

# HSK

## Hand Welding Extruders



*HSK10DI120 with  
Digital Pre-heater*

# HSK / PWS

plastic welding equipment  
plastic welding school

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## Hand welding extruder HSK10 DE compact



### BASIC EXTRUDER

- Extrusion welding from PE, PP, PVC
- temperature probe, location in the melt chamber
- rod feeding, no additional gearing
- Control units for actual / desired mass temperature
- Cold start protection
- Rod diameter 4 mm (5/32") or 3mm (1/8")
- 1 pce nozzle blank included

### TECHNICAL DATA

Output	1.0 kg/h (with PE rod 4mm)
Heating extruder	300W / air 1300W
Drive	460W
Voltage	110V 50/60Hz or 230V 50Hz
Weight	3.2 kg or 7 lbs
Guarantee	screw and cylinder 24 months

### DIMENSIONS

400 x 120 x 200 mm  
16 x 5 x 8 in

### HSK10 DE (WITH HOT AIR BLOWER)

- Works as basic extruder, without external air supply
- Hot air blower controlled (air quantity 300 l/min)
- Technical data see basic extruder
- Heating hot air blower            1300 W

### ADDITIONAL EQUIPMENT

▪ Welding nozzles	Extruder nozzle preheating	Angle adaptor
▪ Transportation box	Prolongation	Air compactor
▪ Welding rod	Widen	

Technical execution subject to modifications

## Hand welding extruder HSK18 /HSK18 E



### BASIC EXTRUDER

- Extrusion welding from PE, PP, PVC
- rod feeding, no additional gearing
- Permanent speed control (no digital controls)
- Rod diameter 3 and 4 mm
- 1 pce nozzle blank included

### TECHNICAL DATA

Output	1.8 kg/h (with PE rod 4 mm)
Heating extruder	with air 3000 W
Drive	750 W
Air requirement	300 l/min.
Voltage	230 V / 50Hz
Weight	4.8 kg
Guarantee	screw and cylinder 24 months

### DIMENSIONS

450 x 75 x 240 mm
18 x 3 x 9.5 in

### HSK18 E (WITH HOT AIR BLOWER)

- Works as basic extruder, without external air supply
- Hot air blower controlled (air quantity 300 l/min)
- Technical data see basic extruder
- Heating hot air blower 3000 W

### ADDITIONAL EQUIPMENT

▪ Welding nozzles	Extruder nozzle preheating	Angle adaptor
▪ Transportation box	Prolongation	Air compactor
▪ Welding rod	Widen	

Technical execution subject to modifications

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## Hand welding extruder HSK18 RSX /HSK18 RFX



<p><b>BASIC EXTRUDER</b></p> <ul style="list-style-type: none"> <li>▪ Extrusion welding from PE, PP, PVC</li> <li>▪ temperature probe, location in the melt chamber</li> <li>▪ rod feeding, no additional gearing</li> <li>▪ Permanent speed control</li> <li>▪ Control units for actual / desired mass and air temperature</li> <li>▪ Cold start protection</li> <li>▪ Rod diameter 3 and 4 mm</li> <li>▪ 1 pce nozzle blank included</li> </ul>		
<p><b>TECHNICAL DATA</b></p> <p>Output 1.8 kg/h (4 lbs) (with PE rod 4 mm)</p> <p>Heating extruder 500 W / air 2200 W</p> <p>Drive 750 W</p> <p>Air requirement 300 l/min.</p> <p>Voltage 230V 50Hz or 120V 50/60Hz</p> <p>Weight 5.3 kg</p> <p>Guarantee screw and cylinder 24 months</p>		<p><b>DIMENSIONS</b></p> <p>450 x 140 x 260 mm</p> <p>18 x 5.5 x 10 in</p>
<p><b>HSK18 RSX (WITH HOT AIR BLOWER)</b></p> <ul style="list-style-type: none"> <li>▪ Works as basic extruder, without external air supply</li> <li>▪ Hot air blower controlled (air quantity 300 l/min)</li> <li>▪ Technical data see basic extruder</li> <li>▪ Heating hot air blower 2200 W</li> </ul>		
<p><b>ADDITIONAL EQUIPMENT</b></p> <ul style="list-style-type: none"> <li>▪ Welding nozzles Extruder nozzle preheating Angle adaptor</li> <li>▪ Transportation box Prolongation Air compactor</li> <li>▪ Welding rod Widen</li> </ul>		
<p>Technical execution subject to modifications</p>		

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## Hand welding extruder HSK18 GSX Pellet-Fed (Granulate)



### BASIC EXTRUDER

- Extrusion welding from PE, PP, PVC
- temperature probe, location in the melt chamber
- Permanent speed control
- Control units for actual / desired mass and air temperature
- Cold start protection
- 1 pce nozzle blank included

### TECHNICAL DATA

Output	1.8 kg/h (4 lbs) (with PE granules)
Heating extruder	500 W / air 2200 W
Drive	750 W
Air requirement	300 l/min.
Voltage	230V 50Hz or 120V 50/60Hz
Weight	6.3 kg
Guarantee	screw and cylinder 24 months

### DIMENSIONS

600 x 200 x 430 mm
23.5 x 8 x 17 in

### HSK18 GSX (WITH HOT AIR BLOWER)

- Works as basic extruder, without external air supply
- Hot air blower controlled (air quantity 300 l/min)
- Technical data see basic extruder
- Heating hot air blower 2200 W

### ADDITIONAL EQUIPMENT

▪ Welding nozzles	Extruder nozzle preheating	Angle adaptor
▪ Transportation box	Prolongation	Air compactor
▪ Granules	Widen	

Technical execution subject to modifications

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### Hand welding extruder HSK22 RSX (Standard and Data Versions)



<b>BASIC EXTRUDER</b> <ul style="list-style-type: none"> <li>▪ Extrusion welding from PE, PP, PVC and PVDF</li> <li>▪ temperature probe, location in the melt chamber</li> <li>▪ rod feeding, no additional gearing</li> <li>▪ Control units for actual / desired mass and air temperature and actual speed</li> <li>▪ Cold start protection</li> <li>▪ Rod diameter 3 and 4 mm</li> <li>▪ 1 pce nozzle blank included</li> <li>▪ Speed control</li> </ul>		<b>Data Version:</b> <ul style="list-style-type: none"> <li>▪ Digital recording of the welding temperature, ambient temperature, the speed and the welding times on SD Card</li> <li>▪ Welder programmed with its own SD card</li> <li>▪ Pre-programmable welding and building materials on SD card</li> <li>▪ Evaluated logs and charts on Excel</li> </ul>
<b>TECHNICAL DATA</b>	<b>DIMENSIONS</b>	
Output Heating extruder Drive Air requirement Voltage Weight Guarantee	2.3 kg/h (with PE rod 4mm) 700W / air 2300W 740W, (Data version: Power drive: 2000W) 230V 50Hz 6.32 kg or 14 lbs (Data version 19 lbs) Screw and cylinder 24 months	600 x 140 x 210 mm 23.5 x 5.5 x 8 in
<b>HSK22RSX (WITH HOT AIR BLOWER)</b> <ul style="list-style-type: none"> <li>▪ Works as basic extruder, without external air supply</li> <li>▪ Hot air blower controlled (air quantity 300 l/min)</li> <li>▪ Technical data see basic extruder</li> <li>▪ Heating hot air blower 2300 W</li> </ul>		
<b>ADDITIONAL EQUIPMENT</b>		
<ul style="list-style-type: none"> <li>▪ Welding nozzles</li> <li>▪ Transportation box</li> <li>▪ Welding rod</li> </ul>	<ul style="list-style-type: none"> <li>Extruder nozzle preheating</li> <li>Prolongation</li> <li>Widen</li> </ul>	<ul style="list-style-type: none"> <li>Angle adaptor</li> <li>Air compactor</li> </ul>
Technical execution subject to modifications		

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## Hand welding extruder HSK28 RSX (Standard and Data Versions)



### BASIC EXTRUDER

- Extrusion welding from PE, PP, PVC and PVDF
- temperature probe, location in the melt chamber
- rod feeding, no additional gearing
- Control units for actual / desired mass and air temperature and actual speed
- Cold start protection
- Rod diameter 3 and 4 mm
- 1 pce nozzle blank included
- Speed control

### Data Version:

- Digital recording of the welding temperature, ambient temperature, the speed and the welding times on SD Card
- Welder programmed with its own SD card
- Pre-programmable welding and building materials on SD card
- Evaluated logs and charts on Excel

### TECHNICAL DATA

Output	3 kg/h (with PE rod 5mm)
Heating extruder	700W / air 2300W
Drive	750W, (Data version: Power drive: 2000W)
Air requirement	230V 50Hz
Voltage	7.4 kg or 16 lbs (Data version 19 lbs)
Weight	Screw and cylinder 24 months
Guarantee	

### DIMENSIONS

600 x 140 x 210 mm  
23.5 x 5.5 x 8 in

### HSK28RSX (WITH HOT AIR BLOWER)

- Works as basic extruder, without external air supply
- Hot air blower controlled (air quantity 300 l/min)
- Technical data see basic extruder
- Heating hot air blower 2300 W

### ADDITIONAL EQUIPMENT

▪ Welding nozzles	Extruder nozzle preheating	Angle adaptor
▪ Transportation box	Prolongation	Air compactor
▪ Welding rod	Widen	

Technical execution subject to modifications

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## Hand welding extruder HSK26 GSX Pellet-Fed (Granulate)



### BASIC EXTRUDER

- Extrusion welding from PE, PP, PVC and PVDF
- temperature probe, location in the melt chamber
- Control units for actual / desired mass and air temperature and actual speed
- Permanent speed control
- Cold start protection
- 1 pce nozzle blank included
- Speedcontrol

### TECHNICAL DATA

Output	2.5 kg/h (with PE pellets)
Heating extruder	700W / air 2300W
Drive	740W
Air requirement	300 l/min
Voltage	230V 50Hz
Weight	7.4 kg or 16 lbs
Guarantee	Screw and cylinder 24 months

### DIMENSIONS

600 x 200 x 430 mm  
23.5 x 8 x 17 in

### HSK26 GSX (WITH HOT AIR BLOWER)

- Works as basic extruder, without external air supply
- Hot air blower controlled (air quantity 300 l/min)
- Technical data see basic extruder
- Heating hot air blower 2300W

### ADDITIONAL EQUIPMENT

- |                      |                            |               |
|----------------------|----------------------------|---------------|
| ▪ Welding nozzles    | Extruder nozzle preheating | Angle adaptor |
| ▪ Transportation box | Prolongation               | Air compactor |
| ▪ Widen              |                            |               |

Technical execution subject to modifications



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## Hand welding extruder HSK40 /HSK40 E



### BASIC EXTRUDER

- Extrusion welding from PE, PP, and PVDF
- rod feeding, no additional gearing
- Cold start protection
- Rod diameter 3, 4 and 5 mm
- 1 pce nozzle blank included

### TECHNICAL DATA

Output	3.8 kg/h (with PE rod 5 mm)
Heating extruder	with air heater 2200 W
Drive	1600W
Air requirement	300 l/min. (version "E")
Voltage	230 V / 50Hz
Weight	8 kg
Guarantee	screw and cylinder 24 months

### DIMENSIONS

600 x 140 x 210 mm
23.5 x 5.5 x 8 in

### HSK40 E (WITH HOT AIR BLOWER)

- Works as basic extruder, without external air supply
- Hot air blower controlled (air quantity 300 l/min)
- Technical data see basic extruder
- Heating hot air blower 2200 W

### ADDITIONAL EQUIPMENT

▪ Welding nozzles	Extruder nozzle preheating	Angle adaptor
▪ Transportation box	Prolongation	Air compactor
▪ Welding rod	Widen	

Technical execution subject to modifications

## Hand welding extruder HSK40 RSX /HSK40 RFX



### BASIC EXTRUDER

- Extrusion welding from PE, PP, PVDF
- temperature probe, location in the melt chamber
- rod feeding, no additional gearing
- Control units for actual / desired mass and air temperature
- Cold start protection
- Rod diameter 3,4 and 5 mm
- 1 pce nozzle blank included

### TECHNICAL DATA

Output	3.8 kg/h (with PE rod 5 mm)
Heating extruder	700 W / air 2200 W
Drive	1150W
Air requirement	300 l/min.
Voltage	230 V / 50Hz
Weight	8.8 Kg / 19.4 lbs
Guarantee	screw and cylinder 24 months

### DIMENSIONS

600 x 140 x 210 mm
23.5 x 5.5 x 8 in

### HSK40 RSX (WITH HOT AIR BLOWER)

- Works as basic extruder, without external air supply
- Hot air blower controlled (air quantity 300 l/min)
- Technical data see basic extruder
- Heating hot air blower 2200 W

### ADDITIONAL EQUIPMENT

▪ Welding nozzles	Extruder nozzle preheating	Angle adaptor
▪ Transportation box	Prolongation	Air compactor
▪ Welding rod	Widen	

Technical execution subject to modifications

## Hand welding extruder HSK60 D /HSK60 DE



### BASIC EXTRUDER

- Extrusion welding from PE, PP, PVC
- temperature probe, location in the melt chamber
- rod feeding, no additional gearing
- Permanent speed control
- Control units for actual / desired mass and air temperature
- Cold start protection
- Rod diameter 3,4 and 5 mm
- 1 pce nozzle blank included

### TECHNICAL DATA

Output	6 kg/h (with PE rod 5mm)
Heating extruder	1200 W / air 3000 W
Drive	2000 W
Air requirement	300 l/min.
Voltage	3 x 230 V / 50Hz
Weight	11.4 kg
Guarantee	screw and cylinder 24 months

### DIMENSIONS

680 x 155 x 340 mm
27 x 6 x 13 in

### HSK60 DE (WITH HOT AIR BLOWER)

- Works as basic extruder, without external air supply
- Hot air blower controlled (air quantity 300 l/min)
- Technical data see basic extruder
- Heating hot air blower                    3000 W

### ADDITIONAL EQUIPMENT

▪ Welding nozzles	Extruder nozzle preheating	Angle adaptor
▪ Transportation box	Prolongation	Air compactor
▪ Welding rod	Widen	

Technical execution subject to modifications.

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## Hand welding extruder HSK60 D-G /HSK60 DE-G



### BASIC EXTRUDER

- Extrusion welding from PE, PP, PVDF
- temperature probe, location in the melt chamber
- Permanent speed control
- Control units for actual / desired mass and air temperature
- Cold start protection
- 1 pce nozzle blank included

### TECHNICAL DATA

Output	6 kg/h (with PE)
Heating extruder	1000W / air 3000W
Drive	2000 W
Air requirement	300 l/min.
Voltage	3 x 230 V / 50Hz
Weight	11.4 kg
Guarantee	screw and cylinder 24 months

### DIMENSIONS

680 x 155 x 340 mm  
27 x 6 x 13 in

### HSK60 DE-G (WITH HOT AIR BLOWER)

- Works as basic extruder, without external air supply
- Hot air blower controlled (air quantity 300 l/min)
- Technical data see basic extruder
- Heating hot air blower 3000 W

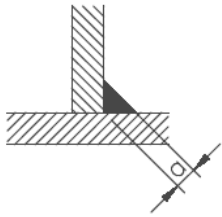
### ADDITIONAL EQUIPMENT

▪ Welding nozzles	Extruder nozzle preheating	Angle adaptor
▪ Transportation box	Prolongation	Air compactor
▪ Welding rod	Widen	

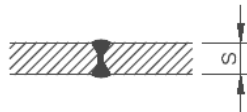
Technical execution subject to modifications.

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## Welding Nozzles



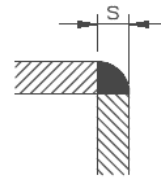
T butt weld  
A - nozzle



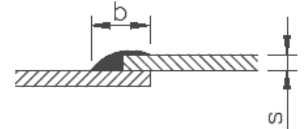
Double v butt weld  
DV - nozzle



Single v butt weld  
V - nozzle



Corner weld  
E - nozzle



Lap weld  
U - nozzle



T butt weld									
Thickness „s“ in mm	5	8	10	12	15	20	25	30	35
nozzle	A 3,5	A 5,6	A 7	A 8,4	A 10,5	A 14	A 17,5	A 21	A 24,5

Double v butt weld									
Thickness „s“ in mm	5	8	10	12	15	20	25	30	35
nozzle	X 5	X 8	X 10	X 12	X 15	X 20	X 25	X 30	X 35

Single v butt weld									
Thickness „s“ in mm	5	8	10	12	15	20	25	30	35
nozzle	V 5	V 8	V 10	V 12	V 15	V 20	V 25	V 30	V 35

Corner butt weld									
Thickness „s“ in mm	5	8	10	12	15	20	25	30	35
nozzle	E 5	E 8	E 10	E 12	E 15	E 20	E 25	E 30	E 35

Lap weld									
Thickness „s“ in mm	3	5	6	8	10				
nozzle	U 3	U 6	U 6	U 8	U 10				



Nozzle blank

Type 1 - 30 x 50 mm (1.1 x 2")  
 Type 2 - 40 x 52 mm (1.5 x 2.04")  
 Type 3 - 90 x 70 mm (3.5 x 2.7")



NR-20  
20mm Round



NR-30  
30mm Round



NR-40  
40mm Round