

TRACK 800 (MODELO 2015) - ISO 11414

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

PHASE	DN	630							710							800						
	SDR	11	13.6	17	21	26	33	41	13.6	17	21	26	33	41	13.6	17	21	26	33	41		
	WALL THICKNESS	57.3	46.4	37.1	30	24.1	19.3	15.4	52.3	41.8	33.9	27.2	21.8	17.4	58.9	47.1	38.1	30.6	24.5	19.6		
	PN	16	12.5	10	8	6.3	5	4	12.5	10	8	6.3	5	4	12.5	10	8	6.3	5	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 40.84 cm2	ADD DRAG PRESSURE																				
		45.5	37.5	30.5	25	20	16.5	13	47.5	38.5	31.5	25.5	21	16.5	60.5	49	40	32.5	26.5	21		
	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)	05:45							06:25							07:10						
③	HEATING PLATE WITHDRAWAL (s)	8																				
④	CHANGEOVER TIME (s)	6																				
⑤	FUSION PRESSURE (bar)	ADD DRAG PRESSURE																				
		45.5	37.5	30.5	25	20	16.5	13	47.5	38.5	31.5	25.5	21	16.5	60.5	49	40	32.5	26.5	21		
	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		

TRACK 800 (MODELO 2015) - DVS 2207-1

BUTT FUSION PARAMETERS FOR PE100 PIPES AND FITTINGS - SDR 11 /SDR 13.6 /SDR 17 / SDR 21 / SDR 26 / SDR 33 / SDR 41

PHASE	DN	630							710							800						
	SDR	11	13.6	17	21	26	33	41	13.6	17	21	26	33	41	13.6	17	21	26	33	41		
	WALL THICKNESS	57.3	46.4	37.1	30	24.1	19.3	15.4	52.3	41.8	33.9	27.2	21.8	17.4	58.9	47.1	38.1	30.6	24.5	24.5		
	PN	16	12.5	10	8	6.3	5	4	12.5	10	8	6.3	5	4	12.5	10	8	6.3	5	4		
	TRIMMING PRESSURE	DRAG PRESSURE + the necessary pressure to produce the trimming operation																				
	HEATING PLATE TEMPERARURE	210°C ±10°C																				
❶	HEAT SOAK PRESSURE (bar) Total pistons area 40.84 cm2	ADD DRAG PRESSURE																				
		38	31	25.5	21	17	13.5	11	39.5	32	26.5	21.5	17.5	14	50.5	41	33.5	27	22	17.5		
	HEATING TIME	AS BEAD IS FORMED																				
	BEAD HEIGHT (mm)	4	3.5	3.5	3	2.5	2.5	2	4	3.5	3	3	2.5	2	4	3.5	3.5	3	2.5	2.5		
❷	HEAT SOAK PRESSURE	IMMOBILIZATION (RELEASE THE PHASE ❶ 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)	09:33	07:44	06:11	05:00	04:01	03:13	02:34	08:43	06:58	05:39	04:32	03:38	02:54	09:49	07:51	06:21	05:06	04:05	03:16		
❸	HEATING PLATE WITHDRAWAL (s)	22	18	16	14	11	10	9	20	17	15	12	11	9	22	19	16	14	12	10		
❹	CHANGEOVER TIME (s)	29	21	19	16	13	11	10	26	20	18	14	12	10	29	24	19	16	13	11		
❺	FUSION PRESSURE (bar)	ADD DRAG PRESSURE																				
		38	31	25.5	21	17	13.5	11	39.5	32	26.5	21.5	17.5	14	50.5	41	33.5	27	22	17.5		
	FUSION TIME (min:s)	67:18	55:51	45:07	36:44	29:50	24:21	19:53	62:18	50:32	41:20	33:25	27:12	22:10	68:54	56:39	46:16	37:26	30:17	24:41		

TRACK 800 (MODELO 2015) - DVS 2207-11

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

PHASE	DN	630					710					800						
	SDR	17.6	26	33	41		17.6	26	33	41		17.6		17.6	26	33	41	
	WALL THICKNESS	35.7	24.1	19.3	15.4	10	40.2	27.2	21.8	17.4	12	28.3		45.3	30.6	24.5	19.6	12
	PN	6	4	3.2	2.5		6	4	3.2	2.5		6		6	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 40.84 cm2	ADD DRAG PRESSURE																
		16.5	11	9	7.5	5	20.5	14.5	11.5	9.5	6.5	18.5		26.5	18	14.5	12	7.5
	HEATING TIME	AS BEAD IS FORMED																
	BEAD HEIGHT (mm)	2	1.5	1.5	1	1	2.5	2	1.5	1	1	2		2.5	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)	07:55	06:21	05:33	04:46	03:37	08:23	06:49	05:58	05:11	04:05	06:58		08:53	07:16	06:25	05:36	04:05
③	HEATING PLATE WITHDRAWAL (s)	14	10	9	8	7	15	11	10	8	7	12		16	12	10	9	7
④	CHANGEOVER TIME (s)	31	21	17	13	10	34	23	19	16	11	24		40	24	20	17	11
⑤	FUSION PRESSURE (bar)	ADD DRAG PRESSURE																
		16.5	11	9	7.5	5	20.5	14.5	11.5	9.5	6.5	18.5		26.5	18	14.5	12	7.5
	FUSION TIME (min:s)	53:14	37:17	30:26	24:51	16:48	58:42	41:38	34:00	27:43	20:00	43:08		64:35	46:16	37:51	30:51	20:00