



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- 11	Units	Remark	GAS-1 (ISO - SDR11-MDPE)											
Cylinder area(Ac)	cm ²	37.68												
Spec	mm		225	250	280	315	355	400	450	500	560	630		
Out dia(Od)	mm		225	250	280	315	355	400	450	500	560	630		
Thickness(t)	mm	Od/SDR	20.5	22.7	25.5	28.6	32.3	36.4	40.9	45.5	50.9	57.3		
In dia(ld)	mm	Od-t*2	184.1	204.5	229.1	257.7	290.5	327.3	368.2	409.1	458.2	515.5		
Area(Ar)	cm ²		131.4	162.2	203.5	257.5	327.0	415.2	525.5	648.8	813.8	1030.0		
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	5.2	6.5	8.1	10.3	13.0	16.5	20.9	25.8	32.4	41.0		
Forming bead	sec	Ht*0.2	45.0	50.0	56.0	63.0	71.0	80.0	90.0	100.0	112.0	126.0		
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.3	0.4	0.5	0.7	0.9	1.1	1.4	1.7	2.2	2.7		
Heating(Ht)	sec	11t	225.0	250.0	280.0	315.0	355.0	400.0	450.0	500.0	560.0	630.0		
Remove Heater	sec	3+0.02Od	7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6		
Fusing	Kg/cm ²		same to forming bead											
Fusing	sec	(3+t)*0.8	18.8	20.6	22.8	25.3	28.2	31.5	35.1	38.8	43.1	48.2		
Cooling	Kg/cm ²		same to forming bead											
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE											
-9	sec	0.8	1178	1309	1466	1649	1859	2095	2356	2618	2932	3299		
10-22	sec	0.9	1325	1473	1649	1856	2091	2356	2651	2945	3299	3711		
23-	sec	1.2t	1473	1636	1833	2062	2324	2618	2945	3273	3665	4124		



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SDR- 17.6		Units	Remark	GAS-2 (ISO - SDR17.6-MDPE)									
Cylinder area(Ac)	cm ²		37.68										
Spec	mm			225	250	280	315	355	400	450	500	560	630
Out dia(Od)	mm			225	250	280	315	355	400	450	500	560	630
Thickness(t)	mm	Od/SDR		12.8	14.2	15.9	17.9	20.2	22.7	25.6	28.4	31.8	35.8
In dia(Id)	mm	Od-t*2		199.4	221.6	248.2	279.2	314.7	354.5	398.9	443.2	496.4	558.4
Area(Ar)	cm ²			85.2	105.2	131.9	167.0	212.1	269.2	340.8	420.7	527.7	667.9
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		3.4	4.2	5.3	6.6	8.4	10.7	13.6	16.7	21.0	26.6
Forming bead	sec	Ht*0.2		28.1	31.3	35.0	39.4	44.4	50.0	56.3	62.5	70.0	78.8
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac		0.2	0.3	0.4	0.4	0.6	0.7	0.9	1.1	1.4	1.8
Heating(Ht)	sec	11t		140.6	156.3	175.0	196.9	221.9	250.0	281.3	312.5	350.0	393.8
Remove Heater	sec	3+0.02Od		7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6
Fusing	Kg/cm ²			same to forming bead									
Fusing	sec	(3+t)*0.8		12.6	13.8	15.1	16.7	18.5	20.6	22.9	25.1	27.9	31.0
Cooling	Kg/cm ²			same to forming bead									
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8		736	818	916	1031	1162	1309	1473	1636	1833	2062
10-22	sec	0.9		828	920	1031	1160	1307	1473	1657	1841	2062	2320
23-	sec	1.2t		920	1023	1145	1289	1452	1636	1841	2045	2291	2577



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SDR- 21	Units	Remark	GAS-3 (ISO - SDR21-MDPE)											
Cylinder area(Ac)	cm ²	37.68												
Spec	mm		225	250	280	315	355	400	450	500	560	630		
Out dia(Od)	mm		225	250	280	315	355	400	450	500	560	630		
Thickness(t)	mm	Od/SDR	10.7	11.9	13.3	15.0	16.9	19.0	21.4	23.8	26.7	30.0		
In dia(Id)	mm	Od-t*2	203.6	226.2	253.3	285.0	321.2	361.9	407.1	452.4	506.7	570.0		
Area(Ar)	cm ²		72.1	89.0	111.6	141.3	179.5	227.8	288.4	356.0	446.6	565.2		
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	2.9	3.5	4.4	5.6	7.1	9.1	11.5	14.2	17.8	22.5		
Forming bead	sec	Ht*0.2	23.6	26.2	29.3	33.0	37.2	41.9	47.1	52.4	58.7	66.0		
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.2	0.2	0.3	0.4	0.5	0.6	0.8	0.9	1.2	1.5		
Heating(Ht)	sec	11t	117.9	131.0	146.7	165.0	186.0	209.5	235.7	261.9	293.3	330.0		
Remove Heater	sec	3+0.02Od	7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6		
Fusing	Kg/cm ²		same to forming bead											
Fusing	sec	(3+t)*0.8	11.0	11.9	13.1	14.4	15.9	17.6	19.5	21.4	23.7	26.4		
Cooling	Kg/cm ²		same to forming bead											
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE											
-9	sec	0.8	617	686	768	864	974	1097	1234	1371	1536	1728		
10-22	sec	0.9	694	771	864	972	1095	1234	1389	1543	1728	1944		
23-	sec	1.2t	771	857	960	1080	1217	1371	1543	1714	1920	2160		



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SDR- 11	Units	Remark	WATER-1 (ISO - SDR11-HDPE)											
Cylinder area(Ac)	cm ²	37.68												
Spec	mm		225	250	280	315	355	400	450	500	560	630		
Out dia(Od)	mm		225	250	280	315	355	400	450	500	560	630		
Thickness(t)	mm	Od/SDR	20.5	22.7	25.5	28.6	32.3	36.4	40.9	45.5	50.9	57.3		
In dia(ld)	mm	Od-t*2	184.1	204.5	229.1	257.7	290.5	327.3	368.2	409.1	458.2	515.5		
Area(Ar)	cm ²		131.4	162.2	203.5	257.5	327.0	415.2	525.5	648.8	813.8	1030.0		
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	5.2	6.5	8.1	10.3	13.0	16.5	20.9	25.8	32.4	41.0		
Forming bead	sec	Ht*0.25	61.4	68.2	76.4	85.9	96.8	109.1	122.7	136.4	152.7	171.8		
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.3	0.4	0.5	0.7	0.9	1.1	1.4	1.7	2.2	2.7		
Heating(Ht)	sec	12t	245.5	272.7	305.5	343.6	387.3	436.4	490.9	545.5	610.9	687.3		
Remove Heater	sec	3+0.02Od	7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6		
Fusing	Kg/cm ²		same to forming bead											
Fusing	sec	(3+t)*0.8	18.8	20.6	22.8	25.3	28.2	31.5	35.1	38.8	43.1	48.2		
Cooling	Kg/cm ²		same to forming bead											
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE											
-9	sec	0.8	1178	1309	1466	1649	1859	2095	2356	2618	2932	3299		
10-22	sec	0.9	1325	1473	1649	1856	2091	2356	2651	2945	3299	3711		
23-	sec	1.2t	1473	1636	1833	2062	2324	2618	2945	3273	3665	4124		



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SDR- 13.5		Units	Remark	WATER-2 (ISO - SDR13.5-HDPE)																		
Cylinder area(Ac)	cm ²		37.68																			
Spec	mm			225	250	280	315	355	400	450	500	560	630									
Out dia(Od)	mm			225	250	280	315	355	400	450	500	560	630									
Thickness(t)	mm	Od/SDR		16.7	18.5	20.7	23.3	26.3	29.6	33.3	37.0	41.5	46.7									
In dia(Id)	mm	Od-t*2		191.7	213.0	238.5	268.3	302.4	340.7	383.3	425.9	477.0	536.7									
Area(Ar)	cm ²			109.0	134.6	168.8	213.7	271.4	344.6	436.1	538.4	675.4	854.8									
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		4.3	5.4	6.7	8.5	10.8	13.7	17.4	21.4	26.9	34.0									
Forming bead	sec	Ht*0.25		50.0	55.6	62.2	70.0	78.9	88.9	100.0	111.1	124.4	140.0									
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac		0.3	0.4	0.4	0.6	0.7	0.9	1.2	1.4	1.8	2.3									
Heating(Ht)	sec	12t		200.0	222.2	248.9	280.0	315.6	355.6	400.0	444.4	497.8	560.0									
Remove Heater	sec	3+0.02Od		7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6									
Fusing	Kg/cm ²			same to forming bead																		
Fusing	sec	(3+t)*0.8		15.7	17.2	19.0	21.1	23.4	26.1	29.1	32.0	35.6	39.7									
Cooling	Kg/cm ²			same to forming bead																		
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE																		
-9	sec	0.8		960	1067	1195	1344	1515	1707	1920	2133	2389	2688									
10-22	sec	0.9		1080	1200	1344	1512	1704	1920	2160	2400	2688	3024									
23-	sec	1.2t		1200	1333	1493	1680	1893	2133	2400	2667	2987	3360									



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SDR- 15.5		Units	Remark	WATER-3 (ISO - SDR15.5-HDPE)																
Cylinder area(Ac)	cm ²		37.68																	
Spec	mm			225	250	280	315	355	400	450	500	560	630							
Out dia(Od)	mm			225	250	280	315	355	400	450	500	560	630							
Thickness(t)	mm	Od/SDR		14.5	16.1	18.1	20.3	22.9	25.8	29.0	32.3	36.1	40.6							
In dia(Id)	mm	Od-t*2		196.0	217.7	243.9	274.4	309.2	348.4	391.9	435.5	487.7	548.7							
Area(Ar)	cm ²			95.9	118.4	148.6	188.0	238.8	303.2	383.8	473.8	594.3	752.2							
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		3.8	4.7	5.9	7.5	9.5	12.1	15.3	18.9	23.7	29.9							
Forming bead	sec	Ht*0.25		43.5	48.4	54.2	61.0	68.7	77.4	87.1	96.8	108.4	121.9							
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac		0.3	0.3	0.4	0.5	0.6	0.8	1.0	1.3	1.6	2.0							
Heating(Ht)	sec	12t		174.2	193.5	216.8	243.9	274.8	309.7	348.4	387.1	433.5	487.7							
Remove Heater	sec	3+0.02Od		7.5	8.0	8.6	9.3	10.1	11.0	12.0	13.0	14.2	15.6							
Fusing	Kg/cm ²			same to forming bead																
Fusing	sec	(3+t)*0.8		14.0	15.3	16.9	18.7	20.7	23.0	25.6	28.2	31.3	34.9							
Cooling	Kg/cm ²			same to forming bead																
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE																
-9	sec	0.8		836	929	1041	1171	1319	1486	1672	1858	2081	2341							
10-22	sec	0.9		941	1045	1171	1317	1484	1672	1881	2090	2341	2634							
23-	sec	1.2t		1045	1161	1301	1463	1649	1858	2090	2323	2601	2926							