

# **SFS** intec



## **isoweld™ 3000**

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# English

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# ***isoweld*<sup>TM</sup> 3000 induction welding tool**

## **Identification**

Type: ***isoweld*<sup>TM</sup> 3000**  
Manufacturer: SFS intec  
Division Construction  
Rosenbergsaustasse 10  
CH-9435 Heerbrugg  
Switzerland  
www.sfsintec.biz

Rating: see type plate

The induction welding tool of the ***isoweld*<sup>TM</sup> 3000** series has been designed and assembled in Switzerland.

Responsible for documentation:

**Daniel Gasser,**  
Product development

## **Preface**

### **Purpose of the document**

This document is written for skilled building operatives working in the field of flat roofs. It is intended to instruct skilled operatives in how to work safely and efficiently with the units (see the section on "Safety instructions").

### **Structure of the documentation**

The documentation describes all the phases in the life of the tool from transport, installation, operation, maintenance and servicing up to disposal.

This manual was drawn up taking into account the provisions of the EU Machinery Directive 2006/42/EC, Annex I, Clause 1.7.4 "Instructions".

The original operating instructions were prepared in German.

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## Symbols used

### ⚠ DANGER!

Indicates a hazardous situation. Death or severe permanent injury could result if the situation is not avoided.

### ⚠ WARNING!

Indicates a potentially hazardous situation. Death or severe permanent injury could result if the situation is not avoided.

### ⚠ CAUTION!

Indicates a potentially hazardous situation. Slight or minor permanent injury could result if the situation is not avoided.



This symbol highlights hazard instructions that must be observed when dealing with electrical equipment.



This symbol signals hazards that must be taken account of when working on roofs.



This symbol signals hazards associated with crane transport.



This symbol signals risks for people who have a cardiac pacemaker.



This symbol makes clear the requirement to wear personal protective equipment. Personal protective equipment always includes: safety glasses, safety gloves, safety shoes, closely fitting working clothes as well as a belt and safety rope. In every case the internal accident prevention requirements must be observed.



The operating instructions must be read and understood before setting up or using the tool. The instructions must be observed. Ask the responsible department if the operating instructions are missing or if you do not understand sections of the operating instructions.



This symbol signals hazards associated with magnetic fields.



This symbol highlights instructions that point out a fire hazard.

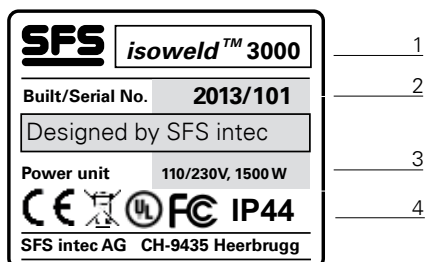


Instructions regarding additional important information.

### Keep this document safe

These operating instructions are part of the product and must be kept with the unit at all times. They must be available to the operator at all times.

## Rating plate



- 1 Machine type
- 2 Year of manufacture, serial number
- 3 Technical data
- 4 CE, UL, FCC marking  
Protection rating

## Safety instructions

### Meaning of general safety instructions

The general safety instructions in this section provide information on possible residual hazards that are always present or that could occur unexpectedly, despite the correct usage of the unit.

The safety instructions must be observed by all persons who work on or with the tool to prevent physical injury, damage or harm to the environment. These persons are therefore obliged to read, understand and observe the provisions of this section.

## Safety instructions

### Meaning of specific safety instructions

For certain situations the applicable safety instructions are given at the relevant place in the operating instructions. These instructions must be observed in order to prevent physical injury, damage or harm to the environment.

### Statutory requirements

In addition to the safety instructions in this operating manual, the statutory accident prevention and environmental protection regulations applicable in the country of use must be observed. Likewise the generally accepted rules for safety and working in a technically correct manner must be observed.

### Consequences of failure to observe the safety instructions

Failure to observe the safety instructions can lead to accidents with resultant physical injury, damage or harm to the environment.

The manufacturer accepts no liability for injury or damage resulting from failure to observe the safety instructions.

### Intended use

The induction welding tool has been designed exclusively for the installation of roofing membranes recommended by SFS intec on roofs.

Only fasteners, stress plates and sleeves approved for the tool and provided by SFS intec may be used. The tool must be used within the limits defined in the "Technical data" section.

### Foreseeable misuse

- Starting to use the tool without instruction.
- Rendering the safety features inoperative and removing the warning labels.
- Working on roofs with a slope of more than 10°.
- Working backwards on roofs.
- Unsafeguarded or reckless working on roofs.
- Modifying the tool without the permission of the manufacturer.
- Using accessories or spare parts from another manufacturer without the permission of SFS intec.

### DANGER!

- In the case of misuse there is a risk of death or injury, damage to the tool and damage to the material processed.
- It is not permitted to open the *isoweld*<sup>TM</sup> 3000 induction welding tool under any circumstances. Non-observance involves the risk of death or injury, damage to the tool and damage to the processed material.

## Safety instructions

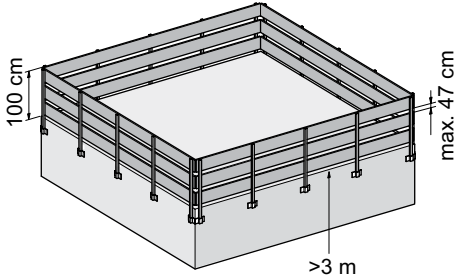
### General safety instructions

- Keep your workplace tidy. An untidy workplace increases the risk of accident.
- Take account of environmental influences. Do not expose the induction welding tool to rain. Do not use the induction welding tool in damp or wet conditions. Ensure that you have good lighting. Do not use the induction welding tool in the proximity of flammable liquids or gases.
- Never start the welding process while the supply cable is under the tool. Ensure that the cable is far enough away from the inductor during the work process.
- Keep children at a safe distance. Do not allow third parties to touch the machine or the cable.
- Always wear the correct personal protective equipment when working. Personal protective equipment includes: safety goggles, safety gloves, safety shoes, closely fitting working clothes.
- Place the electric cable (supply cable) in a suitable location. Ensure that it does not constitute a trip hazard and does not wear through. Regularly check the electric cable, inductor cable and temperature cable for damage.
- Always switch the tool off and remove the mains connector during breaks or maintenance work. Do not leave the tool unattended.
- Use approved and appropriately labelled extension cables when working outdoors.
- The induction welding tool and the hand magnets may have an effect on the function of cardiac pacemakers and implanted defibrillators. It is possible that cardiac pacemakers switch to test mode and cause discomfort. It is possible that defibrillators cease to function. If you are fitted with any such instruments, you must keep a minimum distance of 50 cm from the inductor (also hand inductor) and the magnets. You must warn persons fitted with such instruments against coming too close to the magnets and inductors.
- Do not hold any objects containing metal in the direct proximity of the inductor (e.g. watches, jewellery, keys, mobile phones, hearing equipment, implants etc.).
- Regularly check the tool for damage, and that it is functioning properly. Use the tool only if it is functioning properly.
- Repairs may only be carried out by a specialist.
- When carrying out maintenance and service work, the power connection to the tool must be disconnected.
- It is imperative to comply with the safety regulations in the respective country.
- The functionality of this system is guaranteed when original fastener, stress plate, sleeve and spare parts from SFS intec are used, and the unit is operated in accordance with the operating instructions.
- The *isoweld*<sup>TM</sup> stress plates become very hot due to the induction process. There is a risk of burns when touching the stress plates immediately following the welding process.
- Only use system components from SFS intec or approved by SFS intec. Do not use any accessories or spare parts from other manufacturers without approval by SFS intec.

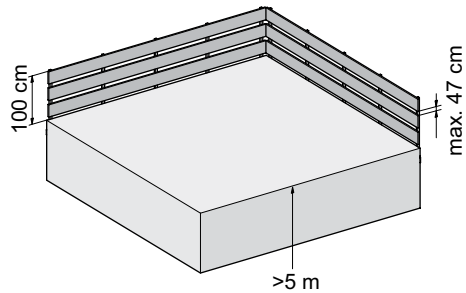
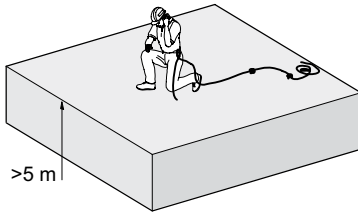


## Special safety instructions

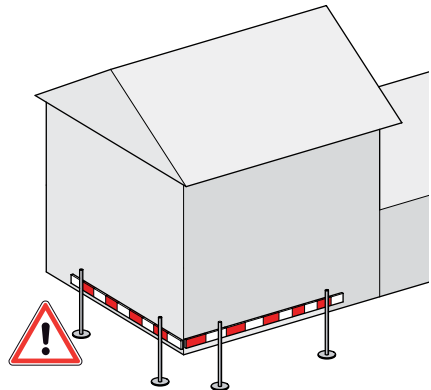
- When working on roofs with a slope of between 0 and 10° a guard rail must be fixed at the edge of the roof.
- When the roof slope is more than 10° special safety devices must be employed.
- When the working height is more than 3 m above ground, appropriate fall prevention measures must be employed.



- Fall prevention measures for work lasting less than 2 working days. In the case of work that takes longer, proceed as described above.

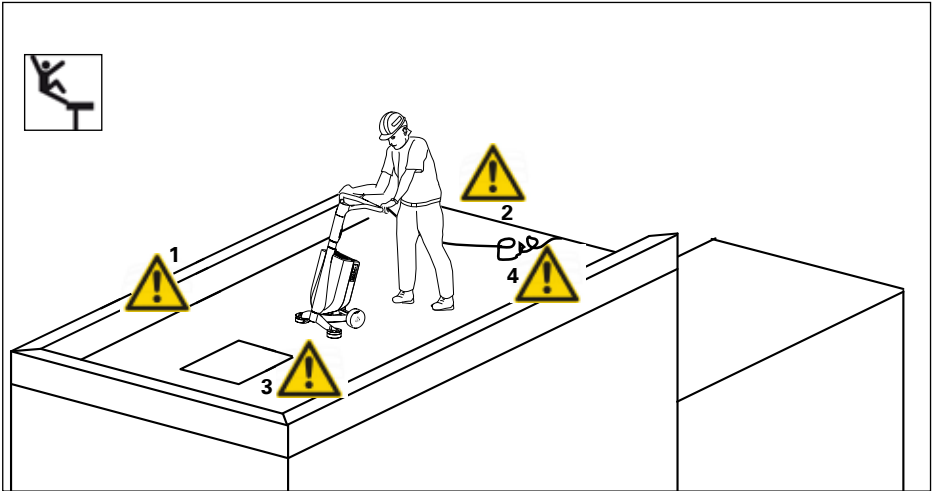


- Risk of falling through: beware of areas in the roof that are not structurally safe, e.g. rooflights, tarpaulins etc. These areas must be appropriately marked and/or secured with gangways.
- When working on roofs the entire risk area on the ground must be cordoned off and signed. It is important to ensure that third parties are not endangered by falling objects.





## Danger areas



- 1 Fall hazard at roof edge
- 2 Fall hazard at step in roof
- 3 Break-through hazard, e.g. glass windows
- 4 Trip hazard from cable

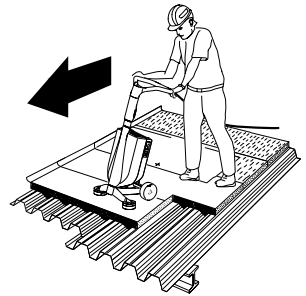
### Working position

Always work forward

 **DANGER!**

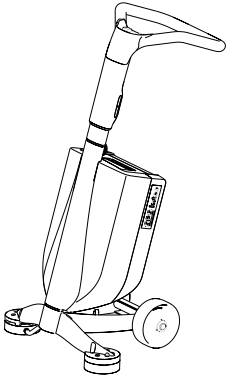


Always work in a forward direction,  
never backwards.

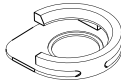


## System components

### Included in delivery:

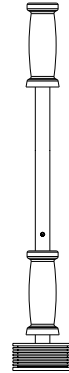


Induction welding tool  
*isoweld™ 3000*



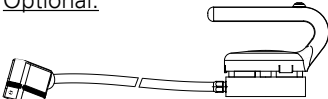
Calibration template  
*isoweld™*

### Additional accessories:



Magnet  
FI Magnet

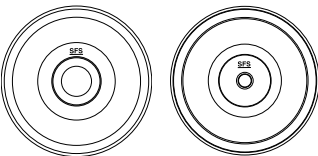
### Optional:



Hand inductor  
FI-H

### Fixing components:

#### Stress plate:



FI-P-16.0  
for sleeve

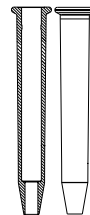
FI-P-6.8  
for fastener

#### Fastener:



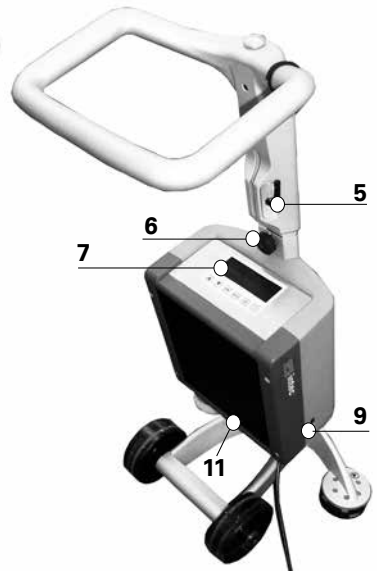
BS-6.1xL	TI-T25-6.3xL
BS-4.8xL	TIA-T25-6.3
BS-S-6,1	LBS-T25-8.0xL
BS-S-4.8xL	LBS-S-T25-8.0xL
TS-T25-6.0xL	FB-S-T25xL
DT-4.8xL	SBF-6.0xL
DT-S-4.8xL	SBF-S-6.0xL
DT-6.3xL	DF-#15xL

#### Sleeve:



FI-R-20xL

## Overview *isoweld*<sup>TM</sup> 3000

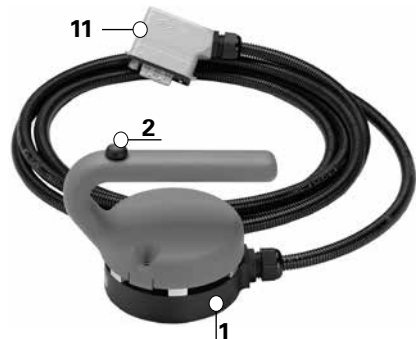


### Calibration template



- 1 Inductor
- 2 Start button
- 3 Cable holder
- 4 Handle
- 5 Clamping lever for height adjustment
- 6 Clamping lever for plug connection
- 7 Display
- 8 Generator
- 9 On/Off switch
- 10 Calibration template
- 11 Connector

### Hand inductor, FI-H (optional)



## Standard items supplied



### Induction welding tool, complete

- 1 Induction welding tool *isoweld™3000*
- 1 Calibration template
- 1 Set of instruction material
- 5 Protective foils for inductor
- 1 Transport box

## Description of function

The *isoweld™3000* induction welding tool has been designed for efficient welding of waterproof membranes with metal stress plates. It is possible to use PVC and TPO waterproof membranes. The tool has been designed as an upright unit and therefore allows ergonomic work without excessive fatigue. As soon as the induction welding tool has been placed over a metal stress plate, the welding process is triggered by pressing the start button. The welding process ensures that the waterproof membrane is connected to the stress plate. It is important that this connection is subsequently weighed down with a magnet.

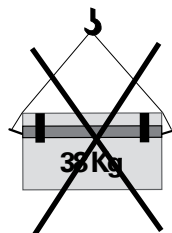
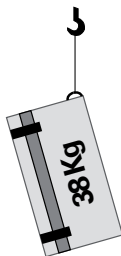
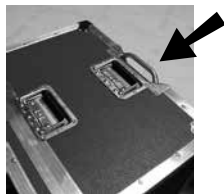
## Transport

**⚠ DANGER!**



### Falling load

Only lift the tool when it is in the closed transport container.  
Never hang the transport container from its handles.  
Instead, use the hook provided at the container (see photo).

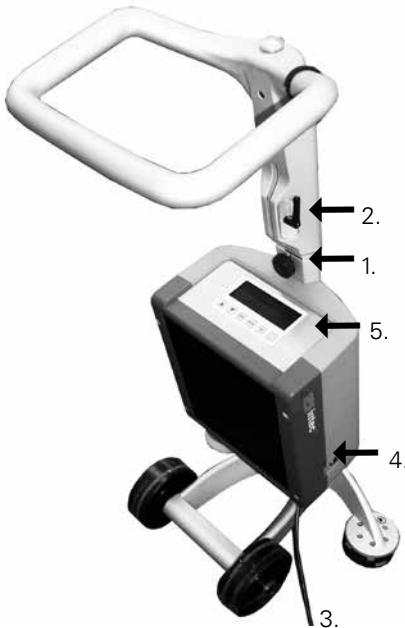


## Start-up

 **The induction welding tool is delivered ready for operation ex-works.**



After opening the container, the body of the unit can be carefully lifted out. Then the handle of the tool (see overview) is removed from the transport box and carefully inserted into the tool.



1. Use fixing screw to secure the push-fit connection.

 **Ensure that the connection is correctly made.**

2. Adjust the handle to an ergonomic working height. For this purpose, release the clamping lever at the upright and adjust the height. Re-tighten the clamping lever.

3. Connect the tool to a suitable power source.

- the cable should not be too long
- suitable conductor cross section
- unroll extension cable


4. Operate mains switch to turn unit on.

5. The display shows the input screen.

 **The country-specific regulations must be observed.**

## Start-up

Before working with the induction welding tool, the project parameters must be entered into the display. The parameters required are the waterproof membrane material and thickness. The following options are available:

 **Note:** the settings (parameters) used last will be loaded. It is possible to either adopt these settings or make new selections of the following settings.

Waterproof membrane material	Waterproof membrane thickness (mm/mil)				
PVC	0.9-1.1/35-44	1.2-1.4/45-59	1.5-1.7/60-69	1.8-2.0/70-79	2.1-2.3/80-90
TPO					



Display examples

For changing the settings, proceed as follows:

The position display is on the choice of the waterproof membrane material (\* first line).

1. Press the button **OK**. ≥ appears and flashes.
2. Press the **▲** button or press the **▼** button until the required waterproof membrane material is displayed.
3. Confirm the selection by pressing the **OK** button. \* appears.
4. Press the **▼** button to go to the waterproof membrane thickness selection.
5. Press the **OK** button. ≥ appears and flashes.
6. Press the **▲** or **▼** button to determine the waterproof membrane thickness.
7. Confirm the selection by pressing the **OK** button.

 **The parameters have now been set and stored.**

## Calibration

### When should the tool be calibrated?

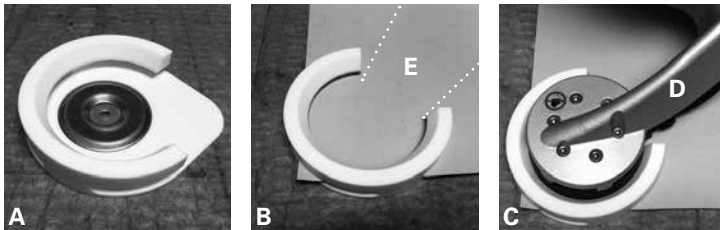
- every morning before starting work
- when moving to another building site
- when working with a different material (PVC instead of TPO or vice-versa, thinner or thicker waterproof membrane)
- change from 110V to 230V or vice-versa
- change of generator (USA, CAN) or transformer (UK)




### Ensure that the project parameters are set correctly (waterproof membrane material and thickness).

### Only use material for calibration which has been defined for the current project.

### Calibration process

1. Use the calibration template and place an *isoweld*<sup>TM</sup> plate into the recess provided for it (A).
2. Push the calibration template on to the corner of the waterproof membrane (B).
3. Place the inductor into the calibration device and ensure that it is positioned correctly (C): the arm (D) to the inductor must be resting in the recess (E) provided.




4. Press the  or  button to move to CALIBRATION.
5. Start the calibration function by pressing the  button.
6. You are now in the calibration program.
7. Press the start button (2).
8. The automatic calibration is completed when there is a beeping sound for 1 second and the display returns to standard view.








### The tool is now calibrated.


## Additional setting options

By pressing the  button you can set the **volume** and tone of the signal sound and the **unit of measure** (mm/mil).




To set one of these parameters, proceed as follows:  
For example, the position display is on **selection of volume** (\*first line).

1. Press the  button. ≥ appears and flashes.
2. Press the  or  button until the required volume is reached.
3. Confirm the selection by pressing the  button. \* appears.
4. Press the  button to move to the selection of tone or unit of measure.
5. If you want to change these too, repeat steps 1 to 3 accordingly.
6. Press the Menu button in order to return to the standard view.

 **The parameters have now been set and stored.**

 **The tool is now ready for operation.** (status display  lights up green).

## Test welding

 SFS intec recommends that a test weld be carried out after calibration and before starting installation. Position a stress plate on a level, heat-resistant base and place a piece of the waterproof membrane to be used on it. Carry out a test weld (see section on welding operation). Allow the weld to cool down for at least 10 minutes. Try to disengage the plate from the waterproof membrane with the help of pliers. If the membrane offers a lot of resistance or is destroyed in the process (after tearing off the stress plate), the weld has been successful. Should the welded waterproof membrane not have sufficient adhesion to the stress plate, you need to check the settings (parameters) at the tool etc. For technical assistance, please contact your service provider. You will find this at [www.sfsintec.biz](http://www.sfsintec.biz).





## Operation: welding

**⚠ DANGER!**

### Danger of falling!

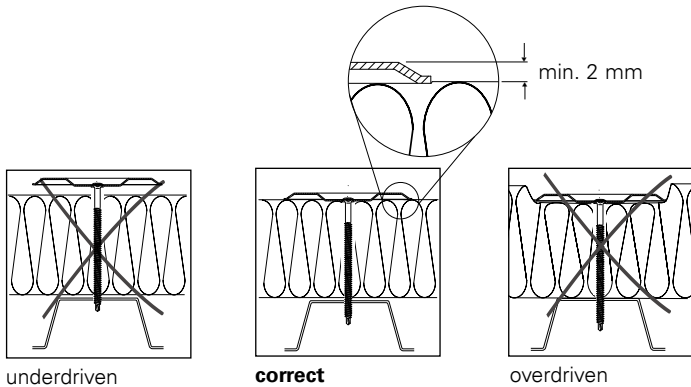


Careless working on the roof can lead to falls. When working on a roof you must wear appropriate safety equipment. Never use the tool backwards, but always in a forwards direction (see sections on Hazards and Work position).





The induction welding tool and the hand magnets may have an effect on the function of cardiac pacemakers and implanted defibrillators. It is possible that cardiac pacemakers switch to test mode and cause discomfort. It is possible that defibrillators cease to function. If you are fitted with any such instruments, you must keep a minimum distance of 50 cm from the inductor (also hand inductor) and the magnets. You must warn persons fitted with such instruments against coming too close to the magnets and inductors.

**👉 Before installing the waterproof membrane, SFS intec recommends that the position of the plates on top of the insulation be checked. Should the height of any stress plate be incorrect, the height needs to be corrected.**



**👉 Before carrying out the welding, SFS intec recommends marking the position of the stress plates on the top face of the waterproof membrane.**

## Operation: welding

1. Preparing the magnet.
2. Place inductor (1) on stress plate.
3. Press the start button on the handle (3).
  - a. If the unit has been placed correctly, which means that the cover is sufficient, a continuous signal sound will be heard (1 second) and the status display  changes to orange. The welding process will start automatically.
  - b. If the unit is not correctly placed, i.e. the cover is insufficient, the inductor (1) has to be moved until the position is correct (see Fig.1). As soon as the position is correct, the welding process starts automatically.
  - c. The tool is equipped with an acoustic search mode which helps the user to position the inductor precisely on the stress plate. The search mode is active for max. 15 seconds. When the time limit has been exceeded, a failure signal sound can be heard (2 seconds). In this case, acknowledge the signal by pressing the  button, allow the stress plate to cool down and restart the welding process (step 1 and subsequent steps).

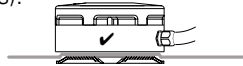
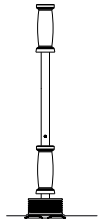


Fig. 1

4. The welding process takes approx. 3 to 4 seconds and is terminated with a double signal sound.


**Caution:** moving the tool before the welding process has been completed will always result in an error message and a faulty weld!

5. After completing the welding process, move the tool from the weld and immediately place a magnet on the welded point. Allow the magnet to remain for at least 1 minute. The magnet ensures the necessary pressure and cooling of the stress plate. It is an essential part of achieving a good weld!






 **The magnet must be placed within the first 3 seconds after terminating the welding.**

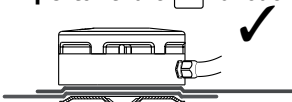
 **Check the underside of the magnet regularly and remove any metallic particles.**

 **The magnet must not be rotated during or after positioning if there is contact with the waterproof membrane. If this instruction is not followed, the waterproof membrane may be damaged.**

6. Move to the next plate position and repeat the search and welding process as described in steps 1 to 5.
7. At the end of the welding work, switch off the tool at the main switch and then disconnect from the mains.

 **Overlaps of waterproof membrane** in the area of the stress plate should be avoided. However, should this situation arise the special function of the welding tool can be used. Instead of proceeding with normal welding, the  function key can be pressed. Now proceed as steps 1 to 5.

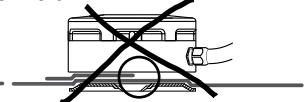
**Important:** the  function will only remain active for one weld.



Full overlap



Partial overlap

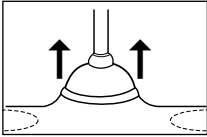


Partial overlap

## Checking the welding



If the correct parameters have been selected for the welding and the recommended test weld has been successful with positive results, and the instructions in the operating instructions have been followed, no further checks of the operation are necessary.



☞ Should you be uncertain about whether some welds have completed properly, SFS intec recommends testing with a commercially available suction pad. Use the suction pad to try to lift the waterproof membrane at the point in question. If this is possible, the weld has yet to be made.

## Operation: working with the hand inductor



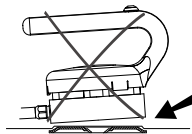
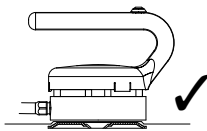
Fig. 2

Alternatively it is also possible to carry out welds with the hand inductor (available as an option). This may be appropriate on roof upstands, around rooflights, on shed roofs etc.

The hand inductor is controlled via the main tool and automatically adopts all functions and settings from it!

1. Unplug the inductor from the main tool
2. Plug the hand inductor into the main tool (see Fig. 2).
3. Carry out calibration as described in the "Calibration" section.
4. For further steps, see "Operation: welding" section.

☞ **Please note that the underside of the inductor must be positioned parallel to the top face of the plate!**



## Technical data

### Tool dimensions:

Height: approx. 1100 mm (assembled)  
Depth: 600 mm  
Weight: 18.5 Kg (complete)

### Induction generator:

Electrical connection: 110V / 230 V  
Power consumption: 1500 Watt  
Frequency: 50 Hz / 60 Hz

### Dimensions of transport box:

L/W/H: 770 x 560 x 500 mm  
Weight: 19.5 Kg

## Error messages

Error message	Cause	Action
Error <b>01</b> voltage problem	Voltage supply is too low for the tool	Press the <b>OK</b> button. <ul style="list-style-type: none"> <li>Choose an electricity circuit with less load</li> <li>Reduce the length of the supply cable</li> <li>Change the supply voltage to 230 V (GB, USA, CAN).</li> </ul>
Error <b>02</b> overload	Max. permitted inductor current exceeded	Press the <b>OK</b> button. <ul style="list-style-type: none"> <li>Restart the welding process</li> <li>Should this error message be displayed repeatedly, please contact your SFS intec service provider.</li> </ul>
Error <b>03</b> system error	System error	Press the <b>OK</b> button. <ul style="list-style-type: none"> <li>Restart the welding process</li> <li>Should this error message be displayed repeatedly, please contact your SFS intec service provider.</li> </ul>
Error <b>04</b> system too hot	Tool has heated up too much	Press the <b>OK</b> button. Turn off the tool at the main switch and allow to cool down.
Error <b>05</b> welding not complete	Required welding temperature not reached	Press the <b>OK</b> button. Allow the weld point to cool down and restart welding process.
Error <b>06</b> no plate	Max. search time exceeded	Press the <b>OK</b> button. <ul style="list-style-type: none"> <li>Check that there is a stress plate</li> <li>Allow the weld point to cool down and restart welding process.</li> <li>Should this error message be displayed several times, recalibrate the tool.</li> </ul>
Error <b>07</b> plate lost	Inductor has been accidentally moved during the welding process	Press the <b>OK</b> button. Allow the weld point to cool down and restart welding process.
Error <b>08</b> temperature sensor	Temperature sensor defective	Press the <b>OK</b> button. Contact your SFS intec service provider.
Error <b>09</b> no calibration	The program used has not been calibrated	Press the <b>OK</b> button. Calibrate the tool in accordance with the "Calibration" section.
Error <b>10</b> mains voltage	Permissible input voltage too low	Press the <b>OK</b> button. <ul style="list-style-type: none"> <li>Choose an electricity circuit with less load</li> <li>Reduce the length of the supply cable</li> <li>Change the supply voltage to 230 V (GB, USA, CAN).</li> </ul>

## Disposal

The tool must not be disposed of with household refuse. Dispose of the tool at the disposal points provided for this type of equipment in accordance with the national or local regulations.

The tool must be disposed of in accordance with the European Directive 2002/96/EC (WEEE). This directive regulates the return and recycling of waste equipment within the EU.



## Maintenance, service and warranty

- Regularly clean the tool using a soft cloth and mild cleansing solution.
- Protect the tool from moisture and dirt.

### Electrical maintenance

On principle, electrical equipment may only be serviced and repaired by qualified technicians.

### Service

For technical information, please contact SFS intec tool service.

### Warranty

1. This induction welding tool has been carefully checked, tested and subjected to strict quality control.
2. We warrant the rectification, free of charge, of defects on the induction welding tool that occur within 24 months of the date of sale to the end user and that are due to a material or manufacturing fault. Individual special regulations apply to the conditions of the warranty in some countries. We reserve the right to rework defective parts or replace them with new ones. The ownership of the replaced parts is transferred to us.
3. Improper usage or handling, as well as the opening of the tool by unauthorised repair centres, will render void any claims under the warranty. The warranty excludes the following: damage caused by penetration of water or other liquids, a cut or damaged cable, damage to the electronics and mechanical damage caused by overloading. Likewise excluded are wear parts such as the induction coil, gliding foil etc.
4. Claims under the warranty can only be accepted if defects (as well as transport damage) are notified without delay. The statute of limitations is not automatically extended by the provision of service under the warranty.
5. If you wish to make a claim under the warranty, please send the original proof of purchase, together with the tool, to one of our SFS sales outlets. You will find these at [www.sfsintec.biz](http://www.sfsintec.biz).
6. Any further claims by the purchaser – in particular the right to rescission, price reduction or claims for damages – are excluded due to the warranty obligations undertaken by us, as far as permitted by the law.
7. The purchaser is entitled, at the purchaser's choice, to a price reduction (reduction of the purchase price) or rescission (annulment of the contract of purchase), if we are unable to rectify within a reasonable period any defects that may occur.

## Declaration of conformity

We SFS intec AG  
Division Construction  
Rosenbergsaustr. 10  
CH-9435 Heerbrugg

hereby declare that the products in the series

**Type: *isoweld*™ 3000**

comply with all the essential requirements of the following directives:

**2006/95/EC EU Low Voltage Directive**  
**2004/108/EC EU EMC Directive**

Person authorised to compile the technical documentation as per Annex VII A of the directive 2006/42/EC:

**Daniel Gasser**  
**SFS intec AG**  
**Rosenbergsaustr. 10**  
**CH-9435 Heerbrugg**

Harmonised standards applied:

ISO 12100-1, ISO 12100-2, EN 60204-1, EN 61000-6-2, EN 61000-6-3, EN 61000-6-4



**Peter Savoie**  
Head of Quality Management,  
Environment and Safety  
SFS intec AG



**Daniel Gasser**  
Head of Product Development,  
SFS intec AG

In the case of modification of the tool this declaration and the warranty will be rendered void.

**We reserve the right to make modifications!**