



## **HM806T\_R26** **TRANSFORMER**

### **FULLY-AUTOMATIC UNIT**

The HM806T\_R26 is a fully-automatic, six-channel heattreatment -unit for preheating and annealing metal workpieces. The output-power of the model HM806T\_R26 is thyristor-controlled, which enables the use of different sizes of heating elements. Setting, control, monitoring and documentation of the heattreatment -parameters are carried out by the computerized HeatMasters' Control System. The HM806T\_R26 provides accurate heat-treatment and easy documentation. The HM806T\_R26 can be long-distance controlled by a gsm-dataline.



**HEATMASTERS®**  
*the wizards of metal*



# HM806T\_R26 TRANSFORMER

## PROGRAMMING

The heat-treatment -parameters are programmed in the memory of the HM-Rigel26 -controller and the heating can be started at any desired time. The HM806\_R26/HM806T\_R26 will carry out the programmed heat-treatment -process according to the given phases.

## DATA REGISTRATION

The unit registers the achieved heat-treatment -results in its memory, which enables easy preparation of the heat-treatment -documents. A separate temperature recorder is not needed.

## CAPACITY

The HM806T\_R26 has six heating-channels and six independent programming alternatives. The signal lights of the HM806T\_R26 will indicate any disturbances in the electric network and/or in the heating elements, as well as any other disturbances during the heat-treatment.

*HM806T\_R26 Back*



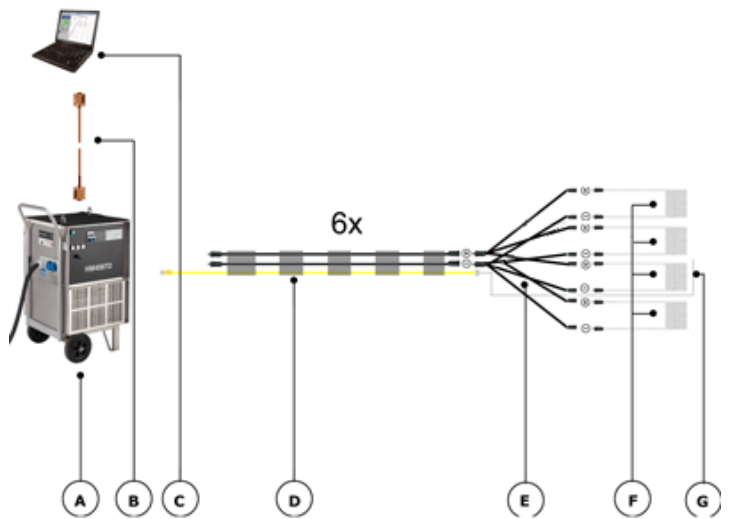
## BASIC EQUIPMENT HM806T\_R26

Basic equipment combination of HM806T\_R26 includes items mentioned in table below

### HM806T\_R26 equipment

HM806T\_R26 -standard combination:

Qty	Code	Product
A	1	1008502 HM806T_R26 heat treatment unit
B	1	1300502 Data cable between the PC and the heating unit
C	1	HM25 software (PC)
D	6	1101010 Secondary cable set-50-12,5
E	12	1102006 Splitter-4-16-2,0
F	24	200xxxx Heating elements
G	6	1600804 Thermocouple wire



**Secondary cables are marked with channel number to avoid wrong connections.**

**Cables are also marked with heating unit's serial number, so they are following the machine everywhere.**

**Heat treatment certificates can be printed with a normal office printer from the PC's memory.**

## ACCESSORIES USED WITH HM806T\_R26 UNIT

Following optional accessories are available for HM806T\_R26 heat treatment equipment:

Code	Product
1200506	Compensating cable-13,5 Additional cable when using two measuring points in one channel
1101026	Secondary cable extension set-50-12,5 - L = 12,5 m - (+/-) power cables Ø50mm <sup>2</sup> - Compensating cable Cables binded together with shrink plastic
1101034	Secondary cable extension set-50-25,0 - L = 25,0 m - (+/-) power cables Ø50mm <sup>2</sup> - Compensating cable Cables binded together with shrink plastic
3900557	HM-Rigel26-GSM set Enables longdistance control and alarms
3900534	HM-Rigel26-RK6 card Enables six extra measuring points
2102006	Radio modem set
1300506	USB-RS232 adapter

**Compensating cable-13,5 is a single cable for extra T/C of the heating channel. The cable can be integrated to the secondary cable set if so required.**

**Standard length of secondary cable set is 12,5 m and it can be extended with cable sets mentioned in table. Cables are made of several sets, so they are easier to handle.**

**HM-Rigel26-GSM set enables wireless contact to the heating unit from the PC, alarms to gsm phone and to receive information of the status of the heating process to the gsm phone.**

**HM-Rigel26-RK6 card enables to measure and record temperature from six extra measuring points. The feature is for recording only.**

**Radio modem technology gives possibility for wireless connection between the PC and the heating unit. This solution is mostly used on site operations. Depending of the enviroment and used antenna the distance can be even 2000 m.**

## HM406T\_R26 TECHNICAL DATA

Connection voltage	400V/3-phase/50Hz
Heating power	80 kVA;ED 100%
Fuse	120A
Secondary voltage	70V
Main switch	With ground fault (circuit) interrupter
Heating channels	6 x 200A
Additional outputs	2 x 230V, 10A
Heating elements	24 heating elements can be connected. Four elements per channel
Temperature range	20 ... 1050 °C
Control system	HM-Rigel26 controller with HM25 software
Alarm system	Signal lights
	Optional long distance alarm to a mobile phone when using HM-Rigel26 GSM alarm card
Dimensions	
Length, mm	900
Width, mm	600
Height, mm	1020
Weight, kg	320



**HM190 T/C attachment unit  
including leather case**



**Thermocouple wire**



**Steel band and the case**

## TOOLS NEEDED IN THE HEAT TREATMENT WORK

Following tools and consumables are necessary in most heat treatment operations with HM806T\_R26 and other heat treatment units:

Code	Product
1500510	HM190 T/C attachment unit including leather case
1600804	T/C wire-K-0,8-871, Thermocouple wire, k-type, Ø0,8mm, heat resistance up to 870 °C, 1 coil = 300m
1600805	T/C wire-K-0,8-1427, Thermocouple wire, k-type, Ø0,8mm, heat resistance up to 1200 °C, 1 coil = 300m
1700502	Band tensioner
1700504	Band clip sealer
1700506	Steel band 0,5x16mm
1700507	Case for steel band
1700508	Band clip (2000 pc/pack)
1801506	Class fiber cloth, in preheating works
1800505	Mineral wool PV100-VM50, in post weld heat

### Accessories

Code	Product
1300506	USB-RS232 adapter



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