

Table for PVDF

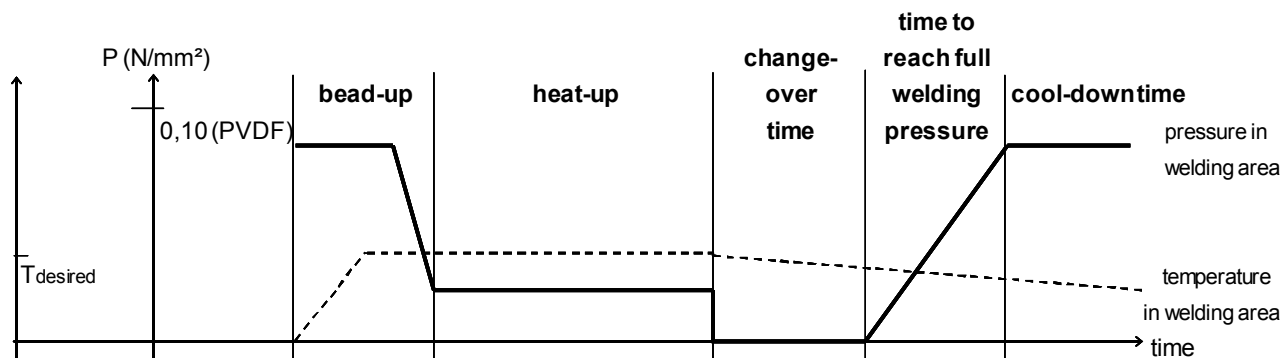


Foundation: 2208, 2207 Part 15 German association for welding
 Use for: **4002 (with 2. cylinder)**

1 bar on manometer: **36 N**

The standard value for heating element temperature is 240° C +/- 8° C.
 The **smaller** the pipe wall the **higher** the temperature.

Additional to the given bead-up force and to the welding force the moving force of the support must be added !



The following pressure values are only valid if the 2. cylinder is used.

pipe diameter OD [mm]	pipe wall (s) [mm]	bead-up pressure [bar]	circular bead min. [mm]	heat-up time [s]	max. change-over time [s]	time to reach welding pressure [s]	welding pressure [bar]	cool-down time [min]
140	4,3	6	0,5	83	3	4	6	7,0
	6,7	8	0,6	107	4	6	8	10,0
160	4,9	7	0,5	89	3	5	7	8,0
	7,7	11	0,7	117	4	6	11	11,0
180	5,5	9	0,5	95	4	5	9	8,5
	8,6	13	0,8	126	4	6	13	12,5
200	6,2	11	0,6	102	4	5	11	9,5
	9,6	16	1,0	136	4	7	16	13,5
225	6,9	14	0,7	109	4	6	14	10,5
	10,8	21	1,0	148	4	7	21	15,0
250	7,7	17	0,7	117	4	6	17	11,0
	11,9	25	1,1	159	4	8	25	16,5
280	8,6	21	0,8	126	4	6	21	12,5
315	9,7	26	1,0	137	4	7	26	13,5