



Saemin Electronics Industries Corp.

HEAD OFFICE : 49-25, GimpoHegang 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

ISO 9001 Registered

AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 5	Units	Remark	JIS - SDR5.0-MDPE								
Cylinder area(Ac)	cm ²	37.68									
Spec	mm		200	250	300	350	400	450	500	550	600
Out dia(Od)	mm		216	267	318	370	420	457.2	508	558.8	609.6
Thickness(t)	mm	Od/SDR	43.2	53.4	63.6	74.0	84.0	91.4	101.6	111.8	121.9
In dia(Id)	mm	Od-t*2	129.6	160.2	190.8	222.0	252.0	274.3	304.8	335.3	365.8
Area(Ar)	cm ²		234.4	358.2	508.0	687.8	886.2	1050.2	1296.5	1568.8	1867.0
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	9.3	14.3	20.2	27.4	35.3	41.8	51.6	62.5	74.3
Forming bead	sec	Ht*0.2	95.0	117.5	139.9	162.8	184.8	201.2	223.5	245.9	268.2
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.6	1.0	1.3	1.8	2.4	2.8	3.4	4.2	5.0
Heating(Ht)	sec	11t	475.2	587.4	699.6	814.0	924.0	1005.8	1117.6	1229.4	1341.1
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2
Fusing	Kg/cm ²		same to forming bead								
Fusing	sec	(3+t)*0.8	37.0	45.1	53.3	61.6	69.6	75.6	83.7	91.8	99.9
Cooling	Kg/cm ²		same to forming bead								
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE								
-9	sec	0.8	2488	3076	3663	4262	4838	5267	5852	6437	7023
10-22	sec	0.9	2799	3460	4121	4795	5443	5925	6584	7242	7900
23-	sec	1.2t	3110	3845	4579	5328	6048	6584	7315	8047	8778



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SDR- 6	Units	Remark	JIS - SDR6.0-MDPE								
Cylinder area(Ac)	cm ²	37.68									
Spec	mm		200	250	300	350	400	450	500	550	600
Out dia(Od)	mm		216	267	318	370	420	457.2	508	558.8	609.6
Thickness(t)	mm	Od/SDR	36.0	44.5	53.0	61.7	70.0	76.2	84.7	93.1	101.6
In dia(Id)	mm	Od-t*2	144.0	178.0	212.0	246.7	280.0	304.8	338.7	372.5	406.4
Area(Ar)	cm ²		203.5	310.9	441.0	597.0	769.3	911.6	1125.4	1361.8	1620.6
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	8.1	12.4	17.6	23.8	30.6	36.3	44.8	54.2	64.5
Forming bead	sec	Ht*0.2	79.2	97.9	116.6	135.7	154.0	167.6	186.3	204.9	223.5
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.5	0.8	1.2	1.6	2.0	2.4	3.0	3.6	4.3
Heating(Ht)	sec	11t	396.0	489.5	583.0	678.3	770.0	838.2	931.3	1024.5	1117.6
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2
Fusing	Kg/cm ²		same to forming bead								
Fusing	sec	(3+t)*0.8	31.2	38.0	44.8	51.7	58.4	63.4	70.1	76.9	83.7
Cooling	Kg/cm ²		same to forming bead								
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE								
-9	sec	0.8	2074	2563	3053	3552	4032	4389	4877	5364	5852
10-22	sec	0.9	2333	2884	3434	3996	4536	4938	5486	6035	6584
23-	sec	1.2t	2592	3204	3816	4440	5040	5486	6096	6706	7315



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SDR- 7	Units	Remark	JIS - SDR7.0-MDPE								
Cylinder area(Ac)	cm ²	37.68									
Spec	mm		200	250	300	350	400	450	500	550	600
Out dia(Od)	mm		216	267	318	370	420	457.2	508	558.8	609.6
Thickness(t)	mm	Od/SDR	30.9	38.1	45.4	52.9	60.0	65.3	72.6	79.8	87.1
In dia(Id)	mm	Od-t*2	154.3	190.7	227.1	264.3	300.0	326.6	362.9	399.1	435.4
Area(Ar)	cm ²		179.4	274.1	388.8	526.4	678.2	803.7	992.2	1200.6	1428.8
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	7.1	10.9	15.5	21.0	27.0	32.0	39.5	47.8	56.9
Forming bead	sec	Ht*0.2	67.9	83.9	99.9	116.3	132.0	143.7	159.7	175.6	191.6
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.5	0.7	1.0	1.4	1.8	2.1	2.6	3.2	3.8
Heating(Ht)	sec	11t	339.4	419.6	499.7	581.4	660.0	718.5	798.3	878.1	957.9
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2
Fusing	Kg/cm ²		same to forming bead								
Fusing	sec	(3+t)*0.8	27.1	32.9	38.7	44.7	50.4	54.7	60.5	66.3	72.1
Cooling	Kg/cm ²		same to forming bead								
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE								
-9	sec	0.8	1777	2197	2617	3045	3456	3762	4180	4598	5016
10-22	sec	0.9	2000	2472	2944	3425	3888	4232	4703	5173	5643
23-	sec	1.2t	2222	2746	3271	3806	4320	4703	5225	5748	6270



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SDR- 7.4			JIS - SDR7.4-MDPE								
Cylinder area(Ac)	Units	Remark									
	cm ²	37.68									
Spec	mm		200	250	300	350	400	450	500	550	600
Out dia(Od)	mm		216	267	318	370	420	457.2	508	558.8	609.6
Thickness(t)	mm	Od/SDR	29.2	36.1	43.0	50.0	56.8	61.8	68.6	75.5	82.4
In dia(Id)	mm	Od-t*2	157.6	194.8	232.1	270.0	306.5	333.6	370.7	407.8	444.8
Area(Ar)	cm ²		171.2	261.6	371.1	502.4	647.4	767.1	947.1	1145.9	1363.8
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	6.8	10.4	14.8	20.0	25.8	30.5	37.7	45.6	54.3
Forming bead	sec	Ht*0.2	64.2	79.4	94.5	110.0	124.9	135.9	151.0	166.1	181.2
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.5	0.7	1.0	1.3	1.7	2.0	2.5	3.0	3.6
Heating(Ht)	sec	11t	321.1	396.9	472.7	550.0	624.3	679.6	755.1	830.6	906.2
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2
Fusing	Kg/cm ²		same to forming bead								
Fusing	sec	(3+t)*0.8	25.8	31.3	36.8	42.4	47.8	51.8	57.3	62.8	68.3
Cooling	Kg/cm ²		same to forming bead								
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE								
-9	sec	0.8	1681	2078	2475	2880	3269	3559	3954	4350	4745
10-22	sec	0.9	1891	2338	2785	3240	3678	4004	4448	4893	5338
23-	sec	1.2t	2102	2598	3094	3600	4086	4448	4943	5437	5931



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SDR- 9	Units	Remark	JIS - SDR9.0-MDPE								
Cylinder area(Ac)	cm ²	37.68									
Spec	mm		200	250	300	350	400	450	500	550	600
Out dia(Od)	mm		216	267	318	370	420	457.2	508	558.8	609.6
Thickness(t)	mm	Od/SDR	24.0	29.7	35.3	41.1	46.7	50.8	56.4	62.1	67.7
In dia(Id)	mm	Od-t*2	168.0	207.7	247.3	287.8	326.7	355.6	395.1	434.6	474.1
Area(Ar)	cm ²		144.7	221.1	313.6	424.6	547.1	648.3	800.3	968.4	1152.5
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	5.8	8.8	12.5	16.9	21.8	25.8	31.9	38.6	45.9
Forming bead	sec	Ht*0.2	52.8	65.3	77.7	90.4	102.7	111.8	124.2	136.6	149.0
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.4	0.6	0.8	1.1	1.5	1.7	2.1	2.6	3.1
Heating(Ht)	sec	11t	264.0	326.3	388.7	452.2	513.3	558.8	620.9	683.0	745.1
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2
Fusing	Kg/cm ²		same to forming bead								
Fusing	sec	(3+t)*0.8	21.6	26.1	30.7	35.3	39.7	43.0	47.6	52.1	56.6
Cooling	Kg/cm ²		same to forming bead								
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE								
-9	sec	0.8	1382	1709	2035	2368	2688	2926	3251	3576	3901
10-22	sec	0.9	1555	1922	2290	2664	3024	3292	3658	4023	4389
23-	sec	1.2t	1728	2136	2544	2960	3360	3658	4064	4470	4877



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 11			JIS - SDR11.0-MDPE								
Cylinder area(Ac)	Units	Remark									
	cm ²	37.68									
Spec	mm		200	250	300	350	400	450	500	550	600
Out dia(Od)	mm		216	267	318	370	420	457.2	508	558.8	609.6
Thickness(t)	mm	Od/SDR	19.6	24.3	28.9	33.6	38.2	41.6	46.2	50.8	55.4
In dia(Id)	mm	Od-t*2	176.7	218.5	260.2	302.7	343.6	374.1	415.6	457.2	498.8
Area(Ar)	cm ²		121.1	185.0	262.4	355.3	457.8	542.4	669.7	810.3	964.3
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	4.8	7.4	10.4	14.1	18.2	21.6	26.7	32.3	38.4
Forming bead	sec	Ht*0.2	43.2	53.4	63.6	74.0	84.0	91.4	101.6	111.8	121.9
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.3	0.5	0.7	0.9	1.2	1.4	1.8	2.2	2.6
Heating(Ht)	sec	11t	216.0	267.0	318.0	370.0	420.0	457.2	508.0	558.8	609.6
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2
Fusing	Kg/cm ²		same to forming bead								
Fusing	sec	(3+t)*0.8	18.1	21.8	25.5	29.3	32.9	35.7	39.3	43.0	46.7
Cooling	Kg/cm ²		same to forming bead								
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE								
-9	sec	0.8	1131	1398	1665	1937	2199	2394	2660	2926	3192
10-22	sec	0.9	1272	1573	1873	2180	2474	2693	2993	3292	3591
23-	sec	1.2t	1414	1748	2081	2422	2749	2993	3325	3658	3990



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SDR- 13.6			JIS - SDR13.6-MDPE								
Cylinder area(Ac)	Units	Remark									
	cm ²	37.68									
Spec	mm		200	250	300	350	400	450	500	550	600
Out dia(Od)	mm		216	267	318	370	420	457.2	508	558.8	609.6
Thickness(t)	mm	Od/SDR	15.9	19.6	23.4	27.2	30.9	33.6	37.4	41.1	44.8
In dia(Id)	mm	Od-t*2	184.2	227.7	271.2	315.6	358.2	390.0	433.3	476.6	520.0
Area(Ar)	cm ²		99.8	152.5	216.3	292.8	377.3	447.1	552.0	667.9	794.9
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	4.0	6.1	8.6	11.7	15.0	17.8	22.0	26.6	31.6
Forming bead	sec	Ht*0.2	34.9	43.2	51.4	59.9	67.9	74.0	82.2	90.4	98.6
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.3	0.4	0.6	0.8	1.0	1.2	1.5	1.8	2.1
Heating(Ht)	sec	11t	174.7	216.0	257.2	299.3	339.7	369.8	410.9	452.0	493.1
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2
Fusing	Kg/cm ²		same to forming bead								
Fusing	sec	(3+t)*0.8	15.1	18.1	21.1	24.2	27.1	29.3	32.3	35.3	38.3
Cooling	Kg/cm ²		same to forming bead								
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE								
-9	sec	0.8	915	1131	1347	1567	1779	1936	2152	2367	2582
10-22	sec	0.9	1029	1272	1515	1763	2001	2178	2420	2663	2905
23-	sec	1.2t	1144	1414	1684	1959	2224	2420	2689	2958	3227



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SDR- 15.5			JIS - SDR15.5-MDPE								
Cylinder area(Ac)	Units	Remark									
	cm ²	37.68									
Spec	mm		200	250	300	350	400	450	500	550	600
Out dia(Od)	mm		216	267	318	370	420	457.2	508	558.8	609.6
Thickness(t)	mm	Od/SDR	13.9	17.2	20.5	23.9	27.1	29.5	32.8	36.1	39.3
In dia(Id)	mm	Od-t*2	188.1	232.5	277.0	322.3	365.8	398.2	442.5	486.7	530.9
Area(Ar)	cm ²		88.4	135.1	191.6	259.4	334.3	396.1	489.1	591.8	704.2
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	3.5	5.4	7.6	10.3	13.3	15.8	19.5	23.6	28.0
Forming bead	sec	Ht*0.2	30.7	37.9	45.1	52.5	59.6	64.9	72.1	79.3	86.5
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.2	0.4	0.5	0.7	0.9	1.1	1.3	1.6	1.9
Heating(Ht)	sec	11t	153.3	189.5	225.7	262.6	298.1	324.5	360.5	396.6	432.6
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2
Fusing	Kg/cm ²		same to forming bead								
Fusing	sec	(3+t)*0.8	13.5	16.2	18.8	21.5	24.1	26.0	28.6	31.2	33.9
Cooling	Kg/cm ²		same to forming bead								
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE								
-9	sec	0.8	803	992	1182	1375	1561	1699	1888	2077	2265
10-22	sec	0.9	903	1116	1329	1547	1756	1911	2124	2336	2549
23-	sec	1.2t	1003	1240	1477	1719	1951	2124	2360	2596	2832



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 17			JIS - SDR17.0-MDPE								
Cylinder area(Ac)	Units	Remark									
	cm ²	37.68									
Spec	mm		200	250	300	350	400	450	500	550	600
Out dia(Od)	mm		216	267	318	370	420	457.2	508	558.8	609.6
Thickness(t)	mm	Od/SDR	12.7	15.7	18.7	21.8	24.7	26.9	29.9	32.9	35.9
In dia(Id)	mm	Od-t*2	190.6	235.6	280.6	326.5	370.6	403.4	448.2	493.1	537.9
Area(Ar)	cm ²		81.1	123.9	175.8	238.0	306.7	363.4	448.6	542.8	646.0
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	3.2	4.9	7.0	9.5	12.2	14.5	17.9	21.6	25.7
Forming bead	sec	Ht*0.2	28.0	34.6	41.2	47.9	54.4	59.2	65.7	72.3	78.9
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.2	0.3	0.5	0.6	0.8	1.0	1.2	1.4	1.7
Heating(Ht)	sec	11t	139.8	172.8	205.8	239.4	271.8	295.8	328.7	361.6	394.4
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2
Fusing	Kg/cm ²		same to forming bead								
Fusing	sec	(3+t)*0.8	12.6	15.0	17.4	19.8	22.2	23.9	26.3	28.7	31.1
Cooling	Kg/cm ²		same to forming bead								
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE								
-9	sec	0.8	732	905	1077	1254	1423	1549	1721	1893	2065
10-22	sec	0.9	823	1018	1212	1410	1601	1743	1936	2130	2324
23-	sec	1.2t	915	1131	1347	1567	1779	1936	2152	2367	2582



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HEAD OFFICE : 49-25, Gimpoheangang 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

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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 17.6			JIS - SDR17.6-MDPE								
Cylinder area(Ac)	Units	Remark									
	cm ²	37.68									
Spec	mm		200	250	300	350	400	450	500	550	600
Out dia(Od)	mm		216	267	318	370	420	457.2	508	558.8	609.6
Thickness(t)	mm	Od/SDR	12.3	15.2	18.1	21.0	23.9	26.0	28.9	31.8	34.6
In dia(Id)	mm	Od-t*2	191.5	236.7	281.9	328.0	372.3	405.2	450.3	495.3	540.3
Area(Ar)	cm ²		78.5	120.0	170.2	230.4	296.8	351.7	434.2	525.4	625.3
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	3.1	4.8	6.8	9.2	11.8	14.0	17.3	20.9	24.9
Forming bead	sec	Ht*0.2	27.0	33.4	39.8	46.3	52.5	57.2	63.5	69.9	76.2
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.2	0.3	0.5	0.6	0.8	0.9	1.2	1.4	1.7
Heating(Ht)	sec	11t	135.0	166.9	198.8	231.3	262.5	285.8	317.5	349.3	381.0
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2
Fusing	Kg/cm ²		same to forming bead								
Fusing	sec	(3+t)*0.8	12.2	14.5	16.9	19.2	21.5	23.2	25.5	27.8	30.1
Cooling	Kg/cm ²		same to forming bead								
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE								
-9	sec	0.8	707	874	1041	1211	1375	1496	1663	1829	1995
10-22	sec	0.9	795	983	1171	1362	1546	1683	1870	2057	2244
23-	sec	1.2t	884	1092	1301	1514	1718	1870	2078	2286	2494



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

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

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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 19			JIS - SDR19.0-MDPE								
Cylinder area(Ac)	Units	Remark									
	cm ²	37.68									
Spec	mm		200	250	300	350	400	450	500	550	600
Out dia(Od)	mm		216	267	318	370	420	457.2	508	558.8	609.6
Thickness(t)	mm	Od/SDR	11.4	14.1	16.7	19.5	22.1	24.1	26.7	29.4	32.1
In dia(Id)	mm	Od-t*2	193.3	238.9	284.5	331.1	375.8	409.1	454.5	500.0	545.4
Area(Ar)	cm ²		73.0	111.6	158.3	214.3	276.2	327.3	404.0	488.9	581.8
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	2.9	4.4	6.3	8.5	11.0	13.0	16.1	19.5	23.2
Forming bead	sec	Ht*0.2	25.0	30.9	36.8	42.8	48.6	52.9	58.8	64.7	70.6
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.2	0.3	0.4	0.6	0.7	0.9	1.1	1.3	1.5
Heating(Ht)	sec	11t	125.1	154.6	184.1	214.2	243.2	264.7	294.1	323.5	352.9
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2
Fusing	Kg/cm ²		same to forming bead								
Fusing	sec	(3+t)*0.8	11.5	13.6	15.8	18.0	20.1	21.7	23.8	25.9	28.1
Cooling	Kg/cm ²		same to forming bead								
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE								
-9	sec	0.8	655	809	964	1122	1273	1386	1540	1694	1848
10-22	sec	0.9	737	911	1085	1262	1432	1559	1733	1906	2079
23-	sec	1.2t	819	1012	1205	1402	1592	1733	1925	2118	2310



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HEAD OFFICE : 49-25, Gimpoheangang 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

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SDR- 21	Units	Remark	JIS - SDR21.0-MDPE								
Cylinder area(Ac)	cm ²	37.68									
Spec	mm		200	250	300	350	400	450	500	550	600
Out dia(Od)	mm		216	267	318	370	420	457.2	508	558.8	609.6
Thickness(t)	mm	Od/SDR	10.3	12.7	15.1	17.6	20.0	21.8	24.2	26.6	29.0
In dia(Id)	mm	Od-t*2	195.4	241.6	287.7	334.8	380.0	413.7	459.6	505.6	551.5
Area(Ar)	cm ²		66.4	101.5	144.0	195.0	251.2	297.7	367.5	444.7	529.2
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	2.6	4.0	5.7	7.8	10.0	11.8	14.6	17.7	21.1
Forming bead	sec	Ht*0.2	22.6	28.0	33.3	38.8	44.0	47.9	53.2	58.5	63.9
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.2	0.3	0.4	0.5	0.7	0.8	1.0	1.2	1.4
Heating(Ht)	sec	11t	113.1	139.9	166.6	193.8	220.0	239.5	266.1	292.7	319.3
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2
Fusing	Kg/cm ²		same to forming bead								
Fusing	sec	(3+t)*0.8	10.6	12.6	14.5	16.5	18.4	19.8	21.8	23.7	25.6
Cooling	Kg/cm ²		same to forming bead								
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE								
-9	sec	0.8	592	732	872	1015	1152	1254	1393	1533	1672
10-22	sec	0.9	667	824	981	1142	1296	1411	1568	1724	1881
23-	sec	1.2t	741	915	1090	1269	1440	1568	1742	1916	2090



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HEAD OFFICE : 49-25, GimpoHegang 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

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SDR- 22			JIS - SDR22.0-MDPE								
Cylinder area(Ac)	Units	Remark									
	cm ²	37.68									
Spec	mm		200	250	300	350	400	450	500	550	600
Out dia(Od)	mm		216	267	318	370	420	457.2	508	558.8	609.6
Thickness(t)	mm	Od/SDR	9.8	12.1	14.5	16.8	19.1	20.8	23.1	25.4	27.7
In dia(Id)	mm	Od-t*2	196.4	242.7	289.1	336.4	381.8	415.6	461.8	508.0	554.2
Area(Ar)	cm ²		63.6	97.1	137.8	186.5	240.3	284.8	351.6	425.4	506.3
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	2.5	3.9	5.5	7.4	9.6	11.3	14.0	16.9	20.2
Forming bead	sec	Ht*0.2	21.6	26.7	31.8	37.0	42.0	45.7	50.8	55.9	61.0
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.2	0.3	0.4	0.5	0.6	0.8	0.9	1.1	1.3
Heating(Ht)	sec	11t	108.0	133.5	159.0	185.0	210.0	228.6	254.0	279.4	304.8
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2
Fusing	Kg/cm ²		same to forming bead								
Fusing	sec	(3+t)*0.8	10.3	12.1	14.0	15.9	17.7	19.0	20.9	22.7	24.6
Cooling	Kg/cm ²		same to forming bead								
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE								
-9	sec	0.8	566	699	833	969	1100	1197	1330	1463	1596
10-22	sec	0.9	636	786	937	1090	1237	1347	1496	1646	1796
23-	sec	1.2t	707	874	1041	1211	1375	1496	1663	1829	1995



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HEAD OFFICE : 49-25, Gimpoheangang 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

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SDR- 26			JIS - SDR26.0-MDPE								
Cylinder area(Ac)	Units	Remark									
	cm ²	37.68									
Spec	mm		200	250	300	350	400	450	500	550	600
Out dia(Od)	mm		216	267	318	370	420	457.2	508	558.8	609.6
Thickness(t)	mm	Od/SDR	8.3	10.3	12.2	14.2	16.2	17.6	19.5	21.5	23.4
In dia(Id)	mm	Od-t*2	199.4	246.5	293.5	341.5	387.7	422.0	468.9	515.8	562.7
Area(Ar)	cm ²		54.2	82.8	117.4	159.0	204.8	242.7	299.7	362.6	431.5
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	2.2	3.3	4.7	6.3	8.2	9.7	11.9	14.4	17.2
Forming bead	sec	Ht*0.2	18.3	22.6	26.9	31.3	35.5	38.7	43.0	47.3	51.6
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.1	0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.1
Heating(Ht)	sec	11t	91.4	113.0	134.5	156.5	177.7	193.4	214.9	236.4	257.9
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2
Fusing	Kg/cm ²		same to forming bead								
Fusing	sec	(3+t)*0.8	9.0	10.6	12.2	13.8	15.3	16.5	18.0	19.6	21.2
Cooling	Kg/cm ²		same to forming bead								
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE								
-9	sec	0.8	479	592	704	820	930	1013	1125	1238	1350
10-22	sec	0.9	538	665	793	922	1047	1139	1266	1393	1519
23-	sec	1.2t	598	739	881	1025	1163	1266	1407	1547	1688



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HEAD OFFICE : 49-25, Gimpo-hangang 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

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SDR- 33			JIS - SDR33.0-MDPE								
Cylinder area(Ac)	Units	Remark									
	cm ²	37.68									
Spec	mm		200	250	300	350	400	450	500	550	600
Out dia(Od)	mm		216	267	318	370	420	457.2	508	558.8	609.6
Thickness(t)	mm	Od/SDR	6.5	8.1	9.6	11.2	12.7	13.9	15.4	16.9	18.5
In dia(Id)	mm	Od-t*2	202.9	250.8	298.7	347.6	394.5	429.5	477.2	524.9	572.7
Area(Ar)	cm ²		43.0	65.8	93.3	126.3	162.8	192.9	238.1	288.1	342.9
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	1.7	2.6	3.7	5.0	6.5	7.7	9.5	11.5	13.6
Forming bead	sec	Ht*0.2	14.4	17.8	21.2	24.7	28.0	30.5	33.9	37.3	40.6
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.1	0.2	0.2	0.3	0.4	0.5	0.6	0.8	0.9
Heating(Ht)	sec	11t	72.0	89.0	106.0	123.3	140.0	152.4	169.3	186.3	203.2
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2
Fusing	Kg/cm ²		same to forming bead								
Fusing	sec	(3+t)*0.8	7.6	8.9	10.1	11.4	12.6	13.5	14.7	15.9	17.2
Cooling	Kg/cm ²		same to forming bead								
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE								
-9	sec	0.8	377	466	555	646	733	798	887	975	1064
10-22	sec	0.9	424	524	624	727	825	898	998	1097	1197
23-	sec	1.2t	471	583	694	807	916	998	1108	1219	1330



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HEAD OFFICE : 49-25, Gimpoheangang 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

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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 41			JIS - SDR41.0-MDPE								
Cylinder area(Ac)	Units	Remark									
	cm ²	37.68									
Spec	mm		200	250	300	350	400	450	500	550	600
Out dia(Od)	mm		216	267	318	370	420	457.2	508	558.8	609.6
Thickness(t)	mm	Od/SDR	5.3	6.5	7.8	9.0	10.2	11.2	12.4	13.6	14.9
In dia(Id)	mm	Od-t*2	205.5	254.0	302.5	352.0	399.5	434.9	483.2	531.5	579.9
Area(Ar)	cm ²		34.9	53.3	75.6	102.3	131.8	156.2	192.8	233.3	277.7
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	2.1	3.0	4.1	5.2	6.2	7.7	9.3	11.1
Forming bead	sec	Ht*0.2	11.6	14.3	17.1	19.9	22.5	24.5	27.3	30.0	32.7
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.1	0.1	0.2	0.3	0.3	0.4	0.5	0.6	0.7
Heating(Ht)	sec	11t	58.0	71.6	85.3	99.3	112.7	122.7	136.3	149.9	163.6
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2
Fusing	Kg/cm ²		same to forming bead								
Fusing	sec	(3+t)*0.8	6.6	7.6	8.6	9.6	10.6	11.3	12.3	13.3	14.3
Cooling	Kg/cm ²		same to forming bead								
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE								
-9	sec	0.8	303	375	447	520	590	642	714	785	856
10-22	sec	0.9	341	422	503	585	664	723	803	883	963
23-	sec	1.2t	379	469	558	650	738	803	892	981	1071



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HEAD OFFICE : 49-25, Gimpo-hangang 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

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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	37.68										
Spec	mm			200	250	300	350	400	450	500	550	600	
Out dia(Od)	mm			216	267	318	370	420	457.2	508	558.8	609.6	
Thickness(t)	mm	Od/SDR		4.2	5.2	6.2	7.3	8.2	9.0	10.0	11.0	12.0	
In dia(Id)	mm	Od-t*2		207.5	256.5	305.5	355.5	403.5	439.3	488.1	536.9	585.7	
Area(Ar)	cm ²			28.2	43.0	61.0	82.6	106.5	126.2	155.8	188.5	224.3	
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		1.1	1.7	2.4	3.3	4.2	5.0	6.2	7.5	8.9	
Forming bead	sec	Ht*0.2		9.3	11.5	13.7	16.0	18.1	19.7	21.9	24.1	26.3	
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac		0.1	0.1	0.2	0.2	0.3	0.3	0.4	0.5	0.6	
Heating(Ht)	sec	11t		46.6	57.6	68.6	79.8	90.6	98.6	109.6	120.5	131.5	
Remove Heater	sec	3+0.02Od		7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2	
Fusing	Kg/cm ²			same to forming bead									
Fusing	sec	(3+t)*0.8		5.8	6.6	7.4	8.2	9.0	9.6	10.4	11.2	12.0	
Cooling	Kg/cm ²			same to forming bead									
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8		244	302	359	418	474	516	574	631	688	
10-22	sec	0.9		274	339	404	470	534	581	645	710	775	
23-	sec	1.2t		305	377	449	522	593	645	717	789	861	