

Table for PP



Basis: DVS data sheets 2207, 2208 - State 2017

Field of application: **16000**

1 bar on manometer: **463** N (Effective surface of cylinder: 4626 mm² / 7,17 inch²)

The heating element temperature is 210° C ± 10° C / 410° 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%.

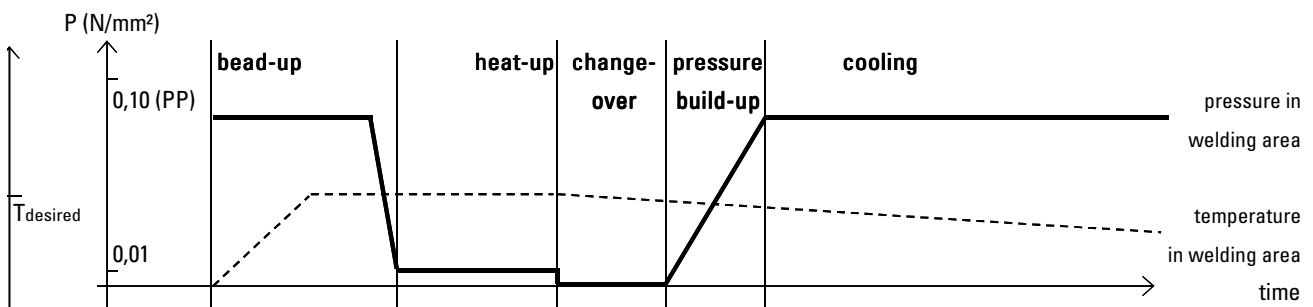
You must add the motion pressure of the welding machine to the indicated bead-up and welding pressure in each case!

The maximum pressure of the welding machine is to be observed.

1 These cooling times are only valid under the following conditions:

- Welding connection is produced under workshop conditions
- Removal from the welding machine and temporary storage until complete cooling time elapses only cause minor strain for the welding connection

All information without guarantee



| pipe wall (s) | 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 [min:s] | 15-25°C 59-77°F [min:s] | > 25°C > 77°F [min:s] | |
| DA 1000 | | | | | | | | | | | |
| 24,5 | 41 | 17 | 2,5 | 04:05 | 12 | 13 | 17 | 17:56 | 22:43 | 30:17 | 15:09 |
| 30,6 | 33 | 21 | 3 | 05:06 | 14 | 16 | 21 | 22:21 | 28:11 | 37:26 | 18:56 |
| 38,2 | 26 | 25 | 3,5 | 06:22 | 16 | 20 | 25 | 27:50 | 35:06 | 46:29 | 23:44 |
| DA 1200 | | | | | | | | | | | |
| 29,4 | 41 | 24 | 3 | 04:54 | 13 | 16 | 24 | 21:28 | 27:05 | 36:01 | 18:10 |
| 36,7 | 33 | 29 | 3 | 06:07 | 16 | 19 | 29 | 26:47 | 33:44 | 44:39 | 22:49 |
| 45,9 | 26 | 36 | 3,5 | 07:39 | 19 | 23 | 36 | 33:10 | 42:13 | 55:57 | 28:29 |
| DA 1400 | | | | | | | | | | | |
| 34,3 | 41 | 32 | 3 | 05:43 | 15 | 18 | 32 | 25:02 | 31:33 | 41:49 | 21:17 |
| 42,9 | 33 | 40 | 3,5 | 07:09 | 18 | 22 | 40 | 31:05 | 39:27 | 52:16 | 26:38 |
| 53,5 | 26 | 49 | 4 | 08:55 | 21 | 27 | 49 | 38:27 | 49:09 | 65:12 | 33:06 |
| DA 1600 | | | | | | | | | | | |
| 39,2 | 41 | 42 | 3,5 | 06:32 | 17 | 20 | 42 | 28:31 | 36:02 | 47:42 | 24:21 |
| 49,0 | 33 | 52 | 3,5 | 08:10 | 20 | 25 | 52 | 35:18 | 45:05 | 59:46 | 30:23 |
| 61,2 | 26 | 64 | 4 | 10:12 | 23 | 31 | 64 | 43:50 | 56:05 | 74:26 | 37:43 |