



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-HDPE				
Cylinder area(Ac)	cm ²	21.98					
Spec	mm		200	250	300	350	400
Out dia(Od)	mm		216	267	318	370	420
Thickness(t)	mm	Od/SDR	43.2	53.4	63.6	74.0	84.0
In dia(Id)	mm	Od-t*2	129.6	160.2	190.8	222.0	252.0
Area(Ar)	cm ²		234.4	358.2	508.0	687.8	886.2
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	16.0	24.4	34.7	46.9	60.5
Forming bead	sec	Ht*0.25	129.6	160.2	190.8	222.0	252.0
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	1.1	1.6	2.3	3.1	4.0
Heating(Ht)	sec	12t	518.4	640.8	763.2	888.0	1008.0
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4
Fusing	Kg/cm ²		same to forming bead				
Fusing	sec	(3+t)*0.8	37.0	45.1	53.3	61.6	69.6
Cooling	Kg/cm ²		same to forming bead				
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE				
-9	sec	0.8	2488	3076	3663	4262	4838
10-22	sec	0.9	2799	3460	4121	4795	5443
23-	sec	1.2t	3110	3845	4579	5328	6048



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SDR- 6	Units	Remark	JIS - SDR6.0-HDPE					
Cylinder area(Ac)	cm ²	21.98						
Spec	mm		200	250	300	350	400	
Out dia(Od)	mm		216	267	318	370	420	
Thickness(t)	mm	Od/SDR	36.0	44.5	53.0	61.7	70.0	
In dia(Id)	mm	Od-t*2	144.0	178.0	212.0	246.7	280.0	
Area(Ar)	cm ²		203.5	310.9	441.0	597.0	769.3	
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	13.9	21.2	30.1	40.7	52.5	
Forming bead	sec	Ht*0.25	108.0	133.5	159.0	185.0	210.0	
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.9	1.4	2.0	2.7	3.5	
Heating(Ht)	sec	12t	432.0	534.0	636.0	740.0	840.0	
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	
Fusing	Kg/cm ²		same to forming bead					
Fusing	sec	(3+t)*0.8	31.2	38.0	44.8	51.7	58.4	
Cooling	Kg/cm ²		same to forming bead					
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE					
-9	sec	0.8	2074	2563	3053	3552	4032	
10-22	sec	0.9	2333	2884	3434	3996	4536	
23-	sec	1.2t	2592	3204	3816	4440	5040	



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SDR- 7	Units	Remark	JIS - SDR7.0-HDPE				
Cylinder area(Ac)	cm ²	21.98					
Spec	mm		200	250	300	350	400
Out dia(Od)	mm		216	267	318	370	420
Thickness(t)	mm	Od/SDR	30.9	38.1	45.4	52.9	60.0
In dia(Id)	mm	Od-t*2	154.3	190.7	227.1	264.3	300.0
Area(Ar)	cm ²		179.4	274.1	388.8	526.4	678.2
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	12.2	18.7	26.5	35.9	46.3
Forming bead	sec	Ht*0.25	92.6	114.4	136.3	158.6	180.0
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.8	1.2	1.8	2.4	3.1
Heating(Ht)	sec	12t	370.3	457.7	545.1	634.3	720.0
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4
Fusing	Kg/cm ²		same to forming bead				
Fusing	sec	(3+t)*0.8	27.1	32.9	38.7	44.7	50.4
Cooling	Kg/cm ²		same to forming bead				
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE				
-9	sec	0.8	1777	2197	2617	3045	3456
10-22	sec	0.9	2000	2472	2944	3425	3888
23-	sec	1.2t	2222	2746	3271	3806	4320



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SDR- 7.4		Units	Remark	JIS - SDR7.4-HDPE				
Cylinder area(Ac)	cm ²	21.98						
Spec	mm			200	250	300	350	400
Out dia(Od)	mm			216	267	318	370	420
Thickness(t)	mm	Od/SDR		29.2	36.1	43.0	50.0	56.8
In dia(Id)	mm	Od-t*2		157.6	194.8	232.1	270.0	306.5
Area(Ar)	cm ²			171.2	261.6	371.1	502.4	647.4
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		11.7	17.9	25.3	34.3	44.2
Forming bead	sec	Ht*0.25		87.6	108.2	128.9	150.0	170.3
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac		0.8	1.2	1.7	2.3	2.9
Heating(Ht)	sec	12t		350.3	433.0	515.7	600.0	681.1
Remove Heater	sec	3+0.02Od		7.3	8.3	9.4	10.4	11.4
Fusing	Kg/cm ²			same to forming bead				
Fusing	sec	(3+t)*0.8		25.8	31.3	36.8	42.4	47.8
Cooling	Kg/cm ²			same to forming bead				
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE				
-9	sec	0.8		1681	2078	2475	2880	3269
10-22	sec	0.9		1891	2338	2785	3240	3678
23-	sec	1.2t		2102	2598	3094	3600	4086



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SDR- 9			JIS - SDR9.0-HDPE				
Cylinder area(Ac)	Units	Remark					
	cm ²	21.98					
Spec	mm		200	250	300	350	400
Out dia(Od)	mm		216	267	318	370	420
Thickness(t)	mm	Od/SDR	24.0	29.7	35.3	41.1	46.7
In dia(Id)	mm	Od-t*2	168.0	207.7	247.3	287.8	326.7
Area(Ar)	cm ²		144.7	221.1	313.6	424.6	547.1
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	9.9	15.1	21.4	29.0	37.3
Forming bead	sec	Ht*0.25	72.0	89.0	106.0	123.3	140.0
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.7	1.0	1.4	1.9	2.5
Heating(Ht)	sec	12t	288.0	356.0	424.0	493.3	560.0
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4
Fusing	Kg/cm ²		same to forming bead				
Fusing	sec	(3+t)*0.8	21.6	26.1	30.7	35.3	39.7
Cooling	Kg/cm ²		same to forming bead				
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE				
-9	sec	0.8	1382	1709	2035	2368	2688
10-22	sec	0.9	1555	1922	2290	2664	3024
23-	sec	1.2t	1728	2136	2544	2960	3360



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SDR- 11	Units	Remark	JIS - SDR11.0-HDPE				
Cylinder area(Ac)	cm ²	21.98					
Spec	mm		200	250	300	350	400
Out dia(Od)	mm		216	267	318	370	420
Thickness(t)	mm	Od/SDR	19.6	24.3	28.9	33.6	38.2
In dia(Id)	mm	Od-t*2	176.7	218.5	260.2	302.7	343.6
Area(Ar)	cm ²		121.1	185.0	262.4	355.3	457.8
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	8.3	12.6	17.9	24.2	31.2
Forming bead	sec	Ht*0.25	58.9	72.8	86.7	100.9	114.5
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.6	0.8	1.2	1.6	2.1
Heating(Ht)	sec	12t	235.6	291.3	346.9	403.6	458.2
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4
Fusing	Kg/cm ²		same to forming bead				
Fusing	sec	(3+t)*0.8	18.1	21.8	25.5	29.3	32.9
Cooling	Kg/cm ²		same to forming bead				
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE				
-9	sec	0.8	1131	1398	1665	1937	2199
10-22	sec	0.9	1272	1573	1873	2180	2474
23-	sec	1.2t	1414	1748	2081	2422	2749



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SDR- 13.6	Units	Remark	JIS - SDR13.6-HDPE				
Cylinder area(Ac)	cm ²	21.98					
Spec	mm		200	250	300	350	400
Out dia(Od)	mm		216	267	318	370	420
Thickness(t)	mm	Od/SDR	15.9	19.6	23.4	27.2	30.9
In dia(Id)	mm	Od-t*2	184.2	227.7	271.2	315.6	358.2
Area(Ar)	cm ²		99.8	152.5	216.3	292.8	377.3
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	6.8	10.4	14.8	20.0	25.8
Forming bead	sec	Ht*0.25	47.6	58.9	70.1	81.6	92.6
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.5	0.7	1.0	1.3	1.7
Heating(Ht)	sec	12t	190.6	235.6	280.6	326.5	370.6
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4
Fusing	Kg/cm ²		same to forming bead				
Fusing	sec	(3+t)*0.8	15.1	18.1	21.1	24.2	27.1
Cooling	Kg/cm ²		same to forming bead				
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE				
-9	sec	0.8	915	1131	1347	1567	1779
10-22	sec	0.9	1029	1272	1515	1763	2001
23-	sec	1.2t	1144	1414	1684	1959	2224



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SDR- 15.5	Units	Remark	JIS - SDR15.5-HDPE				
Cylinder area(Ac)	cm ²	21.98					
Spec	mm		200	250	300	350	400
Out dia(Od)	mm		216	267	318	370	420
Thickness(t)	mm	Od/SDR	13.9	17.2	20.5	23.9	27.1
In dia(Id)	mm	Od-t*2	188.1	232.5	277.0	322.3	365.8
Area(Ar)	cm ²		88.4	135.1	191.6	259.4	334.3
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	6.0	9.2	13.1	17.7	22.8
Forming bead	sec	Ht*0.25	41.8	51.7	61.5	71.6	81.3
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.4	0.6	0.9	1.2	1.5
Heating(Ht)	sec	12t	167.2	206.7	246.2	286.5	325.2
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4
Fusing	Kg/cm ²		same to forming bead				
Fusing	sec	(3+t)*0.8	13.5	16.2	18.8	21.5	24.1
Cooling	Kg/cm ²		same to forming bead				
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE				
-9	sec	0.8	803	992	1182	1375	1561
10-22	sec	0.9	903	1116	1329	1547	1756
23-	sec	1.2t	1003	1240	1477	1719	1951



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 17	Units	Remark	JIS - SDR17.0-HDPE				
Cylinder area(Ac)	cm ²	21.98					
Spec	mm		200	250	300	350	400
Out dia(Od)	mm		216	267	318	370	420
Thickness(t)	mm	Od/SDR	12.7	15.7	18.7	21.8	24.7
In dia(Id)	mm	Od-t*2	190.6	235.6	280.6	326.5	370.6
Area(Ar)	cm ²		81.1	123.9	175.8	238.0	306.7
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	5.5	8.5	12.0	16.2	20.9
Forming bead	sec	Ht*0.25	38.1	47.1	56.1	65.3	74.1
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.4	0.6	0.8	1.1	1.4
Heating(Ht)	sec	12t	152.5	188.5	224.5	261.2	296.5
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4
Fusing	Kg/cm ²		same to forming bead				
Fusing	sec	(3+t)*0.8	12.6	15.0	17.4	19.8	22.2
Cooling	Kg/cm ²		same to forming bead				
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE				
-9	sec	0.8	732	905	1077	1254	1423
10-22	sec	0.9	823	1018	1212	1410	1601
23-	sec	1.2t	915	1131	1347	1567	1779



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SDR- 17.6	Units	Remark	JIS - SDR17.6-HDPE				
Cylinder area(Ac)	cm ²	21.98					
Spec	mm		200	250	300	350	400
Out dia(Od)	mm		216	267	318	370	420
Thickness(t)	mm	Od/SDR	12.3	15.2	18.1	21.0	23.9
In dia(Id)	mm	Od-t*2	191.5	236.7	281.9	328.0	372.3
Area(Ar)	cm ²		78.5	120.0	170.2	230.4	296.8
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	5.4	8.2	11.6	15.7	20.3
Forming bead	sec	Ht*0.25	36.8	45.5	54.2	63.1	71.6
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.4	0.5	0.8	1.0	1.4
Heating(Ht)	sec	12t	147.3	182.0	216.8	252.3	286.4
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4
Fusing	Kg/cm ²		same to forming bead				
Fusing	sec	(3+t)*0.8	12.2	14.5	16.9	19.2	21.5
Cooling	Kg/cm ²		same to forming bead				
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE				
-9	sec	0.8	707	874	1041	1211	1375
10-22	sec	0.9	795	983	1171	1362	1546
23-	sec	1.2t	884	1092	1301	1514	1718



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SDR- 19	Units	Remark	JIS - SDR19.0-HDPE				
Cylinder area(Ac)	cm ²	21.98					
Spec	mm		200	250	300	350	400
Out dia(Od)	mm		216	267	318	370	420
Thickness(t)	mm	Od/SDR	11.4	14.1	16.7	19.5	22.1
In dia(Id)	mm	Od-t*2	193.3	238.9	284.5	331.1	375.8
Area(Ar)	cm ²		73.0	111.6	158.3	214.3	276.2
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	5.0	7.6	10.8	14.6	18.8
Forming bead	sec	Ht*0.25	34.1	42.2	50.2	58.4	66.3
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.3	0.5	0.7	1.0	1.3
Heating(Ht)	sec	12t	136.4	168.6	200.8	233.7	265.3
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4
Fusing	Kg/cm ²		same to forming bead				
Fusing	sec	(3+t)*0.8	11.5	13.6	15.8	18.0	20.1
Cooling	Kg/cm ²		same to forming bead				
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE				
-9	sec	0.8	655	809	964	1122	1273
10-22	sec	0.9	737	911	1085	1262	1432
23-	sec	1.2t	819	1012	1205	1402	1592



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 21	Units	Remark	JIS - SDR21.0-HDPE				
Cylinder area(Ac)	cm ²	21.98					
Spec	mm		200	250	300	350	400
Out dia(Od)	mm		216	267	318	370	420
Thickness(t)	mm	Od/SDR	10.3	12.7	15.1	17.6	20.0
In dia(Id)	mm	Od-t*2	195.4	241.6	287.7	334.8	380.0
Area(Ar)	cm ²		66.4	101.5	144.0	195.0	251.2
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	4.5	6.9	9.8	13.3	17.1
Forming bead	sec	Ht*0.25	30.9	38.1	45.4	52.9	60.0
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.3	0.5	0.7	0.9	1.1
Heating(Ht)	sec	12t	123.4	152.6	181.7	211.4	240.0
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4
Fusing	Kg/cm ²		same to forming bead				
Fusing	sec	(3+t)*0.8	10.6	12.6	14.5	16.5	18.4
Cooling	Kg/cm ²		same to forming bead				
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE				
-9	sec	0.8	592	732	872	1015	1152
10-22	sec	0.9	667	824	981	1142	1296
23-	sec	1.2t	741	915	1090	1269	1440



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- 22		Units	Remark	JIS - SDR22.0-HDPE				
Cylinder area(Ac)	cm ²		21.98					
Spec	mm			200	250	300	350	400
Out dia(Od)	mm			216	267	318	370	420
Thickness(t)	mm	Od/SDR		9.8	12.1	14.5	16.8	19.1
In dia(Id)	mm	Od-t*2		196.4	242.7	289.1	336.4	381.8
Area(Ar)	cm ²			63.6	97.1	137.8	186.5	240.3
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		4.3	6.6	9.4	12.7	16.4
Forming bead	sec	Ht*0.25		29.5	36.4	43.4	50.5	57.3
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac		0.3	0.4	0.6	0.8	1.1
Heating(Ht)	sec	12t		117.8	145.6	173.5	201.8	229.1
Remove Heater	sec	3+0.02Od		7.3	8.3	9.4	10.4	11.4
Fusing	Kg/cm ²			same to forming bead				
Fusing	sec	(3+t)*0.8		10.3	12.1	14.0	15.9	17.7
Cooling	Kg/cm ²			same to forming bead				
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE				
-9	sec	0.8		566	699	833	969	1100
10-22	sec	0.9		636	786	937	1090	1237
23-	sec	1.2t		707	874	1041	1211	1375



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 26	Units	Remark	JIS - SDR26.0-HDPE					
Cylinder area(Ac)	cm ²	21.98						
Spec	mm		200	250	300	350	400	
Out dia(Od)	mm		216	267	318	370	420	
Thickness(t)	mm	Od/SDR	8.3	10.3	12.2	14.2	16.2	
In dia(Id)	mm	Od-t*2	199.4	246.5	293.5	341.5	387.7	
Area(Ar)	cm ²		54.2	82.8	117.4	159.0	204.8	
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	3.7	5.6	8.0	10.8	14.0	
Forming bead	sec	Ht*0.25	24.9	30.8	36.7	42.7	48.5	
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.2	0.4	0.5	0.7	0.9	
Heating(Ht)	sec	12t	99.7	123.2	146.8	170.8	193.8	
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	
Fusing	Kg/cm ²		same to forming bead					
Fusing	sec	(3+t)*0.8	9.0	10.6	12.2	13.8	15.3	
Cooling	Kg/cm ²		same to forming bead					
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE					
-9	sec	0.8	479	592	704	820	930	
10-22	sec	0.9	538	665	793	922	1047	
23-	sec	1.2t	598	739	881	1025	1163	



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 33	Units	Remark	JIS - SDR33.0-HDPE				
Cylinder area(Ac)	cm ²	21.98					
Spec	mm		200	250	300	350	400
Out dia(Od)	mm		216	267	318	370	420
Thickness(t)	mm	Od/SDR	6.5	8.1	9.6	11.2	12.7
In dia(Id)	mm	Od-t*2	202.9	250.8	298.7	347.6	394.5
Area(Ar)	cm ²		43.0	65.8	93.3	126.3	162.8
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	4.5	6.4	8.6	11.1
Forming bead	sec	Ht*0.25	19.6	24.3	28.9	33.6	38.2
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.2	0.3	0.4	0.6	0.7
Heating(Ht)	sec	12t	78.5	97.1	115.6	134.5	152.7
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4
Fusing	Kg/cm ²		same to forming bead				
Fusing	sec	(3+t)*0.8	7.6	8.9	10.1	11.4	12.6
Cooling	Kg/cm ²		same to forming bead				
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE				
-9	sec	0.8	377	466	555	646	733
10-22	sec	0.9	424	524	624	727	825
23-	sec	1.2t	471	583	694	807	916



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 41	Units	Remark	JIS - SDR41.0-HDPE				
Cylinder area(Ac)	cm ²	21.98					
Spec	mm		200	250	300	350	400
Out dia(Od)	mm		216	267	318	370	420
Thickness(t)	mm	Od/SDR	5.3	6.5	7.8	9.0	10.2
In dia(Id)	mm	Od-t*2	205.5	254.0	302.5	352.0	399.5
Area(Ar)	cm ²		34.9	53.3	75.6	102.3	131.8
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	2.4	3.6	5.2	7.0	9.0
Forming bead	sec	Ht*0.25	15.8	19.5	23.3	27.1	30.7
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.2	0.2	0.3	0.5	0.6
Heating(Ht)	sec	12t	63.2	78.1	93.1	108.3	122.9
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4
Fusing	Kg/cm ²		same to forming bead				
Fusing	sec	(3+t)*0.8	6.6	7.6	8.6	9.6	10.6
Cooling	Kg/cm ²		same to forming bead				
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE				
-9	sec	0.8	303	375	447	520	590
10-22	sec	0.9	341	422	503	585	664
23-	sec	1.2t	379	469	558	650	738



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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 51	Units	Remark	JIS - SDR51.0-HDPE				
Cylinder area(Ac)	cm ²	21.98					
Spec	mm		200	250	300	350	400
Out dia(Od)	mm		216	267	318	370	420
Thickness(t)	mm	Od/SDR	4.2	5.2	6.2	7.3	8.2
In dia(Id)	mm	Od-t*2	207.5	256.5	305.5	355.5	403.5
Area(Ar)	cm ²		28.2	43.0	61.0	82.6	106.5
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	1.9	2.9	4.2	5.6	7.3
Forming bead	sec	Ht*0.25	12.7	15.7	18.7	21.8	24.7
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.1	0.2	0.3	0.4	0.5
Heating(Ht)	sec	12t	50.8	62.8	74.8	87.1	98.8
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4
Fusing	Kg/cm ²		same to forming bead				
Fusing	sec	(3+t)*0.8	5.8	6.6	7.4	8.2	9.0
Cooling	Kg/cm ²		same to forming bead				
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE				
-9	sec	0.8	244	302	359	418	474
10-22	sec	0.9	274	339	404	470	534
23-	sec	1.2t	305	377	449	522	593