



## Saemin Electronics Industries Corp.

HEAD OFFICE : #926-2 WHAGOG-DONG GANGSEO-GU SEOUL, KOREA.

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ISO 9001 Registered

AUTOMATIC & MANUAL BUTT FUSION MACHINE / ELECTRO FUSION PROCESSOR

SDR- 11		Units	Remark	GAS-1 (ISO - SDR11-MDPE)											
Cylinder area(Ac)	cm <sup>2</sup>		7.22												
Spec	mm			75	90	110	125	140	160	180	200	225	250	280	315
Out dia(Od)	mm			75	90	110	125	140	160	180	200	225	250	280	315
Thickness(t)	mm	Od/SDR		6.8	8.2	10.0	11.4	12.7	14.5	16.4	18.2	20.5	22.7	25.5	28.6
In dia(Id)	mm	Od-t*2		61.4	73.6	90.0	102.3	114.5	130.9	147.3	163.6	184.1	204.5	229.1	257.7
Area(Ar)	cm <sup>2</sup>			14.6	21.0	31.4	40.5	50.9	66.4	84.1	103.8	131.4	162.2	203.5	257.5
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		3.0	4.4	6.5	8.4	10.6	13.8	17.5	21.6	27.3	33.7	42.3	53.5
Forming bead	sec	Ht*0.2		15.0	18.0	22.0	25.0	28.0	32.0	36.0	40.0	45.0	50.0	56.0	63.0
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.2	0.3	0.4	0.6	0.7	0.9	1.2	1.4	1.8	2.2	2.8	3.6
Heating(Ht)	sec	11t		75.0	90.0	110.0	125.0	140.0	160.0	180.0	200.0	225.0	250.0	280.0	315.0
Remove Heater	sec	3+0.02Od		4.5	4.8	5.2	5.5	5.8	6.2	6.6	7.0	7.5	8.0	8.6	9.3
Fusing	Kg/cm <sup>2</sup>			same to forming bead											
Fusing	sec	(3+t)*0.8		7.9	8.9	10.4	11.5	12.6	14.0	15.5	16.9	18.8	20.6	22.8	25.3
Cooling	Kg/cm <sup>2</sup>			same to forming bead											
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE											
-9	sec	0.8		393	471	576	655	733	838	943	1047	1178	1309	1466	1649
10-22	sec	0.9		442	530	648	736	825	943	1060	1178	1325	1473	1649	1856
23-	sec	1.2t		491	589	720	818	916	1047	1178	1309	1473	1636	1833	2062



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SDR- 17.6		Units	Remark	GAS-2 (ISO - SDR17.6-MDPE)											
Cylinder area(Ac)	cm <sup>2</sup>		7.22												
Spec	mm			75	90	110	125	140	160	180	200	225	250	280	315
Out dia(Od)	mm			75	90	110	125	140	160	180	200	225	250	280	315
Thickness(t)	mm	Od/SDR		4.3	5.1	6.3	7.1	8.0	9.1	10.2	11.4	12.8	14.2	15.9	17.9
In dia(Id)	mm	Od-t*2		66.5	79.8	97.5	110.8	124.1	141.8	159.5	177.3	199.4	221.6	248.2	279.2
Area(Ar)	cm <sup>2</sup>			9.5	13.6	20.4	26.3	33.0	43.1	54.5	67.3	85.2	105.2	131.9	167.0
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		2.0	2.8	4.2	5.5	6.9	8.9	11.3	14.0	17.7	21.8	27.4	34.7
Forming bead	sec	Ht*0.2		9.4	11.3	13.8	15.6	17.5	20.0	22.5	25.0	28.1	31.3	35.0	39.4
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.1	0.2	0.3	0.4	0.5	0.6	0.8	0.9	1.2	1.5	1.8	2.3
Heating(Ht)	sec	11t		46.9	56.3	68.8	78.1	87.5	100.0	112.5	125.0	140.6	156.3	175.0	196.9
Remove Heater	sec	3+0.02Od		4.5	4.8	5.2	5.5	5.8	6.2	6.6	7.0	7.5	8.0	8.6	9.3
Fusing	Kg/cm <sup>2</sup>			same to forming bead											
Fusing	sec	(3+t)*0.8		5.8	6.5	7.4	8.1	8.8	9.7	10.6	11.5	12.6	13.8	15.1	16.7
Cooling	Kg/cm <sup>2</sup>			same to forming bead											
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE											
-9	sec	0.8		245	295	360	409	458	524	589	655	736	818	916	1031
10-22	sec	0.9		276	331	405	460	515	589	663	736	828	920	1031	1160
23-	sec	1.2t		307	368	450	511	573	655	736	818	920	1023	1145	1289



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SDR- 21		Units	Remark	GAS-3 (ISO - SDR21-MDPE)											
Cylinder area(Ac)	cm <sup>2</sup>		7.22												
Spec	mm			75	90	110	125	140	160	180	200	225	250	280	315
Out dia(Od)	mm			75	90	110	125	140	160	180	200	225	250	280	315
Thickness(t)	mm	Od/SDR		3.6	4.3	5.2	6.0	6.7	7.6	8.6	9.5	10.7	11.9	13.3	15.0
In dia(Id)	mm	Od-t*2		67.9	81.4	99.5	113.1	126.7	144.8	162.9	181.0	203.6	226.2	253.3	285.0
Area(Ar)	cm <sup>2</sup>			8.0	11.5	17.2	22.3	27.9	36.5	46.1	57.0	72.1	89.0	111.6	141.3
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		1.7	2.4	3.6	4.6	5.8	7.6	9.6	11.8	15.0	18.5	23.2	29.4
Forming bead	sec	Ht*0.2		7.9	9.4	11.5	13.1	14.7	16.8	18.9	21.0	23.6	26.2	29.3	33.0
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.1	0.2	0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.5	2.0
Heating(Ht)	sec	11t		39.3	47.1	57.6	65.5	73.3	83.8	94.3	104.8	117.9	131.0	146.7	165.0
Remove Heater	sec	3+0.02Od		4.5	4.8	5.2	5.5	5.8	6.2	6.6	7.0	7.5	8.0	8.6	9.3
Fusing	Kg/cm <sup>2</sup>			same to forming bead											
Fusing	sec	(3+t)*0.8		5.3	5.8	6.6	7.2	7.7	8.5	9.3	10.0	11.0	11.9	13.1	14.4
Cooling	Kg/cm <sup>2</sup>			same to forming bead											
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE											
-9	sec	0.8		206	247	302	343	384	439	494	549	617	686	768	864
10-22	sec	0.9		231	278	339	386	432	494	555	617	694	771	864	972
23-	sec	1.2t		257	309	377	429	480	549	617	686	771	857	960	1080



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SDR- 11		Units	Remark	WATER-1 (ISO - SDR11.0-HDPE)											
Cylinder area(Ac)	cm <sup>2</sup>		7.22												
Spec	mm			75	90	110	125	140	160	180	200	225	250	280	315
Out dia(Od)	mm			75	90	110	125	140	160	180	200	225	250	280	315
Thickness(t)	mm	Od/SDR		6.8	8.2	10.0	11.4	12.7	14.5	16.4	18.2	20.5	22.7	25.5	28.6
In dia(Id)	mm	Od-t*2		61.4	73.6	90.0	102.3	114.5	130.9	147.3	163.6	184.1	204.5	229.1	257.7
Area(Ar)	cm <sup>2</sup>			14.6	21.0	31.4	40.5	50.9	66.4	84.1	103.8	131.4	162.2	203.5	257.5
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		3.0	4.4	6.5	8.4	10.6	13.8	17.5	21.6	27.3	33.7	42.3	53.5
Forming bead	sec	Ht*0.25		20.5	24.5	30.0	34.1	38.2	43.6	49.1	54.5	61.4	68.2	76.4	85.9
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.2	0.3	0.4	0.6	0.7	0.9	1.2	1.4	1.8	2.2	2.8	3.6
Heating(Ht)	sec	12t		81.8	98.2	120.0	136.4	152.7	174.5	196.4	218.2	245.5	272.7	305.5	343.6
Remove Heater	sec	3+0.02Od		4.5	4.8	5.2	5.5	5.8	6.2	6.6	7.0	7.5	8.0	8.6	9.3
Fusing	Kg/cm <sup>2</sup>			same to forming bead											
Fusing	sec	(3+t)*0.8		7.9	8.9	10.4	11.5	12.6	14.0	15.5	16.9	18.8	20.6	22.8	25.3
Cooling	Kg/cm <sup>2</sup>			same to forming bead											
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE											
-9	sec	0.8		393	471	576	655	733	838	943	1047	1178	1309	1466	1649
10-22	sec	0.9		442	530	648	736	825	943	1060	1178	1325	1473	1649	1856
23-	sec	1.2t		491	589	720	818	916	1047	1178	1309	1473	1636	1833	2062



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SDR- 13.5		Units	Remark	WATER-2 (ISO - SDR13.5-HDPE)											
Cylinder area(Ac)	cm <sup>2</sup>		7.22												
Spec	mm			75	90	110	125	140	160	180	200	225	250	280	315
Out dia(Od)	mm			75	90	110	125	140	160	180	200	225	250	280	315
Thickness(t)	mm	Od/SDR		5.6	6.7	8.1	9.3	10.4	11.9	13.3	14.8	16.7	18.5	20.7	23.3
In dia(Id)	mm	Od-t*2		63.9	76.7	93.7	106.5	119.3	136.3	153.3	170.4	191.7	213.0	238.5	268.3
Area(Ar)	cm <sup>2</sup>			12.1	17.4	26.1	33.7	42.2	55.1	69.8	86.1	109.0	134.6	168.8	213.7
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		2.5	3.6	5.4	7.0	8.8	11.5	14.5	17.9	22.7	28.0	35.1	44.4
Forming bead	sec	Ht*0.25		16.7	20.0	24.4	27.8	31.1	35.6	40.0	44.4	50.0	55.6	62.2	70.0
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.2	0.2	0.4	0.5	0.6	0.8	1.0	1.2	1.5	1.9	2.3	3.0
Heating(Ht)	sec	12t		66.7	80.0	97.8	111.1	124.4	142.2	160.0	177.8	200.0	222.2	248.9	280.0
Remove Heater	sec	3+0.02Od		4.5	4.8	5.2	5.5	5.8	6.2	6.6	7.0	7.5	8.0	8.6	9.3
Fusing	Kg/cm <sup>2</sup>			same to forming bead											
Fusing	sec	(3+t)*0.8		6.8	7.7	8.9	9.8	10.7	11.9	13.1	14.3	15.7	17.2	19.0	21.1
Cooling	Kg/cm <sup>2</sup>			same to forming bead											
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE											
-9	sec	0.8		320	384	469	533	597	683	768	853	960	1067	1195	1344
10-22	sec	0.9		360	432	528	600	672	768	864	960	1080	1200	1344	1512
23-	sec	1.2t		400	480	587	667	747	853	960	1067	1200	1333	1493	1680



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SDR- 15.5		Units	Remark	WATER-3 (ISO - SDR15.5-HDPE)											
Cylinder area(Ac)	cm <sup>2</sup>		7.22												
Spec	mm			75	90	110	125	140	160	180	200	225	250	280	315
Out dia(Od)	mm			75	90	110	125	140	160	180	200	225	250	280	315
Thickness(t)	mm	Od/SDR		4.8	5.8	7.1	8.1	9.0	10.3	11.6	12.9	14.5	16.1	18.1	20.3
In dia(Id)	mm	Od-t*2		65.3	78.4	95.8	108.9	121.9	139.4	156.8	174.2	196.0	217.7	243.9	274.4
Area(Ar)	cm <sup>2</sup>			10.7	15.4	22.9	29.6	37.1	48.5	61.4	75.8	95.9	118.4	148.6	188.0
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		2.2	3.2	4.8	6.2	7.7	10.1	12.8	15.7	19.9	24.6	30.9	39.1
Forming bead	sec	Ht*0.25		14.5	17.4	21.3	24.2	27.1	31.0	34.8	38.7	43.5	48.4	54.2	61.0
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.1	0.2	0.3	0.4	0.5	0.7	0.9	1.0	1.3	1.6	2.1	2.6
Heating(Ht)	sec	12t		58.1	69.7	85.2	96.8	108.4	123.9	139.4	154.8	174.2	193.5	216.8	243.9
Remove Heater	sec	3+0.02Od		4.5	4.8	5.2	5.5	5.8	6.2	6.6	7.0	7.5	8.0	8.6	9.3
Fusing	Kg/cm <sup>2</sup>			same to forming bead											
Fusing	sec	(3+t)*0.8		6.3	7.0	8.1	8.9	9.6	10.7	11.7	12.7	14.0	15.3	16.9	18.7
Cooling	Kg/cm <sup>2</sup>			same to forming bead											
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE											
-9	sec	0.8		279	334	409	465	520	595	669	743	836	929	1041	1171
10-22	sec	0.9		314	376	460	523	585	669	753	836	941	1045	1171	1317
23-	sec	1.2t		348	418	511	581	650	743	836	929	1045	1161	1301	1463