

# TRACK 250 - ISO 11414

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

PHASE	DN	63				75				90				110				125				140				160				180				200				225				250			
	SDR	7.4	9	11	13.6	7.4	9	11	13.6	7.4	9	11	13.6	7.4	9	11	13.6	7.4	9	11	13.6	7.4	9	11	13.6	7.4	9	11	13.6	7.4	9	11	13.6	7.4	9	11	13.6	7.4	9	11	13.6				
	WALL THICKNESS	8.6	7.1	5.8	4.7	10.3	8.4	6.8	5.5	12.3	10.1	8.2	6.6	15.1	12.3	10	8.1	17.1	14	11.4	9.2	19.2	15.7	12.7	10.3	21.9	17.9	14.6	11.8	24.6	20.1	16.4	13.3	27.4	22.4	18.2	14.7	30.8	25.1	20.5	16.6	34.2	27.9	22.7	18.4
	PN	25	20	16	12.5	25	20	16	12.5	25	20	16	12.5	25	20	16	12.5	25	20	16	12.5	25	20	16	12.5	25	20	16	12.5	25	20	16	12.5	25	20	16	12.5	25	20	16	12.5	25	20	16	12.5
TRIMMING PRESSURE	DRAG PRESSURE + the necessary pressure to produce the trimming operation																																												
HEATING PLATE TEMPERATURE	210°C ± 10°C																																												
HEAT SOAK PRESSURE (bar) Total pistons area 9.8 cm <sup>2</sup>	ADD DRAG PRESSURE																																												
HEATING TIME	AS BEAD B1 IS FORMED																																												
BEAD B1 (bead width)	From 1 to 2 mm																De 2 a 3 mm																												
HEAT SOAK PRESSURE	IMMOBILIZATION (RELEASE THE PHASE ● HEAT SOAK PRESSURE MOVING DOWNWARDS THE DRAIN VALVE LEVER)																																												
HEAT SOAK PRESSURE	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)	01:02				01:08				01:15				01:25				01:33				01:44				01:50				02:00				02:10				02:23				02:35				
HEATING PLATE WITHDRAWAL (s)	3.5								4								4.5								5								5.5												
CHANGEOVER TIME (s)	3.5								4								4.5								5								5.5												
FUSION PRESSURE (bar)	ADD DRAG PRESSURE																																												
FUSION TIME (min)	Minimum 10																																												
COOLING TIME (min:s)	12:54	10:39	08:42	07:03	15:27	12:36	10:12	08:15	18:27	15:09	12:18	10:03	20:00	18:27	15:00	12:09	20:00	20:00	17:06	13:48	20:00	20:00	19:03	15:27	20:00	20:00	20:00	17:42	20:00	20:00	20:00	19:57	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	63				75				90				110				125				140				160				180				200				225				250			
	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	17	21	26	33	17	21	26	33				
	WALL THICKNESS	3.8	3	2.4	2.3	4.5	3.6	2.9	2.3	5.4	4.3	3.5	2.8	6.6	5.3	4.2	3.4	7.4	6	4.8	3.9	8.3	6.7	5.4	4.3	9.5	7.7	6.2	4.9	10.7	8.6	6.9	5.5	11.9	9.6	7.7	6.2	13.4	10.8	8.6	6.9	14.8	11.9	9.6	7.7
	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	10	8	6.3	4	10	8	6.3	4
TRIMMING PRESSURE	DRAG PRESSURE + the necessary pressure to produce the trimming operation																																												
HEATING PLATE TEMPERATURE	210°C ± 10°C																																												
HEAT SOAK PRESSURE (bar) Total pistons area 9.8 cm <sup>2</sup>	ADD DRAG PRESSURE																																												
HEATING TIME	AS BEAD B1 IS FORMED																																												
BEAD B1 (bead width)	From 1 to 2 mm																De 2 a 3 mm																												
HEAT SOAK PRESSURE	IMMOBILIZATION (RELEASE THE PHASE ● HEAT SOAK PRESSURE MOVING DOWNWARDS THE DRAIN VALVE LEVER)																																												
HEAT SOAK PRESSURE	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)	01:02				01:08				01:15				01:25				01:33				01:44				01:50				02:00				02:10				02:23				02:35				
HEATING PLATE WITHDRAWAL (s)	3.5								4								4.5								5								5.5												
CHANGEOVER TIME (s)	3.5								4								4.5								5								5.5												
FUSION PRESSURE (bar)	ADD DRAG PRESSURE																																												
FUSION TIME (min)	Minimum 10																																												
COOLING TIME (min:s)	05:42	04:30	03:36	03:27	06:45	05:24	04:21	03:27	08:06	06:27	05:15	04:12	09:54	07:57	06:18	05:06	11:06	09:00	07:12	05:51	12:27	10:03	08:06	06:27	14:15	11:33	09:18	07:21	16:03	12:54	10:21	08:15	17:51	14:24	11:33	09:18	20:00	16:12	12:54	10:21	20:00	17:51	14:24	11:33	

# TRACK 250 - DVS 2207-1

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

PHASE	DN	63				75				90				110				125				140				160				180				200				225				250			
	SDR	63	9	11	13.6	7.4	9	11	13.6	7.4	9	11	13.6	7.4	9	11	13.6	7.4	9	11	13.6	7.4	9	11	13.6	7.4	9	11	13.6	7.4	9	11	13.6	7.4	9	11	13.6	7.4	9	11	13.6				
	WALL THICKNESS	8.6	7.1	5.8	4.7	10.3	8.4	6.8	5.5	12.3	10.1	8.2	6.6	15.1	12.3	10	8.1	17.1	14	11.4	9.2	19.2	15.7	12.7	10.3	21.9	17.9	14.6	11.8	24.6	20.1	16.4	13.3	27.4	22.4	18.2	14.7	30.8	25.1	20.5	16.6	34.2	27.9	22.7	18.4
	PN	25	20	16	12.5	25	20	16	12.5	25	20	16	12.5	25	20	16	12.5	25	20	16	12.5	25	20	16	12.5	25	20	16	12.5	25	20	16	12.5	25	20	16	12.5	25	20	16	12.5	25	20	16	12.5
TRIMMING PRESSURE	DRAG PRESSURE + the necessary pressure to produce the trimming operation																																												
HEATING PLATE TEMPERATURE	210°C ±10°C																																												
HEAT SOAK PRESSURE (bar) Total pistons area 9.8 cm <sup>2</sup>	ADD DRAG PRESSURE																																												
	2.2	2	1.5	1.3	3	2.7	2.2	2	4.5	4	3.2	2.5	7	5.8	5	4	9	7.5	6.2	5	11	9.5	8	6.5	14.5	12.5	10	8.5	18.5	15.5	13	10.5	23	19	16	13	29	24	20	16.5	35.5	30	25	20.5	
HEATING TIME	AS BEAD IS FORMED																																												
BEAD HEIGHT (mm)	1.5	1.5	1	1	1.5	1.5	1	1	2	1.5	1.5	1	2	2	1.5	1.5	2	2	1.5	1.5	2.5	2	2	1.5	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	
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)	01:26	01:11	00:58	00:47	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	03:12	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	
HEATING PLATE WITHDRAWAL (s)	6	6	5	5	7	7	6	5	8	7	7	6	9	8	9	7	9	9	8	7	10	9	8	7	11	10	9	8	11	10	9	9	12	10	10	9	14	12	10	9	15	15	11	10	
CHANGEOVER TIME (s)	6	6	5	5	7	7	6	5	8	7	7	6	9	8	9	7	10	9	8	7	11	9	8	7	12	11	9	8	13	11	9	9	14	12	11	9	16	14	11	10	17	18	12	11	
FUSION PRESSURE (bar)	ADD DRAG PRESSURE																																												
	2.2	2	1.5	1.3	3	2.7	2.2	2	4.5	4	3.2	2.5	7	5.8	5	4	9	7.5	6.2	5	11	9.5	8	6.5	14.5	12.5	10	8.5	18.5	15.5	13	10.5	23	19	16	13	29	24	20	16.5	35.5	30	25	20.5	
FUSION TIME (min:s)	11:55	10:07	08:05	06:19	13:58	11:41	09:41	07:36	16:21	13:43	11:26	09:22	19:33	16:21	13:36	11:19	21:50	18:17	15:17	12:38	24:14	20:14	16:48	13:58	27:19	22:45	18:58	15:46	30:24	25:15	21:02	17:29	33:39	27:53	23:05	19:05	37:40	30:58	25:43	21:15	41:41	34:15	28:14	23:19	

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

PHASE	DN	63				75				90				110				125				140				160				180				200				225				250			
	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	17	21	26	33	17	21	26	33	17	21	26	33
	WALL THICKNESS	3.8	3	2.4	2.3	4.5	3.6	2.9	2.3	5.4	4.3	3.5	2.8	6.6	5.3	4.2	3.4	7.4	6	4.8	3.9	8.3	6.7	5.4	4.3	9.5	7.7	6.2	4.9	10.7	8.6	6.9	5.5	11.9	9.6	7.7	6.2	13.4	10.8	8.6	6.9	14.8	11.9	9.6	7.7
	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	10	8	6.3	4	10	8	6.3	4
TRIMMING PRESSURE	DRAG PRESSURE + the necessary pressure to produce the trimming operation																																												
HEATING PLATE TEMPERATURE	210°C ±10°C																																												
HEAT SOAK PRESSURE (bar) Total pistons area 9.8 cm <sup>2</sup>	ADD DRAG PRESSURE																																												
	1	1	0.7	0.7	1.5	1.2	1	0.8	2	1.8	1.5	1.2	3.5	2.7	2.2	1.7	4.2	3.5	2.8	2.3	5.2	4.5	3.5	3	7	5.5	4.5	3.5	8.5	7	6	4.5	11	9	7	6	13.5	11	9	7	16.5	13.5	11	9	
HEATING TIME	AS BEAD IS FORMED																																												
BEAD HEIGHT (mm)	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	1	0.5	0.5	0.5	1	1	0.5	0.5	1.5	1	1	0.5	1.5	1	1	0.5	1.5	1.5	1	1	1.5	1.5	1	1	1.5	1.5	1.5	1	2	1.5	1.5	1	2	1.5	1.5	1.5	
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)	00:38	00:30	00:24	00:23	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	
HEATING PLATE WITHDRAWAL (s)	5	5	5	5	5	5	5	5	5	5	5	5	6	5	5	5	6	6	5	5	6	6	5	5	7	6	6	5	7	7	6	5	8	7	6	6	8	8	7	6	9	8	7	6	
CHANGEOVER TIME (s)	5	5	5	5	5	5	5	5	5	5	5	5	6	5	5	5	6	6	5	5	6	6	5	5	7	6	6	5	7	7	6	5	8	7	6	6	9	8	7	6	9	8	7	6	
FUSION PRESSURE (bar)	ADD DRAG PRESSURE																																												
	1	1	0.7	0.7	1.5	1.2	1	0.8	2	1.8	1.5	1.2	3.5	2.7	2.2	1.7	4.2	3.5	2.8	2.3	5.2	4.5	3.5	3	7	5.5	4.5	3.5	8.5	7	6	4.5	11	9	7	6	13.5	11	9	7	16.5	13.5	11	9	
FUSION TIME (min:s)	06:00	06:00	06:00	06:00	06:00	06:00	06:00	06:00	07:26	06:00	06:00	06:00	09:22	07:17	06:00	06:00	10:29	08:24	06:29	06:00	11:34	09:31	07:26	06:00	13:00	10:50	08:43	06:38	14:26	11:55	09:50	07:36	15:53	13:07	10:50	08:43	17:36	14:34	11:55	09:50	19:12	15:53	13:07	10:50	

# TRACK 250 - DVS 2207-11

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

PHASE	DN	63			75			90			110			125			140			160			180			200			225			250		
	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
	WALL THICKNESS	8.6	5.8	3.6	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
	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
①	TRIMMING PRESSURE	DRAG PRESSURE + the necessary pressure to produce the trimming operation																																
	HEATING PLATE TEMPERATURE	210°C ±10°C																																
	HEAT SOAK PRESSURE (bar) Total pistons area 9.8 cm <sup>2</sup>	ADD DRAG PRESSURE																																
	HEATING TIME	AS BEAD IS FORMED																																
	BEAD HEIGHT (mm)	1	0.5	0.5	1	0.5	0.5	1	1	0.5	1	1	0.5	1	1	1	1.5	1	1	1.5	1	1		1	1		1	1		1.5	1		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)	03:17	02:36	01:48	03:41	02:52	02:09	04:09	03:12	02:25	04:43	03:37	02:44	05:07	03:57	02:56	05:32	04:14	03:09	05:59	04:37	03:24		04:58	03:40		05:20	03:57		05:45	04:15		06:07	04:32
③	HEATING PLATE WITHDRAWAL (s)	6	5	5	6	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
④	CHANGEOVER TIME (s)	8	6	6	8	7	6	11	8	6	13	9	7	16	11	7	17	11	8	19	12	8		16	8		16	11		18	11		18	12
⑤	FUSION PRESSURE (bar)	ADD DRAG PRESSURE																																
		1.5	1	0.7	2	1.5	1	3	2	1.5	4.5	3.2	2	6	4	2.7	7.5	5.2	3.5	9.5	7	4.5		8.5	5.5		10.5	7		13.5	8.5		16.5	10.5
	FUSION TIME (min:s)	14:34	09:07	06:00	17:17	11:31	06:00	20:26	13:55	07:26	24:26	16:48	10:19	27:17	19:02	12:10	30:17	21:00	13:36	34:09	23:43	15:22		26:17	17:07		28:51	19:02		32:09	21:09		35:17	23:09

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

PHASE	DN	63			75			90			110			125			140			160			180			200			225			250						
	SDR	26	33		26	33		26	33	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				
	WALL THICKNESS	2.5	2		2.9	2.3		3.5	2.8	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		
	PN	4	3.2		4	3.2		4	3.2	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	4	3.2	2.5	4	3.2	2.5				
	TRIMMING PRESSURE	DRAG PRESSURE + the necessary pressure to produce the trimming operation																																				
	HEATING PLATE TEMPERATURE	210°C ±10°C																																				
①	HEAT SOAK PRESSURE (bar) Total pistons area 9.8 cm <sup>2</sup>	ADD DRAG PRESSURE																																				
	HEATING TIME	AS BEAD IS FORMED																																				
	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					
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)	01:15	01:00		01:27	01:09		01:45	01:24	00:28	02:06	01:42	01:21	02:20	01:57	01:33	02:29	02:09	01:45	02:42	02:21	02:00	02:53	02:31	02:12	03:05	02:42	02:21	01:30	03:17	02:53	02:31	03:31	03:05	02:42	01:45		
③	HEATING PLATE WITHDRAWAL (s)	5	5		5	5		5	5	5	5	5	5	5	5	5	6	5	5	6	5	5	6	5	5	6	5	5	6	6	5	6	6	5	6	6	5	5
④	CHANGEOVER TIME (s)	6	6		6	6		6	6	5	6	6	6	6	6	6	6	6	7	6	6	7	6	6	7	7	6	6	7	7	6	8	7	6	6	6		
⑤	FUSION PRESSURE (bar)	ADD DRAG PRESSURE																																				
		0.5	0.4		0.7	0.5		1	0.8	1.2	1.5	1.2	1	2	1.5	1.2	2.5	2	1.5	3	2.5	2	4	3	2.5	4.5	4	3	2	6	5	4	7.5	6	5	3		
	FUSION TIME (min:s)	06:00	06:00		06:00	06:00		06:00	06:00	06:00	06:00	06:00	06:00	06:43	06:00	06:00	11:34	06:00	06:00	10:05	06:58	06:00	11:46	08:24	06:00	13:07	10:05	06:58	06:00	14:34	11:46	08:24	16:10	13:07	10:05	06:00		

# TRACK 250 - DVS 2207-15

## BUTT FUSION PARAMETERS FOR NATURAL PVDF PIPES AND FITTINGS - SDR 21 / SDR 33 / VENTILATION

PHASE	DN	63		75	90		110		125		140		160		180		200		225		250						
	SDR	21		21	21	33	21	33		21	33	21	33		21	33	21	33		21	33	21	33				
	WALL THICKNESS	3	2	3.6	4.3	2.8	5.3	3.4	3	6	3.9	6.7	4.3	3	7.7	4.9	3	8.6	5.5	9.6	6.2	3	10.8	6.9	11.9	7.7	3
	ISO	S-10	V	S-10	S-10	S-16	S-10	S-16	V	S-10	S-16	S-10	S-16	V	S-10	S-16	V	S-10	S-16	S-10	S-16	V	S-10	S-16	S-10	S-16	V
TRIMMING PRESSURE	<b>DRAG PRESSURE + the necessary pressure to produce the trimming operation</b>																										
HEATING PLATE TEMPERATURE	<b>240°C ±8°C</b>																										
①	HEAT SOAK PRESSURE (bar) Total pistons area 9.8 cm <sup>2</sup>	<b>ADD DRAG PRESSURE</b>																									
		0.6	0.4	0.8	1.2	0.8	1.8	1.2	1	2.3	1.5	2.9	1.9	1.3	3.8	2.5	1.5	4.7	3.1	5.9	3.8	1.9	7.4	4.8	9	6	2.4
	HEATING TIME	<b>AS BEAD IS FORMED</b>																									
	BEAD HEIGHT (mm)	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.7	0.5	0.5	0.7	0.5	0.5	0.9	0.5	1	0.6	0.6	1	0.7	1.1	0.7	0.7
②	HEAT SOAK PRESSURE	<b>IMMOBILIZATION (RELEASE THE PHASE ① HEAT SOAK PRESSURE MOVING DOWNWARDS THE DRAIN VALVE LEVER)</b>																									
		<b>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</b>																									
	HEAT SOAK TIME (min:s ±10s)	01:10	01:00	01:16	01:23	01:08	01:33	01:14	01:10	01:40	01:19	02:47	01:23	01:10	03:06	01:29	01:10	02:06	01:35	02:16	01:42	01:10	02:28	01:49	02:39	01:57	01:10
③ HEATING PLATE WITHDRAWAL (s)	3	3	3	3	3	3	3	3	4	3	4	3	3	4	3	3	4	3	4	4	4	4	4	4	4	4	
④ CHANGEOVER TIME (s)	3	3	4	4	3	4	4	4	4	4	5	4	4	6	4	4	6	5	7	6	6	7	6	6	6	6	
⑤	FUSION PRESSURE (bar)	<b>ADD DRAG PRESSURE</b>																									
		0.6	0.4	0.8	1.2	0.8	1.8	1.2	1	2.3	1.5	2.9	1.9	1.3	3.8	2.5	1.5	4.7	3.1	5.9	3.8	1.9	7.4	4.8	9	6	2.4
FUSION TIME (min:s)	05:41	05:04	06:08	07:00	05:34	08:15	05:56	05:41	09:07	06:30	09:58	07:00	05:23	11:11	07:45	05:23	12:17	08:30	13:31	09:21	05:27	14:48	10:13	15:54	11:11	05:27	