



# TRACK 400R - DVS 2207-1:2016

## PARÁMETROS DE FUSIÓN A TOPE PARA TUBOS Y ACCESORIOS DE PE100 - SDR 7.4/SDR 9/SDR 11/SDR 13.6

### BUTT FUSION PARAMETERS FOR POLYETHYLENE (PE) PIPES AND FITTINGS - SDR 7.4/SDR 9/SDR 11/SDR 13.6

| FASE<br>PHASE | DN  | 75  |       |       |       | 90    |       |       |       | 110   |       |       |       | 125   |       |       |       | 140   |       |       |       | 160   |       |       |       | 180   |       |       |       | 200   |       |       |       | 225   |       |       |       | 250   |       |       |       | 280   |       |       |       | 315   |       |       |       | 355   |       |       |       | 400   |       |       |       |
|---------------|---|---|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
|               |   | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       |
| 1             | PRESIÓN DE REFRENTADO<br>TRIMMING PRESSURE  | PRESIÓN DE ARRASTRE + la presión necesaria para que se produzca el corte de viruta<br>DRAG PRESSURE + the necessary pressure to produce the trimming operation  |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|               | TEMPERATURA PLACA HEATING<br>PLATE TEMPERATURE  | 220°C ±10°C   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
| 2             | PRESIÓN PRE-CALENTAMIENTO (bar)<br>Superficie pistón 12.56 cm <sup>2</sup><br>HEAT SOAK PRESSURE (bar)<br>Piston area 12.56 cm <sup>2</sup> | AÑADIR PRESIÓN DE ARRASTRE / ADD DRAG PRESSURE  |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|               | TIEMPO PRE-CALENTAMIENTO<br>HEATING TIME  | HASTA LA FORMACIÓN DEL CORDÓN / AS BEAD IS FORMED   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
| 3             | CALENTAMIENTO<br>HEAT SOAK PRESSURE   | INMOVILIZACIÓN (DESPRESURIZAR LA PRESIÓN DE LA FASE 2 DE PRE-CALENTAMIENTO BAJANDO LA VÁLVULA DE DESCARGA) / IMMOBILIZATION (RELEASE THE PHASE 2 HEAT SOAK PRESSURE MOVING DOWNWARDS THE DRAIN VALVE LEVER)<br>¡ ATENCIÓN ! REDUCIR LA PRESIÓN A LA MÍNIMA NECESARIA (NO POR DEBAJO DEL ARRASTRE) PARA MANTENER EL CONTACTO DE LA PLACA CON LOS TUBOS Y SUBIR LA PALANCA DE LA VÁLVULA DE DESCARGA<br>ATTENTION ! REDUCE THE PRESSURE TO A MINIMUM NECESSARY TO KEEP THE CONTACT BETWEEN HEATING PLATE AND PIPE ENDS; THEN MOVE UPWARDS THE DRAIN VALVE LEVER |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|               | TIEMPO DE CALENTAMIENTO<br>HEAT SOAK TIME (min:s)   | 01:43   | 01:24 | 01:08 | 00:55 | 02:03 | 01:41 | 01:22 | 01:06 | 02:31 | 02:03 | 01:40 | 01:21 | 02:51 | 02:20 | 01:54 | 01:32 | 02:37 | 02:07 | 01:43 | 03:39 | 02:59 | 02:26 | 01:58 | 04:06 | 03:21 | 02:44 | 02:13 | 04:34 | 03:44 | 03:02 | 02:27 | 05:08 | 04:11 | 03:25 | 02:46 | 05:42 | 04:39 | 03:47 | 03:04 | 06:23 | 05:12 | 04:14 | 03:26 | 07:11 | 05:50 | 04:46 | 03:53 | 08:05 | 06:35 | 05:22 | 04:21 | 09:07 | 07:25 | 06:04 | 04:54 |       |
| 4             | EXTRACCIÓN PLACA (s)<br>HEATER WITHDRAWAL (s)   | AÑADIR PRESIÓN DE ARRASTRE / ADD DRAG PRESSURE  |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|               | TIEMPO DE RAMPA (s)<br>CHANGEOVER TIME (s)  | HASTA LA FORMACIÓN DEL CORDÓN / AS BEAD IS FORMED   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
| 5             | PRESIÓN DE FUSIÓN (bar)<br>FUSION PRESSURE (bar)  | AÑADIR PRESIÓN DE ARRASTRE / ADD DRAG PRESSURE  |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|               | TIEMPO DE FUSIÓN (min:s)<br>Hasta 15°C<br>Up to 15°C<br>De 15°C a 25°C<br>From 15°C to 25°C<br>Desde 25°C<br>From 25°C                      | 8:19  | 6:59  | 5:50  | 4:48  | 9:42  | 8:10  | 6:50  | 5:41  | 11:30 | 9:42  | 8:06  | 6:46  | 12:47 | 10:47 | 9:05  | 7:32  | 14:09 | 11:53 | 9:57  | 8:19  | 16:04 | 13:18 | 11:10 | 9:22  | 18:00 | 14:47 | 12:20 | 10:20 | 20:01 | 16:26 | 13:29 | 11:14 | 22:29 | 18:21 | 15:04 | 12:27 | 24:58 | 20:23 | 16:39 | 13:37 | 27:54 | 22:47 | 18:34 | 15:09 | 31:13 | 25:33 | 20:53 | 17:04 | 34:58 | 28:44 | 23:31 | 19:04 | 39:17 | 32:12 | 26:34 | 21:28 |

## PARÁMETROS DE FUSIÓN A TOPE PARA TUBOS Y ACCESORIOS DE PE100 - SDR 17/SDR 21/SDR 26/SDR 33

### BUTT FUSION PARAMETERS FOR POLYETHYLENE (PE) PIPES AND FITTINGS - SDR 17/SDR 21/SDR 26/SDR 33

| FASE<br>PHASE | DN  | 75  |       |       |       | 90    |       |       |       | 110   |       |       |       | 125   |       |       |       | 140   |       |       |       | 160   |       |       |       | 180   |       |       |       | 200   |       |       |       | 225   |       |       |       | 250   |       |       |       | 280   |       |       |       | 315   |       |       |       | 355   |       |       |       | 400   |       |       |       |
|---------------|---|---|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
|               |   | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       | SDR   |       |       |       |
| 1             | PRESIÓN DE REFRENTADO<br>TRIMMING PRESSURE  | PRESIÓN DE ARRASTRE + la presión necesaria para que se produzca el corte de viruta<br>DRAG PRESSURE + the necessary pressure to produce the trimming operation  |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|               | TEMPERATURA PLACA HEATING<br>PLATE TEMPERATURE  | 220°C ±10°C   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
| 2             | PRESIÓN PRE-CALENTAMIENTO (bar)<br>Superficie pistón 12.56 cm <sup>2</sup><br>HEAT SOAK PRESSURE (bar)<br>Piston area 12.56 cm <sup>2</sup> | AÑADIR PRESIÓN DE ARRASTRE / ADD DRAG PRESSURE  |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|               | TIEMPO PRE-CALENTAMIENTO<br>HEATING TIME  | HASTA LA FORMACIÓN DEL CORDÓN / AS BEAD IS FORMED   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
| 3             | CALENTAMIENTO<br>HEAT SOAK PRESSURE   | INMOVILIZACIÓN (DESPRESURIZAR LA PRESIÓN DE LA FASE 2 DE PRE-CALENTAMIENTO BAJANDO LA VÁLVULA DE DESCARGA) / IMMOBILIZATION (RELEASE THE PHASE 2 HEAT SOAK PRESSURE MOVING DOWNWARDS THE DRAIN VALVE LEVER)<br>¡ ATENCIÓN ! REDUCIR LA PRESIÓN A LA MÍNIMA NECESARIA (NO POR DEBAJO DEL ARRASTRE) PARA MANTENER EL CONTACTO DE LA PLACA CON LOS TUBOS Y SUBIR LA PALANCA DE LA VÁLVULA DE DESCARGA<br>ATTENTION ! REDUCE THE PRESSURE TO A MINIMUM NECESSARY TO KEEP THE CONTACT BETWEEN HEATING PLATE AND PIPE ENDS; THEN MOVE UPWARDS THE DRAIN VALVE LEVER |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|               | TIEMPO DE CALENTAMIENTO<br>HEAT SOAK TIME (min:s)   | 00:45   | 00:36 | 00:29 | 00:23 | 00:54 | 00:43 | 00:35 | 00:28 | 01:06 | 00:53 | 00:42 | 00:34 | 01:14 | 01:00 | 00:48 | 00:39 | 01:23 | 01:07 | 00:54 | 00:43 | 01:35 | 01:17 | 01:02 | 00:49 | 01:47 | 01:26 | 01:09 | 00:55 | 01:59 | 01:36 | 01:17 | 01:02 | 02:14 | 01:48 | 01:26 | 01:09 | 02:28 | 01:59 | 01:36 | 01:17 | 02:46 | 02:14 | 01:47 | 01:26 | 03:07 | 02:30 | 02:01 | 01:37 | 03:31 | 02:49 | 02:16 | 01:49 | 03:57 | 03:11 | 02:33 | 02:03 |
| 4             | EXTRACCIÓN PLACA (s)<br>HEATER WITHDRAWAL (s)   | AÑADIR PRESIÓN DE ARRASTRE / ADD DRAG PRESSURE  |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|               | TIEMPO DE RAMPA (s)<br>CHANGEOVER TIME (s)  | HASTA LA FORMACIÓN DEL CORDÓN / AS BEAD IS FORMED   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
| 5             | PRESIÓN DE FUSIÓN (bar)<br>FUSION PRESSURE (bar)  | AÑADIR PRESIÓN DE ARRASTRE / ADD DRAG PRESSURE  |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|               | TIEMPO DE FUSIÓN (min:s)<br>Hasta 15°C<br>Up to 15°C<br>De 15°C a 25°C<br>From 15°C to 25°C<br>Desde 25°C<br>From 25°C                      | 4:00  | 3:12  | 2:35  | 02:03 | 4:43  | 3:49  | 3:07  | 2:29  | 5:41  | 4:38  | 3:44  | 3:01  | 6:17  | 5:12  | 4:14  | 3:28  | 6:55  | 5:46  | 4:43  | 3:49  | 7:45  | 6:29  | 5:22  | 4:19  | 8:35  | 7:07  | 5:55  | 4:48  | 9:26  | 7:49  | 6:29  | 5:22  | 10:24 | 8:40  | 7:07  | 5:55  | 11:18 | 9:26  | 7:49  | 6:29  | 12:27 | 10:24 | 8:35  | 7:07  | 13:30 | 11:26 | 9:34  | 7:53  | 15:30 | 12:39 | 10:32 | 08:44 | 17:21 | 14:04 | 11:37 | 09:42 |

# TRACK 400R - DVS 2207-11: 2017

## PARÁMETROS DE FUSIÓN A TOPE PARA TUBOS Y ACCESORIOS DE POLIPROPILENO (PP) - SDR 7.4/SDR 11/SDR 17.6

### BUTT FUSION PARAMETERS FOR POLYPROPYLENE (PP) PIPES AND FITTINGS - SDR 7.4/SDR 11/SDR 17.6

| FASE PHASE                              | DN   | 75  |       |       | 90    |       |       | 110   |       |       | 125   |       |       | 140   |       |       | 160   |       |       | 180   |       |       | 200   |       |       | 225   |       |       | 250   |       |       | 280   |       |       | 315   |       |    | 355  |  |  | 400 |  |  |
|---|--|---|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|----|------|--|--|-----|--|--|
|   |  | SDR   | 7.4   | 11    | 17.6  | 7.4   | 11    | 17.6  | 7.4   | 11    | 17.6  | 7.4   | 11    | 17.6  | 7.4   | 11    | 17.6  | 7.4   | 11    | 17.6  | 7.4   | 11    | 17.6  | 7.4   | 11    | 17.6  | 7.4   | 11    | 17.6  | 7.4   | 11    | 17.6  | 7.4   | 11    | 17.6  | 7.4   | 11 | 17.6 |  |  |     |  |  |
|   | ESPESOR/WALL THICKNESS   | 10.3  | 6.8   | 4.3   | 12.3  | 8.2   | 5.1   | 15.1  | 10    | 6.3   | 17.1  | 11.4  | 7.1   | 19.2  | 12.7  | 8     | 21.9  | 14.6  | 9.1   | 16.4  | 10.2  | 18.2  | 11.4  | 20.5  | 12.8  | 22.7  | 14.2  | 25.4  | 15.9  | 28.6  | 17.9  | 32.2  | 20.1  | 36.3  | 22.7  |       |    |      |  |  |     |  |  |
|   | PN   | 16  | 10    | 6     | 16    | 10    | 6     | 16    | 10    | 6     | 16    | 10    | 6     | 16    | 10    | 6     | 16    | 10    | 6     | 16    | 10    | 6     | 16    | 10    | 6     | 16    | 10    | 6     | 16    | 10    | 6     | 16    | 10    | 6     | 16    | 10    | 6  |      |  |  |     |  |  |
| PRESIÓN DE REFRENTADO TRIMMING PRESSURE |  | PRESIÓN DE ARRASTRE + la presión necesaria para que se produzca el corte de viruta<br>DRAG PRESSURE + the necessary pressure to produce the trimming operation  |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |    |      |  |  |     |  |  |
| TEMPERATURA PLACA HEATER TEMPERATURE    |  | 210°C ±10°C   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |    |      |  |  |     |  |  |
| 1                                       | PRESIÓN PRE-CALENTAMIENTO (bar) Superficie pistón 12.56 cm <sup>2</sup> HEAT SOAK PRESSURE (bar) Piston area 12.56 cm <sup>2</sup> | AÑADIR PRESIÓN DE ARRASTRE / ADD DRAG PRESSURE  |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |    |      |  |  |     |  |  |
|   | TIEMPO PRE-CALENTAMIENTO HEATING TIME  | HASTA LA FORMACIÓN DEL CORDÓN / AS BEAD IS FORMED   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |    |      |  |  |     |  |  |
|   | ALTURA CORDÓN (mm) BEAD HEIGHT (mm)  | 1   | 0.5   | 0.5   | 1     | 1     | 0.5   | 1     | 1     | 0.5   | 1     | 1     | 1     | 1.5   | 1     | 1     | 1     | 1     | 1     | 1     | 1     | 1     | 1     | 1.5   | 1     | 1     | 1     | 1.5   | 1     | 1     | 2     | 1     | 2     | 1.5   | 2     | 1.5   |    |      |  |  |     |  |  |
| CALENTAMIENTO HEAT SOAK PRESSURE        |  | INMOVILIZACIÓN (DESPRESURIZAR LA PRESIÓN DE LA FASE 2 DE PRE-CALENTAMIENTO BAJANDO LA VÁLVULA DE DESCARGA) / IMMOBILIZATION (RELEASE THE PHASE 2 HEAT SOAK PRESSURE MOVING DOWNWARDS THE DRAIN VALVE LEVER)   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |    |      |  |  |     |  |  |
|   |  | ¡ATENCIÓN! REDUCIR LA PRESIÓN A LA MÍNIMA NECESARIA (NO POR DEBAJO DEL ARRASTRE) PARA MANTENER EL CONTACTO DE LA PLACA CON LOS TUBOS Y SUBIR LA PALANCA DE LA VÁLVULA DE DESCARGA<br>ATTENTION! REDUCE THE PRESSURE TO A MINIMUM NECESSARY TO KEEP THE CONTACT BETWEEN HEATING PLATE AND PIPE ENDS; THEN MOVE UPWARDS THE DRAIN VALVE LEVER |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |    |      |  |  |     |  |  |
| 2                                       | TIEMPO DE CALENTAMIENTO HEAT SOAK TIME (min:s)   | 01:57   | 01:19 | 00:51 | 02:18 | 01:34 | 01:00 | 02:46 | 01:53 | 01:13 | 03:07 | 02:09 | 01:22 | 03:28 | 02:22 | 01:32 | 03:53 | 02:41 | 01:44 | 03:00 | 01:56 | 03:18 | 02:09 | 03:40 | 02:23 | 04:00 | 02:37 | 04:25 | 02:55 | 04:53 | 03:15 | 05:22 | 03:36 | 05:56 | 04:00 |       |    |      |  |  |     |  |  |
| 3                                       | EXTRACCIÓN PLACA (s) HEATER WITHDRAWAL (s)   | 7   | 6     | 5     | 7     | 6     | 5     | 8     | 6     | 6     | 9     | 7     | 6     | 9     | 7     | 6     | 10    | 8     | 6     | 8     | 6     | 9     | 7     | 9     | 7     | 10    | 8     | 11    | 8     | 12    | 8     | 12    | 9     | 14    | 10    |       |    |      |  |  |     |  |  |
| 4                                       | TIEMPO DE RAMPA (s) CHANGEOVER TIME (s)  | 8   | 7     | 6     | 11    | 8     | 6     | 13    | 9     | 7     | 16    | 11    | 7     | 17    | 11    | 8     | 19    | 12    | 8     | 15    | 8     | 16    | 11    | 18    | 11    | 18    | 12    | 22    | 16    | 24    | 16    | 25    | 18    | 32    | 18    |       |    |      |  |  |     |  |  |
| 5                                       | PRESIÓN DE FUSIÓN (bar) FUSION PRESSURE (bar)  | AÑADIR PRESIÓN DE ARRASTRE / ADD DRAG PRESSURE  |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |    |      |  |  |     |  |  |
|   | TIEMPO DE FUSIÓN (min:s) FUSION TIME (min:s)   | Hasta 15°C Up to 15°C   | 08:19 | 05:50 | 03:49 | 09:42 | 06:50 | 04:29 | 11:30 | 08:06 | 05:26 | 12:47 | 09:05 | 06:04 | 14:09 | 09:57 | 06:42 | 16:04 | 11:10 | 07:28 | 12:20 | 08:14 | 13:29 | 09:05 | 15:04 | 10:01 | 16:39 | 10:55 | 18:34 | 12:00 | 20:53 | 13:18 | 23:31 | 14:47 | 26:29 | 16:39 |    |      |  |  |     |  |  |
|   |  | De 15°C a 25°C From 15°C to 25°C  | 10:28 | 07:18 | 04:47 | 12:15 | 08:35 | 05:36 | 14:39 | 10:12 | 06:48 | 16:22 | 11:28 | 07:35 | 18:10 | 12:36 | 08:24 | 20:29 | 14:14 | 09:23 | 15:46 | 10:23 | 17:19 | 11:28 | 19:17 | 12:41 | 21:10 | 13:53 | 23:29 | 15:21 | 26:22 | 17:03 | 29:38 | 18:57 | 33:22 | 21:10 |    |      |  |  |     |  |  |
|   |  | Desde 25°C From 25°C  | 13:28 | 09:16 | 06:13 | 15:52 | 10:56 | 07:13 | 19:16 | 13:06 | 08:40 | 21:42 | 14:47 | 09:37 | 24:14 | 16:21 | 10:42 | 27:19 | 18:39 | 12:01 | 20:51 | 13:20 | 23:02 | 14:47 | 25:43 | 16:28 | 28:14 | 18:10 | 31:19 | 20:14 | 35:04 | 22:40 | 39:20 | 25:15 | 44:10 | 28:14 |    |      |  |  |     |  |  |

## PARÁMETROS DE FUSIÓN A TOPE PARA TUBOS Y ACCESORIOS DE POLIPROPILENO (PP) - SDR26/SDR 33/SDR41

### BUTT FUSION PARAMETERS FOR POLYPROPYLENE (PP) PIPES AND FITTINGS - SDR26/SDR 33/SDR41

| FASE PHASE                              | DN   | 75  |       | 90    |       | 110   |       |       | 125   |       |       | 140   |       |       | 160   |       |       | 180   |       |       | 200   |       |       | 225   |       |       | 250   |       |       | 280   |       |       | 315   |       |       | 355   |       |       | 400   |       |       |       |       |       |       |       |       |
|---|--|---|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
|   |  | SDR   | 26    | 33    | 26    | 33    | 26    | 33    | 41    | 26    | 33    | 41    | 26    | 33    | 41    | 26    | 33    | 41    | 26    | 33    | 41    | 26    | 33    | 41    | 26    | 33    | 41    | 26    | 33    | 41    | 26    | 33    | 41    | 26    | 33    | 41    |       |       |       |       |       |       |       |       |       |       |       |
|   | ESPESOR/WALL THICKNESS   | 2.9   | 2.3   | 3.5   | 2.8   | 4.2   | 3.4   | 2.7   | 4.8   | 3.9   | 3.1   | 5.4   | 4.3   | 3.5   | 6.2   | 4.9   | 4     | 6.9   | 5.5   | 4.4   | 7.7   | 6.2   | 4.9   | 3     | 8.6   | 6.9   | 5.5   | 9.6   | 7.7   | 6.2   | 3.5   | 10.7  | 8.6   | 6.9   | 12.1  | 9.7   | 7.7   | 5     | 13.6  | 10.9  | 8.7   | 6     | 15.3  | 12.3  | 9.8   | 6     |       |
|   | PN   | 4   | 3.2   | 4     | 3.2   | 4     | 3.2   | 2.5   | 4     | 3.2   | 2.5   | 4     | 3.2   | 2.5   | 4     | 3.2   | 2.5   | 4     | 3.2   | 2.5   | 4     | 3.2   | 2.5   | 4     | 3.2   | 2.5   | 4     | 3.2   | 2.5   | 4     | 3.2   | 2.5   | 4     | 3.2   | 2.5   | 4     | 3.2   | 2.5   | 4     | 3.2   | 2.5   | 4     | 3.2   | 2.5   |       |       |       |
| PRESIÓN DE REFRENTADO TRIMMING PRESSURE |  | PRESIÓN DE ARRASTRE + la presión necesaria para que se produzca el corte de viruta<br>DRAG PRESSURE + the necessary pressure to produce the trimming operation  |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
| TEMPERATURA PLACA HEATER TEMPERATURE    |  | 210°C ±10°C   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
| 1                                       | PRESIÓN PRE-CALENTAMIENTO (bar) Superficie pistón 12.56 cm <sup>2</sup> HEAT SOAK PRESSURE (bar) Piston area 12.56 cm <sup>2</sup> | AÑADIR PRESIÓN DE ARRASTRE / ADD DRAG PRESSURE  |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|   | TIEMPO PRE-CALENTAMIENTO HEATING TIME  | HASTA LA FORMACIÓN DEL CORDÓN / AS BEAD IS FORMED   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|   | ALTURA CORDÓN (mm) BEAD HEIGHT (mm)  | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   | 0.5   |       |       |       |       |
| CALENTAMIENTO HEAT SOAK PRESSURE        |  | INMOVILIZACIÓN (DESPRESURIZAR LA PRESIÓN DE LA FASE 2 DE PRE-CALENTAMIENTO BAJANDO LA VÁLVULA DE DESCARGA) / IMMOBILIZATION (RELEASE THE PHASE 2 HEAT SOAK PRESSURE MOVING DOWNWARDS THE DRAIN VALVE LEVER)   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|   |  | ¡ATENCIÓN! REDUCIR LA PRESIÓN A LA MÍNIMA NECESARIA (NO POR DEBAJO DEL ARRASTRE) PARA MANTENER EL CONTACTO DE LA PLACA CON LOS TUBOS Y SUBIR LA PALANCA DE LA VÁLVULA DE DESCARGA<br>ATTENTION! REDUCE THE PRESSURE TO A MINIMUM NECESSARY TO KEEP THE CONTACT BETWEEN HEATING PLATE AND PIPE ENDS; THEN MOVE UPWARDS THE DRAIN VALVE LEVER |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
| 2                                       | TIEMPO DE CALENTAMIENTO HEAT SOAK TIME (min:s)   | 00:34   | 00:27 | 00:41 | 00:33 | 00:49 | 00:40 | 00:32 | 00:56 | 00:46 | 00:37 | 01:03 | 00:51 | 00:41 | 01:12 | 00:57 | 00:47 | 01:20 | 01:04 | 00:52 | 01:29 | 01:12 | 00:57 | 00:35 | 01:38 | 01:20 | 01:04 | 01:49 | 01:29 | 01:12 | 00:41 | 02:01 | 01:38 | 01:20 | 02:16 | 01:50 | 01:29 | 00:59 | 02:31 | 02:03 | 01:39 | 01:10 | 02:48 | 02:18 | 01:51 | 01:10 |       |
| 3                                       | EXTRACCIÓN PLACA (s) HEATER WITHDRAWAL (s)   | 5   | 5     | 5     | 5     | 5     | 5     | 5     | 5     | 5     | 5     | 6     | 5     | 5     | 6     | 5     | 5     | 6     | 5     | 6     | 5     | 6     | 5     | 5     | 6     | 5     | 6     | 5     | 6     | 5     | 6     | 5     | 6     | 6     | 6     | 6     | 6     | 5     | 8     | 7     | 6     | 5     | 8     | 7     | 6     | 7     |       |
| 4                                       | TIEMPO DE RAMPA (s) CHANGEOVER TIME (s)  | 6   | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     | 6     |
| 5                                       | PRESIÓN DE FUSIÓN (bar) FUSION PRESSURE (bar)  | AÑADIR PRESIÓN DE ARRASTRE / ADD DRAG PRESSURE  |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|   | TIEMPO DE FUSIÓN (min:s) FUSION TIME (min:s)   | Hasta 15°C Up to 15°C   | 02:35 | 02:03 | 03:07 | 02:29 | 03:44 | 03:01 | 02:24 | 04:14 | 03:28 | 02:45 | 04:43 | 03:49 | 03:07 | 05:22 | 04:19 | 03:33 | 05:55 | 04:48 | 03:55 | 06:29 | 05:22 | 04:19 | 02:40 | 07:07 | 05:55 | 04:48 | 07:49 | 06:29 | 05:22 | 03:07 | 08:35 | 07:07 | 05:55 | 09:34 | 07:53 | 06:29 | 04:24 | 10:32 | 08:44 | 07:11 | 05:12 | 11:37 | 09:42 | 07:58 | 05:12 |
|   |  | De 15°C a 25°C From 15°C to 25°C  | 03:13 | 02:33 | 03:53 | 03:07 | 04:40 | 03:47 | 03:00 | 05:18 | 04:20 | 03:27 | 05:54 | 04:47 | 03:53 | 06:42 | 05:24 | 04:27 | 07:24 | 06:00 | 04:53 | 08:08 | 06:42 | 05:24 | 03:20 | 08:56 | 07:24 | 06:00 | 09:50 | 08:08 | 06:42 | 03:53 | 10:50 | 08:56 | 07:24 | 12:05 | 09:56 | 08:08 | 05:30 | 13:22 | 11:01 | 09:02 | 06:30 | 14:50 | 12:15 | 10:01 | 06:30 |
|   |  | Desde 25°C From 25°C  | 04:11 | 03:19 | 05:03 | 04:03 | 06:04 | 04:55 | 03:54 | 06:52 | 05:38 | 04:29 | 07:35 | 06:13 | 05:03 | 08:32 | 06:59 | 05:47 | 09:23 | 07:42 | 06:21 | 10:20 | 08:32 | 06:59 | 04:20 | 11:25 | 09:23 | 07:42 | 12:37 | 10:20 | 08:32 | 05:03 | 13:56 | 11:25 | 09:23 | 15:37 | 12:44 | 10:20 | 07:06 | 17:27 | 14:11 | 11:32 | 08:18 | 19:30 | 15:52 | 12:52 | 08:18 |

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