

- - - 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- 11			GAS-1 (JIS - SDR11-MDPE)				
Cylinder area(Ac)	Units	Remark					
	cm ²	10.99					
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	16.5	25.2	35.8	48.5	62.5
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	1.1	1.7	2.4	3.2	4.2
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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SDR- 17			GAS-2 (JIS - SDR17-MDPE)				
Cylinder area(Ac)	Units	Remark					
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	11.1	16.9	24.0	32.5	41.9
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	0.7	1.1	1.6	2.2	2.8
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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SDR- 11			WATER-1 (JIS - SDR11-HDPE)				
Cylinder area(Ac)	Units	Remark					
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	16.5	25.2	35.8	48.5	62.5
Forming bead	sec	Ht*0.25	58.9	72.8	86.7	100.9	114.5
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	1.1	1.7	2.4	3.2	4.2
Heating(Ht)	sec	12t	235.6	291.3	346.9	403.6	458.2
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	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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SDR- 13.5			WATER-2 (JIS - SDR13.5-HDPE)				
Cylinder area(Ac)	Units	Remark					
Spec	mm		200	250	300	350	400
Out dia(Od)	mm		216	267	318	370	420
Thickness(t)	mm	Od/SDR	16.0	19.8	23.6	27.4	31.1
In dia(Id)	mm	Od-t*2	184.0	227.4	270.9	315.2	357.8
Area(Ar)	cm ²		100.5	153.5	217.8	294.8	379.9
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	13.7	21.0	29.7	40.2	51.9
Forming bead	sec	Ht*0.25	48.0	59.3	70.7	82.2	93.3
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.9	1.4	2.0	2.7	3.5
Heating(Ht)	sec	12t	192.0	237.3	282.7	328.9	373.3
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	15.2	18.2	21.2	24.3	27.3
Cooling	Kg/cm ²		same to forming bead				
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE				
-9	sec	0.8	922	1139	1357	1579	1792
10-22	sec	0.9	1037	1282	1526	1776	2016
23-	sec	1.2t	1152	1424	1696	1973	2240

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SDR- 15.5			WATER-3 (JIS - SDR15.5-HDPE)				
Cylinder area(Ac)	Units	Remark					
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	12.1	18.4	26.2	35.4	45.6
Forming bead	sec	Ht*0.25	41.8	51.7	61.5	71.6	81.3
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.8	1.2	1.7	2.4	3.0
Heating(Ht)	sec	12t	167.2	206.7	246.2	286.5	325.2
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	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