

# Table for PE



Basis: DVS data sheets 2207, 2208 - State 2016

Field of application: **HRG 8 / HRG 10 / HRG 12 / HRG 14 / HRG 16**

1 bar on pressure gauge: **463** N (Effective surface of cylinder: 4626 mm<sup>2</sup> / 7,17 inch<sup>2</sup>)

The heating element temperature is 220° C ± 10° C / 428° F ± 18° F.

The change-over time should be kept as low as possible.

The joining pressure build-up time should be recognized as maximum value and may be underrun by up to 50%.

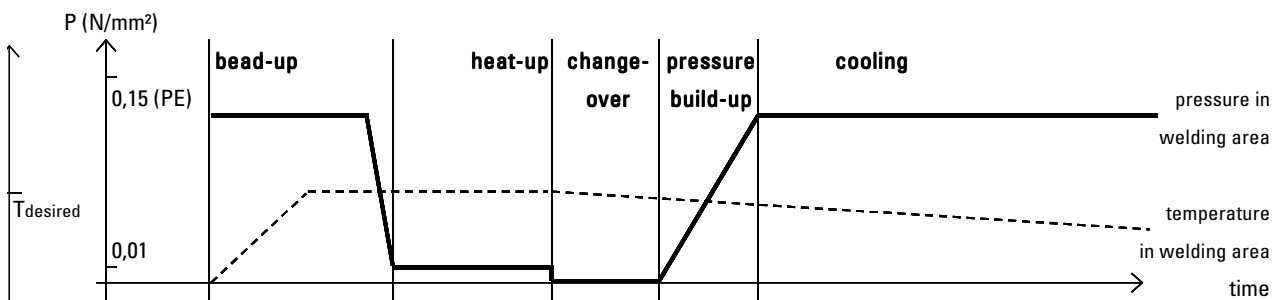
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All information without guarantee



pipe (s) (s) [mm]	SDR degree	bead-up pressure [bar]	circular bead height min. [mm]	heat-up time [min:s]	max. change- over time [s]	pressure build-up time [s]	welding pressure [bar]	cooling time for ambient temperature			special cooling time ① [min:s]
								< 15°C < 59°F	15-25°C 59-77°F	> 25°C > 77°F	
<b>DA 500</b>											
12,3	41	7	2	02:03	8	8	7	09:42	12:15	15:52	08:10
15,3	33	8	2	02:33	9	9	8	11:37	14:50	19:30	09:53
19,1	26	10	2,5	03:11	10	11	10	14:04	18:05	24:07	12:03
28,4	17,6	14	3	04:44	13	15	14	20:45	26:11	34:50	17:32
29,7	17	15	3	04:57	13	16	15	21:41	27:22	36:22	18:21
45,4	11	22	3,5	07:34	19	23	22	32:49	41:45	55:20	28:10
56,0	9	26	4	09:20	21	28	26	40:12	51:24	68:12	34:36
68,3	7,4	31	4	11:23	25	34	31	48:49	62:28	82:58	41:59
<b>DA 560</b>											
13,7	41	8	2	02:17	8	9	8	10:36	13:27	17:34	08:58
17,2	33	10	2	02:52	9	10	10	12:51	16:27	21:49	10:58
21,4	26	12	2,5	03:34	11	12	12	15:43	20:03	26:45	13:22
31,7	17,6	18	3	05:17	14	17	18	23:09	29:11	38:44	19:38
33,2	17	18	3	05:32	15	17	18	24:14	30:33	40:31	20:35
50,8	11	27	4	08:28	20	25	27	36:34	46:43	61:58	31:29
62,5	9	32	4	10:25	23	31	32	44:45	57:15	76:00	38:30
75,8	7,4	38	4,5	12:38	26	35	38	54:04	69:13	91:58	46:29

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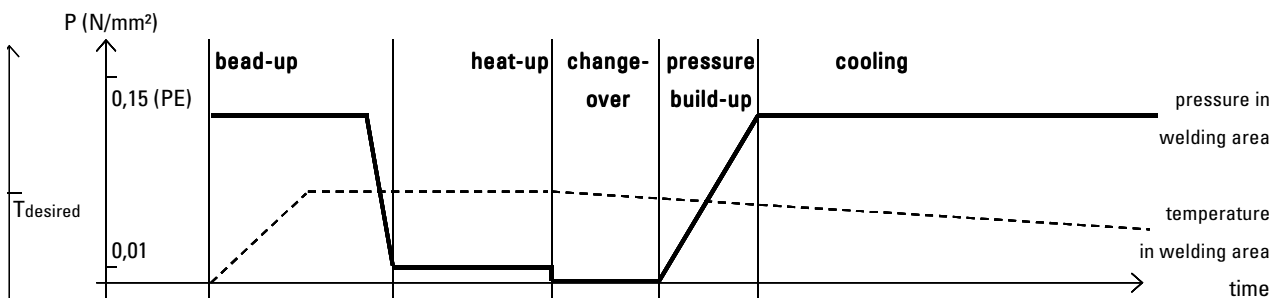
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								< 15°C < 59°F	15-25°C 59-77°F	> 25°C > 77°F	
<b>DA 630</b>											
15,4	41	10	2	02:34	9	9	10	11:41	14:55	19:38	09:57
19,3	33	12	2,5	03:13	10	11	12	14:13	18:15	24:21	12:10
24,1	26	15	2,5	04:01	11	13	15	17:39	22:22	29:50	14:55
35,7	17,6	22	3	05:57	16	18	22	26:03	32:49	43:28	22:10
37,4	17	23	3,5	06:14	16	19	23	27:17	34:22	45:30	23:15
57,2	11	34	4	09:32	22	29	34	41:02	52:29	69:38	35:19
62,5	9	37	4	10:25	23	31	37	44:45	57:15	76:00	38:30
85,1	7,4	48	4,5	14:11	29	35	48	60:34	77:35	103:07	52:04
<b>DA 710</b>											
17,4	41	13	2	02:54	10	10	13	12:58	16:38	22:03	11:05
21,8	33	16	2,5	03:38	11	12	16	16:00	20:24	27:12	13:36
27,2	26	19	3	04:32	12	15	19	19:52	25:05	33:25	16:46
40,2	17,6	28	3,5	06:42	17	20	28	29:13	36:57	48:56	24:58
42,1	17	29	3,5	07:01	18	21	29	30:32	38:42	51:17	26:08
64,5	11	43	4	10:45	24	32	43	46:09	59:03	78:24	39:42
78,9	9	51	4,5	13:09	27	35	51	56:14	72:01	95:41	48:20
95,9	7,4	60	5	15:59	31	35	60	68:08	87:19	116:05	58:32

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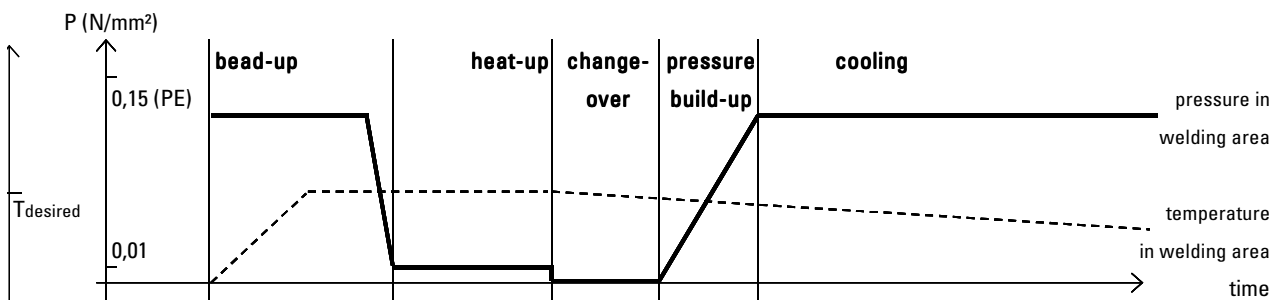
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								< 15°C < 59°F	15-25°C 59-77°F	> 25°C > 77°F	
<b>DA 800</b>											
19,6	41	16	2,5	03:16	10	11	16	14:26	18:31	24:41	12:21
24,5	33	20	2,5	04:05	12	13	20	17:56	22:43	30:17	15:09
30,6	26	24	3	05:06	14	16	24	22:21	28:11	37:26	18:56
45,3	17,6	35	3,5	07:33	19	23	35	32:45	41:40	55:13	28:06
47,4	17	37	3,5	07:54	19	24	37	34:12	43:36	57:48	29:24
72,7	11	54	4,5	12:07	26	35	54	51:53	66:26	88:14	44:37
88,9	9	65	4,5	14:49	30	35	65	63:14	81:01	107:41	54:20
108,1	7,4	77	5	18:01	35	35	77	76:40	98:17	130:43	65:52
<b>DA 900</b>											
22,0	41	20	2,5	03:40	11	12	20	16:09	20:34	27:26	13:43
27,6	33	25	3	04:36	13	15	25	20:10	25:27	33:53	17:01
34,4	26	31	3	05:44	15	18	31	25:07	31:38	41:56	21:21
51,0	17,6	45	4	08:30	20	26	45	36:42	46:54	62:12	31:36
53,3	17	46	4	08:53	21	27	46	38:19	48:58	64:58	32:59
81,8	11	69	4,5	13:38	28	35	69	58:16	74:37	99:10	50:05
100,0	9	82	5	16:40	32	35	82	71:00	91:00	121:00	61:00
121,6	7,4	97	5,5	20:16	35	35	97	86:07	110:26	146:55	73:58

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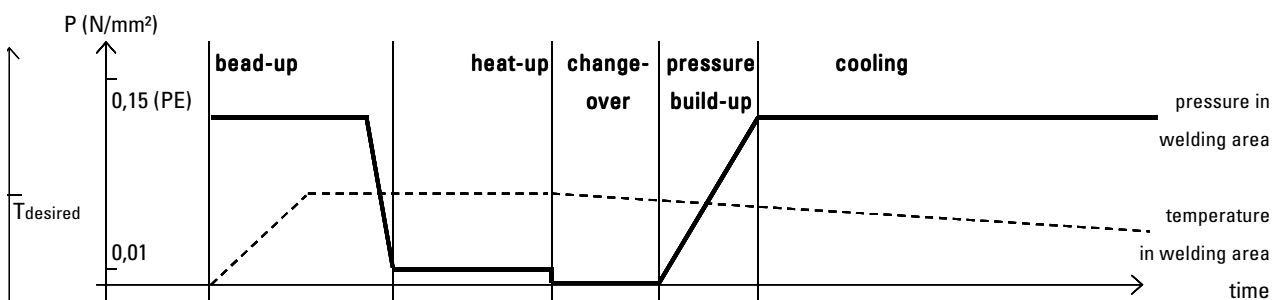
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								< 15°C < 59°F	15-25°C 59-77°F	> 25°C > 77°F	
<b>DA 1000</b>											
24,5	41	25	2,5	04:05	12	13	25	17:56	22:43	30:17	15:09
30,6	33	31	3	05:06	14	16	31	22:21	28:11	37:26	18:56
38,2	26	38	3,5	06:22	16	20	38	27:50	35:06	46:29	23:44
56,7	17,6	55	4	09:27	22	28	55	40:41	52:02	69:02	35:01
59,3	17	57	4	09:53	22	30	57	42:31	54:22	72:10	36:35
90,9	11	85	5	15:09	30	35	85	64:38	82:49	110:05	55:32
111,1	9	101	5,5	18:31	35	35	101	78:46	100:59	134:19	67:40
135,1	7,4	119	6	22:31	35	35	119	95:34	122:35	163:07	82:04
<b>DA 1200</b>											
29,4	41	36	3	04:54	13	16	36	21:28	27:05	36:01	18:10
36,7	33	44	3	06:07	16	19	44	26:47	33:44	44:39	22:49
45,9	26	54	3,5	07:39	19	23	54	33:10	42:13	55:57	28:29
68,0	17,6	79	4	11:20	24	34	79	48:36	62:12	82:36	41:48
70,6	17	82	4,5	11:46	25	35	82	50:25	64:32	85:43	43:22
109,1	11	122	5	18:11	35	35	122	77:22	99:11	131:55	66:28
133,3	9	145	6	22:13	35	35	145	94:19	120:58	160:58	80:59
162,2	7,4	172	6,5	27:02	35	35	172	114:32	146:59	195:38	98:19

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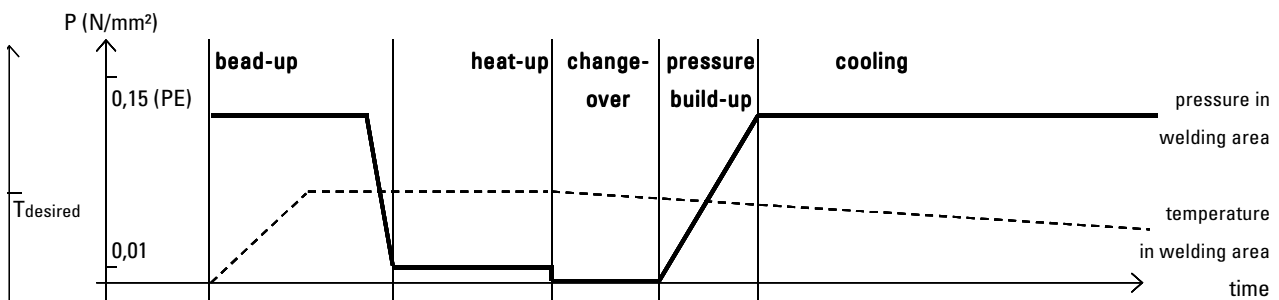
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								< 15°C < 59°F	15-25°C 59-77°F	> 25°C > 77°F	
<b>DA 1400</b>											
29,4	41	42	3	04:54	13	16	42	21:28	27:05	36:01	18:10
36,7	33	51	3	06:07	16	19	51	26:47	33:44	44:39	22:49
45,9	26	64	3,5	07:39	19	23	64	33:10	42:13	55:57	28:29
68,0	17,6	93	4	11:20	24	34	93	48:36	62:12	82:36	41:48
70,6	17	96	4,5	11:46	25	35	96	50:25	64:32	85:43	43:22
109,1	11	144	5	18:11	35	35	144	77:22	99:11	131:55	66:28
133,3	9	172	6	22:13	35	35	172	94:19	120:58	160:58	80:59
162,2	7,4	205	6,5	27:02	35	35	205	114:32	146:59	195:38	98:19
<b>DA 1600</b>											
29,4	41	47	3	04:54	13	16	47	21:28	27:05	36:01	18:10
36,7	33	59	3	06:07	16	19	59	26:47	33:44	44:39	22:49
45,9	26	73	3,5	07:39	19	23	73	33:10	42:13	55:57	28:29
68,0	17,6	107	4	11:20	24	34	107	48:36	62:12	82:36	41:48
70,6	17	110	4,5	11:46	25	35	110	50:25	64:32	85:43	43:22
109,1	11	166	5	18:11	35	35	166	77:22	99:11	131:55	66:28
133,3	9	199	6	22:13	35	35	199	94:19	120:58	160:58	80:59
162,2	7,4	238	6,5	27:02	35	35	238	114:32	146:59	195:38	98:19