

- - - 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 : #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	JIS - SDR5.0-HDPE									
Cylinder area(Ac)	cm <sup>2</sup>		7.22										
Spec	mm			50	65	75	100	125	150	175	200	250	300
Out dia(Od)	mm			60	76	89	114	140	165	190	216	267	318
Thickness(t)	mm	Od/SDR		12.0	15.2	17.8	22.8	28.0	33.0	38.0	43.2	53.4	63.6
In dia(Id)	mm	Od-t*2		36.0	45.6	53.4	68.4	84.0	99.0	114.0	129.6	160.2	190.8
Area(Ar)	cm <sup>2</sup>			18.1	29.0	39.8	65.3	98.5	136.8	181.4	234.4	358.2	508.0
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		3.8	6.0	8.3	13.6	20.5	28.4	37.7	48.7	74.4	105.5
Forming bead	sec	Ht*0.25		36.0	45.6	53.4	68.4	84.0	99.0	114.0	129.6	160.2	190.8
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.3	0.4	0.6	0.9	1.4	1.9	2.5	3.2	5.0	7.0
Heating(Ht)	sec	12t		144.0	182.4	213.6	273.6	336.0	396.0	456.0	518.4	640.8	763.2
Remove Heater	sec	3+0.02Od		4.2	4.5	4.8	5.3	5.8	6.3	6.8	7.3	8.3	9.4
Fusing	Kg/cm <sup>2</sup>			same to forming bead									
Fusing	sec	(3+t)*0.8		12.0	14.6	16.6	20.6	24.8	28.8	32.8	37.0	45.1	53.3
Cooling	Kg/cm <sup>2</sup>			same to forming bead									
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8		691	876	1025	1313	1613	1901	2189	2488	3076	3663
10-22	sec	0.9		778	985	1153	1477	1814	2138	2462	2799	3460	4121
23-	sec	1.2t		864	1094	1282	1642	2016	2376	2736	3110	3845	4579

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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 6		Units	Remark	JIS - SDR6.0-HDPE									
Cylinder area(Ac)	cm <sup>2</sup>		7.22										
Spec	mm			50	65	75	100	125	150	175	200	250	300
Out dia(Od)	mm			60	76	89	114	140	165	190	216	267	318
Thickness(t)	mm	Od/SDR		10.0	12.7	14.8	19.0	23.3	27.5	31.7	36.0	44.5	53.0
In dia(Id)	mm	Od-t*2		40.0	50.7	59.3	76.0	93.3	110.0	126.7	144.0	178.0	212.0
Area(Ar)	cm <sup>2</sup>			15.7	25.2	34.5	56.7	85.5	118.7	157.4	203.5	310.9	441.0
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		3.3	5.2	7.2	11.8	17.8	24.7	32.7	42.3	64.6	91.6
Forming bead	sec	Ht*0.25		30.0	38.0	44.5	57.0	70.0	82.5	95.0	108.0	133.5	159.0
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.2	0.3	0.5	0.8	1.2	1.6	2.2	2.8	4.3	6.1
Heating(Ht)	sec	12t		120.0	152.0	178.0	228.0	280.0	330.0	380.0	432.0	534.0	636.0
Remove Heater	sec	3+0.02Od		4.2	4.5	4.8	5.3	5.8	6.3	6.8	7.3	8.3	9.4
Fusing	Kg/cm <sup>2</sup>			same to forming bead									
Fusing	sec	(3+t)*0.8		10.4	12.5	14.3	17.6	21.1	24.4	27.7	31.2	38.0	44.8
Cooling	Kg/cm <sup>2</sup>			same to forming bead									
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8		576	730	854	1094	1344	1584	1824	2074	2563	3053
10-22	sec	0.9		648	821	961	1231	1512	1782	2052	2333	2884	3434
23-	sec	1.2t		720	912	1068	1368	1680	1980	2280	2592	3204	3816

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SDR- 7		Units	Remark	JIS - SDR7.0-HDPE									
Cylinder area(Ac)	cm <sup>2</sup>		7.22										
Spec	mm			50	65	75	100	125	150	175	200	250	300
Out dia(Od)	mm			60	76	89	114	140	165	190	216	267	318
Thickness(t)	mm	Od/SDR		8.6	10.9	12.7	16.3	20.0	23.6	27.1	30.9	38.1	45.4
In dia(Id)	mm	Od-t*2		42.9	54.3	63.6	81.4	100.0	117.9	135.7	154.3	190.7	227.1
Area(Ar)	cm <sup>2</sup>			13.8	22.2	30.5	50.0	75.4	104.7	138.8	179.4	274.1	388.8
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		2.9	4.6	6.3	10.4	15.7	21.7	28.8	37.3	56.9	80.8
Forming bead	sec	Ht*0.25		25.7	32.6	38.1	48.9	60.0	70.7	81.4	92.6	114.4	136.3
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.2	0.3	0.4	0.7	1.0	1.4	1.9	2.5	3.8	5.4
Heating(Ht)	sec	12t		102.9	130.3	152.6	195.4	240.0	282.9	325.7	370.3	457.7	545.1
Remove Heater	sec	3+0.02Od		4.2	4.5	4.8	5.3	5.8	6.3	6.8	7.3	8.3	9.4
Fusing	Kg/cm <sup>2</sup>			same to forming bead									
Fusing	sec	(3+t)*0.8		9.3	11.1	12.6	15.4	18.4	21.3	24.1	27.1	32.9	38.7
Cooling	Kg/cm <sup>2</sup>			same to forming bead									
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8		494	625	732	938	1152	1358	1563	1777	2197	2617
10-22	sec	0.9		555	704	824	1055	1296	1527	1759	2000	2472	2944
23-	sec	1.2t		617	782	915	1173	1440	1697	1954	2222	2746	3271



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SDR- 7.4		Units	Remark	JIS - SDR7.4-HDPE									
Cylinder area(Ac)	cm <sup>2</sup>		7.22										
Spec	mm			50	65	75	100	125	150	175	200	250	300
Out dia(Od)	mm			60	76	89	114	140	165	190	216	267	318
Thickness(t)	mm	Od/SDR		8.1	10.3	12.0	15.4	18.9	22.3	25.7	29.2	36.1	43.0
In dia(Id)	mm	Od-t*2		43.8	55.5	64.9	83.2	102.2	120.4	138.6	157.6	194.8	232.1
Area(Ar)	cm <sup>2</sup>			13.2	21.2	29.1	47.7	71.9	99.9	132.5	171.2	261.6	371.1
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		2.7	4.4	6.0	9.9	14.9	20.8	27.5	35.6	54.4	77.1
Forming bead	sec	Ht*0.25		24.3	30.8	36.1	46.2	56.8	66.9	77.0	87.6	108.2	128.9
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.2	0.3	0.4	0.7	1.0	1.4	1.8	2.4	3.6	5.1
Heating(Ht)	sec	12t		97.3	123.2	144.3	184.9	227.0	267.6	308.1	350.3	433.0	515.7
Remove Heater	sec	3+0.02Od		4.2	4.5	4.8	5.3	5.8	6.3	6.8	7.3	8.3	9.4
Fusing	Kg/cm <sup>2</sup>			same to forming bead									
Fusing	sec	(3+t)*0.8		8.9	10.6	12.0	14.7	17.5	20.2	22.9	25.8	31.3	36.8
Cooling	Kg/cm <sup>2</sup>			same to forming bead									
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8		467	592	693	887	1090	1284	1479	1681	2078	2475
10-22	sec	0.9		525	666	779	998	1226	1445	1664	1891	2338	2785
23-	sec	1.2t		584	739	866	1109	1362	1605	1849	2102	2598	3094

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SDR- 9		Units	Remark	JIS - SDR9.0-HDPE									
Cylinder area(Ac)	cm <sup>2</sup>		7.22										
Spec	mm			50	65	75	100	125	150	175	200	250	300
Out dia(Od)	mm			60	76	89	114	140	165	190	216	267	318
Thickness(t)	mm	Od/SDR		6.7	8.4	9.9	12.7	15.6	18.3	21.1	24.0	29.7	35.3
In dia(Id)	mm	Od-t*2		46.7	59.1	69.2	88.7	108.9	128.3	147.8	168.0	207.7	247.3
Area(Ar)	cm <sup>2</sup>			11.2	17.9	24.6	40.3	60.8	84.4	112.0	144.7	221.1	313.6
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		2.3	3.7	5.1	8.4	12.6	17.5	23.3	30.1	45.9	65.2
Forming bead	sec	Ht*0.25		20.0	25.3	29.7	38.0	46.7	55.0	63.3	72.0	89.0	106.0
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.2	0.2	0.3	0.6	0.8	1.2	1.6	2.0	3.1	4.3
Heating(Ht)	sec	12t		80.0	101.3	118.7	152.0	186.7	220.0	253.3	288.0	356.0	424.0
Remove Heater	sec	3+0.02Od		4.2	4.5	4.8	5.3	5.8	6.3	6.8	7.3	8.3	9.4
Fusing	Kg/cm <sup>2</sup>			same to forming bead									
Fusing	sec	(3+t)*0.8		7.7	9.2	10.3	12.5	14.8	17.1	19.3	21.6	26.1	30.7
Cooling	Kg/cm <sup>2</sup>			same to forming bead									
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8		384	486	570	730	896	1056	1216	1382	1709	2035
10-22	sec	0.9		432	547	641	821	1008	1188	1368	1555	1922	2290
23-	sec	1.2t		480	608	712	912	1120	1320	1520	1728	2136	2544

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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 11		Units	Remark	JIS - SDR11.0-HDPE									
Cylinder area(Ac)	cm <sup>2</sup>		7.22										
Spec	mm			50	65	75	100	125	150	175	200	250	300
Out dia(Od)	mm			60	76	89	114	140	165	190	216	267	318
Thickness(t)	mm	Od/SDR		5.5	6.9	8.1	10.4	12.7	15.0	17.3	19.6	24.3	28.9
In dia(Id)	mm	Od-t*2		49.1	62.2	72.8	93.3	114.5	135.0	155.5	176.7	218.5	260.2
Area(Ar)	cm <sup>2</sup>			9.3	15.0	20.6	33.7	50.9	70.7	93.7	121.1	185.0	262.4
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		1.9	3.1	4.3	7.0	10.6	14.7	19.5	25.2	38.4	54.5
Forming bead	sec	Ht*0.25		16.4	20.7	24.3	31.1	38.2	45.0	51.8	58.9	72.8	86.7
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.1	0.2	0.3	0.5	0.7	1.0	1.3	1.7	2.6	3.6
Heating(Ht)	sec	12t		65.5	82.9	97.1	124.4	152.7	180.0	207.3	235.6	291.3	346.9
Remove Heater	sec	3+0.02Od		4.2	4.5	4.8	5.3	5.8	6.3	6.8	7.3	8.3	9.4
Fusing	Kg/cm <sup>2</sup>			same to forming bead									
Fusing	sec	(3+t)*0.8		6.8	7.9	8.9	10.7	12.6	14.4	16.2	18.1	21.8	25.5
Cooling	Kg/cm <sup>2</sup>			same to forming bead									
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8		314	398	466	597	733	864	995	1131	1398	1665
10-22	sec	0.9		353	448	524	672	825	972	1119	1272	1573	1873
23-	sec	1.2t		393	497	583	746	916	1080	1244	1414	1748	2081

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SDR- 13.6		Units	Remark	JIS - SDR13.6-HDPE													
Cylinder area(Ac)	cm <sup>2</sup>		7.22														
Spec	mm			50	65	75	100	125	150	175	200	250	300				
Out dia(Od)	mm			60	76	89	114	140	165	190	216	267	318				
Thickness(t)	mm	Od/SDR		4.4	5.6	6.5	8.4	10.3	12.1	14.0	15.9	19.6	23.4				
In dia(Id)	mm	Od-t*2		51.2	64.8	75.9	97.2	119.4	140.7	162.1	184.2	227.7	271.2				
Area(Ar)	cm <sup>2</sup>			7.7	12.4	16.9	27.8	41.9	58.2	77.2	99.8	152.5	216.3				
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		1.6	2.6	3.5	5.8	8.7	12.1	16.0	20.7	31.7	44.9				
Forming bead	sec	Ht*0.25		13.2	16.8	19.6	25.1	30.9	36.4	41.9	47.6	58.9	70.1				
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.1	0.2	0.2	0.4	0.6	0.8	1.1	1.4	2.1	3.0				
Heating(Ht)	sec	12t		52.9	67.1	78.5	100.6	123.5	145.6	167.6	190.6	235.6	280.6				
Remove Heater	sec	3+0.02Od		4.2	4.5	4.8	5.3	5.8	6.3	6.8	7.3	8.3	9.4				
Fusing	Kg/cm <sup>2</sup>			same to forming bead													
Fusing	sec	(3+t)*0.8		5.9	6.9	7.6	9.1	10.6	12.1	13.6	15.1	18.1	21.1				
Cooling	Kg/cm <sup>2</sup>			same to forming bead													
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE													
-9	sec	0.8		254	322	377	483	593	699	805	915	1131	1347				
10-22	sec	0.9		286	362	424	543	667	786	905	1029	1272	1515				
23-	sec	1.2t		318	402	471	604	741	874	1006	1144	1414	1684				



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SDR- 15.5			JIS - SDR15.5-HDPE										
Units	Remark												
Cylinder area(Ac)	cm <sup>2</sup>	7.22											
Spec	mm		50	65	75	100	125	150	175	200	250	300	
Out dia(Od)	mm		60	76	89	114	140	165	190	216	267	318	
Thickness(t)	mm	Od/SDR	3.9	4.9	5.7	7.4	9.0	10.6	12.3	13.9	17.2	20.5	
In dia(Id)	mm	Od-t*2	52.3	66.2	77.5	99.3	121.9	143.7	165.5	188.1	232.5	277.0	
Area(Ar)	cm <sup>2</sup>		6.8	10.9	15.0	24.6	37.1	51.6	68.4	88.4	135.1	191.6	
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	1.4	2.3	3.1	5.1	7.7	10.7	14.2	18.4	28.1	39.8	
Forming bead	sec	Ht*0.25	11.6	14.7	17.2	22.1	27.1	31.9	36.8	41.8	51.7	61.5	
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.1	0.2	0.2	0.3	0.5	0.7	0.9	1.2	1.9	2.7	
Heating(Ht)	sec	12t	46.5	58.8	68.9	88.3	108.4	127.7	147.1	167.2	206.7	246.2	
Remove Heater	sec	3+0.02Od	4.2	4.5	4.8	5.3	5.8	6.3	6.8	7.3	8.3	9.4	
Fusing	Kg/cm <sup>2</sup>		same to forming bead										
Fusing	sec	(3+t)*0.8	5.5	6.3	7.0	8.3	9.6	10.9	12.2	13.5	16.2	18.8	
Cooling	Kg/cm <sup>2</sup>		same to forming bead										
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE										
-9	sec	0.8	223	282	331	424	520	613	706	803	992	1182	
10-22	sec	0.9	251	318	372	477	585	690	794	903	1116	1329	
23-	sec	1.2t	279	353	413	530	650	766	883	1003	1240	1477	



- - - 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.

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ISO 9001 Registered

AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 17		Units	Remark	JIS - SDR17.0-HDPE									
Cylinder area(Ac)	cm <sup>2</sup>		7.22										
Spec	mm			50	65	75	100	125	150	175	200	250	300
Out dia(Od)	mm			60	76	89	114	140	165	190	216	267	318
Thickness(t)	mm	Od/SDR		3.5	4.5	5.2	6.7	8.2	9.7	11.2	12.7	15.7	18.7
In dia(Id)	mm	Od-t*2		52.9	67.1	78.5	100.6	123.5	145.6	167.6	190.6	235.6	280.6
Area(Ar)	cm <sup>2</sup>			6.3	10.0	13.8	22.6	34.1	47.3	62.8	81.1	123.9	175.8
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		1.3	2.1	2.9	4.7	7.1	9.8	13.0	16.9	25.7	36.5
Forming bead	sec	Ht*0.25		10.6	13.4	15.7	20.1	24.7	29.1	33.5	38.1	47.1	56.1
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.1	0.1	0.2	0.3	0.5	0.7	0.9	1.1	1.7	2.4
Heating(Ht)	sec	12t		42.4	53.6	62.8	80.5	98.8	116.5	134.1	152.5	188.5	224.5
Remove Heater	sec	3+0.02Od		4.2	4.5	4.8	5.3	5.8	6.3	6.8	7.3	8.3	9.4
Fusing	Kg/cm <sup>2</sup>			same to forming bead									
Fusing	sec	(3+t)*0.8		5.2	6.0	6.6	7.8	9.0	10.2	11.3	12.6	15.0	17.4
Cooling	Kg/cm <sup>2</sup>			same to forming bead									
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8		203	258	302	386	474	559	644	732	905	1077
10-22	sec	0.9		229	290	339	435	534	629	724	823	1018	1212
23-	sec	1.2t		254	322	377	483	593	699	805	915	1131	1347

- - - 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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ISO 9001 Registered

AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 17.6		Units	Remark	JIS - SDR17.6-HDPE									
Cylinder area(Ac)	cm <sup>2</sup>		7.22										
Spec	mm			50	65	75	100	125	150	175	200	250	300
Out dia(Od)	mm			60	76	89	114	140	165	190	216	267	318
Thickness(t)	mm	Od/SDR		3.4	4.3	5.1	6.5	8.0	9.4	10.8	12.3	15.2	18.1
In dia(Id)	mm	Od-t*2		53.2	67.4	78.9	101.0	124.1	146.3	168.4	191.5	236.7	281.9
Area(Ar)	cm <sup>2</sup>			6.1	9.7	13.3	21.9	33.0	45.8	60.7	78.5	120.0	170.2
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		1.3	2.0	2.8	4.5	6.9	9.5	12.6	16.3	24.9	35.4
Forming bead	sec	Ht*0.25		10.2	13.0	15.2	19.4	23.9	28.1	32.4	36.8	45.5	54.2
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.1	0.1	0.2	0.3	0.5	0.6	0.8	1.1	1.7	2.4
Heating(Ht)	sec	12t		40.9	51.8	60.7	77.7	95.5	112.5	129.5	147.3	182.0	216.8
Remove Heater	sec	3+0.02Od		4.2	4.5	4.8	5.3	5.8	6.3	6.8	7.3	8.3	9.4
Fusing	Kg/cm <sup>2</sup>			same to forming bead									
Fusing	sec	(3+t)*0.8		5.1	5.9	6.4	7.6	8.8	9.9	11.0	12.2	14.5	16.9
Cooling	Kg/cm <sup>2</sup>			same to forming bead									
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8		196	249	291	373	458	540	622	707	874	1041
10-22	sec	0.9		221	280	328	420	515	608	700	795	983	1171
23-	sec	1.2t		245	311	364	466	573	675	777	884	1092	1301

- - - 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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ISO 9001 Registered

AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 19	Units	Remark	JIS - SDR19.0-HDPE									
Cylinder area(Ac)	cm <sup>2</sup>	7.22										
Spec	mm		50	65	75	100	125	150	175	200	250	300
Out dia(Od)	mm		60	76	89	114	140	165	190	216	267	318
Thickness(t)	mm	Od/SDR	3.2	4.0	4.7	6.0	7.4	8.7	10.0	11.4	14.1	16.7
In dia(Id)	mm	Od-t*2	53.7	68.0	79.6	102.0	125.3	147.6	170.0	193.3	238.9	284.5
Area(Ar)	cm <sup>2</sup>		5.6	9.0	12.4	20.3	30.7	42.6	56.5	73.0	111.6	158.3
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	1.9	2.6	4.2	6.4	8.9	11.7	15.2	23.2	32.9
Forming bead	sec	Ht*0.25	9.5	12.0	14.1	18.0	22.1	26.1	30.0	34.1	42.2	50.2
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.1	0.1	0.2	0.3	0.4	0.6	0.8	1.0	1.5	2.2
Heating(Ht)	sec	12t	37.9	48.0	56.2	72.0	88.4	104.2	120.0	136.4	168.6	200.8
Remove Heater	sec	3+0.02Od	4.2	4.5	4.8	5.3	5.8	6.3	6.8	7.3	8.3	9.4
Fusing	Kg/cm <sup>2</sup>		same to forming bead									
Fusing	sec	(3+t)*0.8	4.9	5.6	6.1	7.2	8.3	9.3	10.4	11.5	13.6	15.8
Cooling	Kg/cm <sup>2</sup>		same to forming bead									
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8	182	230	270	346	424	500	576	655	809	964
10-22	sec	0.9	205	259	304	389	477	563	648	737	911	1085
23-	sec	1.2t	227	288	337	432	531	625	720	819	1012	1205

- - - 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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ISO 9001 Registered

AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 21		Units	Remark	JIS - SDR21.0-HDPE													
Cylinder area(Ac)	cm <sup>2</sup>		7.22														
Spec	mm			50	65	75	100	125	150	175	200	250	300				
Out dia(Od)	mm			60	76	89	114	140	165	190	216	267	318				
Thickness(t)	mm	Od/SDR		2.9	3.6	4.2	5.4	6.7	7.9	9.0	10.3	12.7	15.1				
In dia(Id)	mm	Od-t*2		54.3	68.8	80.5	103.1	126.7	149.3	171.9	195.4	241.6	287.7				
Area(Ar)	cm <sup>2</sup>			5.1	8.2	11.3	18.5	27.9	38.8	51.4	66.4	101.5	144.0				
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		1.1	1.7	2.3	3.8	5.8	8.1	10.7	13.8	21.1	29.9				
Forming bead	sec	Ht*0.25		8.6	10.9	12.7	16.3	20.0	23.6	27.1	30.9	38.1	45.4				
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.1	0.1	0.2	0.3	0.4	0.5	0.7	0.9	1.4	2.0				
Heating(Ht)	sec	12t		34.3	43.4	50.9	65.1	80.0	94.3	108.6	123.4	152.6	181.7				
Remove Heater	sec	3+0.02Od		4.2	4.5	4.8	5.3	5.8	6.3	6.8	7.3	8.3	9.4				
Fusing	Kg/cm <sup>2</sup>			same to forming bead													
Fusing	sec	(3+t)*0.8		4.7	5.3	5.8	6.7	7.7	8.7	9.6	10.6	12.6	14.5				
Cooling	Kg/cm <sup>2</sup>			same to forming bead													
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE													
-9	sec	0.8		165	208	244	313	384	453	521	592	732	872				
10-22	sec	0.9		185	235	275	352	432	509	586	667	824	981				
23-	sec	1.2t		206	261	305	391	480	566	651	741	915	1090				

- - - 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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ISO 9001 Registered

AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 22		Units	Remark	JIS - SDR22.0-HDPE									
Cylinder area(Ac)	cm <sup>2</sup>		7.22										
Spec	mm			50	65	75	100	125	150	175	200	250	300
Out dia(Od)	mm			60	76	89	114	140	165	190	216	267	318
Thickness(t)	mm	Od/SDR		2.7	3.5	4.0	5.2	6.4	7.5	8.6	9.8	12.1	14.5
In dia(Id)	mm	Od-t*2		54.5	69.1	80.9	103.6	127.3	150.0	172.7	196.4	242.7	289.1
Area(Ar)	cm <sup>2</sup>			4.9	7.9	10.8	17.7	26.7	37.1	49.2	63.6	97.1	137.8
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		1.0	1.6	2.2	3.7	5.5	7.7	10.2	13.2	20.2	28.6
Forming bead	sec	Ht*0.25		8.2	10.4	12.1	15.5	19.1	22.5	25.9	29.5	36.4	43.4
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.1	0.1	0.1	0.2	0.4	0.5	0.7	0.9	1.3	1.9
Heating(Ht)	sec	12t		32.7	41.5	48.5	62.2	76.4	90.0	103.6	117.8	145.6	173.5
Remove Heater	sec	3+0.02Od		4.2	4.5	4.8	5.3	5.8	6.3	6.8	7.3	8.3	9.4
Fusing	Kg/cm <sup>2</sup>			same to forming bead									
Fusing	sec	(3+t)*0.8		4.6	5.2	5.6	6.5	7.5	8.4	9.3	10.3	12.1	14.0
Cooling	Kg/cm <sup>2</sup>			same to forming bead									
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8		157	199	233	298	367	432	497	566	699	833
10-22	sec	0.9		177	224	262	336	412	486	560	636	786	937
23-	sec	1.2t		196	249	291	373	458	540	622	707	874	1041

- - - 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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ISO 9001 Registered

AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 26		Units	Remark	JIS - SDR26.0-HDPE									
Cylinder area(Ac)	cm <sup>2</sup>		7.22										
Spec	mm			50	65	75	100	125	150	175	200	250	300
Out dia(Od)	mm			60	76	89	114	140	165	190	216	267	318
Thickness(t)	mm	Od/SDR		2.3	2.9	3.4	4.4	5.4	6.3	7.3	8.3	10.3	12.2
In dia(Id)	mm	Od-t*2		55.4	70.2	82.2	105.2	129.2	152.3	175.4	199.4	246.5	293.5
Area(Ar)	cm <sup>2</sup>			4.2	6.7	9.2	15.1	22.8	31.6	41.9	54.2	82.8	117.4
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		0.9	1.4	1.9	3.1	4.7	6.6	8.7	11.3	17.2	24.4
Forming bead	sec	Ht*0.25		6.9	8.8	10.3	13.2	16.2	19.0	21.9	24.9	30.8	36.7
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.1	0.1	0.1	0.2	0.3	0.4	0.6	0.8	1.1	1.6
Heating(Ht)	sec	12t		27.7	35.1	41.1	52.6	64.6	76.2	87.7	99.7	123.2	146.8
Remove Heater	sec	3+0.02Od		4.2	4.5	4.8	5.3	5.8	6.3	6.8	7.3	8.3	9.4
Fusing	Kg/cm <sup>2</sup>			same to forming bead									
Fusing	sec	(3+t)*0.8		4.2	4.7	5.1	5.9	6.7	7.5	8.2	9.0	10.6	12.2
Cooling	Kg/cm <sup>2</sup>			same to forming bead									
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8		133	168	197	253	310	366	421	479	592	704
10-22	sec	0.9		150	189	222	284	349	411	474	538	665	793
23-	sec	1.2t		166	210	246	316	388	457	526	598	739	881

- - - 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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ISO 9001 Registered

AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 33		Units	Remark	JIS - SDR33.0-HDPE									
Cylinder area(Ac)	cm <sup>2</sup>		7.22										
Spec	mm			50	65	75	100	125	150	175	200	250	300
Out dia(Od)	mm			60	76	89	114	140	165	190	216	267	318
Thickness(t)	mm	Od/SDR		1.8	2.3	2.7	3.5	4.2	5.0	5.8	6.5	8.1	9.6
In dia(Id)	mm	Od-t*2		56.4	71.4	83.6	107.1	131.5	155.0	178.5	202.9	250.8	298.7
Area(Ar)	cm <sup>2</sup>			3.3	5.3	7.3	12.0	18.1	25.1	33.3	43.0	65.8	93.3
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		0.7	1.1	1.5	2.5	3.8	5.2	6.9	8.9	13.7	19.4
Forming bead	sec	Ht*0.25		5.5	6.9	8.1	10.4	12.7	15.0	17.3	19.6	24.3	28.9
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.0	0.1	0.1	0.2	0.3	0.3	0.5	0.6	0.9	1.3
Heating(Ht)	sec	12t		21.8	27.6	32.4	41.5	50.9	60.0	69.1	78.5	97.1	115.6
Remove Heater	sec	3+0.02Od		4.2	4.5	4.8	5.3	5.8	6.3	6.8	7.3	8.3	9.4
Fusing	Kg/cm <sup>2</sup>			same to forming bead									
Fusing	sec	(3+t)*0.8		3.9	4.2	4.6	5.2	5.8	6.4	7.0	7.6	8.9	10.1
Cooling	Kg/cm <sup>2</sup>			same to forming bead									
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8		105	133	155	199	244	288	332	377	466	555
10-22	sec	0.9		118	149	175	224	275	324	373	424	524	624
23-	sec	1.2t		131	166	194	249	305	360	415	471	583	694

- - - 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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ISO 9001 Registered

AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 41		Units	Remark	JIS - SDR41.0-HDPE													
Cylinder area(Ac)	cm <sup>2</sup>		7.22														
Spec	mm			50	65	75	100	125	150	175	200	250	300				
Out dia(Od)	mm			60	76	89	114	140	165	190	216	267	318				
Thickness(t)	mm	Od/SDR		1.5	1.9	2.2	2.8	3.4	4.0	4.6	5.3	6.5	7.8				
In dia(Id)	mm	Od-t*2		57.1	72.3	84.7	108.4	133.2	157.0	180.7	205.5	254.0	302.5				
Area(Ar)	cm <sup>2</sup>			2.7	4.3	5.9	9.7	14.6	20.3	27.0	34.9	53.3	75.6				
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		0.6	0.9	1.2	2.0	3.0	4.2	5.6	7.2	11.1	15.7				
Forming bead	sec	Ht*0.25		4.4	5.6	6.5	8.3	10.2	12.1	13.9	15.8	19.5	23.3				
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.0	0.1	0.1	0.1	0.2	0.3	0.4	0.5	0.7	1.0				
Heating(Ht)	sec	12t		17.6	22.2	26.0	33.4	41.0	48.3	55.6	63.2	78.1	93.1				
Remove Heater	sec	3+0.02Od		4.2	4.5	4.8	5.3	5.8	6.3	6.8	7.3	8.3	9.4				
Fusing	Kg/cm <sup>2</sup>			same to forming bead													
Fusing	sec	(3+t)*0.8		3.6	3.9	4.1	4.6	5.1	5.6	6.1	6.6	7.6	8.6				
Cooling	Kg/cm <sup>2</sup>			same to forming bead													
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE													
-9	sec	0.8		84	107	125	160	197	232	267	303	375	447				
10-22	sec	0.9		95	120	141	180	221	261	300	341	422	503				
23-	sec	1.2t		105	133	156	200	246	290	334	379	469	558				



- - - 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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ISO 9001 Registered

AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 51	Units	Remark	JIS - SDR51.0-HDPE									
Cylinder area(Ac)	cm <sup>2</sup>	7.22										
Spec	mm		50	65	75	100	125	150	175	200	250	300
Out dia(Od)	mm		60	76	89	114	140	165	190	216	267	318
Thickness(t)	mm	Od/SDR	1.2	1.5	1.7	2.2	2.7	3.2	3.7	4.2	5.2	6.2
In dia(Id)	mm	Od-t*2	57.6	73.0	85.5	109.5	134.5	158.5	182.5	207.5	256.5	305.5
Area(Ar)	cm <sup>2</sup>		2.2	3.5	4.8	7.8	11.8	16.4	21.8	28.2	43.0	61.0
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	0.5	0.7	1.0	1.6	2.5	3.4	4.5	5.9	8.9	12.7
Forming bead	sec	Ht*0.25	3.5	4.5	5.2	6.7	8.2	9.7	11.2	12.7	15.7	18.7
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.0	0.0	0.1	0.1	0.2	0.2	0.3	0.4	0.6	0.8
Heating(Ht)	sec	12t	14.1	17.9	20.9	26.8	32.9	38.8	44.7	50.8	62.8	74.8
Remove Heater	sec	3+0.02Od	4.2	4.5	4.8	5.3	5.8	6.3	6.8	7.3	8.3	9.4
Fusing	Kg/cm <sup>2</sup>		same to forming bead									
Fusing	sec	(3+t)*0.8	3.3	3.6	3.8	4.2	4.6	5.0	5.4	5.8	6.6	7.4
Cooling	Kg/cm <sup>2</sup>		same to forming bead									
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8	68	86	101	129	158	186	215	244	302	359
10-22	sec	0.9	76	97	113	145	178	210	241	274	339	404
23-	sec	1.2t	85	107	126	161	198	233	268	305	377	449