



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

ISO 9001 Registered

AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 5	Units	Remark	JIS - SDR5.0-MDPE											
Cylinder area(Ac)	cm ²	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 ²		18.1	29.0	39.8	65.3	98.5	136.8	181.4	234.4	358.2	508.0		
Heater Temp														
-9	℃		210<215<220											
10-22	℃		205<210<215											
23-	℃		200<205<210											
Forming bead	Kg/cm ²	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*0.2	26.4	33.4	39.2	50.2	61.6	72.6	83.6	95.0	117.5	139.9		
Heating(Hp)	Kg/cm ²	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	11t	132.0	167.2	195.8	250.8	308.0	363.0	418.0	475.2	587.4	699.6		
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 ²		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 ²		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		

- - - 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- 6	Units	Remark	JIS - SDR6.0-MDPE											
Cylinder area(Ac)	cm ²	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 ²		15.7	25.2	34.5	56.7	85.5	118.7	157.4	203.5	310.9	441.0		
Heater Temp														
-9	℃		210<215<220											
10-22	℃		205<210<215											
23-	℃		200<205<210											
Forming bead	Kg/cm ²	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*0.2	22.0	27.9	32.6	41.8	51.3	60.5	69.7	79.2	97.9	116.6		
Heating(Hp)	Kg/cm ²	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	11t	110.0	139.3	163.2	209.0	256.7	302.5	348.3	396.0	489.5	583.0		
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 ²		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 ²		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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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 7	Units	Remark	JIS - SDR7.0-MDPE											
Cylinder area(Ac)	cm ²	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 ²		13.8	22.2	30.5	50.0	75.4	104.7	138.8	179.4	274.1	388.8		
Heater Temp														
-9	℃		210<215<220											
10-22	℃		205<210<215											
23-	℃		200<205<210											
Forming bead	Kg/cm ²	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*0.2	18.9	23.9	28.0	35.8	44.0	51.9	59.7	67.9	83.9	99.9		
Heating(Hp)	Kg/cm ²	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	11t	94.3	119.4	139.9	179.1	220.0	259.3	298.6	339.4	419.6	499.7		
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 ²		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 ²		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-MDPE											
Cylinder area(Ac)	cm ²	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 ²		13.2	21.2	29.1	47.7	71.9	99.9	132.5	171.2	261.6	371.1		
Heater Temp														
-9	℃		210<215<220											
10-22	℃		205<210<215											
23-	℃		200<205<210											
Forming bead	Kg/cm ²	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*0.2	17.8	22.6	26.5	33.9	41.6	49.1	56.5	64.2	79.4	94.5		
Heating(Hp)	Kg/cm ²	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	11t	89.2	113.0	132.3	169.5	208.1	245.3	282.4	321.1	396.9	472.7		
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 ²		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 ²		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-MDPE											
Cylinder area(Ac)	cm ²	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 ²		11.2	17.9	24.6	40.3	60.8	84.4	112.0	144.7	221.1	313.6		
Heater Temp														
-9	℃		210<215<220											
10-22	℃		205<210<215											
23-	℃		200<205<210											
Forming bead	Kg/cm ²	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*0.2	14.7	18.6	21.8	27.9	34.2	40.3	46.4	52.8	65.3	77.7		
Heating(Hp)	Kg/cm ²	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	11t	73.3	92.9	108.8	139.3	171.1	201.7	232.2	264.0	326.3	388.7		
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 ²		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 ²		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-MDPE											
Cylinder area(Ac)	cm ²	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 ²		9.3	15.0	20.6	33.7	50.9	70.7	93.7	121.1	185.0	262.4		
Heater Temp														
-9	℃		210<215<220											
10-22	℃		205<210<215											
23-	℃		200<205<210											
Forming bead	Kg/cm ²	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*0.2	12.0	15.2	17.8	22.8	28.0	33.0	38.0	43.2	53.4	63.6		
Heating(Hp)	Kg/cm ²	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	11t	60.0	76.0	89.0	114.0	140.0	165.0	190.0	216.0	267.0	318.0		
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 ²		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 ²		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		

- - - 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- 13.6		Units	Remark	JIS - SDR13.6-MDPE																	
Cylinder area(Ac)	cm ²		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 ²			7.7	12.4	16.9	27.8	41.9	58.2	77.2	99.8	152.5	216.3								
Heater Temp																					
-9	℃			210<215<220																	
10-22	℃			205<210<215																	
23-	℃			200<205<210																	
Forming bead	Kg/cm ²	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*0.2		9.7	12.3	14.4	18.4	22.6	26.7	30.7	34.9	43.2	51.4								
Heating(Hp)	Kg/cm ²	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	11t		48.5	61.5	72.0	92.2	113.2	133.5	153.7	174.7	216.0	257.2								
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 ²			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 ²			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		Units	Remark	JIS - SDR15.5-MDPE												
Cylinder area(Ac)	cm ²		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 ²			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 ²	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*0.2		8.5	10.8	12.6	16.2	19.9	23.4	27.0	30.7	37.9	45.1			
Heating(Hp)	Kg/cm ²	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	11t		42.6	53.9	63.2	80.9	99.4	117.1	134.8	153.3	189.5	225.7			
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 ²			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 ²			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			



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 17	Units	Remark	JIS - SDR17.0-MDPE											
Cylinder area(Ac)	cm ²	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 ²		6.3	10.0	13.8	22.6	34.1	47.3	62.8	81.1	123.9	175.8		
Heater Temp														
-9	℃		210<215<220											
10-22	℃		205<210<215											
23-	℃		200<205<210											
Forming bead	Kg/cm ²	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*0.2	7.8	9.8	11.5	14.8	18.1	21.4	24.6	28.0	34.6	41.2		
Heating(Hp)	Kg/cm ²	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	11t	38.8	49.2	57.6	73.8	90.6	106.8	122.9	139.8	172.8	205.8		
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 ²		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 ²		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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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 17.6		Units	Remark	JIS - SDR17.6-MDPE													
Cylinder area(Ac)	cm ²		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 ²			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 ²	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*0.2		7.5	9.5	11.1	14.3	17.5	20.6	23.8	27.0	33.4	39.8				
Heating(Hp)	Kg/cm ²	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	11t		37.5	47.5	55.6	71.3	87.5	103.1	118.8	135.0	166.9	198.8				
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 ²			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 ²			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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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 19	Units	Remark	JIS - SDR19.0-MDPE											
Cylinder area(Ac)	cm ²	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 ²		5.6	9.0	12.4	20.3	30.7	42.6	56.5	73.0	111.6	158.3		
Heater Temp														
-9	℃		210<215<220											
10-22	℃		205<210<215											
23-	℃		200<205<210											
Forming bead	Kg/cm ²	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*0.2	6.9	8.8	10.3	13.2	16.2	19.1	22.0	25.0	30.9	36.8		
Heating(Hp)	Kg/cm ²	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	11t	34.7	44.0	51.5	66.0	81.1	95.5	110.0	125.1	154.6	184.1		
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 ²		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 ²		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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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 21	Units	Remark	JIS - SDR21.0-MDPE											
Cylinder area(Ac)	cm ²	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 ²		5.1	8.2	11.3	18.5	27.9	38.8	51.4	66.4	101.5	144.0		
Heater Temp														
-9	℃		210<215<220											
10-22	℃		205<210<215											
23-	℃		200<205<210											
Forming bead	Kg/cm ²	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*0.2	6.3	8.0	9.3	11.9	14.7	17.3	19.9	22.6	28.0	33.3		
Heating(Hp)	Kg/cm ²	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	11t	31.4	39.8	46.6	59.7	73.3	86.4	99.5	113.1	139.9	166.6		
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 ²		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 ²		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		



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 22		Units	Remark	JIS - SDR22.0-MDPE												
Cylinder area(Ac)	cm ²		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 ²			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 ²	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*0.2		6.0	7.6	8.9	11.4	14.0	16.5	19.0	21.6	26.7	31.8			
Heating(Hp)	Kg/cm ²	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	11t		30.0	38.0	44.5	57.0	70.0	82.5	95.0	108.0	133.5	159.0			
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 ²			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 ²			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			



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 26		Units	Remark	JIS - SDR26.0-MDPE												
Cylinder area(Ac)	cm ²		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 ²			4.2	6.7	9.2	15.1	22.8	31.6	41.9	54.2	82.8	117.4			
Heater Temp																
-9	℃			210<215<220												
10-22	℃			205<210<215												
23-	℃			200<205<210												
Forming bead	Kg/cm ²	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*0.2		5.1	6.4	7.5	9.6	11.8	14.0	16.1	18.3	22.6	26.9			
Heating(Hp)	Kg/cm ²	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	11t		25.4	32.2	37.7	48.2	59.2	69.8	80.4	91.4	113.0	134.5			
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 ²			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 ²			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			



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 33	Units	Remark	JIS - SDR33.0-MDPE											
Cylinder area(Ac)	cm ²	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 ²		3.3	5.3	7.3	12.0	18.1	25.1	33.3	43.0	65.8	93.3		
Heater Temp														
-9	℃		210<215<220											
10-22	℃		205<210<215											
23-	℃		200<205<210											
Forming bead	Kg/cm ²	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*0.2	4.0	5.1	5.9	7.6	9.3	11.0	12.7	14.4	17.8	21.2		
Heating(Hp)	Kg/cm ²	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	11t	20.0	25.3	29.7	38.0	46.7	55.0	63.3	72.0	89.0	106.0		
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 ²		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 ²		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		



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 41	Units	Remark	JIS - SDR41.0-MDPE											
Cylinder area(Ac)	cm ²	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 ²		2.7	4.3	5.9	9.7	14.6	20.3	27.0	34.9	53.3	75.6		
Heater Temp														
-9	℃		210<215<220											
10-22	℃		205<210<215											
23-	℃		200<205<210											
Forming bead	Kg/cm ²	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*0.2	3.2	4.1	4.8	6.1	7.5	8.9	10.2	11.6	14.3	17.1		
Heating(Hp)	Kg/cm ²	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	11t	16.1	20.4	23.9	30.6	37.6	44.3	51.0	58.0	71.6	85.3		
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 ²		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 ²		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		



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 51	Units	Remark	JIS - SDR51.0-MDPE											
Cylinder area(Ac)	cm ²	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 ²		2.2	3.5	4.8	7.8	11.8	16.4	21.8	28.2	43.0	61.0		
Heater Temp														
-9	℃		210<215<220											
10-22	℃		205<210<215											
23-	℃		200<205<210											
Forming bead	Kg/cm ²	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*0.2	2.6	3.3	3.8	4.9	6.0	7.1	8.2	9.3	11.5	13.7		
Heating(Hp)	Kg/cm ²	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	11t	12.9	16.4	19.2	24.6	30.2	35.6	41.0	46.6	57.6	68.6		
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 ²		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 ²		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		