandatory, but do not require automatic welding processes.
- The 4th clamp of the machine chassis can be easily removed by loosening 3 bolts, for welding operations at locations where positioning the machine is a challenge and for joints with tees or other fitting elements. This turns the machine into a fully functional "short" chassis with only three clamps.
- The machine chassis is set on a specifically developed support frame exhibiting a warp resistance that manages with ease even the most extreme pipe parameters. Operators can be sure that the machine chassis does not tilt or twist even when very long lengths of pipe with very thick walls are processed.

- Large, knurled turning knobs mean easy handling for the operator who opens or closes the clamps of the machines sized up to O.D. 315. No tools are needed for this.
- The facing tool with integrated micro-safety switch is driven by a high-quality power drive engaged by a transmission chain. The precision heating element ships with a very rugged anti-stick coating.
- A carrying rack is provided for the heating element and the facing tool, to store them with no worries about the heat.
- Maximum protection of the machine, while it is stowed away, is provided (up to O.D. 315) by an optionally available, high-quality transport box that has been specifically designed for the entire machine assembly, with drawer-style storage compartments for the reducer inserts.
- For all machines a welding neck support is of course available, too.

All components are covered by the HÜRNER warranty.



Centralized temperature control



All connections at the back panel of the hydraulic unit



Transport box



Welding neck support

HÜRNER Manual Hydraulic characteristics

Welding monitoring system	Heating element temperature
Display screen	Numeric 7-segment characters, character height 10 mm
Approvals, quality, ingress protection	CE, ISO 9001: 2015, IP 54 (IP 64 optional), WEEE Reg. No. DE 74849106, RoHS-compliant
Hydraulic unit	Only one external power supply needed, all connections and a power socket for the operator's convenience at the back of the enclosure ¹⁾ Digital heating element temperature control, adjustable at the hydraulic unit Hydraulic unit fully encased in rugged steel enclosure weighing as little as 19.5 kg (up to O.D. 335 mm) Max. pressure, up to O.D. 355 mm, 130 bar, O.D. 500 - 630 mm, 150 bar, O.D. 800 - 1600 mm, 220 bar Accurate and maintenance-free gauge showing the welding pressures Easy upgrade of the hydraulic and control unit with a SPG 2.0 data logger for report generation ■ Pressure sensor 160 bar installable to the hydraulic unit ■ Specifically designed support for construction site-suitable installation of the data logger to the edge of the hydraulics ■ Pressure and temperature lines connected directly to the hydraulic unit with very short lengths of hose or cable ■ Power supply to the data logger from the power socket of the hydraulic unit
Manufacturer warranty	12 months

¹⁾ Only if prepared for SPG data logger