

TRACK 315 - ISO 11414

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

| PHASE | DN | 90 | | | | 110 | | | | 125 | | | | 140 | | | | 160 | | | | 180 | | | | 200 | | | | 225 | | | | 250 | | | | 280 | | | | 315 | | | |
|---------------------------|--|--|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|----------------|-------|-------|-------|-------|-------|-------|-------|-------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| | 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 | 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 | 38.3 | 31.2 | 25.4 | 20.6 | 43.1 | 35 | 28.6 | 23.3 |
| | 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 | | | | | | | | | | | | | | | | | | | | | | | | 225°C ±10°C | | | | | | | | | | | | | | | | | | | | |
| 1 | HEAT SOAK PRESSURE (bar) Total pistons area 9.8 cm ² | ADD DRAG PRESSURE | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | 5.5 | 4.7 | 4 | 3.2 | 8.2 | 7 | 6 | 5 | 10.5 | 9 | 7.5 | 6.2 | 13.5 | 11.3 | 9.5 | 7.5 | 17.5 | 15 | 12 | 10 | 22 | 18.5 | 15.5 | 13 | 27.5 | 23 | 19 | 16 | 34.5 | 29 | 24 | 20 | 42.5 | 36 | 30 | 24.5 | 53.5 | 45 | 37.5 | 31 | 67.5 | 56.5 | 47 | 39 |
| | HEATING TIME | AS BEAD B1 IS FORMED | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| BEAD B1 (bead width) | From 1 to 2 mm | | | | | | | | | | | | | | | | From 2 to 3 mm | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2 | HEAT SOAK PRESSURE | IMMOBILIZATION (RELEASE THE PHASE ● HEAT SOAK PRESSURE MOVING DOWNWARDS THE DRAIN VALVE LEVER) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | HEAT SOAK TIME (min:s ±10s) | 01:15 | | | | 01:25 | | | | 01:33 | | | | 01:44 | | | | 01:50 | | | | 02:00 | | | | 02:10 | | | | 02:23 | | | | 02:35 | | | | 02:50 | | | | 03:08 | | | |
| 3 | HEATING PLATE WITHDRAWAL (s) | | | | | 4 | | | | | | | | 4.5 | | | | | | | | 5 | | | | | | | | 5.5 | | | | | | | | 6 | | | | | | | |
| 4 | CHANGE OVER TIME (s) | | | | | 4 | | | | | | | | 4.5 | | | | | | | | 5 | | | | | | | | 5.5 | | | | | | | | 6 | | | | | | | |
| 5 | FUSION PRESSURE (bar) | ADD DRAG PRESSURE | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | 5.5 | 4.7 | 4 | 3.2 | 8.2 | 7 | 6 | 5 | 10.5 | 9 | 7.5 | 6.2 | 13.5 | 11.3 | 9.5 | 7.5 | 17.5 | 15 | 12 | 10 | 22 | 18.5 | 15.5 | 13 | 27.5 | 23 | 19 | 16 | 34.5 | 29 | 24 | 20 | 42.5 | 36 | 30 | 24.5 | 53.5 | 45 | 37.5 | 31 | 67.5 | 56.5 | 47 | 39 |
| 6 | FUSION TIME (min) | Minimum 10 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 6 | COOLING TIME (min:s) | 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 | 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 | 90 | | | | 110 | | | | 125 | | | | 140 | | | | 160 | | | | 180 | | | | 200 | | | | 225 | | | | 250 | | | | 280 | | | | 315 | | | |
|---------------------------|--|--|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|----------------|-------|-------|-------|-------|-------|-------|-------|-------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| | 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 | 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 | 16.6 | 13.4 | 10.7 | 8.6 | 18.7 | 15 | 12.1 | 9.7 |
| | 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 | | | | | | | | | | | | | | | | | | | | | | | | 225°C ±10°C | | | | | | | | | | | | | | | | | | | | |
| 1 | HEAT SOAK PRESSURE (bar) Total pistons area 9.8 cm ² | ADD DRAG PRESSURE | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | 2.5 | 2 | 1.7 | 1.5 | 4 | 3.2 | 2.5 | 2 | 5 | 4 | 3.3 | 2.7 | 6.5 | 5 | 4.2 | 3.5 | 8.5 | 7 | 5.5 | 4.5 | 10.5 | 8.5 | 7 | 5.5 | 13 | 10.5 | 8.5 | 7 | 16.5 | 13.5 | 11 | 8.5 | 20 | 16.5 | 13.5 | 11 | 25 | 20.5 | 16.5 | 13.5 | 32 | 26 | 21 | 17 |
| | HEATING TIME | AS BEAD B1 IS FORMED | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| BEAD B1 (bead width) | From 1 to 2 mm | | | | | | | | | | | | | | | | From 2 to 3 mm | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2 | HEAT SOAK PRESSURE | IMMOBILIZATION (RELEASE THE PHASE ● HEAT SOAK PRESSURE MOVING DOWNWARDS THE DRAIN VALVE LEVER) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | HEAT SOAK TIME (min:s ±10s) | 01:15 | | | | 01:25 | | | | 01:33 | | | | 01:44 | | | | 01:50 | | | | 02:00 | | | | 02:10 | | | | 02:23 | | | | 02:35 | | | | 02:50 | | | | 03:08 | | | |
| 3 | HEATING PLATE WITHDRAWAL (s) | | | | | 4 | | | | | | | | 4.5 | | | | | | | | 5 | | | | | | | | 5.5 | | | | | | | | 6 | | | | | | | |
| 4 | CHANGE OVER TIME (s) | | | | | 4 | | | | | | | | 4.5 | | | | | | | | 5 | | | | | | | | 5.5 | | | | | | | | 6 | | | | | | | |
| 5 | FUSION PRESSURE (bar) | ADD DRAG PRESSURE | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | 2.5 | 2 | 1.7 | 1.5 | 4 | 3.2 | 2.5 | 2 | 5 | 4 | 3.3 | 2.7 | 6.5 | 5 | 4.2 | 3.5 | 8.5 | 7 | 5.5 | 4.5 | 10.5 | 8.5 | 7 | 5.5 | 13 | 10.5 | 8.5 | 7 | 16.5 | 13.5 | 11 | 8.5 | 20 | 16.5 | 13.5 | 11 | 25 | 20.5 | 16.5 | 13.5 | 32 | 26 | 21 | 17 |
| 6 | FUSION TIME (min) | Minimum 10 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 6 | COOLING TIME (min:s) | 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 | 20:00 | 20:00 | 16:03 | 12:54 | 20:00 | 20:00 | 18:09 | 14:33 |

TRACK 315 - DVS 2207-1

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

| PHASE | DN | 90 | | | | 110 | | | | 125 | | | | 140 | | | | 160 | | | | 180 | | | | 200 | | | | 225 | | | | 250 | | | | 280 | | | | 315 | | | | | | |
|-------|--|--|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|----|----|----|
| | 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 | 7.4 | 9 | 11 | 13.6 | | | |
| | WALL THICKNESS | 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 | 38.3 | 31.2 | 25.4 | 20.6 | 43.1 | 35 | 28.6 | 23.3 | | | |
| | 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 | 25 | 20 | 16 |
| | 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 ² | ADD DRAG PRESSURE | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | HEATING TIME | AS BEAD IS FORMED | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | BEAD HEIGHT (mm) | 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 | 3.5 | 3 | 2.5 | 2.5 | 3.5 | 3 | 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) | 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 | 16 | 13 | 12 | 10 | 18 | 16 | 12 | 11 | | | |
| ④ | CHANGEOVER TIME (s) | 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 | 19 | 15 | 13 | 11 | 22 | 19 | 14 | 13 | | | |
| ⑤ | FUSION PRESSURE (bar) | ADD DRAG PRESSURE | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | FUSION TIME (min:s) | 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 | 46:30 | 38:09 | 31:19 | 25:50 | 52:02 | 42:38 | 35:04 | 28:55 | | | |

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

| PHASE | DN | 90 | | | | 110 | | | | 125 | | | | 140 | | | | 160 | | | | 180 | | | | 200 | | | | 225 | | | | 250 | | | | 315 | | | | 315 | | | | | | |
|-------|--|--|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|----|---|-----|
| | 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 | 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 | 16.6 | 13.4 | 10.7 | 8.6 | 18.7 | 15 | 12.1 | 9.7 | | | |
| | 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 | 10 | 8 | 6.3 |
| | 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 ² | ADD DRAG PRESSURE | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | HEATING TIME | AS BEAD IS FORMED | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | BEAD HEIGHT (mm) | 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 | 1 | 1.5 | 1.5 | 1 | 1 | 1.5 | 1.5 | 1 | 2 | 1.5 | 1.5 | 1 | 2 | 1.5 | 1.5 | 1.5 | 2 | 2 | 1.5 | 1.5 | 2 | 2 | 1.5 | 1.5 | | | | | |
| 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) | 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 | 9 | 8 | 7 | 6 | 10 | 9 | 8 | 7 | | | |
| ④ | CHANGEOVER TIME (s) | 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 | 10 | 9 | 7 | 6 | 11 | 9 | 8 | 7 | | | |
| ⑤ | FUSION PRESSURE (bar) | ADD DRAG PRESSURE | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | FUSION TIME (min:s) | 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 | 21:15 | 17:36 | 14:26 | 11:55 | 23:39 | 19:26 | 16:07 | 13:14 | | | |

TRACK 315 - DVS 2207-15

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

| PHASE | DN | 90 | | 110 | | | 125 | | 140 | | | 160 | | | 180 | | 200 | | | 225 | | 250 | | | 280 | | 315 | | | |
|-------|--|--|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|---|
| | SDR | 21 | 33 | 21 | 33 | | 21 | 33 | 21 | 33 | | 21 | 33 | | 21 | 33 | 21 | 33 | | 21 | 33 | 21 | 33 | | 21 | 33 | 21 | 33 | | |
| | WALL THICKNESS | 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 | 13.4 | 8.6 | 15 | 9.7 | 4 | |
| | PN | 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 | S-10 | S-16 | S-10 | S-16 | V | |
| | TRIMMING PRESSURE | DRAG PRESSURE + the necessary pressure to produce the trimming operation | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | HEATING PLATE TEMPERATURE | 240°C ±8°C | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1 | HEAT SOAK PRESSURE (bar) Total pistons area 9.8 cm ² | ADD DRAG PRESSURE | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | 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 | 11.5 | 7.5 | 14.5 | 9.5 | 4 | |
| | HEATING TIME | AS BEAD IS FORMED | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | BEAD HEIGHT (mm) | 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 | 1.1 | 0.8 | 1.3 | 1 | 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) | 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 | 02:54 | 02:06 | 03:10 | 02:17 | 01:20 | |
| 3 | HEATING PLATE WITHDRAWAL (s) | 3 | 3 | 3 | 3 | 3 | 4 | 3 | 4 | 3 | 3 | 4 | 3 | 3 | 4 | 3 | 4 | 4 | 4 | 4 | 4 | 4 | 4 | 4 | 4 | 4 | 4 | 5 | 4 | 4 |
| 4 | CHANGEOVER TIME (s) | 4 | 3 | 4 | 4 | 4 | 4 | 4 | 5 | 4 | 4 | 6 | 4 | 4 | 6 | 5 | 7 | 6 | 6 | 7 | 6 | 6 | 6 | 6 | 6 | 6 | 6 | 9 | 7 | 7 |
| 5 | FUSION PRESSURE (bar) | ADD DRAG PRESSURE | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | 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 | 11.5 | 7.5 | 14.5 | 9.5 | 4 | |
| | FUSION TIME (min:s) | 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 | 17:24 | 12:17 | 19:00 | 13:38 | 06:40 | |