



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 (JIS - SDR11-MDPE)								
Cylinder area(Ac)	cm ²	37.68									
Spec	mm		200	250	300	350	400	450	500	550	600
Out dia(Od)	mm		216	267	318	370	420	457.2	508	558.8	609.6
Thickness(t)	mm	Od/SDR	19.6	24.3	28.9	33.6	38.2	41.6	46.2	50.8	55.4
In dia(Id)	mm	Od-t*2	176.7	218.5	260.2	302.7	343.6	374.1	415.6	457.2	498.8
Area(Ar)	cm ²		121.1	185.0	262.4	355.3	457.8	542.4	669.7	810.3	964.3
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	4.8	7.4	10.4	14.1	18.2	21.6	26.7	32.3	38.4
Forming bead	sec	Ht*0.2	43.2	53.4	63.6	74.0	84.0	91.4	101.6	111.8	121.9
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.3	0.5	0.7	0.9	1.2	1.4	1.8	2.2	2.6
Heating(Ht)	sec	11t	216.0	267.0	318.0	370.0	420.0	457.2	508.0	558.8	609.6
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2
Fusing	Kg/cm ²		same to forming bead								
Fusing	sec	(3+t)*0.8	18.1	21.8	25.5	29.3	32.9	35.7	39.3	43.0	46.7
Cooling	Kg/cm ²		same to forming bead								
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE								
-9	sec	0.8	1131	1398	1665	1937	2199	2394	2660	2926	3192
10-22	sec	0.9	1272	1573	1873	2180	2474	2693	2993	3292	3591
23-	sec	1.2t	1414	1748	2081	2422	2749	2993	3325	3658	3990



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SDR- 17	Units	Remark	GAS-2 (JIS - SDR17-MDPE)								
Cylinder area(Ac)	cm ²	37.68									
Spec	mm		200	250	300	350	400	450	500	550	600
Out dia(Od)	mm		216	267	318	370	420	457.2	508	558.8	609.6
Thickness(t)	mm	Od/SDR	12.7	15.7	18.7	21.8	24.7	26.9	29.9	32.9	35.9
In dia(Id)	mm	Od-t*2	190.6	235.6	280.6	326.5	370.6	403.4	448.2	493.1	537.9
Area(Ar)	cm ²		81.1	123.9	175.8	238.0	306.7	363.4	448.6	542.8	646.0
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	3.2	4.9	7.0	9.5	12.2	14.5	17.9	21.6	25.7
Forming bead	sec	Ht*0.2	28.0	34.6	41.2	47.9	54.4	59.2	65.7	72.3	78.9
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.2	0.3	0.5	0.6	0.8	1.0	1.2	1.4	1.7
Heating(Ht)	sec	11t	139.8	172.8	205.8	239.4	271.8	295.8	328.7	361.6	394.4
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2
Fusing	Kg/cm ²		same to forming bead								
Fusing	sec	(3+t)*0.8	12.6	15.0	17.4	19.8	22.2	23.9	26.3	28.7	31.1
Cooling	Kg/cm ²		same to forming bead								
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE								
-9	sec	0.8	732	905	1077	1254	1423	1549	1721	1893	2065
10-22	sec	0.9	823	1018	1212	1410	1601	1743	1936	2130	2324
23-	sec	1.2t	915	1131	1347	1567	1779	1936	2152	2367	2582



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SDR- 11	Units	Remark	WATER-1 (JIS - SDR11-HDPE)								
Cylinder area(Ac)	cm ²	37.68									
Spec	mm		200	250	300	350	400	450	500	550	600
Out dia(Od)	mm		216	267	318	370	420	457.2	508	558.8	609.6
Thickness(t)	mm	Od/SDR	19.6	24.3	28.9	33.6	38.2	41.6	46.2	50.8	55.4
In dia(Id)	mm	Od-t*2	176.7	218.5	260.2	302.7	343.6	374.1	415.6	457.2	498.8
Area(Ar)	cm ²		121.1	185.0	262.4	355.3	457.8	542.4	669.7	810.3	964.3
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	4.8	7.4	10.4	14.1	18.2	21.6	26.7	32.3	38.4
Forming bead	sec	Ht*0.25	58.9	72.8	86.7	100.9	114.5	124.7	138.5	152.4	166.3
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.3	0.5	0.7	0.9	1.2	1.4	1.8	2.2	2.6
Heating(Ht)	sec	12t	235.6	291.3	346.9	403.6	458.2	498.8	554.2	609.6	665.0
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2
Fusing	Kg/cm ²		same to forming bead								
Fusing	sec	(3+t)*0.8	18.1	21.8	25.5	29.3	32.9	35.7	39.3	43.0	46.7
Cooling	Kg/cm ²		same to forming bead								
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE								
-9	sec	0.8	1131	1398	1665	1937	2199	2394	2660	2926	3192
10-22	sec	0.9	1272	1573	1873	2180	2474	2693	2993	3292	3591
23-	sec	1.2t	1414	1748	2081	2422	2749	2993	3325	3658	3990



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SDR- 13.5		Units	Remark	WATER-2 (JIS - SDR13.5-HDPE)									
Cylinder area(Ac)	cm ²		37.68										
Spec	mm			200	250	300	350	400	450	500	550	600	
Out dia(Od)	mm			216	267	318	370	420	457.2	508	558.8	609.6	
Thickness(t)	mm	Od/SDR		16.0	19.8	23.6	27.4	31.1	33.9	37.6	41.4	45.2	
In dia(Id)	mm	Od-t*2		184.0	227.4	270.9	315.2	357.8	389.5	432.7	476.0	519.3	
Area(Ar)	cm ²			100.5	153.5	217.8	294.8	379.9	450.2	555.8	672.5	800.3	
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		4.0	6.1	8.7	11.7	15.1	17.9	22.1	26.8	31.9	
Forming bead	sec	Ht*0.25		48.0	59.3	70.7	82.2	93.3	101.6	112.9	124.2	135.5	
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac		0.3	0.4	0.6	0.8	1.0	1.2	1.5	1.8	2.1	
Heating(Ht)	sec	12t		192.0	237.3	282.7	328.9	373.3	406.4	451.6	496.7	541.9	
Remove Heater	sec	3+0.02Od		7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2	
Fusing	Kg/cm ²			same to forming bead									
Fusing	sec	(3+t)*0.8		15.2	18.2	21.2	24.3	27.3	29.5	32.5	35.5	38.5	
Cooling	Kg/cm ²			same to forming bead									
Cooling Time				10MINUTE <= COOLING TIME <= 35MINUTE									
-9	sec	0.8		922	1139	1357	1579	1792	1951	2167	2384	2601	
10-22	sec	0.9		1037	1282	1526	1776	2016	2195	2438	2682	2926	
23-	sec	1.2t		1152	1424	1696	1973	2240	2438	2709	2980	3251	



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SDR- 15.5			WATER-3 (JIS - SDR15.5-HDPE)								
Units	Remark										
Cylinder area(Ac)	cm ²	37.68									
Spec	mm		200	250	300	350	400	450	500	550	600
Out dia(Od)	mm		216	267	318	370	420	457.2	508	558.8	609.6
Thickness(t)	mm	Od/SDR	13.9	17.2	20.5	23.9	27.1	29.5	32.8	36.1	39.3
In dia(Id)	mm	Od-t*2	188.1	232.5	277.0	322.3	365.8	398.2	442.5	486.7	530.9
Area(Ar)	cm ²		88.4	135.1	191.6	259.4	334.3	396.1	489.1	591.8	704.2
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	3.5	5.4	7.6	10.3	13.3	15.8	19.5	23.6	28.0
Forming bead	sec	Ht*0.25	41.8	51.7	61.5	71.6	81.3	88.5	98.3	108.2	118.0
Heating(Hp)	Kg/cm ²	Ar*0.1/Ac	0.2	0.4	0.5	0.7	0.9	1.1	1.3	1.6	1.9
Heating(Ht)	sec	12t	167.2	206.7	246.2	286.5	325.2	354.0	393.3	432.6	471.9
Remove Heater	sec	3+0.02Od	7.3	8.3	9.4	10.4	11.4	12.1	13.2	14.2	15.2
Fusing	Kg/cm ²		same to forming bead								
Fusing	sec	(3+t)*0.8	13.5	16.2	18.8	21.5	24.1	26.0	28.6	31.2	33.9
Cooling	Kg/cm ²		same to forming bead								
Cooling Time			10MINUTE <= COOLING TIME <= 35MINUTE								
-9	sec	0.8	803	992	1182	1375	1561	1699	1888	2077	2265
10-22	sec	0.9	903	1116	1329	1547	1756	1911	2124	2336	2549
23-	sec	1.2t	1003	1240	1477	1719	1951	2124	2360	2596	2832