



## Saemin Electronics Industries Corp.

HEAD OFFICE : #926-2 WHAGOG-DONG GANGSEO-GU SEOUL, KOREA.

Tel : 82-2-2696-8848 Fax : 82-2-2601-1496

URL <http://www.selding.com> E-mail : [selding@selding.com](mailto:selding@selding.com)

ISO 9001 Registered

AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 5	Units	Remark	ISO - SDR5.0-HDPE							
Cylinder area(Ac)	cm <sup>2</sup>	10.99								
Spec	mm		180	200	225	250	280	315	355	400
Out dia(Od)	mm		180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR	36.0	40.0	45.0	50.0	56.0	63.0	71.0	80.0
In dia(Id)	mm	Od-t*2	108.0	120.0	135.0	150.0	168.0	189.0	213.0	240.0
Area(Ar)	cm <sup>2</sup>		162.8	201.0	254.3	314.0	393.9	498.5	633.1	803.8
Heater Temp										
-9	°C		210<215<220							
10-22	°C		205<210<215							
23-	°C		200<205<210							
Forming bead	Kg/cm <sup>2</sup>	Ar*1.5/Ac	22.2	27.4	34.7	42.9	53.8	68.0	86.4	109.7
Forming bead	sec	Ht*0.25	108.0	120.0	135.0	150.0	168.0	189.0	213.0	240.0
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	1.5	1.8	2.3	2.9	3.6	4.5	5.8	7.3
Heating(Ht)	sec	12t	432.0	480.0	540.0	600.0	672.0	756.0	852.0	960.0
Remove Heater	sec	3+0.02Od	6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>		same to forming bead							
Fusing	sec	(3+t)*0.8	31.2	34.4	38.4	42.4	47.2	52.8	59.2	66.4
Cooling	Kg/cm <sup>2</sup>		same to forming bead							
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8	2074	2304	2592	2880	3226	3629	4090	4608
10-22	sec	0.9	2333	2592	2916	3240	3629	4082	4601	5184
23-	sec	1.2t	2592	2880	3240	3600	4032	4536	5112	5760



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SDR- 6	Units	Remark	ISO - SDR6.0-HDPE							
Cylinder area(Ac)	cm <sup>2</sup>	10.99								
Spec	mm		180	200	225	250	280	315	355	400
Out dia(Od)	mm		180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR	30.0	33.3	37.5	41.7	46.7	52.5	59.2	66.7
In dia(Id)	mm	Od-t*2	120.0	133.3	150.0	166.7	186.7	210.0	236.7	266.7
Area(Ar)	cm <sup>2</sup>		141.3	174.4	220.8	272.6	341.9	432.7	549.6	697.8
Heater Temp										
-9	°C		210<215<220							
10-22	°C		205<210<215							
23-	°C		200<205<210							
Forming bead	Kg/cm <sup>2</sup>	Ar*1.5/Ac	19.3	23.8	30.1	37.2	46.7	59.1	75.0	95.2
Forming bead	sec	Ht*0.25	90.0	100.0	112.5	125.0	140.0	157.5	177.5	200.0
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	1.3	1.6	2.0	2.5	3.1	3.9	5.0	6.3
Heating(Ht)	sec	12t	360.0	400.0	450.0	500.0	560.0	630.0	710.0	800.0
Remove Heater	sec	3+0.02Od	6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>		same to forming bead							
Fusing	sec	(3+t)*0.8	26.4	29.1	32.4	35.7	39.7	44.4	49.7	55.7
Cooling	Kg/cm <sup>2</sup>		same to forming bead							
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8	1728	1920	2160	2400	2688	3024	3408	3840
10-22	sec	0.9	1944	2160	2430	2700	3024	3402	3834	4320
23-	sec	1.2t	2160	2400	2700	3000	3360	3780	4260	4800



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SDR- 7			ISO - SDR7.0-HDPE							
Cylinder area(Ac)	Units	Remark								
	cm <sup>2</sup>	10.99								
Spec	mm		180	200	225	250	280	315	355	400
Out dia(Od)	mm		180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR	25.7	28.6	32.1	35.7	40.0	45.0	50.7	57.1
In dia(Id)	mm	Od-t*2	128.6	142.9	160.7	178.6	200.0	225.0	253.6	285.7
Area(Ar)	cm <sup>2</sup>		124.6	153.8	194.6	240.3	301.4	381.5	484.6	615.2
Heater Temp										
-9	°C		210<215<220							
10-22	°C		205<210<215							
23-	°C		200<205<210							
Forming bead	Kg/cm <sup>2</sup>	Ar*1.5/Ac	17.0	21.0	26.6	32.8	41.1	52.1	66.1	84.0
Forming bead	sec	Ht*0.25	77.1	85.7	96.4	107.1	120.0	135.0	152.1	171.4
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	1.1	1.4	1.8	2.2	2.7	3.5	4.4	5.6
Heating(Ht)	sec	12t	308.6	342.9	385.7	428.6	480.0	540.0	608.6	685.7
Remove Heater	sec	3+0.02Od	6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>		same to forming bead							
Fusing	sec	(3+t)*0.8	23.0	25.3	28.1	31.0	34.4	38.4	43.0	48.1
Cooling	Kg/cm <sup>2</sup>		same to forming bead							
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8	1481	1646	1851	2057	2304	2592	2921	3291
10-22	sec	0.9	1666	1851	2083	2314	2592	2916	3286	3703
23-	sec	1.2t	1851	2057	2314	2571	2880	3240	3651	4114



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SDR- 7.4	Units	Remark	ISO - SDR7.4-HDPE							
Cylinder area(Ac)	cm <sup>2</sup>	10.99								
Spec	mm		180	200	225	250	280	315	355	400
Out dia(Od)	mm		180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR	24.3	27.0	30.4	33.8	37.8	42.6	48.0	54.1
In dia(Id)	mm	Od-t*2	131.4	145.9	164.2	182.4	204.3	229.9	259.1	291.9
Area(Ar)	cm <sup>2</sup>		118.9	146.8	185.8	229.4	287.7	364.1	462.5	587.2
Heater Temp										
-9	°C		210<215<220							
10-22	°C		205<210<215							
23-	°C		200<205<210							
Forming bead	Kg/cm <sup>2</sup>	Ar*1.5/Ac	16.2	20.0	25.4	31.3	39.3	49.7	63.1	80.1
Forming bead	sec	Ht*0.25	73.0	81.1	91.2	101.4	113.5	127.7	143.9	162.2
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	1.1	1.3	1.7	2.1	2.6	3.3	4.2	5.3
Heating(Ht)	sec	12t	291.9	324.3	364.9	405.4	454.1	510.8	575.7	648.6
Remove Heater	sec	3+0.02Od	6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>		same to forming bead							
Fusing	sec	(3+t)*0.8	21.9	24.0	26.7	29.4	32.7	36.5	40.8	45.6
Cooling	Kg/cm <sup>2</sup>		same to forming bead							
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8	1401	1557	1751	1946	2179	2452	2763	3114
10-22	sec	0.9	1576	1751	1970	2189	2452	2758	3109	3503
23-	sec	1.2t	1751	1946	2189	2432	2724	3065	3454	3892



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SDR- 9	Units	Remark	ISO - SDR9.0-HDPE							
Cylinder area(Ac)	cm <sup>2</sup>	10.99								
Spec	mm		180	200	225	250	280	315	355	400
Out dia(Od)	mm		180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR	20.0	22.2	25.0	27.8	31.1	35.0	39.4	44.4
In dia(Id)	mm	Od-t*2	140.0	155.6	175.0	194.4	217.8	245.0	276.1	311.1
Area(Ar)	cm <sup>2</sup>		100.5	124.0	157.0	193.8	243.1	307.7	390.8	496.2
Heater Temp										
-9	°C		210<215<220							
10-22	°C		205<210<215							
23-	°C		200<205<210							
Forming bead	Kg/cm <sup>2</sup>	Ar*1.5/Ac	13.7	16.9	21.4	26.5	33.2	42.0	53.3	67.7
Forming bead	sec	Ht*0.25	60.0	66.7	75.0	83.3	93.3	105.0	118.3	133.3
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.9	1.1	1.4	1.8	2.2	2.8	3.6	4.5
Heating(Ht)	sec	12t	240.0	266.7	300.0	333.3	373.3	420.0	473.3	533.3
Remove Heater	sec	3+0.02Od	6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>		same to forming bead							
Fusing	sec	(3+t)*0.8	18.4	20.2	22.4	24.6	27.3	30.4	34.0	38.0
Cooling	Kg/cm <sup>2</sup>		same to forming bead							
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8	1152	1280	1440	1600	1792	2016	2272	2560
10-22	sec	0.9	1296	1440	1620	1800	2016	2268	2556	2880
23-	sec	1.2t	1440	1600	1800	2000	2240	2520	2840	3200



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

			ISO - SDR11.0-HDPE							
SDR- 11	Units	Remark								
Cylinder area(Ac)	cm <sup>2</sup>	10.99								
Spec	mm		180	200	225	250	280	315	355	400
Out dia(Od)	mm		180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR	16.4	18.2	20.5	22.7	25.5	28.6	32.3	36.4
In dia(Id)	mm	Od-t*2	147.3	163.6	184.1	204.5	229.1	257.7	290.5	327.3
Area(Ar)	cm <sup>2</sup>		84.1	103.8	131.4	162.2	203.5	257.5	327.0	415.2
Heater Temp										
-9	°C		210<215<220							
10-22	°C		205<210<215							
23-	°C		200<205<210							
Forming bead	Kg/cm <sup>2</sup>	Ar*1.5/Ac	11.5	14.2	17.9	22.1	27.8	35.1	44.6	56.7
Forming bead	sec	Ht*0.25	49.1	54.5	61.4	68.2	76.4	85.9	96.8	109.1
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.8	0.9	1.2	1.5	1.9	2.3	3.0	3.8
Heating(Ht)	sec	12t	196.4	218.2	245.5	272.7	305.5	343.6	387.3	436.4
Remove Heater	sec	3+0.02Od	6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>		same to forming bead							
Fusing	sec	(3+t)*0.8	15.5	16.9	18.8	20.6	22.8	25.3	28.2	31.5
Cooling	Kg/cm <sup>2</sup>		same to forming bead							
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8	943	1047	1178	1309	1466	1649	1859	2095
10-22	sec	0.9	1060	1178	1325	1473	1649	1856	2091	2356
23-	sec	1.2t	1178	1309	1473	1636	1833	2062	2324	2618



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SDR- 13.6			ISO - SDR13.6-HDPE							
Cylinder area(Ac)	Units	Remark								
	cm <sup>2</sup>	10.99								
Spec	mm		180	200	225	250	280	315	355	400
Out dia(Od)	mm		180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR	13.2	14.7	16.5	18.4	20.6	23.2	26.1	29.4
In dia(Id)	mm	Od-t*2	153.5	170.6	191.9	213.2	238.8	268.7	302.8	341.2
Area(Ar)	cm <sup>2</sup>		69.3	85.6	108.3	133.7	167.7	212.2	269.6	342.2
Heater Temp										
-9	°C		210<215<220							
10-22	°C		205<210<215							
23-	°C		200<205<210							
Forming bead	Kg/cm <sup>2</sup>	Ar*1.5/Ac	9.5	11.7	14.8	18.2	22.9	29.0	36.8	46.7
Forming bead	sec	Ht*0.25	39.7	44.1	49.6	55.1	61.8	69.5	78.3	88.2
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.6	0.8	1.0	1.2	1.5	1.9	2.5	3.1
Heating(Ht)	sec	12t	158.8	176.5	198.5	220.6	247.1	277.9	313.2	352.9
Remove Heater	sec	3+0.02Od	6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>		same to forming bead							
Fusing	sec	(3+t)*0.8	13.0	14.2	15.6	17.1	18.9	20.9	23.3	25.9
Cooling	Kg/cm <sup>2</sup>		same to forming bead							
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8	762	847	953	1059	1186	1334	1504	1694
10-22	sec	0.9	858	953	1072	1191	1334	1501	1691	1906
23-	sec	1.2t	953	1059	1191	1324	1482	1668	1879	2118



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SDR- 15.5			ISO - SDR15.5-HDPE							
Cylinder area(Ac)	Units	Remark								
	cm <sup>2</sup>	10.99								
Spec	mm		180	200	225	250	280	315	355	400
Out dia(Od)	mm		180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR	11.6	12.9	14.5	16.1	18.1	20.3	22.9	25.8
In dia(Id)	mm	Od-t*2	156.8	174.2	196.0	217.7	243.9	274.4	309.2	348.4
Area(Ar)	cm <sup>2</sup>		61.4	75.8	95.9	118.4	148.6	188.0	238.8	303.2
Heater Temp										
-9	°C		210<215<220							
10-22	°C		205<210<215							
23-	°C		200<205<210							
Forming bead	Kg/cm <sup>2</sup>	Ar*1.5/Ac	8.4	10.3	13.1	16.2	20.3	25.7	32.6	41.4
Forming bead	sec	Ht*0.25	34.8	38.7	43.5	48.4	54.2	61.0	68.7	77.4
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.6	0.7	0.9	1.1	1.4	1.7	2.2	2.8
Heating(Ht)	sec	12t	139.4	154.8	174.2	193.5	216.8	243.9	274.8	309.7
Remove Heater	sec	3+0.02Od	6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>		same to forming bead							
Fusing	sec	(3+t)*0.8	11.7	12.7	14.0	15.3	16.9	18.7	20.7	23.0
Cooling	Kg/cm <sup>2</sup>		same to forming bead							
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8	669	743	836	929	1041	1171	1319	1486
10-22	sec	0.9	753	836	941	1045	1171	1317	1484	1672
23-	sec	1.2t	836	929	1045	1161	1301	1463	1649	1858





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			ISO - SDR17.0-HDPE							
SDR- 17	Units	Remark								
Cylinder area(Ac)	cm <sup>2</sup>	10.99								
Spec	mm		180	200	225	250	280	315	355	400
Out dia(Od)	mm		180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR	10.6	11.8	13.2	14.7	16.5	18.5	20.9	23.5
In dia(Id)	mm	Od-t*2	158.8	176.5	198.5	220.6	247.1	277.9	313.2	352.9
Area(Ar)	cm <sup>2</sup>		56.3	69.5	88.0	108.7	136.3	172.5	219.1	278.1
Heater Temp										
-9	°C		210<215<220							
10-22	°C		205<210<215							
23-	°C		200<205<210							
Forming bead	Kg/cm <sup>2</sup>	Ar*1.5/Ac	7.7	9.5	12.0	14.8	18.6	23.5	29.9	38.0
Forming bead	sec	Ht*0.25	31.8	35.3	39.7	44.1	49.4	55.6	62.6	70.6
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.5	0.6	0.8	1.0	1.2	1.6	2.0	2.5
Heating(Ht)	sec	12t	127.1	141.2	158.8	176.5	197.6	222.4	250.6	282.4
Remove Heater	sec	3+0.02Od	6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>		same to forming bead							
Fusing	sec	(3+t)*0.8	10.9	11.8	13.0	14.2	15.6	17.2	19.1	21.2
Cooling	Kg/cm <sup>2</sup>		same to forming bead							
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8	610	678	762	847	949	1067	1203	1355
10-22	sec	0.9	686	762	858	953	1067	1201	1353	1525
23-	sec	1.2t	762	847	953	1059	1186	1334	1504	1694



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 17.6			ISO - SDR17.6-HDPE							
Cylinder area(Ac)	Units	Remark								
	cm <sup>2</sup>	10.99								
Spec	mm		180	200	225	250	280	315	355	400
Out dia(Od)	mm		180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR	10.2	11.4	12.8	14.2	15.9	17.9	20.2	22.7
In dia(Id)	mm	Od-t*2	159.5	177.3	199.4	221.6	248.2	279.2	314.7	354.5
Area(Ar)	cm <sup>2</sup>		54.5	67.3	85.2	105.2	131.9	167.0	212.1	269.2
Heater Temp										
-9	°C		210<215<220							
10-22	°C		205<210<215							
23-	°C		200<205<210							
Forming bead	Kg/cm <sup>2</sup>	Ar*1.5/Ac	7.4	9.2	11.6	14.4	18.0	22.8	28.9	36.7
Forming bead	sec	Ht*0.25	30.7	34.1	38.4	42.6	47.7	53.7	60.5	68.2
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.5	0.6	0.8	1.0	1.2	1.5	1.9	2.4
Heating(Ht)	sec	12t	122.7	136.4	153.4	170.5	190.9	214.8	242.0	272.7
Remove Heater	sec	3+0.02Od	6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>		same to forming bead							
Fusing	sec	(3+t)*0.8	10.6	11.5	12.6	13.8	15.1	16.7	18.5	20.6
Cooling	Kg/cm <sup>2</sup>		same to forming bead							
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8	589	655	736	818	916	1031	1162	1309
10-22	sec	0.9	663	736	828	920	1031	1160	1307	1473
23-	sec	1.2t	736	818	920	1023	1145	1289	1452	1636



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 19			ISO - SDR19.0-HDPE							
Cylinder area(Ac)	Units	Remark								
	cm <sup>2</sup>	10.99								
Spec	mm		180	200	225	250	280	315	355	400
Out dia(Od)	mm		180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR	9.5	10.5	11.8	13.2	14.7	16.6	18.7	21.1
In dia(Id)	mm	Od-t*2	161.1	178.9	201.3	223.7	250.5	281.8	317.6	357.9
Area(Ar)	cm <sup>2</sup>		50.7	62.6	79.3	97.9	122.7	155.4	197.3	250.5
Heater Temp										
-9	°C		210<215<220							
10-22	°C		205<210<215							
23-	°C		200<205<210							
Forming bead	Kg/cm <sup>2</sup>	Ar*1.5/Ac	6.9	8.5	10.8	13.4	16.8	21.2	26.9	34.2
Forming bead	sec	Ht*0.25	28.4	31.6	35.5	39.5	44.2	49.7	56.1	63.2
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.5	0.6	0.7	0.9	1.1	1.4	1.8	2.3
Heating(Ht)	sec	12t	113.7	126.3	142.1	157.9	176.8	198.9	224.2	252.6
Remove Heater	sec	3+0.02Od	6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>		same to forming bead							
Fusing	sec	(3+t)*0.8	10.0	10.8	11.9	12.9	14.2	15.7	17.3	19.2
Cooling	Kg/cm <sup>2</sup>		same to forming bead							
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8	546	606	682	758	849	955	1076	1213
10-22	sec	0.9	614	682	767	853	955	1074	1211	1364
23-	sec	1.2t	682	758	853	947	1061	1194	1345	1516

- - - P E P I P E F U S I O N T E C H N O L O G Y S e l d i n g - s e r i e s - - -



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

			ISO - SDR21.0-HDPE							
SDR- 21	Units	Remark								
Cylinder area(Ac)	cm <sup>2</sup>	10.99								
Spec	mm		180	200	225	250	280	315	355	400
Out dia(Od)	mm		180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR	8.6	9.5	10.7	11.9	13.3	15.0	16.9	19.0
In dia(Id)	mm	Od-t*2	162.9	181.0	203.6	226.2	253.3	285.0	321.2	361.9
Area(Ar)	cm <sup>2</sup>		46.1	57.0	72.1	89.0	111.6	141.3	179.5	227.8
Heater Temp										
-9	°C		210<215<220							
10-22	°C		205<210<215							
23-	°C		200<205<210							
Forming bead	Kg/cm <sup>2</sup>	Ar*1.5/Ac	6.3	7.8	9.8	12.1	15.2	19.3	24.5	31.1
Forming bead	sec	Ht*0.25	25.7	28.6	32.1	35.7	40.0	45.0	50.7	57.1
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.4	0.5	0.7	0.8	1.0	1.3	1.6	2.1
Heating(Ht)	sec	12t	102.9	114.3	128.6	142.9	160.0	180.0	202.9	228.6
Remove Heater	sec	3+0.02Od	6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>		same to forming bead							
Fusing	sec	(3+t)*0.8	9.3	10.0	11.0	11.9	13.1	14.4	15.9	17.6
Cooling	Kg/cm <sup>2</sup>		same to forming bead							
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8	494	549	617	686	768	864	974	1097
10-22	sec	0.9	555	617	694	771	864	972	1095	1234
23-	sec	1.2t	617	686	771	857	960	1080	1217	1371



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

			ISO - SDR22.0-HDPE							
SDR- 22	Units	Remark								
Cylinder area(Ac)	cm <sup>2</sup>	10.99								
Spec	mm		180	200	225	250	280	315	355	400
Out dia(Od)	mm		180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR	8.2	9.1	10.2	11.4	12.7	14.3	16.1	18.2
In dia(Id)	mm	Od-t*2	163.6	181.8	204.5	227.3	254.5	286.4	322.7	363.6
Area(Ar)	cm <sup>2</sup>		44.1	54.5	69.0	85.1	106.8	135.2	171.7	218.0
Heater Temp										
-9	°C		210<215<220							
10-22	°C		205<210<215							
23-	°C		200<205<210							
Forming bead	Kg/cm <sup>2</sup>	Ar*1.5/Ac	6.0	7.4	9.4	11.6	14.6	18.5	23.4	29.8
Forming bead	sec	Ht*0.25	24.5	27.3	30.7	34.1	38.2	43.0	48.4	54.5
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.4	0.5	0.6	0.8	1.0	1.2	1.6	2.0
Heating(Ht)	sec	12t	98.2	109.1	122.7	136.4	152.7	171.8	193.6	218.2
Remove Heater	sec	3+0.02Od	6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>		same to forming bead							
Fusing	sec	(3+t)*0.8	8.9	9.7	10.6	11.5	12.6	13.9	15.3	16.9
Cooling	Kg/cm <sup>2</sup>		same to forming bead							
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8	471	524	589	655	733	825	929	1047
10-22	sec	0.9	530	589	663	736	825	928	1046	1178
23-	sec	1.2t	589	655	736	818	916	1031	1162	1309



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 26			ISO - SDR26.0-HDPE							
Cylinder area(Ac)	Units	Remark								
	cm <sup>2</sup>	10.99								
Spec	mm		180	200	225	250	280	315	355	400
Out dia(Od)	mm		180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR	6.9	7.7	8.7	9.6	10.8	12.1	13.7	15.4
In dia(Id)	mm	Od-t*2	166.2	184.6	207.7	230.8	258.5	290.8	327.7	369.2
Area(Ar)	cm <sup>2</sup>		37.6	46.4	58.8	72.6	91.0	115.2	146.3	185.8
Heater Temp										
-9	°C		210<215<220							
10-22	°C		205<210<215							
23-	°C		200<205<210							
Forming bead	Kg/cm <sup>2</sup>	Ar*1.5/Ac	5.1	6.3	8.0	9.9	12.4	15.7	20.0	25.4
Forming bead	sec	Ht*0.25	20.8	23.1	26.0	28.8	32.3	36.3	41.0	46.2
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.3	0.4	0.5	0.7	0.8	1.0	1.3	1.7
Heating(Ht)	sec	12t	83.1	92.3	103.8	115.4	129.2	145.4	163.8	184.6
Remove Heater	sec	3+0.02Od	6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>		same to forming bead							
Fusing	sec	(3+t)*0.8	7.9	8.6	9.3	10.1	11.0	12.1	13.3	14.7
Cooling	Kg/cm <sup>2</sup>		same to forming bead							
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8	399	443	498	554	620	698	786	886
10-22	sec	0.9	449	498	561	623	698	785	885	997
23-	sec	1.2t	498	554	623	692	775	872	983	1108



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

			ISO - SDR33.0-HDPE							
SDR- 33	Units	Remark								
Cylinder area(Ac)	cm <sup>2</sup>	10.99								
Spec	mm		180	200	225	250	280	315	355	400
Out dia(Od)	mm		180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR	5.5	6.1	6.8	7.6	8.5	9.5	10.8	12.1
In dia(Id)	mm	Od-t*2	169.1	187.9	211.4	234.8	263.0	295.9	333.5	375.8
Area(Ar)	cm <sup>2</sup>		29.9	36.9	46.7	57.7	72.3	91.6	116.3	147.6
Heater Temp										
-9	°C		210<215<220							
10-22	°C		205<210<215							
23-	°C		200<205<210							
Forming bead	Kg/cm <sup>2</sup>	Ar*1.5/Ac	4.1	5.0	6.4	7.9	9.9	12.5	15.9	20.1
Forming bead	sec	Ht*0.25	16.4	18.2	20.5	22.7	25.5	28.6	32.3	36.4
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.3	0.3	0.4	0.5	0.7	0.8	1.1	1.3
Heating(Ht)	sec	12t	65.5	72.7	81.8	90.9	101.8	114.5	129.1	145.5
Remove Heater	sec	3+0.02Od	6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>		same to forming bead							
Fusing	sec	(3+t)*0.8	6.8	7.2	7.9	8.5	9.2	10.0	11.0	12.1
Cooling	Kg/cm <sup>2</sup>		same to forming bead							
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8	314	349	393	436	489	550	620	698
10-22	sec	0.9	353	393	442	491	550	619	697	785
23-	sec	1.2t	393	436	491	545	611	687	775	873



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

			ISO - SDR41.0-HDPE							
SDR- 41	Units	Remark								
Cylinder area(Ac)	cm <sup>2</sup>	10.99								
Spec	mm		180	200	225	250	280	315	355	400
Out dia(Od)	mm		180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR	4.4	4.9	5.5	6.1	6.8	7.7	8.7	9.8
In dia(Id)	mm	Od-t*2	171.2	190.2	214.0	237.8	266.3	299.6	337.7	380.5
Area(Ar)	cm <sup>2</sup>		24.2	29.9	37.8	46.7	58.6	74.1	94.2	119.5
Heater Temp										
-9	°C		210<215<220							
10-22	°C		205<210<215							
23-	°C		200<205<210							
Forming bead	Kg/cm <sup>2</sup>	Ar*1.5/Ac	3.3	4.1	5.2	6.4	8.0	10.1	12.9	16.3
Forming bead	sec	Ht*0.25	13.2	14.6	16.5	18.3	20.5	23.0	26.0	29.3
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.2	0.3	0.3	0.4	0.5	0.7	0.9	1.1
Heating(Ht)	sec	12t	52.7	58.5	65.9	73.2	82.0	92.2	103.9	117.1
Remove Heater	sec	3+0.02Od	6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>		same to forming bead							
Fusing	sec	(3+t)*0.8	5.9	6.3	6.8	7.3	7.9	8.5	9.3	10.2
Cooling	Kg/cm <sup>2</sup>		same to forming bead							
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8	253	281	316	351	393	443	499	562
10-22	sec	0.9	284	316	356	395	443	498	561	632
23-	sec	1.2t	316	351	395	439	492	553	623	702





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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

			ISO - SDR51.0-HDPE							
SDR- 51	Units	Remark								
Cylinder area(Ac)	cm <sup>2</sup>	10.99								
Spec	mm		180	200	225	250	280	315	355	400
Out dia(Od)	mm		180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR	3.5	3.9	4.4	4.9	5.5	6.2	7.0	7.8
In dia(Id)	mm	Od-t*2	172.9	192.2	216.2	240.2	269.0	302.6	341.1	384.3
Area(Ar)	cm <sup>2</sup>		19.6	24.1	30.6	37.7	47.3	59.9	76.1	96.6
Heater Temp										
-9	°C		210<215<220							
10-22	°C		205<210<215							
23-	°C		200<205<210							
Forming bead	Kg/cm <sup>2</sup>	Ar*1.5/Ac	2.7	3.3	4.2	5.1	6.5	8.2	10.4	13.2
Forming bead	sec	Ht*0.25	10.6	11.8	13.2	14.7	16.5	18.5	20.9	23.5
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.2	0.2	0.3	0.3	0.4	0.5	0.7	0.9
Heating(Ht)	sec	12t	42.4	47.1	52.9	58.8	65.9	74.1	83.5	94.1
Remove Heater	sec	3+0.02Od	6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>		same to forming bead							
Fusing	sec	(3+t)*0.8	5.2	5.5	5.9	6.3	6.8	7.3	8.0	8.7
Cooling	Kg/cm <sup>2</sup>		same to forming bead							
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8	203	226	254	282	316	356	401	452
10-22	sec	0.9	229	254	286	318	356	400	451	508
23-	sec	1.2t	254	282	318	353	395	445	501	565