

Table for PE / zoll



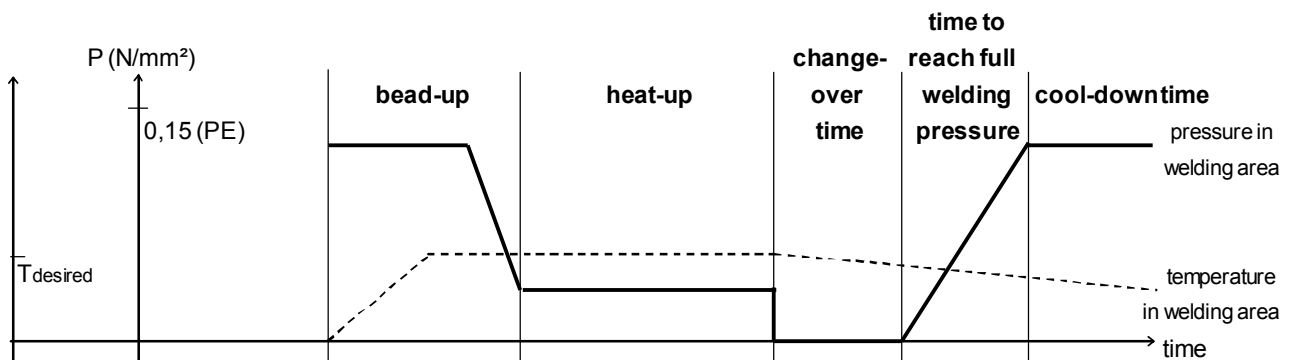
Foundation: 2207, 2208 DIN 16932 German association for welding

Use for: **Miniplast 2 / 110** OD 20 - 110
Maxiplast / 501 / 900 / 955 OD 50 - 160
Instaweld 160 OD 50 - 160
2000 / 3000 Kombi OD 50 - 250
2500 DO 160 / 250 / 315 OD 50 - 315

PE 80 The value for heating element temperature is between 200° C - 220° C.
 The **smaller** the pipe wall the **higher** the temperature.

PE 100 The standard value for heating element temperature is 220° C.
 Increase the change-over time and the welding pressure time at PE 100 as fast as possible !

Additional to the given bead-up force and to the welding force the moving force of the support must be added !
 1 kp = 10 N



pipe diameter OD [mm]	pipe wall (s) [mm]	SDR	bead-up force [kp] [daN]	circular bead min. [mm]	heat-up time [s]	max. change-over time [s]	time to reach welding pressure [s]	welding force [kp] [daN]	cool-down time [min] ^①
26,7	5,0		6	1,0	50	5	5	6	7
33,4	5,0		7	1,0	50	5	5	7	7
60,3	5,5		15	1,0	55	5	5	15	8
88,9	8,1		31	1,5	81	6	6	31	11
114,3	10,4		51	1,5	104	7	7	51	14
168,3	15,3		111	2,0	153	9	9	111	34
219,1	19,9		187	2,5	199	10	11	187	25
273,1	24,8		291	2,5	248	12	13	291	31

① Remaining under the cool-down time for up to 50% is allowed under the following conditions:

- prefabrication under workshop conditions
- low additional pressure at unclamping
- no additional pressure during further cooling down
- load onto the workpieces only after being completely cooled down