



## Saemin Electronics Industries Corp.

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

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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 (JIS - SDR11-MDPE)						
Cylinder area(Ac)	cm <sup>2</sup>	7.22							
Spec	mm		75	100	125	150	200	250	300
Out dia(Od)	mm		89	114	140	165	216	267	318
Thickness(t)	mm	Od/SDR	8.1	10.4	12.7	15.0	19.6	24.3	28.9
In dia(Id)	mm	Od-t*2	72.8	93.3	114.5	135.0	176.7	218.5	260.2
Area(Ar)	cm <sup>2</sup>		20.6	33.7	50.9	70.7	121.1	185.0	262.4
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	4.3	7.0	10.6	14.7	25.2	38.4	54.5
Forming bead	sec	Ht*0.2	17.8	22.8	28.0	33.0	43.2	53.4	63.6
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.3	0.5	0.7	1.0	1.7	2.6	3.6
Heating(Ht)	sec	11t	89.0	114.0	140.0	165.0	216.0	267.0	318.0
Remove Heater	sec	3+0.02Od	4.8	5.3	5.8	6.3	7.3	8.3	9.4
Fusing	Kg/cm <sup>2</sup>		same to forming bead						
Fusing	sec	(3+t)*0.8	8.9	10.7	12.6	14.4	18.1	21.8	25.5
Cooling	Kg/cm <sup>2</sup>		same to forming bead						
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE						
-9	sec	0.8	466	597	733	864	1131	1398	1665
10-22	sec	0.9	524	672	825	972	1272	1573	1873
23-	sec	1.2t	583	746	916	1080	1414	1748	2081



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SDR- 17	Units	Remark	GAS-2 (JIS - SDR17-MDPE)						
Cylinder area(Ac)	cm <sup>2</sup>	7.22							
Spec	mm		75	100	125	150	200	250	300
Out dia(Od)	mm		89	114	140	165	216	267	318
Thickness(t)	mm	Od/SDR	5.2	6.7	8.2	9.7	12.7	15.7	18.7
In dia(Id)	mm	Od-t*2	78.5	100.6	123.5	145.6	190.6	235.6	280.6
Area(Ar)	cm <sup>2</sup>		13.8	22.6	34.1	47.3	81.1	123.9	175.8
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	2.9	4.7	7.1	9.8	16.9	25.7	36.5
Forming bead	sec	Ht*0.2	11.5	14.8	18.1	21.4	28.0	34.6	41.2
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.2	0.3	0.5	0.7	1.1	1.7	2.4
Heating(Ht)	sec	11t	57.6	73.8	90.6	106.8	139.8	172.8	205.8
Remove Heater	sec	3+0.02Od	4.8	5.3	5.8	6.3	7.3	8.3	9.4
Fusing	Kg/cm <sup>2</sup>		same to forming bead						
Fusing	sec	(3+t)*0.8	6.6	7.8	9.0	10.2	12.6	15.0	17.4
Cooling	Kg/cm <sup>2</sup>		same to forming bead						
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE						
-9	sec	0.8	302	386	474	559	732	905	1077
10-22	sec	0.9	339	435	534	629	823	1018	1212
23-	sec	1.2t	377	483	593	699	915	1131	1347



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SDR- 11	Units	Remark	WATER-1 (JIS - SDR11-HDPE)						
Cylinder area(Ac)	cm <sup>2</sup>	7.22							
Spec	mm		75	100	125	150	200	250	300
Out dia(Od)	mm		89	114	140	165	216	267	318
Thickness(t)	mm	Od/SDR	8.1	10.4	12.7	15.0	19.6	24.3	28.9
In dia(Id)	mm	Od-t*2	72.8	93.3	114.5	135.0	176.7	218.5	260.2
Area(Ar)	cm <sup>2</sup>		20.6	33.7	50.9	70.7	121.1	185.0	262.4
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	4.3	7.0	10.6	14.7	25.2	38.4	54.5
Forming bead	sec	Ht*0.25	24.3	31.1	38.2	45.0	58.9	72.8	86.7
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.3	0.5	0.7	1.0	1.7	2.6	3.6
Heating(Ht)	sec	12t	97.1	124.4	152.7	180.0	235.6	291.3	346.9
Remove Heater	sec	3+0.02Od	4.8	5.3	5.8	6.3	7.3	8.3	9.4
Fusing	Kg/cm <sup>2</sup>		same to forming bead						
Fusing	sec	(3+t)*0.8	8.9	10.7	12.6	14.4	18.1	21.8	25.5
Cooling	Kg/cm <sup>2</sup>		same to forming bead						
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE						
-9	sec	0.8	466	597	733	864	1131	1398	1665
10-22	sec	0.9	524	672	825	972	1272	1573	1873
23-	sec	1.2t	583	746	916	1080	1414	1748	2081



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SDR- 13.5			WATER-2 (JIS - SDR13.5-HDPE)						
Cylinder area(Ac)	Units	Remark							
	cm <sup>2</sup>	7.22							
Spec	mm		75	100	125	150	200	250	300
Out dia(Od)	mm		89	114	140	165	216	267	318
Thickness(t)	mm	Od/SDR	6.6	8.4	10.4	12.2	16.0	19.8	23.6
In dia(Id)	mm	Od-t*2	75.8	97.1	119.3	140.6	184.0	227.4	270.9
Area(Ar)	cm <sup>2</sup>		17.1	28.0	42.2	58.6	100.5	153.5	217.8
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	3.5	5.8	8.8	12.2	20.9	31.9	45.2
Forming bead	sec	Ht*0.25	19.8	25.3	31.1	36.7	48.0	59.3	70.7
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.2	0.4	0.6	0.8	1.4	2.1	3.0
Heating(Ht)	sec	12t	79.1	101.3	124.4	146.7	192.0	237.3	282.7
Remove Heater	sec	3+0.02Od	4.8	5.3	5.8	6.3	7.3	8.3	9.4
Fusing	Kg/cm <sup>2</sup>		same to forming bead						
Fusing	sec	(3+t)*0.8	7.7	9.2	10.7	12.2	15.2	18.2	21.2
Cooling	Kg/cm <sup>2</sup>		same to forming bead						
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE						
-9	sec	0.8	380	486	597	704	922	1139	1357
10-22	sec	0.9	427	547	672	792	1037	1282	1526
23-	sec	1.2t	475	608	747	880	1152	1424	1696



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SDR- 15.5			WATER-3 (JIS - SDR15.5-HDPE)						
Cylinder area(Ac)	Units	Remark							
	cm <sup>2</sup>	7.22							
Spec	mm		75	100	125	150	200	250	300
Out dia(Od)	mm		89	114	140	165	216	267	318
Thickness(t)	mm	Od/SDR	5.7	7.4	9.0	10.6	13.9	17.2	20.5
In dia(Id)	mm	Od-t*2	77.5	99.3	121.9	143.7	188.1	232.5	277.0
Area(Ar)	cm <sup>2</sup>		15.0	24.6	37.1	51.6	88.4	135.1	191.6
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	3.1	5.1	7.7	10.7	18.4	28.1	39.8
Forming bead	sec	Ht*0.25	17.2	22.1	27.1	31.9	41.8	51.7	61.5
Heating(Hp)	Kg/cm <sup>2</sup>	Ar*0.1/Ac	0.2	0.3	0.5	0.7	1.2	1.9	2.7
Heating(Ht)	sec	12t	68.9	88.3	108.4	127.7	167.2	206.7	246.2
Remove Heater	sec	3+0.02Od	4.8	5.3	5.8	6.3	7.3	8.3	9.4
Fusing	Kg/cm <sup>2</sup>		same to forming bead						
Fusing	sec	(3+t)*0.8	7.0	8.3	9.6	10.9	13.5	16.2	18.8
Cooling	Kg/cm <sup>2</sup>		same to forming bead						
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE						
-9	sec	0.8	331	424	520	613	803	992	1182
10-22	sec	0.9	372	477	585	690	903	1116	1329
23-	sec	1.2t	413	530	650	766	1003	1240	1477