



Safe handling instructions

- Electrode drying furnace - **PSE 200/400, PSE 300/400**
- Powder drying oven - **PSP 80/400, PSP 120/400**

**Računi:**Raiffeisen bank Austria dd
Petrinjska 59, 10000 Zagreb
IBAN:HR81248400811002 99573
SWIFT COD: RZBHR2xPrivredna banka Zagreb dd
Trg pobjede 27, 35000 Sl.Brod
IBAN:HR9023400091100131481
SWIFT COD: PBZGHR2xMatični broj: 39 432 75
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Mato Sigurnjak dipl.ing.
Temeljni kapital :
8.700.000 kn



SAFETY

- The oven sold with this manual must not be used for any purpose other than the one designed
- Before using the oven, it is advised that all users of the oven use this manual to reduce the possibility of operating errors.
- Do not damage or remove the safety labels from the oven (picture 1, picture 2). All mineral layer electrodes begin to absorb moisture after unpacking. Welding with wet electrodes leads to an increase in arc spraying, underestimation and poor removal of slag. The range of ovens provides an opportunity for any application requiring quality welds.

Remark

- All packaging must always be removed from the electrode. Failure to do so increases the risk of fire.
- In the event of fire or overheating it is important to switch off the power supply.
- Be very careful when removing electrodes or powder from the oven after heating, put on gloves and stay away from elements that are still very hot.



picture 1.



picture 2.

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ELECTRODE AND FLUX DRYER MODELS

Model	Electrode length (mm)	Capacity	Temp.range	Power (Kw)	Use	Art.number
PSE 200/400	350	200 kg	350 °C	1,2	Electrode	16486
PSE 300/400	350	300 kg	350 °C	1,2	Electrode	17262
PSP80/400	-	80 kg	350 °C	1,2	Powder	50315
PSP 120/400	-	120 kg	350 °C	1,2	Powder	18089

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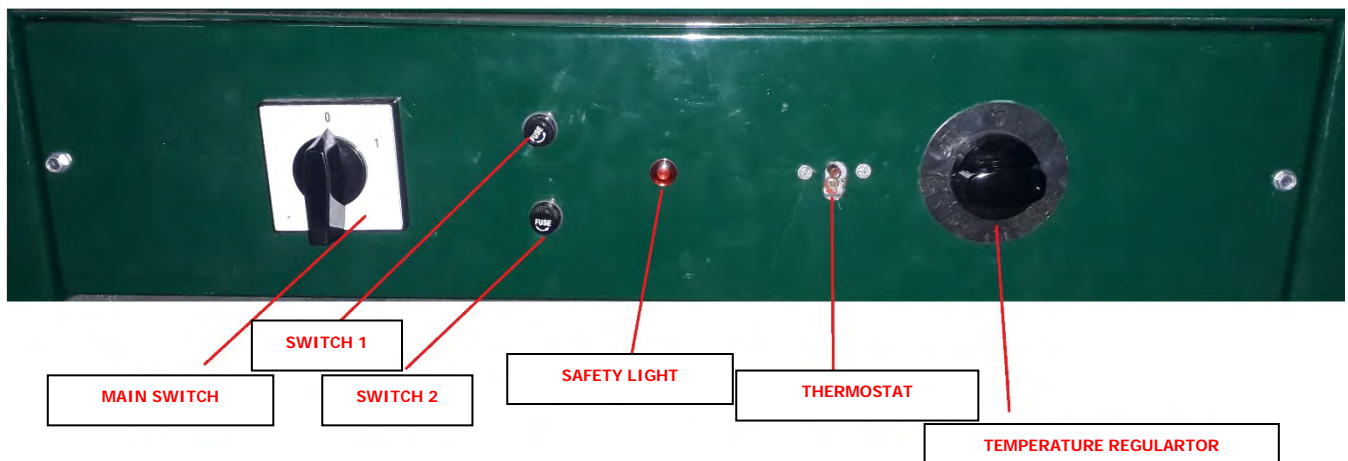
Instalation

The furnace is transported on a pallet securely connected and secured against tipping and damage. If possible place the stove on a level ground, avoid uneven surfaces or any other environment where the stove may become unstable or completely fall off.

Do not place the oven in areas that may be exposed to draft or moisture. After the oven is placed in the optimum location, follow the following guidelines and safe installation.

Make sure the cable is suitable for the oven. Voltage and power are listed on the printed circuit board adjacent to the power cord.

CONTROL PANEL



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INSTRUCTION MANUAL

Starting the oven for the first time

1. Fill the oven with the desired amount of electrodes or powder
2. Make sure the door is completely closed.
3. Make sure the power connector is secure
4. Turn on the oven via the main switch
5. Use the thermostat to set the desired temperature.
6. A signal that the stove is starting to heat will be given by the front panel indicator light.



Remark

Ensure that the tailgate, or vent, is in the fully open position and does not obstruct or obstruct any foreign body.

Maintenance

- Schedule regular maintenance when the oven is in use.
- Make sure the oven is always in good working order.
- Check the power cord regularly and replace it immediately if damaged.
- Check that the heating elements are clear of the slag and that the temperature sensors are properly attached.



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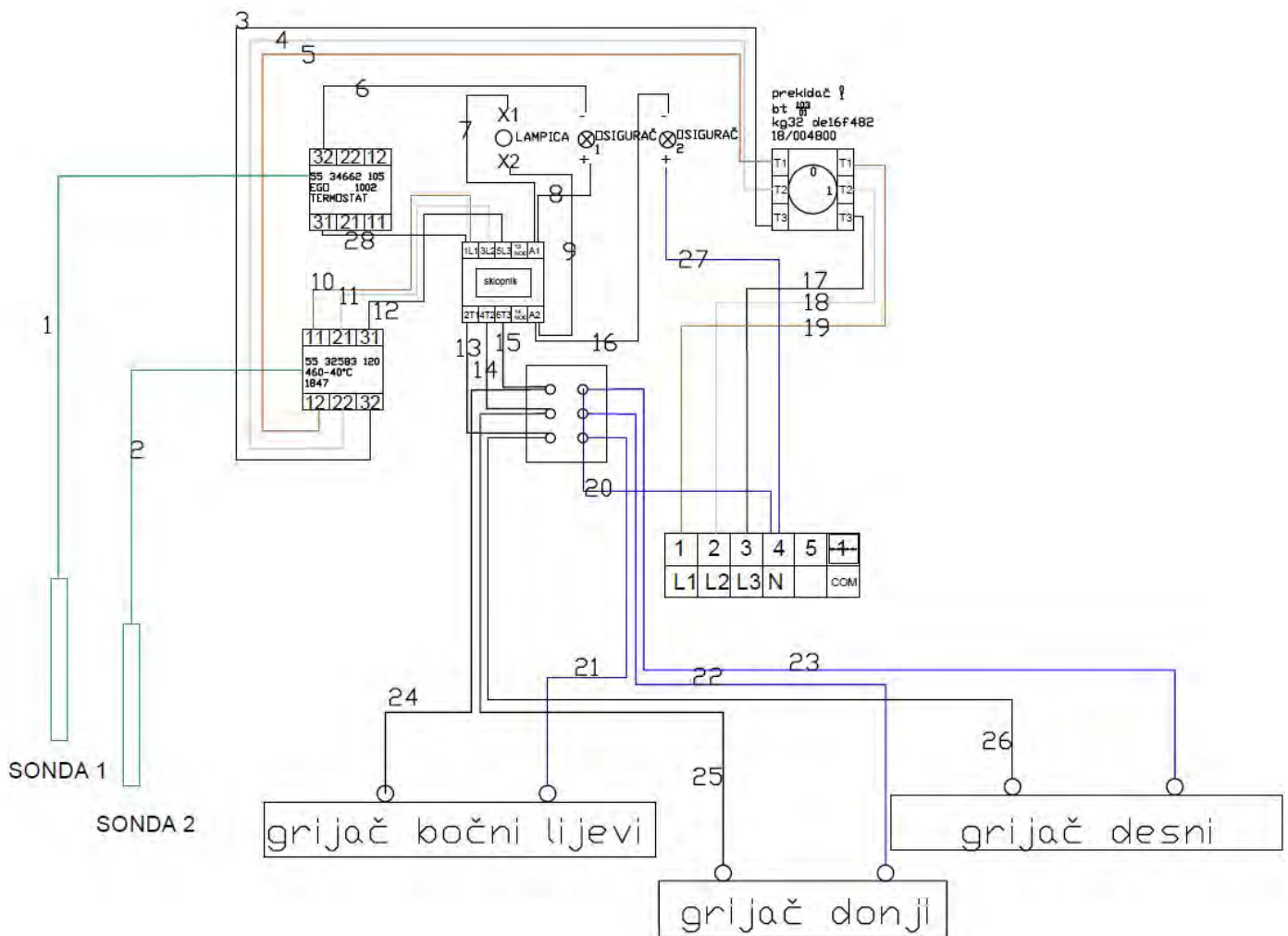


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ELECTRICAL DIAGRAM



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General conditions

Sigmat warrants the products mentioned in this manual for a period of 12 months from the date of delivery. The guarantee is valid for the above mentioned period and only for parts that will be defective without human factor influence.

All costs for parts replacement are borne by the buyer.

Limitations

Sigmat will not be responsible for:

- Improper use of the oven
- Use contrary to national or international regulations regarding the use of the device
- Incorrect or incorrect connection to the mains
- Improper or illicit furnace maintenance
- Unauthorized changes to the device
- Use of non-genuine spare parts or unsuitable components
- Partial or incomplete failure to comply with the instructions.



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Safe handling instructions

- Electrode dryer - **TS1/100, TS1/160**
- Electrode dryer - **TS1/350, TS2/350**
- Electrode dryer - **TS4/350, TS4/350T**

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SAFETY

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Remark

- All packaging must always be removed from the electrodes. Failure to do so increases the risk of fire.
- In the event of fire or overheating it is important to switch off the power supply.
- Be very careful when removing electrodes from the dryer after heating, put on gloves and stay away from elements that are still very hot.



picture 1.



picture 2.

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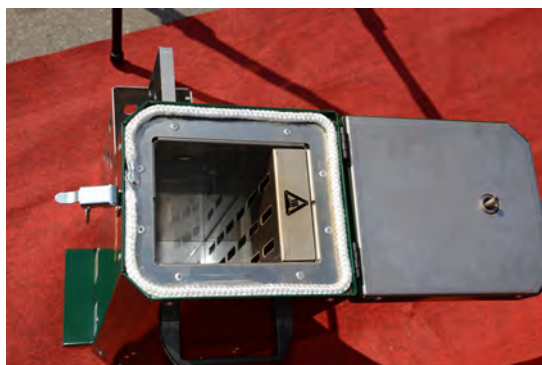


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ELECTRODE DRYER MODELS

Model	Electrode length (mm)	Capacity	Temp.range	Power (Kw)	Use	Art.number
TS1/160	350	4 kg	160 °C	0,12	Electrode	16485
TS1L/160	550	6 kg	160 °C	0,12	Electrode	50581
TS2/160	350	6 kg	160 °C	0,12	Electrode	50582
TS2L/160	550	8 kg	160 °C	0,12	Electrode	50583
TS4/160	350	16 kg	160 °C	0,12	Electrode	50584
TS4L/160	550	24 kg	160 °C	0,12	Electrode	50585
TS1/350	350	4 kg	350 °C	0,6	Electrode	16954
TS1L/350	550	6 kg	350 °C	0,6	Electrode	50586
TS2/350	350	6 kg	350 °C	0,6	Electrode	16534
TS2L/350	550	8 kg	350 °C	0,6	Electrode	50461
TS4/350	350	16 kg	350 °C	0,6	Electrode	17014
TS4L/350	550	24 kg	350 °C	0,6	Electrode	50587



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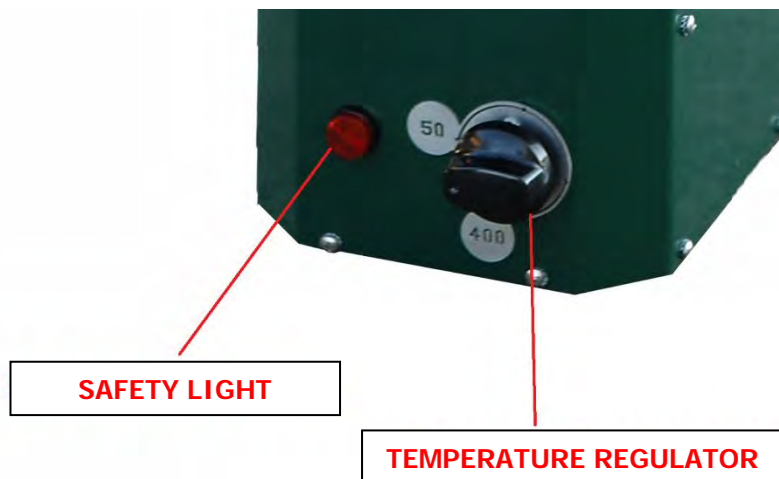
Instalation

The dryer is transported on a pallet securely connected and secured against tipping and damage. If possible place the dryer on a level ground, avoid uneven surfaces or any other environment where the dryer may become unstable or completely fall off.

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Remark

Ensure that the tailgate, or vent, is in the fully open position and does not obstruct or obstruct any foreign body (applies only to dryers containing vent).

Maintenance

- Schedule regular maintenance when the dryer is in use.
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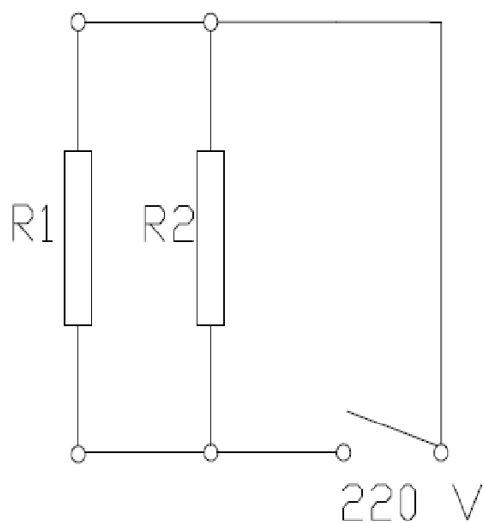
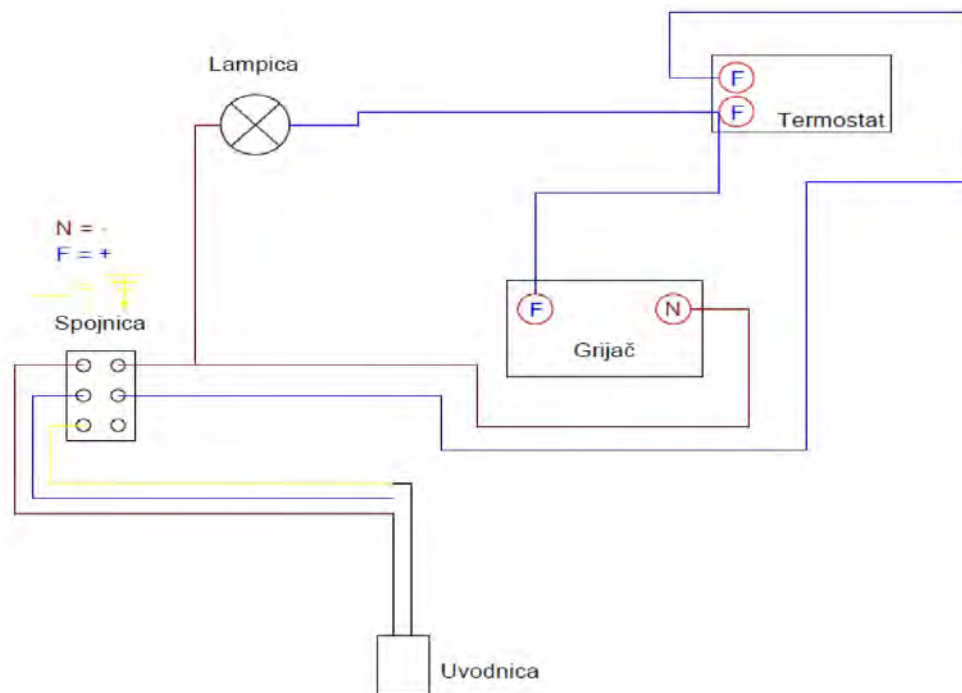


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- ELECTRICAL DIAGRAM (TS1/350, TS2/400, TS4/400, TS4/400T)
- ELECTRICAL DIAGRAM (TS1/100, TS1/160)



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Spare parts

ARTIKL	MODEL	KAPACITET	MAX. TEMPERATURA	ŠIFRA
1	TS1/100	4 kg	100 °C	19638
2	TS1/160	4 kg	160 °C	16485

- Heater FI 65 60W 220V
- Signal light

ARTIKL	MODEL	KAPACITET	MAX. TEMPERATURA	ŠIFRA
1	PSP80/400	80	350 °C	50315
2	PSP 120/400	120	350 °C	18089
3	PSE 200/400	200	350 °C	16486
4	PSE 300/400	300	350 °C	17262

- Stove heater, side - 1200W 230V
- Stove heater, lower - 1200W 230V
- Furnace thermostat 50-40055.34079.010 EGO
- Thermometer 0-400 C FOR A DRYING OVEN
- Signal light
- Thermostat handle
- Door handle

ARTIKL	MODEL	KAPACITET	MAX. TEMPERATURA	ŠIFRA
1	TS1/350	4 kg	350 °C	16954
2	TS2/350	6 kg	400 °C	16534
3	TS4/350	16 kg	400 °C	17014
4	TS4/350T	16 kg	400 °C	50316

- Heater 350C
- Thermostat 0-350 55.13052.108 4EGO1
- Signal light
- Thermostat handle

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