



# HM35 INU INVERTER

## MANUAL AND SEMI-AUTOMATIC HEATING UNITS

HM35 is an inverter-based heating unit which can be used both for induction and resistance heating.

### USER BENEFITS

Its small size and lightweight makes it easy to handle and transport.

Multipurpose unit that is great for various jobs.

Heatmasters control system makes it easy to use.

Powerful induction allows a fast and smooth heating process.



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# HM35 INU INVERTER

HM35 can be used for preheating, post weld heat treatment (pwht), shrink-fitting and other purposes.

There are two options for controlling HM35: stepless manual and semi-automatic heating power adjustment.

Temperature is measured from the surface of the work piece. A mains current socket (AC) provides power for the unit which means that HM35 stands next to the workpiece and adjustments to the heating are convenient to make.

HM35 maintains a workpiece at an even temperature during welding.

*HM35 back*



## BASIC EQUIPMENT HM35 =BI

HM35 is a multipurpose heating unit which uses induction coils or heating resistors. Depending on the size of the pipe or workpiece, one or two units are used. Induction coils or resistors are placed on both sides of the weld seam and when using only one heating unit they are connected in series with a jumper cable.

Induction coils are easy to install and they can be used in tight working places.



*Secondary cable*



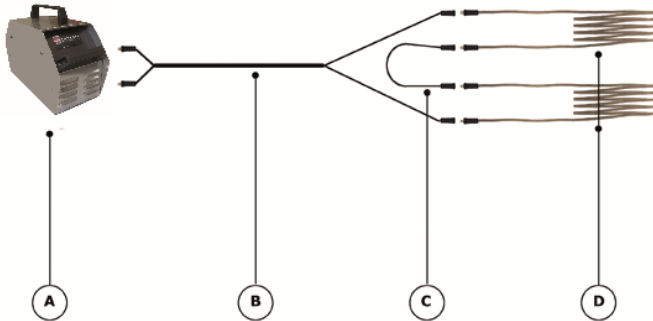
*Jumper cable*



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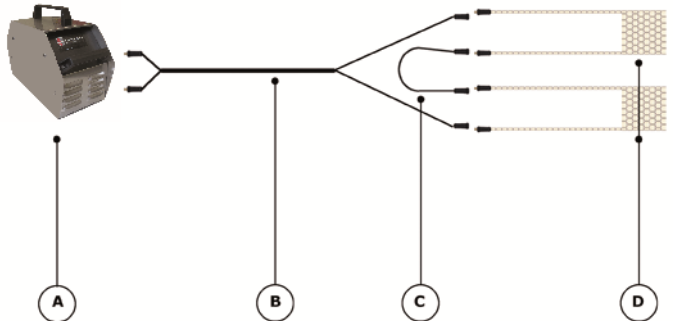
## INDUCTION HEATING

Equipment when using one HM35 unit for heating a pipe weld with maximum diameter of Ø355 mm



## RESISTANCE HEATING

Equipment when using one HM35 unit for heating a pipe weld with half size heating mats



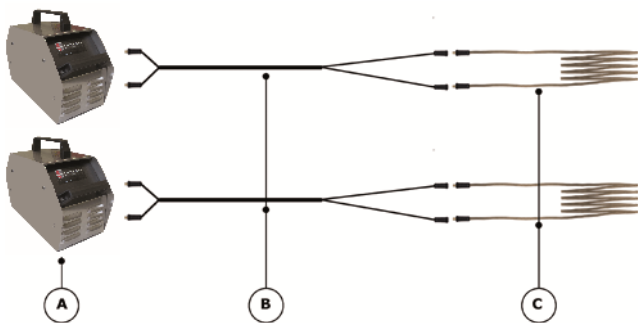
### HM35 unit with two induction coils

Qty	Code	Product
A 1	1000520	HM35 heating unit
B 1	1101002	Secondary set 2,5, L=2,5m
C 1	1102502	Jumper cable 0,5, L=0,5m
D 2	14005xx	Induction coil HM-IC-xx, length according to the pipe $L=400+4 \times 3,14 \times Du$

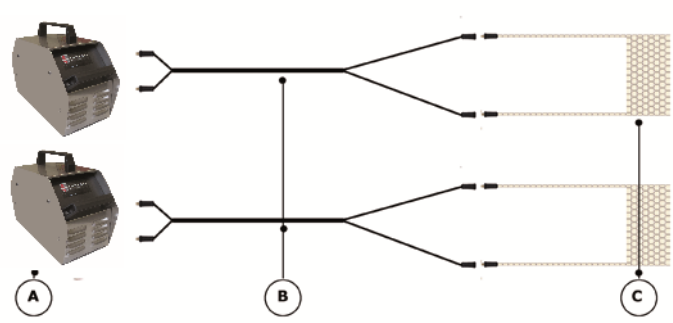
### HM35 unit with two half size heating mats

Qty	Code	Product
A 1	1000520	HM35 heating unit
B 1	1101002	Secondary set 2,5, L=2,5m
C 1	1102502	Jumper cable 0,5, L=0,5m
D 2	20011xx	VHVP type, half size heating mat

Equipment when using two HM35 units for heating a pipe weld with maximum diameter of Ø355-508 mm



Equipment when using two HM35 units for heating a pipe weld with full size heating mats



### Using two HM35 unit with induction coils

Qty	Code	Product
A 2	1000520	HM35 heating unit
B 2	1101002	Secondary set 2,5, L=2,5m
C 2	14005xx	Induction coil HM-IC-xx, length according to the pipe $L=400+4 \times 3,14 \times Du$

### Using two HM35 units with full size heating mats

Qty	Code	Product
A 2	1000520	HM35 heating unit
B 2	1101002	Secondary set 2,5, L=2,5m
C 2	2000xxx	VHV type, full size heating mat

- There should be minimum four (4) laps of coil around the pipe
- Length of tails for connected cables should be 200 mm each
- Du = external pipe diameter





SYVWnci f'ck b Vt'cf

## HM35 INU TECHNICAL DATA

Connection voltage	220 ... 240V/1-phase/50Hz
Power	3,5 kW; ED 100%
Fuse	16A slow
Secondary voltage	0 ... 68V
Secondary current	0 ... 52A
Secondary frequency	18 000 Hz
Heating channels	1
Temperature range	max. 750 °C, induction heating
	max. 1050 °C, resistance heating
Heating elements	Induction coil with maximum length of 10,0 m or resistance heating mat with maximum power of 3,45kW can be connected.
Control system	Heatmasters manual or semi-automatic controller
Alarm system	Signal lights
Dimensions	
Length	420 mm
Width	180 mm
Height	280 mm
Weight	11 kg

## TOOLS AND ACCESSORIES

Following tools and accessories are useful when using resistance heating mats with HM35

Code	Product
1700502	Band tensioner
1700504	Band clip sealer
1700506	Steel band 0,5x16mm
1700507	Case for steel band
1700510	Band clip (2000 pc/pack)
1801506	Class fiber cloth, for preheating

When using induction heating cover the heating area with mineral wool or ceramic blanket.

Code	Product
1800505	Mineral wool
1801025	Ceramic blanket-25-128



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