

TRACK 500 - ISO 11414

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

PHASE	DN	250				280				315				355				400				450				500			
	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
	WALL THICKNESS	34.2	27.9	22.7	18.4	38.3	31.2	25.4	20.6	43.1	35	28.6	23.3	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
	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		20	16	12.5
	TRIMMING PRESSURE	DRAG PRESSURE + the necessary pressure to produce the trimming operation																											
	HEATING PLATE TEMPERARURE	210°C ±10°C												225°C ±10°C															
①	HEAT SOAK PRESSURE (bar) Total pistons area 12.82 cm ²	ADD DRAG PRESSURE																											
		32.5	27.5	23	19	41	34	28.5	23.5	51.5	43	36	30	65.5	55	46	38	83.5	70	58.5	48	105.5	88	74	61		109	91	75
	HEATING TIME	AS BEAD B1 IS FORMED																											
	BEAD B1 (bead width)	De 2 a 3 mm												De 3 a 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)	02:35				02:50				03:08				03:28				03:50				04:15				04:40			
③	HEATING PLATE WITHDRAWAL (s)	5.5				6				6.5				7				7.5				8							
④	CHANGEOVER TIME (s)	5.5				6				6				6				6				6							
⑤	FUSION PRESSURE (bar)	ADD DRAG PRESSURE																											
		32.5	27.5	23	19	41	34	28.5	23.5	51.5	43	36	30	65.5	55	46	38	83.5	70	58.5	48	105.5	88	74	61		109	91	75
	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

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

PHASE	DN	250				280				315				355				400				450				500			
	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
	WALL THICKNESS	14.8	11.9	9.6	7.7	16.6	13.4	10.7	8.6	18.7	15	12.1	9.7	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
	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
	TRIMMING PRESSURE	DRAG PRESSURE + the necessary pressure to produce the trimming operation																											
	HEATING PLATE TEMPERARURE	210°C ±10°C												225°C ±10°C															
①	HEAT SOAK PRESSURE (bar) Total pistons area 12.82 cm ²	ADD DRAG PRESSURE																											
		15.5	12.5	10	8	19.5	16	12.5	10.5	24.5	20	16	13	31	25	20.5	16.5	39.5	32	26	21	50	40.5	33	26.5	61.5	50	40.5	32.5
	HEATING TIME	AS BEAD B1 IS FORMED																											
	BEAD B1 (bead width)	De 2 a 3 mm												De 3 a 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)	02:35				02:50				03:08				03:28				03:50				04:15				04:40			
③	HEATING PLATE WITHDRAWAL (s)	5.5				6				6.5				7				7.5				8							
④	CHANGEOVER TIME (s)	5.5				6				6				6				6				6							
⑤	FUSION PRESSURE (bar)	ADD DRAG PRESSURE																											
		15.5	12.5	10	8	19.5	16	12.5	10.5	24.5	20	16	13	31	25	20.5	16.5	39.5	32	26	21	50	40.5	33	26.5	61.5	50	40.5	32.5
	FUSION TIME (min)	Minimum 10																											
⑥	COOLING TIME (min:s)	20:00	17:51	14:24	11:33	20:00	20:00	16:03	12:54	20:00	20:00	18:09	14:33	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	

TRACK 500 - DVS 2207-1

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

PHASE	DN	250				280				315				355				400				450				500			
	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		9	11	13.6
	WALL THICKNESS	34.2	27.9	22.7	18.4	38.3	31.2	25.4	20.6	43.1	35	28.6	23.3	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
	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		20	16	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 12.82 cm2	ADD DRAG PRESSURE																											
		27	23	19	15.5	34	28.5	24	19.5	43	36	30	25	54.5	46	38	31.5	69.5	58	48.5	40	88	73.5	61.5	50.5		91	76	62.5
	HEATING TIME	AS BEAD IS FORMED																											
	BEAD HEIGHT (mm)	3	3	2.5	2	3.5	3	2.5	2.5	3.5	3	3	2.5	3.5	3.5	3	3	4	3.5	3	3	4	3.5	3.5	3		4	3.5	3
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)	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	10:15	08:20	06:50	05:31		09:16	07:34	06:08
③	HEATING PLATE WITHDRAWAL (s)	15	15	11	10	16	13	12	10	18	16	12	11	20	17	14	12	21	18	16	13	23	20	18	14		22	18	16
④	CHANGEOVER TIME (s)	17	18	12	11	19	15	13	11	22	19	14	13	24	20	16	14	26	21	18	15	30	25	21	16		28	23	19
⑤	FUSION PRESSURE (bar)	ADD DRAG PRESSURE																											
		27	23	19	15.5	34	28.5	24	19.5	43	36	30	25	54.5	46	38	31.5	69.5	58	48.5	40	88	73.5	61.5	50.5		91	76	62.5
	FUSION TIME (min:s)	41:41	34:15	28:14	23:19	46:30	38:09	31:19	25:50	52:02	42:38	35:04	28:55	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

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

PHASE	DN	250				280				315				355				400				450				500			
	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
	WALL THICKNESS	14.8	11.9	9.6	7.7	16.6	13.4	10.7	8.6	18.7	15	12.1	9.7	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
	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
	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 12.82 cm2	ADD DRAG PRESSURE																											
		13	10.5	8.5	7	16	13	10.5	8.5	20.5	16.5	13.5	11	26	21	17	14	33	26.5	21.5	17.5	41.5	34	27.5	22	51	42	34	27.5
	HEATING TIME	AS BEAD IS FORMED																											
	BEAD HEIGHT (mm)	2	1.5	1.5	1.5	2	2	1.5	1.5	2	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
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)	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	04:27	03:35	02:52	02:18	04:56	03:59	03:11	02:33
③	HEATING PLATE WITHDRAWAL (s)	9	8	7	6	9	8	7	6	10	9	8	7	11	9	8	7	11	10	9	8	12	11	9	8	14	11	10	9
④	CHANGEOVER TIME (s)	9	8	7	6	10	9	7	6	11	9	8	7	12	10	9	7	13	11	10	8	14	12	10	9	16	13	11	10
⑤	FUSION PRESSURE (bar)	ADD DRAG PRESSURE																											
		13	10.5	8.5	7	16	13	10.5	8.5	20.5	16.5	13.5	11	26	21	17	14	33	26.5	21.5	17.5	41.5	34	27.5	22	51	42	34	27.5
	FUSION TIME (min:s)	19:12	15:53	13:07	10:50	21:15	17:36	14:26	11:55	23:39	19:26	16:07	13:14	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

TRACK 500 - DVS 2207-11

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

PHASE	DN	250				280				315				355				400				450				500				
	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		
	WALL THICKNESS		22.7	14.2			25.4	15.9			28.6	17.9			32.2	20.1			36.3	22.7			40.9	25.5			45.4	28.3		
	PN	16	10	6		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 12.82 cm2	ADD DRAG PRESSURE																												
			12.5	8			16	10.5			20	13			25.5	16.5			32.5	21	7.5			41	26.5			50.5	32.5	
	HEATING TIME	AS BEAD IS FORMED																												
	BEAD HEIGHT (mm)		1.5	1			1.5	1			2	1			2	1.5			2	1.5	1.5			2.5	1.5			2.5	2	
②	HEAT SOAK PRESSURE	IMMOBILIZATION (RELEASE THE PHASE ① HEAT SOAK PRESSURE MOVING DOWNWARDS THE DRAIN VALVE LEVER)																												
		ATTENTION I: 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)		06:07	04:32			06:34	04:52			07:00	05:17			07:28	05:41			07:60	06:07	05:32			08:28	06:35			08:53	06:58	
③	HEATING PLATE WITHDRAWAL (s)		10	8			11	8			11	8			12	9			14	10	9			16	11			16	12	
④	CHANGEOVER TIME (s)		18	12			21	13			23	14			25	18			32	18	17			40	21			41	24	
⑤	FUSION PRESSURE (bar)	ADD DRAG PRESSURE																												
			12.5	8			16	10.5			20	13			25.5	16.5			32.5	21	7.5			41	26.5			50.5	32.5	
	FUSION TIME (min:s)		35:17	23:09			39:09	25:34			43:33	28:26			48:27	31:34			54:03	35:17	30:17			59:30	39:17			64:42	43:08	

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

PHASE	DN	250				280				315				355				400				450				500			
	SDR	26	33	41		26	33	41		26	33	41		26	33	41		26	33	41		26	33	41		26	33	41	
	WALL THICKNESS	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	17.2	13.8	11	6	19.1	15.3	12.3	8	
	PN	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 TEMPERARURE	210°C ±10°C																											
①	HEAT SOAK PRESSURE (bar) Total pistons area 12.82 cm2	ADD DRAG PRESSURE																											
		5.5	4.5	3.5	2	7	5.5	4.5	9	7	6	4	11.5	9	7.5	5	14.5	11.5	9.5	6	18	15	12	6.5	22.5	18	14.5	9.5	
	HEATING TIME	AS BEAD IS FORMED																											
	BEAD HEIGHT (mm)	1	1	0.5	0.5	1	1	1	0.5	1	1	1	0.5	1	1	1	0.5	1	1	1	0.5	1	1	1	0.5	1.5	1	1	1
②	HEAT SOAK PRESSURE	IMMOBILIZATION (RELEASE THE PHASE ① HEAT SOAK PRESSURE MOVING DOWNWARDS THE DRAIN VALVE LEVER)																											
		ATTENTION I: 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)	03:31	03:05	02:42	01:45	03:47	03:17	02:53	04:06	03:33	03:05	02:23	04:24	03:50	03:19	02:39	04:45	04:09	03:34	02:39	05:08	04:27	03:51	02:39	05:31	04:45	04:09	03:09	
③	HEATING PLATE WITHDRAWAL (s)	6	6	5	5	6	6	6	7	6	6	5	7	7	6	6	8	7	6	5	8	7	7	5	9	8	7	6	
④	CHANGEOVER TIME (s)	8	7	6	6	8	8	7	11	9	7	6	12	10	8	7	13	11	8	6	16	12	11	6	17	14	11	7	
⑤	FUSION PRESSURE (bar)	ADD DRAG PRESSURE																											
		5.5	4.5	3.5	2	7	5.5	4.5	9	7	6	4	11.5	9	7.5	5	14.5	11.5	9.5	6	18	15	12	6.5	22.5	18	14.5	9.5	
	FUSION TIME (min:s)	16:10	13:07	10:05	06:00	17:55	14:34	11:46	20:09	16:19	13:07	07:12	22:17	18:14	14:43	09:36	24:43	20:26	16:26	09:36	27:26	22:34	18:24	09:39	30:09	24:43	20:26	13:36	