



## 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](mailto:selding@selding.com)

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>	10.99								
Spec	mm		180	200	225	250	280	315	355	400
Out dia(Od)	mm		180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR	16.4	18.2	20.5	22.7	25.5	28.6	32.3	36.4
In dia(Id)	mm	Od-t*2	147.3	163.6	184.1	204.5	229.1	257.7	290.5	327.3
Area(Ar)	cm <sup>2</sup>		84.1	103.8	131.4	162.2	203.5	257.5	327.0	415.2
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	11.5	14.2	17.9	22.1	27.8	35.1	44.6	56.7
Forming bead	sec	Ht*0.2	36.0	40.0	45.0	50.0	56.0	63.0	71.0	80.0
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.8	0.9	1.2	1.5	1.9	2.3	3.0	3.8
Heating(Ht)	sec	11t	180.0	200.0	225.0	250.0	280.0	315.0	355.0	400.0
Remove Heater	sec	3+0.02Od	6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>		same to forming bead							
Fusing	sec	(3+t)*0.8	15.5	16.9	18.8	20.6	22.8	25.3	28.2	31.5
Cooling	Kg/cm <sup>2</sup>		same to forming bead							
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8	943	1047	1178	1309	1466	1649	1859	2095
10-22	sec	0.9	1060	1178	1325	1473	1649	1856	2091	2356
23-	sec	1.2t	1178	1309	1473	1636	1833	2062	2324	2618



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SDR- 17.6		Units	Remark	GAS-2 (ISO - SDR17.6-MDPE)							
Cylinder area(Ac)	cm <sup>2</sup>		10.99								
Spec	mm			180	200	225	250	280	315	355	400
Out dia(Od)	mm			180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR		10.2	11.4	12.8	14.2	15.9	17.9	20.2	22.7
In dia(Id)	mm	Od-t*2		159.5	177.3	199.4	221.6	248.2	279.2	314.7	354.5
Area(Ar)	cm <sup>2</sup>			54.5	67.3	85.2	105.2	131.9	167.0	212.1	269.2
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		7.4	9.2	11.6	14.4	18.0	22.8	28.9	36.7
Forming bead	sec	Ht*0.2		22.5	25.0	28.1	31.3	35.0	39.4	44.4	50.0
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.5	0.6	0.8	1.0	1.2	1.5	1.9	2.4
Heating(Ht)	sec	11t		112.5	125.0	140.6	156.3	175.0	196.9	221.9	250.0
Remove Heater	sec	3+0.02Od		6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>			same to forming bead							
Fusing	sec	(3+t)*0.8		10.6	11.5	12.6	13.8	15.1	16.7	18.5	20.6
Cooling	Kg/cm <sup>2</sup>			same to forming bead							
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8		589	655	736	818	916	1031	1162	1309
10-22	sec	0.9		663	736	828	920	1031	1160	1307	1473
23-	sec	1.2t		736	818	920	1023	1145	1289	1452	1636



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SDR- 21		Units	Remark	GAS-3 (ISO - SDR21-MDPE)							
Cylinder area(Ac)	cm <sup>2</sup>	10.99									
Spec	mm			180	200	225	250	280	315	355	400
Out dia(Od)	mm			180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR		8.6	9.5	10.7	11.9	13.3	15.0	16.9	19.0
In dia(Id)	mm	Od-t*2		162.9	181.0	203.6	226.2	253.3	285.0	321.2	361.9
Area(Ar)	cm <sup>2</sup>			46.1	57.0	72.1	89.0	111.6	141.3	179.5	227.8
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		6.3	7.8	9.8	12.1	15.2	19.3	24.5	31.1
Forming bead	sec	Ht*0.2		18.9	21.0	23.6	26.2	29.3	33.0	37.2	41.9
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.4	0.5	0.7	0.8	1.0	1.3	1.6	2.1
Heating(Ht)	sec	11t		94.3	104.8	117.9	131.0	146.7	165.0	186.0	209.5
Remove Heater	sec	3+0.02Od		6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>			same to forming bead							
Fusing	sec	(3+t)*0.8		9.3	10.0	11.0	11.9	13.1	14.4	15.9	17.6
Cooling	Kg/cm <sup>2</sup>			same to forming bead							
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8		494	549	617	686	768	864	974	1097
10-22	sec	0.9		555	617	694	771	864	972	1095	1234
23-	sec	1.2t		617	686	771	857	960	1080	1217	1371

- - - 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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SDR- 11		Units	Remark	WATER-1 (ISO - SDR11-HDPE)							
Cylinder area(Ac)	cm <sup>2</sup>		10.99								
Spec	mm			180	200	225	250	280	315	355	400
Out dia(Od)	mm			180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR		16.4	18.2	20.5	22.7	25.5	28.6	32.3	36.4
In dia(Id)	mm	Od-t*2		147.3	163.6	184.1	204.5	229.1	257.7	290.5	327.3
Area(Ar)	cm <sup>2</sup>			84.1	103.8	131.4	162.2	203.5	257.5	327.0	415.2
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		11.5	14.2	17.9	22.1	27.8	35.1	44.6	56.7
Forming bead	sec	Ht*0.25		49.1	54.5	61.4	68.2	76.4	85.9	96.8	109.1
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.8	0.9	1.2	1.5	1.9	2.3	3.0	3.8
Heating(Ht)	sec	12t		196.4	218.2	245.5	272.7	305.5	343.6	387.3	436.4
Remove Heater	sec	3+0.02Od		6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>			same to forming bead							
Fusing	sec	(3+t)*0.8		15.5	16.9	18.8	20.6	22.8	25.3	28.2	31.5
Cooling	Kg/cm <sup>2</sup>			same to forming bead							
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE							
-9	sec	0.8		943	1047	1178	1309	1466	1649	1859	2095
10-22	sec	0.9		1060	1178	1325	1473	1649	1856	2091	2356
23-	sec	1.2t		1178	1309	1473	1636	1833	2062	2324	2618



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SDR- 13.5		Units	Remark	WATER-2 (ISO - SDR13.5-HDPE)							
Cylinder area(Ac)	cm <sup>2</sup>		10.99								
Spec	mm			180	200	225	250	280	315	355	400
Out dia(Od)	mm			180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR		13.3	14.8	16.7	18.5	20.7	23.3	26.3	29.6
In dia(Id)	mm	Od-t*2		153.3	170.4	191.7	213.0	238.5	268.3	302.4	340.7
Area(Ar)	cm <sup>2</sup>			69.8	86.1	109.0	134.6	168.8	213.7	271.4	344.6
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		9.5	11.8	14.9	18.4	23.0	29.2	37.0	47.0
Forming bead	sec	Ht*0.25		40.0	44.4	50.0	55.6	62.2	70.0	78.9	88.9
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.6	0.8	1.0	1.2	1.5	1.9	2.5	3.1
Heating(Ht)	sec	12t		160.0	177.8	200.0	222.2	248.9	280.0	315.6	355.6
Remove Heater	sec	3+0.02Od		6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>			same to forming bead							
Fusing	sec	(3+t)*0.8		13.1	14.3	15.7	17.2	19.0	21.1	23.4	26.1
Cooling	Kg/cm <sup>2</sup>			same to forming bead							
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE							
	-9	sec	0.8	768	853	960	1067	1195	1344	1515	1707
	10-22	sec	0.9	864	960	1080	1200	1344	1512	1704	1920
	23-	sec	1.2t	960	1067	1200	1333	1493	1680	1893	2133



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SDR- 15.5		Units	Remark	WATER-3 (ISO - SDR15.5-HDPE)							
Cylinder area(Ac)	cm <sup>2</sup>		10.99								
Spec	mm			180	200	225	250	280	315	355	400
Out dia(Od)	mm			180	200	225	250	280	315	355	400
Thickness(t)	mm	Od/SDR		11.6	12.9	14.5	16.1	18.1	20.3	22.9	25.8
In dia(Id)	mm	Od-t*2		156.8	174.2	196.0	217.7	243.9	274.4	309.2	348.4
Area(Ar)	cm <sup>2</sup>			61.4	75.8	95.9	118.4	148.6	188.0	238.8	303.2
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		8.4	10.3	13.1	16.2	20.3	25.7	32.6	41.4
Forming bead	sec	Ht*0.25		34.8	38.7	43.5	48.4	54.2	61.0	68.7	77.4
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac		0.6	0.7	0.9	1.1	1.4	1.7	2.2	2.8
Heating(Ht)	sec	12t		139.4	154.8	174.2	193.5	216.8	243.9	274.8	309.7
Remove Heater	sec	3+0.02Od		6.6	7.0	7.5	8.0	8.6	9.3	10.1	11.0
Fusing	Kg/cm <sup>2</sup>			same to forming bead							
Fusing	sec	(3+t)*0.8		11.7	12.7	14.0	15.3	16.9	18.7	20.7	23.0
Cooling	Kg/cm <sup>2</sup>			same to forming bead							
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE							
	-9	sec	0.8	669	743	836	929	1041	1171	1319	1486
	10-22	sec	0.9	753	836	941	1045	1171	1317	1484	1672
	23-	sec	1.2t	836	929	1045	1161	1301	1463	1649	1858