

- - - 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

ISO 9001 Registered

AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 5			JIS - SDR5.0-MDPE				
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	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*0.2	95.0	117.5	139.9	162.8	184.8
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	1.1	1.6	2.3	3.1	4.0
Heating(Ht)	sec	11t	475.2	587.4	699.6	814.0	924.0
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			JIS - SDR6.0-MDPE				
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*0.2	79.2	97.9	116.6	135.7	154.0
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.9	1.4	2.0	2.7	3.5
Heating(Ht)	sec	11t	396.0	489.5	583.0	678.3	770.0
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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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 7			JIS - SDR7.0-MDPE				
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	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*0.2	67.9	83.9	99.9	116.3	132.0
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.8	1.2	1.8	2.4	3.1
Heating(Ht)	sec	11t	339.4	419.6	499.7	581.4	660.0
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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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 7.4			JIS - SDR7.4-MDPE				
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*0.2	64.2	79.4	94.5	110.0	124.9
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.8	1.2	1.7	2.3	2.9
Heating(Ht)	sec	11t	321.1	396.9	472.7	550.0	624.3
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	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-MDPE				
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*0.2	52.8	65.3	77.7	90.4	102.7
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.7	1.0	1.4	1.9	2.5
Heating(Ht)	sec	11t	264.0	326.3	388.7	452.2	513.3
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	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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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 11			JIS - SDR11.0-MDPE				
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*0.2	43.2	53.4	63.6	74.0	84.0
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.6	0.8	1.2	1.6	2.1
Heating(Ht)	sec	11t	216.0	267.0	318.0	370.0	420.0
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	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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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 13.6			JIS - SDR13.6-MDPE				
Cylinder area(Ac)	Units	Remark					
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*0.2	34.9	43.2	51.4	59.9	67.9
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.5	0.7	1.0	1.3	1.7
Heating(Ht)	sec	11t	174.7	216.0	257.2	299.3	339.7
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	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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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 15.5			JIS - SDR15.5-MDPE				
Cylinder area(Ac)	Units	Remark					
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*0.2	30.7	37.9	45.1	52.5	59.6
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.4	0.6	0.9	1.2	1.5
Heating(Ht)	sec	11t	153.3	189.5	225.7	262.6	298.1
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	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			JIS - SDR17.0-MDPE				
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	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*0.2	28.0	34.6	41.2	47.9	54.4
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.4	0.6	0.8	1.1	1.4
Heating(Ht)	sec	11t	139.8	172.8	205.8	239.4	271.8
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	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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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 17.6			JIS - SDR17.6-MDPE				
Cylinder area(Ac)	Units	Remark	200	250	300	350	400
	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*0.2	27.0	33.4	39.8	46.3	52.5
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.4	0.5	0.8	1.0	1.4
Heating(Ht)	sec	11t	135.0	166.9	198.8	231.3	262.5
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	12.2	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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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 19			JIS - SDR19.0-MDPE				
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	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*0.2	25.0	30.9	36.8	42.8	48.6
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.3	0.5	0.7	1.0	1.3
Heating(Ht)	sec	11t	125.1	154.6	184.1	214.2	243.2
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	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			JIS - SDR21.0-MDPE				
Units	Remark						
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*0.2	22.6	28.0	33.3	38.8	44.0
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.3	0.5	0.7	0.9	1.1
Heating(Ht)	sec	11t	113.1	139.9	166.6	193.8	220.0
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

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AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 22			JIS - SDR22.0-MDPE				
Units	Remark						
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*0.2	21.6	26.7	31.8	37.0	42.0
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.3	0.4	0.6	0.8	1.1
Heating(Ht)	sec	11t	108.0	133.5	159.0	185.0	210.0
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	10.3	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			JIS - SDR26.0-MDPE				
Units	Remark						
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*0.2	18.3	22.6	26.9	31.3	35.5
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.2	0.4	0.5	0.7	0.9
Heating(Ht)	sec	11t	91.4	113.0	134.5	156.5	177.7
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	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			JIS - SDR33.0-MDPE				
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	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*0.2	14.4	17.8	21.2	24.7	28.0
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.2	0.3	0.4	0.6	0.7
Heating(Ht)	sec	11t	72.0	89.0	106.0	123.3	140.0
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	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			JIS - SDR41.0-MDPE				
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	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*0.2	11.6	14.3	17.1	19.9	22.5
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.2	0.2	0.3	0.5	0.6
Heating(Ht)	sec	11t	58.0	71.6	85.3	99.3	112.7
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	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			JIS - SDR51.0-MDPE				
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*0.2	9.3	11.5	13.7	16.0	18.1
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.1	0.2	0.3	0.4	0.5
Heating(Ht)	sec	11t	46.6	57.6	68.6	79.8	90.6
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	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