

TRACK 630 & 800 - ISO 11414

BUTT FUSION PARAMETERS FOR PE100 PIPES AND FITTINGS - SDR 7.4/SDR 9/SDR 11/SDR 13.6

PHASE	DN	355				400				450				500				560				630				710				800				
	SDR	7.4	9	11	13.6	7.4	9	11	13.6	7.4	9	11	13.6	9	11	13.6	9	11	13.6	9	11	13.6	9	11	13.6	9	11	13.6	9	11	13.6			
	WALL THICKNESS	48.5	39.5	32.3	26.1	54.7	44.5	36.4	29.4	61.5	50	41	33.1	55.6	45.5	36.8	62.2	50.9	41.2	70	57.3	46.4					52.3							
	PN	25	20	16	12.5	25	20	16	12.5	25	20	16	12.5	20	16	12.5	20	16	12.5	20	16	12.5	20	16	12.5	20	16	12.5	20	16	12.5	20	16	12.5
	TRIMMING PRESSURE	DRAG PRESSURE + the necessary pressure to produce the trimming operation																																
	HEATING PLATE TEMPERARURE	225°C ±10°C																																
①	HEAT SOAK PRESSURE (bar) Total pistons area 22.38 cm2	ADD DRAG PRESSURE																																
		37.5	31.5	26.5	21.5	47.5	40	33.5	27.5	60.5	50.5	42.5	35	62.5	52	43	78	65.5	54	99	83	68.5					87				110.5			
	HEATING TIME	AS BEAD B1 IS FORMED																																
	BEAD B1 (bead width)	From 3 to 4 mm																																
②	HEAT SOAK PRESSURE	IMMOBILIZATION (RELEASE THE PHASE ① HEAT SOAK PRESSURE MOVING DOWNWARDS THE DRAIN VALVE LEVER)																																
		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																																
	HEAT SOAK TIME (min:s ±10s)	03:28				03:50				04:15				04:40				05:10				05:45				06:25				07:10				
③	HEATING PLATE WITHDRAWAL (s)	6.5				7				7.5												8												
④	CHANGEOVER TIME (s)	6																																
⑤	FUSION PRESSURE (bar)	ADD DRAG PRESSURE																																
		37.5	31.5	26.5	21.5	47.5	40	33.5	27.5	60.5	50.5	42.5	35	62.5	52	43	78	65.5	54	99	83	68.5					87				110.5			
	FUSION TIME (min)	Minimum 10																																
⑥	COOLING TIME (min:s)	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00			

BUTT FUSION PARAMETERS FOR PE100 PIPES AND FITTINGS - SDR 17 / SDR 21 / SDR 26 / SDR 33

PHASE	DN	355				400				450				500				560				630				710				800							
	SDR	17	21	26	33	17	21	26	33	17	21	26	33	17	21	26	33	17	21	26	33	17	21	26	33	17	21	26	33	17	21	26	33				
	WALL THICKNESS	21.1	16.9	13.6	10.9	23.7	19.1	15.3	12.3	26.7	21.5	17.2	13.8	29.6	23.9	19.1	15.3	33	26.7	21.4	17.2	37.1	30	24.1	19.3	41.8	33.9	27.2	21.8	47.1	38.1	30.6	24.5				
	PN	10	8	6.3	4	10	8	6.3	4	10	8	6.3	4	10	8	6.3	4	10	8	6.3	4	10	8	6.3	4	10	8	6.3	4	10	8	6.3	4	10	8	6.3	4
	TRIMMING PRESSURE	DRAG PRESSURE + the necessary pressure to produce the trimming operation																																			
	HEATING PLATE TEMPERARURE	225°C ±10°C																																			
①	HEAT SOAK PRESSURE (bar) Total pistons area 22.38 cm2	ADD DRAG PRESSURE																																			
		18	14.5	11.5	9.5	22.5	18.5	15	12	28.5	23.5	19	15	35	28.5	23	18.5	44	36	29	23.5	55.5	45.5	37	30	70.5	58	47	38	89.5	73.5	59.5	48				
	HEATING TIME	AS BEAD B1 IS FORMED																																			
	BEAD B1 (bead width)	From 3 to 4 mm																																			
②	HEAT SOAK PRESSURE	IMMOBILIZATION (RELEASE THE PHASE ① HEAT SOAK PRESSURE MOVING DOWNWARDS THE DRAIN VALVE LEVER)																																			
		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																																			
	HEAT SOAK TIME (min:s ±10s)	03:28				03:50				04:15				04:40				05:10				05:45				06:25				07:10							
③	HEATING PLATE WITHDRAWAL (s)	6.5				7				7.5												8															
④	CHANGEOVER TIME (s)	6																																			
⑤	FUSION PRESSURE (bar)	ADD DRAG PRESSURE																																			
		18	14.5	11.5	9.5	22.5	18.5	15	12	28.5	23.5	19	15	35	28.5	23	18.5	44	36	29	23.5	55.5	45.5	37	30	70.5	58	47	38	89.5	73.5	59.5	48				
	FUSION TIME (min)	Minimum 10																																			
⑥	COOLING TIME (min:s)	20:00	20:00	20:00	16:21	20:00	20:00	20:00	18:27	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00	20:00				

TRACK 630 & 800 - DVS 2207-1

BUTT FUSION PARAMETERS FOR PE100 PIPES AND FITTINGS - SDR 7.4/SDR 9/SDR 11/SDR 13.6

PHASE	DN	355				400				450				500				560				630				710				800			
	SDR	7.4	9	11	13.6	7.4	9	11	13.6	7.4	9	11	13.6	9	11	13.6	11	13.6	11	13.6	11	13.6	13.6	13.6	13.6	13.6	13.6	13.6	13.6				
	WALL THICKNESS	48.5	39.5	32.2	26.1	54.7	44.5	36.4	29.4	61.5	50	41	33.1	55.6	45.4	36.8	50.9	41.2	57.3	46.4	52.3	52.3	52.3	52.3	52.3	52.3	52.3	52.3	58.9				
	PN	25	20	16	12.5	25	20	16	12.5	25	20	16	12.5	20	16	12.5	16	12.5	16	12.5	16	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5				
	TRIMMING PRESSURE	DRAG PRESSURE + the necessary pressure to produce the trimming operation																															
	HEATING PLATE TEMPERARURE	210°C ±10°C																															
①	HEAT SOAK PRESSURE (bar) Total pistons area 22.38 cm2	ADD DRAG PRESSURE																															
	HEATING TIME	AS BEAD IS FORMED																															
	BEAD HEIGHT (mm)	3.5	3.5	3	3	4	3.5	3	3	4	3.5	3.5	3	4	3.5	3	4	3.5	4	3.5	4	3.5	4	3.5	4	3.5	4	3.5	4				
②	HEAT SOAK PRESSURE	IMMOBILIZATION (RELEASE THE PHASE ① HEAT SOAK PRESSURE MOVING DOWNWARDS THE DRAIN VALVE LEVER)																															
	HEAT SOAK TIME (min:s ±10s)	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																															
③	HEATING PLATE WITHDRAWAL (s)	19	17	14	12	21	18	16	13	23	20	18	14	22	18	16	20	17	22	18	20	18	20	18	20	18	20	18	22				
④	CHANGEOVER TIME (s)	24	20	16	14	26	21	18	15	30	25	21	16	28	23	19	25	21	29	21	26	21	26	21	26	21	26	21	29				
⑤	FUSION PRESSURE (bar)	ADD DRAG PRESSURE																															
	FUSION TIME (min:s)	58:16	47:53	39:20	32:07	64:42	53:39	44:17	36:01	71:30	60:00	49:37	40:23	65:36	54:42	44:46	60:54	46:55	67:18	55:51	62:18	55:51	62:18	55:51	62:18	55:51	62:18	55:51	68:54				

BUTT FUSION PARAMETERS FOR PE100 PIPES AND FITTINGS - SDR 17 / SDR 21 / SDR 26 / SDR 33

PHASE	DN	355				400				450				500				560				630				710				800			
	SDR	17	21	26	33	17	21	26	33	17	21	26	33	17	21	26	33	17	21	26	33	17	21	26	33	17	21	26	33	17	21	26	33
	WALL THICKNESS	21.1	16.9	13.6	10.9	23.7	19.1	15.3	12.3	26.7	21.5	17.2	13.8	29.6	23.9	19.1	15.3	33	26.7	21.4	17.2	37.1	30	24.1	19.3	41.8	33.9	27.2	21.8	47.1	38.1	30.6	24.5
	PN	10	8	6.3	4	10	8	6.3	4	10	8	6.3	4	10	8	6.3	4	10	8	6.3	4	10	8	6.3	4	10	8	6.3	4	10	8	6.3	4
	TRIMMING PRESSURE	DRAG PRESSURE + the necessary pressure to produce the trimming operation																															
	HEATING PLATE TEMPERARURE	210°C ±10°C																															
①	HEAT SOAK PRESSURE (bar) Total pistons area 22.38 cm2	ADD DRAG PRESSURE																															
	HEATING TIME	AS BEAD IS FORMED																															
	BEAD HEIGHT (mm)	2.5	2	2	1.5	2.5	2.5	2	2	3	2.5	2	2	3	2.5	2.5	2	3	3	2.5	2	3.5	3	2.5	2.5	3.5	3	3	2.5	3.5	3.5	3	2.5
②	HEAT SOAK PRESSURE	IMMOBILIZATION (RELEASE THE PHASE ① HEAT SOAK PRESSURE MOVING DOWNWARDS THE DRAIN VALVE LEVER)																															
	HEAT SOAK TIME (min:s ±10s)	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																															
③	HEATING PLATE WITHDRAWAL (s)	11	9	8	7	11	10	9	8	12	11	9	8	14	11	10	9	15	12	11	9	16	14	11	10	17	15	12	11	19	16	14	12
④	CHANGEOVER TIME (s)	12	10	9	7	13	11	10	8	14	12	10	9	16	13	11	10	18	14	12	10	19	16	13	11	20	18	14	12	24	19	16	13
⑤	FUSION PRESSURE (bar)	ADD DRAG PRESSURE																															
	FUSION TIME (min:s)	26:24	21:36	17:50	14:41	29:22	24:07	19:46	16:21	32:50	26:51	21:57	18:03	36:15	29:36	24:07	19:46	40:16	32:50	26:45	21:57	45:07	36:44	29:50	24:21	50:32	41:20	33:25	27:12	56:39	46:16	37:26	30:17

TRACK 630 & 800 - DVS 2207-11

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

PHASE	DN	355				400				450				500				560				630				710				800			
	SDR	7.4	11	17.6		7.4	11	17.6	7.4	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	
	WALL THICKNESS		32.2	20.1			36.3	22.7			40.9	25.5			45.4	28.3				31.7				35.7				40.2				45.3	
	PN	16	10	6		16	10	6	16	16	10	6		16	10	6		16	10	6		16	10	6		16	10	6		16	10	6	
	TRIMMING PRESSURE	DRAG PRESSURE + the necessary pressure to produce the trimming operation																															
	HEATING PLATE TEMPERARURE	210°C ±10°C																															
①	HEAT SOAK PRESSURE (bar) Total pistons area 22.38 cm2	ADD DRAG PRESSURE																															
		14.5	9.5			18.5	12			23.5	15			29	18.5			23.5				30				38	7.5			48			
	HEATING TIME	AS BEAD IS FORMED																															
	BEAD HEIGHT (mm)	2	1.5			2	1.5			2.5	1.5			2.5	2			2				2				2.5	1.5			2.5			
②	HEAT SOAK PRESSURE	IMMOBILIZATION (RELEASE THE PHASE ① HEAT SOAK PRESSURE MOVING DOWNWARDS THE DRAIN VALVE LEVER)																															
		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																															
	HEAT SOAK TIME (min:s ±10s)	07:28	05:41			07:60	06:07			08:28	06:35			08:53	06:58			07:24				07:55				08:23	05:32			08:53			
③	HEATING PLATE WITHDRAWAL (s)	12	9			14	10			16	11			16	12			13				14				15	9			16			
④	CHANGEOVER TIME (s)	25	18			32	18			40	21			41	24			30				31				34	17			40			
⑤	FUSION PRESSURE (bar)	ADD DRAG PRESSURE																															
		14.5	9.5			18.5	12			23.5	15			29	18.5			23.5				30				38	7.5			48			
	FUSION TIME (min:s)	48:35	31:34			54:03	35:17			59:30	39:17			64:42	43:08			47:46				53:14				58:42	30:17			64:35			

BUTT FUSION PARAMETERS FOR POLYPROPYLENE (PP) PIPES AND FITTINGS - SDR 26 / SDR 33 / SDR 41

PHASE	DN	355				400				450				500				560				630				710				800			
	SDR	26	33	41		26	33	41	26	26	33	41		26	33	41		26	33	41		26	33	41		26	33	41		26	33	41	
	WALL THICKNESS	13.6	10.9	8.7	6	15.3	12.3	9.8	17.2	17.2	13.8	11	6	19.1	15.3	12.3	8	21.4	17.2	13.7	8	24.1	19.3	15.4	10	27.2	21.8	17.4	12	30.6	24.5	19.6	12
	PN	4	3.2	2.5		4	3.2	2.5	4	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	
	TRIMMING PRESSURE	DRAG PRESSURE + the necessary pressure to produce the trimming operation																															
	HEATING PLATE TEMPERARURE	210°C ±10°C																															
①	HEAT SOAK PRESSURE (bar) Total pistons area 22.38 cm2	ADD DRAG PRESSURE																															
		6.5	5.5	4	3	8.5	6.5	5.5	18	10.5	8.5	7	3.5	13	10.5	8.5	5.5	16	13	10.5	6	20.5	16.5	13.5	8.5	26	21	17	12	33	26.5	21.5	13.5
	HEATING TIME	AS BEAD IS FORMED																															
	BEAD HEIGHT (mm)	1	1	1	0.5	1	1	1	1	1	1	1	0.5	1.5	1	1	1	1.5	1	1	1	1.5	1	1	1	2	1.5	1	1	2	1.5	1.5	1
②	HEAT SOAK PRESSURE	IMMOBILIZATION (RELEASE THE PHASE ① HEAT SOAK PRESSURE MOVING DOWNWARDS THE DRAIN VALVE LEVER)																															
		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																															
	HEAT SOAK TIME (min:s ±10s)	04:24	03:50	03:19	02:39	04:45	04:09	03:34	05:08	05:08	04:27	03:51	02:39	05:31	04:45	04:09	03:09	05:54	05:08	04:24	03:09	06:21	05:33	04:46	03:37	06:49	05:58	05:11	04:05	07:16	06:25	05:36	04:05
③	HEATING PLATE WITHDRAWAL (s)	7	7	6	6	8	7	6	8	8	7	7	5	9	8	7	6	10	8	7	6	10	9	8	7	11	10	8	7	12	10	9	7
④	CHANGEOVER TIME (s)	12	10	8	7	13	11	8	16	16	12	11	6	17	14	11	7	18	13	11	7	21	17	13	10	23	19	16	11	24	20	17	11
⑤	FUSION PRESSURE (bar)	ADD DRAG PRESSURE																															
		6.5	5.5	4	3	8.5	6.5	5.5	18	10.5	8.5	7	3.5	13	10.5	8.5	5.5	16	13	10.5	6	20.5	16.5	13.5	8.5	26	21	17	12	33	26.5	21.5	13.5
	FUSION TIME (min:s)	22:17	18:14	14:43	09:36	24:43	20:26	16:26	27:26	27:26	22:34	18:24	09:39	30:09	24:43	20:26	13:36	33:26	27:26	22:26	13:36	37:17	30:26	24:51	16:48	41:38	34:00	27:43	20:00	46:16	37:51	30:51	20:00