

- - - 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 - - -



## Saemin Electronics Industries Corp.

HEAD OFFICE : 49-25, Gimpohangang 4-ro 278 beon-gil, Gimpo-si, Gyeonggi-do, KOREA.

Tel : +82-2-2696-8802 (Domestic line : 1877-8852) Fax : +82-505-882-8802

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-MDPE									
Cylinder area(Ac)	cm <sup>2</sup>	37.68										
Spec	mm		225	250	280	315	355	400	450	500	560	630
Out dia(Od)	mm		225	250	280	315	355	400	450	500	560	630
Thickness(t)	mm	Od/SDR	45.0	50.0	56.0	63.0	71.0	80.0	90.0	100.0	112.0	126.0
In dia(Id)	mm	Od-t*2	135.0	150.0	168.0	189.0	213.0	240.0	270.0	300.0	336.0	378.0
Area(Ar)	cm <sup>2</sup>		254.3	314.0	393.9	498.5	633.1	803.8	1017.4	1256.0	1575.5	1994.0
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	10.1	12.5	15.7	19.8	25.2	32.0	40.5	50.0	62.7	79.4
Forming bead	sec	Ht*0.2	99.0	110.0	123.2	138.6	156.2	176.0	198.0	220.0	246.4	277.2
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.7	0.8	1.0	1.3	1.7	2.1	2.7	3.3	4.2	5.3
Heating(Ht)	sec	11t	495.0	550.0	616.0	693.0	781.0	880.0	990.0	1100.0	1232.0	1386.0
Remove Heater	sec	3+0.02Od	7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6
Fusing	Kg/cm <sup>2</sup>		same to forming bead									
Fusing	sec	(3+t)*0.8	38.4	42.4	47.2	52.8	59.2	66.4	74.4	82.4	92.0	103.2
Cooling	Kg/cm <sup>2</sup>		same to forming bead									
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8	2592	2880	3226	3629	4090	4608	5184	5760	6451	7258
10-22	sec	0.9	2916	3240	3629	4082	4601	5184	5832	6480	7258	8165
23-	sec	1.2t	3240	3600	4032	4536	5112	5760	6480	7200	8064	9072

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SDR- 6	Units	Remark	ISO - SDR6.0-MDPE									
Cylinder area(Ac)	cm <sup>2</sup>	37.68										
Spec	mm		225	250	280	315	355	400	450	500	560	630
Out dia(Od)	mm		225	250	280	315	355	400	450	500	560	630
Thickness(t)	mm	Od/SDR	37.5	41.7	46.7	52.5	59.2	66.7	75.0	83.3	93.3	105.0
In dia(Id)	mm	Od-t*2	150.0	166.7	186.7	210.0	236.7	266.7	300.0	333.3	373.3	420.0
Area(Ar)	cm <sup>2</sup>		220.8	272.6	341.9	432.7	549.6	697.8	883.1	1090.3	1367.6	1730.9
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	8.8	10.9	13.6	17.2	21.9	27.8	35.2	43.4	54.4	68.9
Forming bead	sec	Ht*0.2	82.5	91.7	102.7	115.5	130.2	146.7	165.0	183.3	205.3	231.0
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.6	0.7	0.9	1.1	1.5	1.9	2.3	2.9	3.6	4.6
Heating(Ht)	sec	11t	412.5	458.3	513.3	577.5	650.8	733.3	825.0	916.7	1026.7	1155.0
Remove Heater	sec	3+0.02Od	7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6
Fusing	Kg/cm <sup>2</sup>		same to forming bead									
Fusing	sec	(3+t)*0.8	32.4	35.7	39.7	44.4	49.7	55.7	62.4	69.1	77.1	86.4
Cooling	Kg/cm <sup>2</sup>		same to forming bead									
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8	2160	2400	2688	3024	3408	3840	4320	4800	5376	6048
10-22	sec	0.9	2430	2700	3024	3402	3834	4320	4860	5400	6048	6804
23-	sec	1.2t	2700	3000	3360	3780	4260	4800	5400	6000	6720	7560

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SDR- 7	Units	Remark	ISO - SDR7.0-MDPE									
Cylinder area(Ac)	cm <sup>2</sup>	37.68										
Spec	mm		225	250	280	315	355	400	450	500	560	630
Out dia(Od)	mm		225	250	280	315	355	400	450	500	560	630
Thickness(t)	mm	Od/SDR	32.1	35.7	40.0	45.0	50.7	57.1	64.3	71.4	80.0	90.0
In dia(Id)	mm	Od-t*2	160.7	178.6	200.0	225.0	253.6	285.7	321.4	357.1	400.0	450.0
Area(Ar)	cm <sup>2</sup>		194.6	240.3	301.4	381.5	484.6	615.2	778.6	961.2	1205.8	1526.0
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	7.7	9.6	12.0	15.2	19.3	24.5	31.0	38.3	48.0	60.8
Forming bead	sec	Ht*0.2	70.7	78.6	88.0	99.0	111.6	125.7	141.4	157.1	176.0	198.0
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.5	0.6	0.8	1.0	1.3	1.6	2.1	2.6	3.2	4.1
Heating(Ht)	sec	11t	353.6	392.9	440.0	495.0	557.9	628.6	707.1	785.7	880.0	990.0
Remove Heater	sec	3+0.02Od	7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6
Fusing	Kg/cm <sup>2</sup>		same to forming bead									
Fusing	sec	(3+t)*0.8	28.1	31.0	34.4	38.4	43.0	48.1	53.8	59.5	66.4	74.4
Cooling	Kg/cm <sup>2</sup>		same to forming bead									
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8	1851	2057	2304	2592	2921	3291	3703	4114	4608	5184
10-22	sec	0.9	2083	2314	2592	2916	3286	3703	4166	4629	5184	5832
23-	sec	1.2t	2314	2571	2880	3240	3651	4114	4629	5143	5760	6480

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SDR- 7.4	Units	Remark	ISO - SDR7.4-MDPE									
Cylinder area(Ac)	cm <sup>2</sup>	37.68										
Spec	mm		225	250	280	315	355	400	450	500	560	630
Out dia(Od)	mm		225	250	280	315	355	400	450	500	560	630
Thickness(t)	mm	Od/SDR	30.4	33.8	37.8	42.6	48.0	54.1	60.8	67.6	75.7	85.1
In dia(Id)	mm	Od-t*2	164.2	182.4	204.3	229.9	259.1	291.9	328.4	364.9	408.6	459.7
Area(Ar)	cm <sup>2</sup>		185.8	229.4	287.7	364.1	462.5	587.2	743.1	917.5	1150.9	1456.6
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	7.4	9.1	11.5	14.5	18.4	23.4	29.6	36.5	45.8	58.0
Forming bead	sec	Ht*0.2	66.9	74.3	83.2	93.6	105.5	118.9	133.8	148.6	166.5	187.3
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	2.4	3.1	3.9
Heating(Ht)	sec	11t	334.5	371.6	416.2	468.2	527.7	594.6	668.9	743.2	832.4	936.5
Remove Heater	sec	3+0.02Od	7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6
Fusing	Kg/cm <sup>2</sup>		same to forming bead									
Fusing	sec	(3+t)*0.8	26.7	29.4	32.7	36.5	40.8	45.6	51.0	56.5	62.9	70.5
Cooling	Kg/cm <sup>2</sup>		same to forming bead									
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8	1751	1946	2179	2452	2763	3114	3503	3892	4359	4904
10-22	sec	0.9	1970	2189	2452	2758	3109	3503	3941	4378	4904	5517
23-	sec	1.2t	2189	2432	2724	3065	3454	3892	4378	4865	5449	6130



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SDR- 9	Units	Remark	ISO - SDR9.0-MDPE									
Cylinder area(Ac)	cm <sup>2</sup>	37.68										
Spec	mm		225	250	280	315	355	400	450	500	560	630
Out dia(Od)	mm		225	250	280	315	355	400	450	500	560	630
Thickness(t)	mm	Od/SDR	25.0	27.8	31.1	35.0	39.4	44.4	50.0	55.6	62.2	70.0
In dia(Id)	mm	Od-t*2	175.0	194.4	217.8	245.0	276.1	311.1	350.0	388.9	435.6	490.0
Area(Ar)	cm <sup>2</sup>		157.0	193.8	243.1	307.7	390.8	496.2	628.0	775.3	972.5	1230.9
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	7.7	9.7	12.3	15.6	19.8	25.0	30.9	38.7	49.0
Forming bead	sec	Ht*0.2	55.0	61.1	68.4	77.0	86.8	97.8	110.0	122.2	136.9	154.0
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.4	0.5	0.6	0.8	1.0	1.3	1.7	2.1	2.6	3.3
Heating(Ht)	sec	11t	275.0	305.6	342.2	385.0	433.9	488.9	550.0	611.1	684.4	770.0
Remove Heater	sec	3+0.02Od	7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6
Fusing	Kg/cm <sup>2</sup>		same to forming bead									
Fusing	sec	(3+t)*0.8	22.4	24.6	27.3	30.4	34.0	38.0	42.4	46.8	52.2	58.4
Cooling	Kg/cm <sup>2</sup>		same to forming bead									
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8	1440	1600	1792	2016	2272	2560	2880	3200	3584	4032
10-22	sec	0.9	1620	1800	2016	2268	2556	2880	3240	3600	4032	4536
23-	sec	1.2t	1800	2000	2240	2520	2840	3200	3600	4000	4480	5040



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SDR- 11	Units	Remark	ISO - SDR11.0-MDPE									
Cylinder area(Ac)	cm <sup>2</sup>	37.68										
Spec	mm		225	250	280	315	355	400	450	500	560	630
Out dia(Od)	mm		225	250	280	315	355	400	450	500	560	630
Thickness(t)	mm	Od/SDR	20.5	22.7	25.5	28.6	32.3	36.4	40.9	45.5	50.9	57.3
In dia(Id)	mm	Od-t*2	184.1	204.5	229.1	257.7	290.5	327.3	368.2	409.1	458.2	515.5
Area(Ar)	cm <sup>2</sup>		131.4	162.2	203.5	257.5	327.0	415.2	525.5	648.8	813.8	1030.0
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	5.2	6.5	8.1	10.3	13.0	16.5	20.9	25.8	32.4	41.0
Forming bead	sec	Ht*0.2	45.0	50.0	56.0	63.0	71.0	80.0	90.0	100.0	112.0	126.0
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.3	0.4	0.5	0.7	0.9	1.1	1.4	1.7	2.2	2.7
Heating(Ht)	sec	11t	225.0	250.0	280.0	315.0	355.0	400.0	450.0	500.0	560.0	630.0
Remove Heater	sec	3+0.02Od	7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6
Fusing	Kg/cm <sup>2</sup>		same to forming bead									
Fusing	sec	(3+t)*0.8	18.8	20.6	22.8	25.3	28.2	31.5	35.1	38.8	43.1	48.2
Cooling	Kg/cm <sup>2</sup>		same to forming bead									
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8	1178	1309	1466	1649	1859	2095	2356	2618	2932	3299
10-22	sec	0.9	1325	1473	1649	1856	2091	2356	2651	2945	3299	3711
23-	sec	1.2t	1473	1636	1833	2062	2324	2618	2945	3273	3665	4124

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SDR- 13.6	Units	Remark	ISO - SDR13.6-MDPE									
Cylinder area(Ac)	cm <sup>2</sup>	37.68										
Spec	mm		225	250	280	315	355	400	450	500	560	630
Out dia(Od)	mm		225	250	280	315	355	400	450	500	560	630
Thickness(t)	mm	Od/SDR	16.5	18.4	20.6	23.2	26.1	29.4	33.1	36.8	41.2	46.3
In dia(Id)	mm	Od-t*2	191.9	213.2	238.8	268.7	302.8	341.2	383.8	426.5	477.6	537.4
Area(Ar)	cm <sup>2</sup>		108.3	133.7	167.7	212.2	269.6	342.2	433.2	534.8	670.8	849.0
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	4.3	5.3	6.7	8.4	10.7	13.6	17.2	21.3	26.7	33.8
Forming bead	sec	Ht*0.2	36.4	40.4	45.3	51.0	57.4	64.7	72.8	80.9	90.6	101.9
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.3	0.4	0.4	0.6	0.7	0.9	1.1	1.4	1.8	2.3
Heating(Ht)	sec	11t	182.0	202.2	226.5	254.8	287.1	323.5	364.0	404.4	452.9	509.6
Remove Heater	sec	3+0.02Od	7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6
Fusing	Kg/cm <sup>2</sup>		same to forming bead									
Fusing	sec	(3+t)*0.8	15.6	17.1	18.9	20.9	23.3	25.9	28.9	31.8	35.3	39.5
Cooling	Kg/cm <sup>2</sup>		same to forming bead									
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8	953	1059	1186	1334	1504	1694	1906	2118	2372	2668
10-22	sec	0.9	1072	1191	1334	1501	1691	1906	2144	2382	2668	3002
23-	sec	1.2t	1191	1324	1482	1668	1879	2118	2382	2647	2965	3335

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SDR- 15.5	Units	Remark	ISO - SDR15.5-MDPE									
Cylinder area(Ac)	cm <sup>2</sup>	37.68										
Spec	mm		225	250	280	315	355	400	450	500	560	630
Out dia(Od)	mm		225	250	280	315	355	400	450	500	560	630
Thickness(t)	mm	Od/SDR	14.5	16.1	18.1	20.3	22.9	25.8	29.0	32.3	36.1	40.6
In dia(Id)	mm	Od-t*2	196.0	217.7	243.9	274.4	309.2	348.4	391.9	435.5	487.7	548.7
Area(Ar)	cm <sup>2</sup>		95.9	118.4	148.6	188.0	238.8	303.2	383.8	473.8	594.3	752.2
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	3.8	4.7	5.9	7.5	9.5	12.1	15.3	18.9	23.7	29.9
Forming bead	sec	Ht*0.2	31.9	35.5	39.7	44.7	50.4	56.8	63.9	71.0	79.5	89.4
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.3	0.3	0.4	0.5	0.6	0.8	1.0	1.3	1.6	2.0
Heating(Ht)	sec	11t	159.7	177.4	198.7	223.5	251.9	283.9	319.4	354.8	397.4	447.1
Remove Heater	sec	3+0.02Od	7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6
Fusing	Kg/cm <sup>2</sup>		same to forming bead									
Fusing	sec	(3+t)*0.8	14.0	15.3	16.9	18.7	20.7	23.0	25.6	28.2	31.3	34.9
Cooling	Kg/cm <sup>2</sup>		same to forming bead									
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8	836	929	1041	1171	1319	1486	1672	1858	2081	2341
10-22	sec	0.9	941	1045	1171	1317	1484	1672	1881	2090	2341	2634
23-	sec	1.2t	1045	1161	1301	1463	1649	1858	2090	2323	2601	2926





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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 17		Units	Remark	ISO - SDR17.0-MDPE									
Cylinder area(Ac)		cm <sup>2</sup>	37.68										
Spec	mm			225	250	280	315	355	400	450	500	560	630
Out dia(Od)	mm			225	250	280	315	355	400	450	500	560	630
Thickness(t)	mm	Od/SDR		13.2	14.7	16.5	18.5	20.9	23.5	26.5	29.4	32.9	37.1
In dia(Id)	mm	Od-t*2		198.5	220.6	247.1	277.9	313.2	352.9	397.1	441.2	494.1	555.9
Area(Ar)	cm <sup>2</sup>			88.0	108.7	136.3	172.5	219.1	278.1	352.0	434.6	545.2	690.0
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		3.5	4.3	5.4	6.9	8.7	11.1	14.0	17.3	21.7	27.5
Forming bead	sec	Ht*0.2		29.1	32.4	36.2	40.8	45.9	51.8	58.2	64.7	72.5	81.5
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.2	0.3	0.4	0.5	0.6	0.7	0.9	1.2	1.4	1.8
Heating(Ht)	sec	11t		145.6	161.8	181.2	203.8	229.7	258.8	291.2	323.5	362.4	407.6
Remove Heater	sec	3+0.02Od		7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6
Fusing	Kg/cm <sup>2</sup>			same to forming bead									
Fusing	sec	(3+t)*0.8		13.0	14.2	15.6	17.2	19.1	21.2	23.6	25.9	28.8	32.0
Cooling	Kg/cm <sup>2</sup>			same to forming bead									
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8		762	847	949	1067	1203	1355	1525	1694	1897	2135
10-22	sec	0.9		858	953	1067	1201	1353	1525	1715	1906	2135	2401
23-	sec	1.2t		953	1059	1186	1334	1504	1694	1906	2118	2372	2668



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 17.6	Units	Remark	ISO - SDR17.6-MDPE									
Cylinder area(Ac)	cm <sup>2</sup>	37.68										
Spec	mm		225	250	280	315	355	400	450	500	560	630
Out dia(Od)	mm		225	250	280	315	355	400	450	500	560	630
Thickness(t)	mm	Od/SDR	12.8	14.2	15.9	17.9	20.2	22.7	25.6	28.4	31.8	35.8
In dia(Id)	mm	Od-t*2	199.4	221.6	248.2	279.2	314.7	354.5	398.9	443.2	496.4	558.4
Area(Ar)	cm <sup>2</sup>		85.2	105.2	131.9	167.0	212.1	269.2	340.8	420.7	527.7	667.9
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	3.4	4.2	5.3	6.6	8.4	10.7	13.6	16.7	21.0	26.6
Forming bead	sec	Ht*0.2	28.1	31.3	35.0	39.4	44.4	50.0	56.3	62.5	70.0	78.8
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.2	0.3	0.4	0.4	0.6	0.7	0.9	1.1	1.4	1.8
Heating(Ht)	sec	11t	140.6	156.3	175.0	196.9	221.9	250.0	281.3	312.5	350.0	393.8
Remove Heater	sec	3+0.02Od	7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6
Fusing	Kg/cm <sup>2</sup>		same to forming bead									
Fusing	sec	(3+t)*0.8	12.6	13.8	15.1	16.7	18.5	20.6	22.9	25.1	27.9	31.0
Cooling	Kg/cm <sup>2</sup>		same to forming bead									
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8	736	818	916	1031	1162	1309	1473	1636	1833	2062
10-22	sec	0.9	828	920	1031	1160	1307	1473	1657	1841	2062	2320
23-	sec	1.2t	920	1023	1145	1289	1452	1636	1841	2045	2291	2577



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 19	Units	Remark	ISO - SDR19.0-MDPE									
Cylinder area(Ac)	cm <sup>2</sup>	37.68										
Spec	mm		225	250	280	315	355	400	450	500	560	630
Out dia(Od)	mm		225	250	280	315	355	400	450	500	560	630
Thickness(t)	mm	Od/SDR	11.8	13.2	14.7	16.6	18.7	21.1	23.7	26.3	29.5	33.2
In dia(Id)	mm	Od-t*2	201.3	223.7	250.5	281.8	317.6	357.9	402.6	447.4	501.1	563.7
Area(Ar)	cm <sup>2</sup>		79.3	97.9	122.7	155.4	197.3	250.5	317.0	391.4	491.0	621.4
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	3.2	3.9	4.9	6.2	7.9	10.0	12.6	15.6	19.5	24.7
Forming bead	sec	Ht*0.2	26.1	28.9	32.4	36.5	41.1	46.3	52.1	57.9	64.8	72.9
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.2	0.3	0.3	0.4	0.5	0.7	0.8	1.0	1.3	1.6
Heating(Ht)	sec	11t	130.3	144.7	162.1	182.4	205.5	231.6	260.5	289.5	324.2	364.7
Remove Heater	sec	3+0.02Od	7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6
Fusing	Kg/cm <sup>2</sup>		same to forming bead									
Fusing	sec	(3+t)*0.8	11.9	12.9	14.2	15.7	17.3	19.2	21.3	23.5	26.0	28.9
Cooling	Kg/cm <sup>2</sup>		same to forming bead									
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8	682	758	849	955	1076	1213	1364	1516	1698	1910
10-22	sec	0.9	767	853	955	1074	1211	1364	1535	1705	1910	2149
23-	sec	1.2t	853	947	1061	1194	1345	1516	1705	1895	2122	2387

- - - 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

SDR- 21			ISO - SDR21.0-MDPE									
Cylinder area(Ac)	Units	Remark										
	cm <sup>2</sup>	37.68										
Spec	mm		225	250	280	315	355	400	450	500	560	630
Out dia(Od)	mm		225	250	280	315	355	400	450	500	560	630
Thickness(t)	mm	Od/SDR	10.7	11.9	13.3	15.0	16.9	19.0	21.4	23.8	26.7	30.0
In dia(Id)	mm	Od-t*2	203.6	226.2	253.3	285.0	321.2	361.9	407.1	452.4	506.7	570.0
Area(Ar)	cm <sup>2</sup>		72.1	89.0	111.6	141.3	179.5	227.8	288.4	356.0	446.6	565.2
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	2.9	3.5	4.4	5.6	7.1	9.1	11.5	14.2	17.8	22.5
Forming bead	sec	Ht*0.2	23.6	26.2	29.3	33.0	37.2	41.9	47.1	52.4	58.7	66.0
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.2	0.2	0.3	0.4	0.5	0.6	0.8	0.9	1.2	1.5
Heating(Ht)	sec	11t	117.9	131.0	146.7	165.0	186.0	209.5	235.7	261.9	293.3	330.0
Remove Heater	sec	3+0.02Od	7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6
Fusing	Kg/cm <sup>2</sup>		same to forming bead									
Fusing	sec	(3+t)*0.8	11.0	11.9	13.1	14.4	15.9	17.6	19.5	21.4	23.7	26.4
Cooling	Kg/cm <sup>2</sup>		same to forming bead									
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8	617	686	768	864	974	1097	1234	1371	1536	1728
10-22	sec	0.9	694	771	864	972	1095	1234	1389	1543	1728	1944
23-	sec	1.2t	771	857	960	1080	1217	1371	1543	1714	1920	2160



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 22		Units	Remark	ISO - SDR22.0-MDPE									
Cylinder area(Ac)		cm <sup>2</sup>	37.68										
Spec	mm			225	250	280	315	355	400	450	500	560	630
Out dia(Od)	mm			225	250	280	315	355	400	450	500	560	630
Thickness(t)	mm	Od/SDR		10.2	11.4	12.7	14.3	16.1	18.2	20.5	22.7	25.5	28.6
In dia(Id)	mm	Od-t*2		204.5	227.3	254.5	286.4	322.7	363.6	409.1	454.5	509.1	572.7
Area(Ar)	cm <sup>2</sup>			69.0	85.1	106.8	135.2	171.7	218.0	275.9	340.6	427.2	540.7
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	3.4	4.3	5.4	6.8	8.7	11.0	13.6	17.0	21.5
Forming bead	sec	Ht*0.2		22.5	25.0	28.0	31.5	35.5	40.0	45.0	50.0	56.0	63.0
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.2	0.2	0.3	0.4	0.5	0.6	0.7	0.9	1.1	1.4
Heating(Ht)	sec	11t		112.5	125.0	140.0	157.5	177.5	200.0	225.0	250.0	280.0	315.0
Remove Heater	sec	3+0.02Od		7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6
Fusing	Kg/cm <sup>2</sup>			same to forming bead									
Fusing	sec	(3+t)*0.8		10.6	11.5	12.6	13.9	15.3	16.9	18.8	20.6	22.8	25.3
Cooling	Kg/cm <sup>2</sup>			same to forming bead									
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8		589	655	733	825	929	1047	1178	1309	1466	1649
10-22	sec	0.9		663	736	825	928	1046	1178	1325	1473	1649	1856
23-	sec	1.2t		736	818	916	1031	1162	1309	1473	1636	1833	2062

- - - 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

SDR- 26	Units	Remark	ISO - SDR26.0-MDPE									
Cylinder area(Ac)	cm <sup>2</sup>	37.68										
Spec	mm		225	250	280	315	355	400	450	500	560	630
Out dia(Od)	mm		225	250	280	315	355	400	450	500	560	630
Thickness(t)	mm	Od/SDR	8.7	9.6	10.8	12.1	13.7	15.4	17.3	19.2	21.5	24.2
In dia(Id)	mm	Od-t*2	207.7	230.8	258.5	290.8	327.7	369.2	415.4	461.5	516.9	581.5
Area(Ar)	cm <sup>2</sup>		58.8	72.6	91.0	115.2	146.3	185.8	235.2	290.3	364.2	460.9
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	2.3	2.9	3.6	4.6	5.8	7.4	9.4	11.6	14.5	18.3
Forming bead	sec	Ht*0.2	19.0	21.2	23.7	26.7	30.0	33.8	38.1	42.3	47.4	53.3
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.2	0.2	0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2
Heating(Ht)	sec	11t	95.2	105.8	118.5	133.3	150.2	169.2	190.4	211.5	236.9	266.5
Remove Heater	sec	3+0.02Od	7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6
Fusing	Kg/cm <sup>2</sup>		same to forming bead									
Fusing	sec	(3+t)*0.8	9.3	10.1	11.0	12.1	13.3	14.7	16.2	17.8	19.6	21.8
Cooling	Kg/cm <sup>2</sup>		same to forming bead									
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8	498	554	620	698	786	886	997	1108	1241	1396
10-22	sec	0.9	561	623	698	785	885	997	1122	1246	1396	1570
23-	sec	1.2t	623	692	775	872	983	1108	1246	1385	1551	1745



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 33	Units	Remark	ISO - SDR33.0-MDPE									
Cylinder area(Ac)	cm <sup>2</sup>	37.68										
Spec	mm		225	250	280	315	355	400	450	500	560	630
Out dia(Od)	mm		225	250	280	315	355	400	450	500	560	630
Thickness(t)	mm	Od/SDR	6.8	7.6	8.5	9.5	10.8	12.1	13.6	15.2	17.0	19.1
In dia(Id)	mm	Od-t*2	211.4	234.8	263.0	295.9	333.5	375.8	422.7	469.7	526.1	591.8
Area(Ar)	cm <sup>2</sup>		46.7	57.7	72.3	91.6	116.3	147.6	186.8	230.7	289.4	366.2
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	1.9	2.3	2.9	3.6	4.6	5.9	7.4	9.2	11.5	14.6
Forming bead	sec	Ht*0.2	15.0	16.7	18.7	21.0	23.7	26.7	30.0	33.3	37.3	42.0
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.1	0.2	0.2	0.2	0.3	0.4	0.5	0.6	0.8	1.0
Heating(Ht)	sec	11t	75.0	83.3	93.3	105.0	118.3	133.3	150.0	166.7	186.7	210.0
Remove Heater	sec	3+0.02Od	7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6
Fusing	Kg/cm <sup>2</sup>		same to forming bead									
Fusing	sec	(3+t)*0.8	7.9	8.5	9.2	10.0	11.0	12.1	13.3	14.5	16.0	17.7
Cooling	Kg/cm <sup>2</sup>		same to forming bead									
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8	393	436	489	550	620	698	785	873	977	1100
10-22	sec	0.9	442	491	550	619	697	785	884	982	1100	1237
23-	sec	1.2t	491	545	611	687	775	873	982	1091	1222	1375



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 41	Units	Remark	ISO - SDR41.0-MDPE									
Cylinder area(Ac)	cm <sup>2</sup>	37.68										
Spec	mm		225	250	280	315	355	400	450	500	560	630
Out dia(Od)	mm		225	250	280	315	355	400	450	500	560	630
Thickness(t)	mm	Od/SDR	5.5	6.1	6.8	7.7	8.7	9.8	11.0	12.2	13.7	15.4
In dia(Id)	mm	Od-t*2	214.0	237.8	266.3	299.6	337.7	380.5	428.0	475.6	532.7	599.3
Area(Ar)	cm <sup>2</sup>		37.8	46.7	58.6	74.1	94.2	119.5	151.3	186.8	234.3	296.6
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	1.5	1.9	2.3	3.0	3.7	4.8	6.0	7.4	9.3	11.8
Forming bead	sec	Ht*0.2	12.1	13.4	15.0	16.9	19.0	21.5	24.1	26.8	30.0	33.8
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.1	0.1	0.2	0.2	0.2	0.3	0.4	0.5	0.6	0.8
Heating(Ht)	sec	11t	60.4	67.1	75.1	84.5	95.2	107.3	120.7	134.1	150.2	169.0
Remove Heater	sec	3+0.02Od	7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6
Fusing	Kg/cm <sup>2</sup>		same to forming bead									
Fusing	sec	(3+t)*0.8	6.8	7.3	7.9	8.5	9.3	10.2	11.2	12.2	13.3	14.7
Cooling	Kg/cm <sup>2</sup>		same to forming bead									
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8	316	351	393	443	499	562	632	702	787	885
10-22	sec	0.9	356	395	443	498	561	632	711	790	885	996
23-	sec	1.2t	395	439	492	553	623	702	790	878	983	1106





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ISO 9001 Registered

AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 51	Units	Remark	ISO - SDR51.0-MDPE									
Cylinder area(Ac)	cm <sup>2</sup>	37.68										
Spec	mm		225	250	280	315	355	400	450	500	560	630
Out dia(Od)	mm		225	250	280	315	355	400	450	500	560	630
Thickness(t)	mm	Od/SDR	4.4	4.9	5.5	6.2	7.0	7.8	8.8	9.8	11.0	12.4
In dia(Id)	mm	Od-t*2	216.2	240.2	269.0	302.6	341.1	384.3	432.4	480.4	538.0	605.3
Area(Ar)	cm <sup>2</sup>		30.6	37.7	47.3	59.9	76.1	96.6	122.2	150.9	189.3	239.6
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	1.2	1.5	1.9	2.4	3.0	3.8	4.9	6.0	7.5	9.5
Forming bead	sec	Ht*0.2	9.7	10.8	12.1	13.6	15.3	17.3	19.4	21.6	24.2	27.2
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.1	0.1	0.1	0.2	0.2	0.3	0.3	0.4	0.5	0.6
Heating(Ht)	sec	11t	48.5	53.9	60.4	67.9	76.6	86.3	97.1	107.8	120.8	135.9
Remove Heater	sec	3+0.02Od	7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6
Fusing	Kg/cm <sup>2</sup>		same to forming bead									
Fusing	sec	(3+t)*0.8	5.9	6.3	6.8	7.3	8.0	8.7	9.5	10.2	11.2	12.3
Cooling	Kg/cm <sup>2</sup>		same to forming bead									
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8	254	282	316	356	401	452	508	565	632	712
10-22	sec	0.9	286	318	356	400	451	508	572	635	712	800
23-	sec	1.2t	318	353	395	445	501	565	635	706	791	889