

# Table for PP



Basis: DVS data sheets 2207, 2208 - State 2017

Field of application: **Miniplast 2 /110 ; Maxiplast /501/900 /955 ; Instaweld 160 ;  
2000/ 3000 Combi ; 2500 DE 160 / 250 / 315 ; ASM160 / ASM 315 / ASM 355**

Heating element temperature is 210° C ± 10° C / 410° F ± 18°

Change-over time should be kept as low as possible.

Joining force ramp time is to be seen as maximum value and may be underrun by up to 50%.

The individual motion force of each welding machine must be added to the indicated bead-up and welding force!

1 kp = 10 N

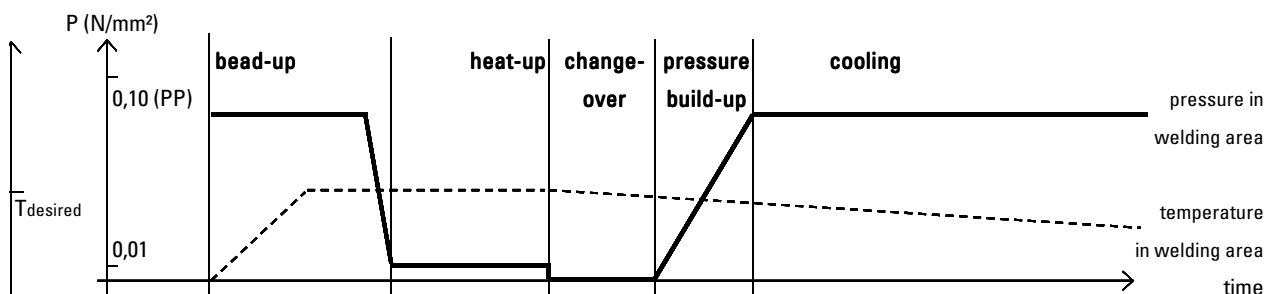
Values apply to butt welding of pipes according to DVS 2207, 2208 DIN 15494. They are standards for saddle welding, they can vary and must be calculated once again if necessary.

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

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- 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 force [kp]	circular bead height min. [mm]	heat-up time [min:s]	max. change-over time [s]	force ramp time [s]	welding force [kp]	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	
[mm]		[daN]		[min:s]	[s]	[s]	[daN]	[min:s]	[min:s]	[min:s]	
<b>DA 20</b>											
1,9	11	2	0,5	00:24	5	6	2	04:00	05:00	06:30	03:30
2,3	9	2	0,5	00:27	5	6	2	04:00	05:00	06:30	03:30
2,8	7,4	2	0,5	00:33	5	6	2	04:00	05:00	06:30	03:30
3,4	6	2	0,5	00:40	5	6	2	04:00	05:00	06:30	03:30
4,1	5	3	0,5	00:48	5	6	3	04:00	05:00	06:30	03:30
<b>DA 25</b>											
2,3	11	2	0,5	00:27	5	6	2	04:00	05:00	06:30	03:30
2,8	9	2	0,5	00:33	5	6	2	04:00	05:00	06:30	03:30
3,5	7,4	3	0,5	00:41	5	6	3	04:00	05:00	06:30	03:30
4,2	6	3	0,5	00:49	5	6	3	04:00	05:00	06:30	03:30
5,1	5	4	0,5	01:00	5	6	4	04:29	05:36	07:13	03:52
<b>DA 32</b>											
1,8	17,6	2	0,5	00:24	5	6	2	04:00	05:00	06:30	03:30
1,9	17	2	0,5	00:24	5	6	2	04:00	05:00	06:30	03:30
2,9	11	3	0,5	00:34	5	6	3	04:00	05:00	06:30	03:30
3,6	9	4	0,5	00:42	5	6	4	04:00	05:00	06:30	03:30
4,4	7,4	4	0,5	00:52	5	6	4	04:00	05:00	06:30	03:30
5,4	6	5	0,5	01:03	5	6	5	04:43	05:54	07:35	04:02
6,5	5	6	0,5	01:15	6	7	6	05:36	07:00	08:54	04:42

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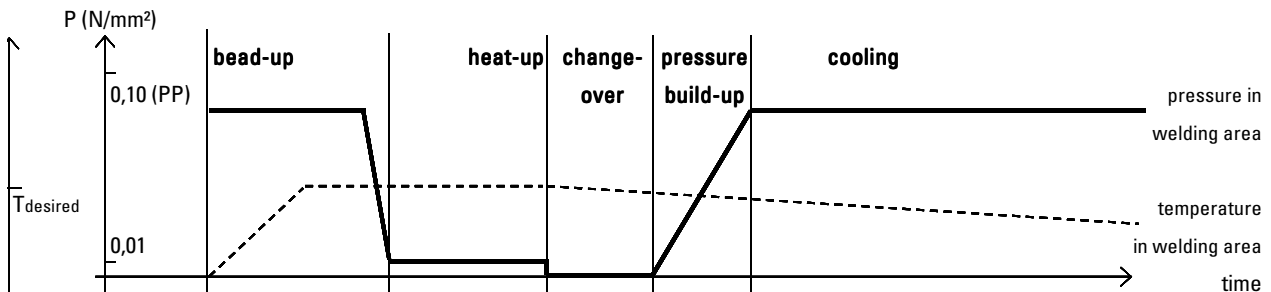
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
[mm]		[daN]					[daN]				
<b>DA 40</b>											
1,8	26	3	0,5	00:24	5	6	3	04:00	05:00	06:30	03:30
2,3	17,6	3	0,5	00:27	5	6	3	04:00	05:00	06:30	03:30
2,4	17	3	0,5	00:28	5	6	3	04:00	05:00	06:30	03:30
3,7	11	5	0,5	00:44	5	6	5	04:00	05:00	06:30	03:30
4,5	9	6	0,5	00:53	5	6	6	04:00	05:00	06:30	03:30
5,5	7,4	6	0,5	01:04	5	6	6	04:48	06:00	07:42	04:06
6,7	6	8	0,5	01:18	6	7	8	05:46	07:12	09:08	04:49
8,1	5	9	1	01:33	6	8	9	06:46	08:29	10:49	05:40
<b>DA 50</b>											
1,8	33	3	0,5	00:24	5	6	3	04:00	05:00	06:30	03:30
2,0	26	4	0,5	00:24	5	6	4	04:00	05:00	06:30	03:30
2,9	17,6	5	0,5	00:34	5	6	5	04:00	05:00	06:30	03:30
3,0	17	5	0,5	00:35	5	6	5	04:00	05:00	06:30	03:30
4,6	11,0	7	0,5	00:54	5	6	7	04:05	05:06	06:37	03:34
5,6	9	8	0,5	01:05	5	6	8	04:53	06:06	07:49	04:10
6,9	7,4	10	0,5	01:20	6	7	10	05:55	07:24	09:23	04:56
8,3	6	11	1	01:35	6	8	11	06:55	08:40	11:04	05:47
10,1	5	13	1	01:54	7	9	13	08:10	10:17	13:13	06:52

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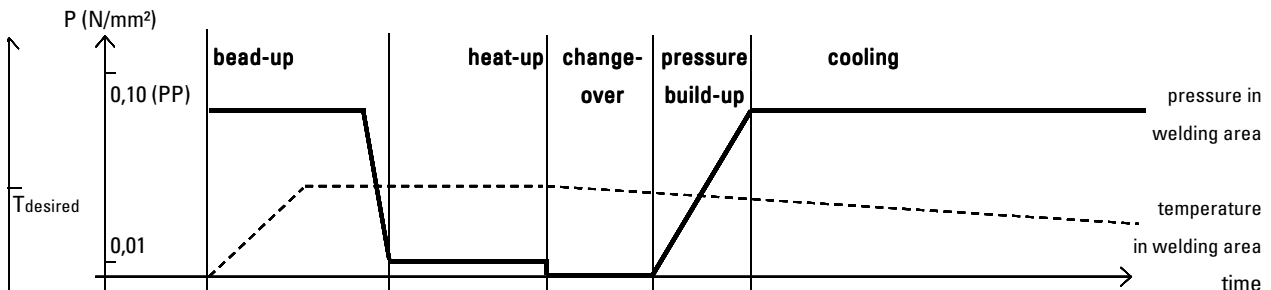
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								< 15°C	15-25°C	> 25°C	
[mm]		[daN]	[mm]	[min:s]	[s]	[s]	[daN]	[min:s]	[min:s]	[min:s]	[min:s]
<b>DA 63</b>											
1,8	41	4	0,5	00:24	5	6	4	04:00	05:00	06:30	03:30
2,0	33	4	0,5	00:24	5	6	4	04:00	05:00	06:30	03:30
2,5	26	5	0,5	00:29	5	6	5	04:00	05:00	06:30	03:30
3,6	17,6	7	0,5	00:42	5	6	7	04:00	05:00	06:30	03:30
3,8	17	8	0,5	00:45	5	6	8	04:00	05:00	06:30	03:30
5,8	11	11	0,5	01:08	6	7	11	05:02	06:18	08:04	04:17
7,1	9	13	1	01:22	6	7	13	06:04	07:35	09:37	05:04
8,6	7,4	15	1	01:38	6	8	15	07:07	08:56	11:25	05:58
10,5	6	18	1	01:59	7	10	18	08:27	10:39	13:42	07:06
12,7	5	21	1	02:22	7	12	21	09:57	12:36	16:21	08:24
<b>DA 75</b>											
1,9	41	5	0,5	00:24	5	6	5	04:00	05:00	06:30	03:30
2,3	33	6	0,5	00:27	5	6	6	04:00	05:00	06:30	03:30
2,9	26	7	0,5	00:34	5	6	7	04:00	05:00	06:30	03:30
4,3	17,6	10	0,5	00:51	5	6	10	04:00	05:00	06:30	03:30
4,5	17	10	0,5	00:53	5	6	10	04:00	05:00	06:30	03:30
6,8	11	15	0,5	01:19	6	7	15	05:50	07:18	09:16	04:53
8,4	9	18	1	01:36	6	8	18	06:59	08:46	11:11	05:50
10,3	7,4	21	1	01:57	7	10	21	08:19	10:28	13:28	06:59
12,5	6	25	1	02:20	7	11	25	09:49	12:26	16:06	08:17
15,1	5	29	1	02:46	8	14	29	11:30	14:39	19:16	09:46

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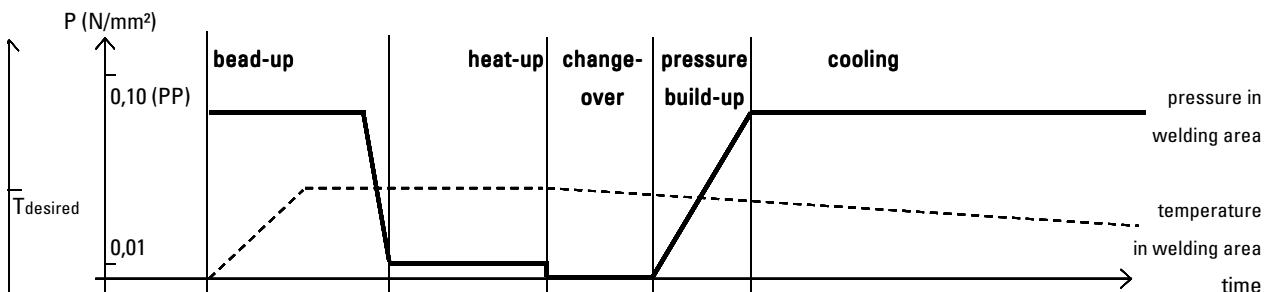
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								< 15°C	15-25°C	> 25°C	
[mm]		[daN]	[mm]	[min:s]	[s]	[s]	[daN]	[min:s]	[min:s]	[min:s]	[min:s]
<b>DA 90</b>											
2,2	41	7	0,5	00:26	5	6	7	04:00	05:00	06:30	03:30
2,8	33	8	0,5	00:33	5	6	8	04:00	05:00	06:30	03:30
3,5	26	10	0,5	00:41	5	6	10	04:00	05:00	06:30	03:30
5,1	17,6	14	0,5	01:00	5	6	14	04:29	05:36	07:13	03:52
5,4	17	15	0,5	01:03	5	6	15	04:43	05:54	07:35	04:02
8,2	11	22	1	01:34	6	8	22	06:50	08:35	10:56	05:43
10,1	9	26	1	01:54	7	9	26	08:10	10:17	13:13	06:52
12,3	7,4	31	1	02:18	7	11	31	09:42	12:15	15:52	08:10
15,0	6	36	1	02:45	8	14	36	11:26	14:34	19:09	09:43
18,1	5	41	1	03:17	9	16	41	13:25	17:14	22:54	11:29
<b>DA 110</b>											
2,7	41	10	0,5	00:32	5	6	10	04:00	05:00	06:30	03:30
3,4	33	12	0,5	00:40	5	6	12	04:00	05:00	06:30	03:30
4,2	26	14	0,5	00:49	5	6	14	04:00	05:00	06:30	03:30
6,3	17,6	21	0,5	01:13	6	7	21	05:26	06:48	08:40	04:35
6,6	17	22	0,5	01:17	6	7	22	05:41	07:06	09:01	04:46
10,0	11	32	1	01:53	7	9	32	08:06	10:12	13:06	06:48
12,3	9	38	1	02:18	7	11	38	09:42	12:15	15:52	08:10
15,1	7,4	46	1	02:46	8	14	46	11:30	14:39	19:16	09:46
18,3	6	53	1	03:19	9	16	53	13:33	17:24	23:09	11:36
22,1	5	62	1,5	03:55	10	19	62	16:13	20:39	27:33	13:46

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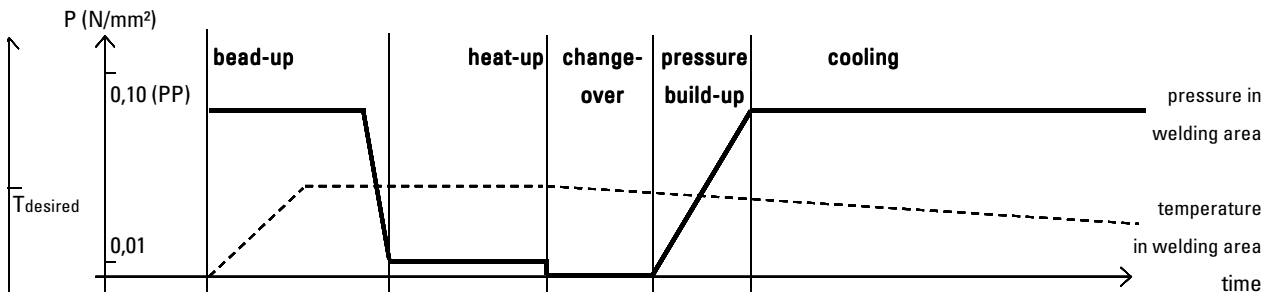
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								< 15°C	15-25°C	> 25°C	
[mm]		[daN]	[mm]	[min:s]	[s]	[s]	[daN]	[min:s]	[min:s]	[min:s]	[min:s]
<b>DA 125</b>											
3,1	41	12	0,5	00:37	5	6	12	04:00	05:00	06:30	03:30
3,9	33	15	0,5	00:46	5	6	15	04:00	05:00	06:30	03:30
4,8	26	19	0,5	00:56	5	6	19	04:14	05:18	06:52	03:41
7,1	17,6	27	1	01:22	6	7	27	06:04	07:35	09:37	05:04
7,4	17	28	1	01:25	6	7	28	06:17	07:52	09:59	05:14
11,4	11	41	1	02:09	7	11	41	09:05	11:28	14:47	07:38
14,0	9	49	1	02:35	8	13	49	10:47	13:43	17:56	09:09
17,1	7,4	58	1	03:07	8	15	58	12:47	16:22	21:42	10:55
20,8	6	69	1,5	03:43	10	18	69	15:17	19:33	26:03	13:02
25,1	5	79	1,5	04:23	11	21	79	18:21	23:14	30:58	15:29
<b>DA 140</b>											
3,5	41	16	0,5	00:41	5	6	16	04:00	05:00	06:30	03:30
4,3	33	19	0,5	00:51	5	6	19	04:00	05:00	06:30	03:30
5,4	26	23	0,5	01:03	5	6	23	04:43	05:54	07:35	04:02
8,0	17,6	34	1	01:32	6	8	34	06:42	08:24	10:42	05:36
8,3	17	35	1	01:35	6	8	35	06:55	08:40	11:04	05:47
12,7	11	51	1	02:22	7	12	51	09:57	12:36	16:21	08:24
15,7	9	62	1	02:53	8	14	62	11:53	15:10	20:00	10:07
19,2	7,4	73	1,5	03:28	9	17	73	14:09	18:10	24:14	12:07
23,3	6	86	1,5	04:06	10	20	86	17:04	21:41	28:55	14:27
28,1	5	99	2	04:48	12	24	99	20:32	25:55	34:29	17:20

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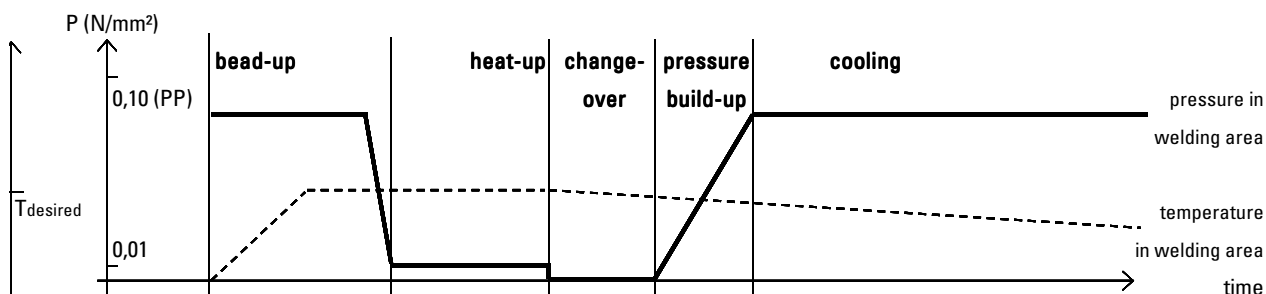
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								< 15°C	15-25°C	> 25°C	
[mm]		[daN]	[mm]	[min:s]	[s]	[s]	[daN]	[min:s]	[min:s]	[min:s]	[min:s]
<b>DA 160</b>											
4,0	41	20	0,5	00:47	5	6	20	04:00	05:00	06:30	03:30
4,9	33	24	0,5	00:57	5	6	24	04:19	05:24	06:59	03:44
6,2	26	30	0,5	01:12	6	7	30	05:22	06:42	08:32	04:31
9,1	17,6	44	1	01:44	6	9	44	07:28	09:23	12:01	06:16
9,5	17	45	1	01:48	6	9	45	07:45	09:45	12:30	06:30
14,6	11	67	1	02:41	8	13	67	11:10	14:14	18:39	09:29
17,9	9	80	1	03:15	9	16	80	13:18	17:03	22:40	11:22
21,9	7,4	96	1,5	03:53	10	19	96	16:04	20:29	27:19	13:39
26,6	6	112	2	04:36	11	23	112	19:26	24:33	32:43	16:23
32,1	5	129	2	05:21	13	28	129	23:26	29:33	39:13	19:53
<b>DA 180</b>											
4,4	41	25	0,5	00:52	5	6	25	04:00	05:00	06:30	03:30
5,5	33	31	0,5	01:04	5	6	31	04:48	06:00	07:42	04:06
6,9	26	38	0,5	01:20	6	7	38	05:55	07:24	09:23	04:56
10,2	17,6	55	1	01:56	7	10	55	08:14	10:23	13:20	06:55
10,7	17	57	1	02:01	7	10	57	08:35	10:50	13:56	07:13
16,4	11	85	1	03:00	8	15	85	12:20	15:46	20:51	10:31
20,1	9	101	1,5	03:36	9	18	101	14:47	18:57	25:15	12:38
24,6	7,4	121	1,5	04:18	11	21	121	18:00	22:48	30:24	15:12
29,0	6	138	2	04:56	12	25	138	21:11	26:44	35:33	17:55
36,1	5	164	2	05:55	14	31	164	26:21	33:11	43:56	22:26

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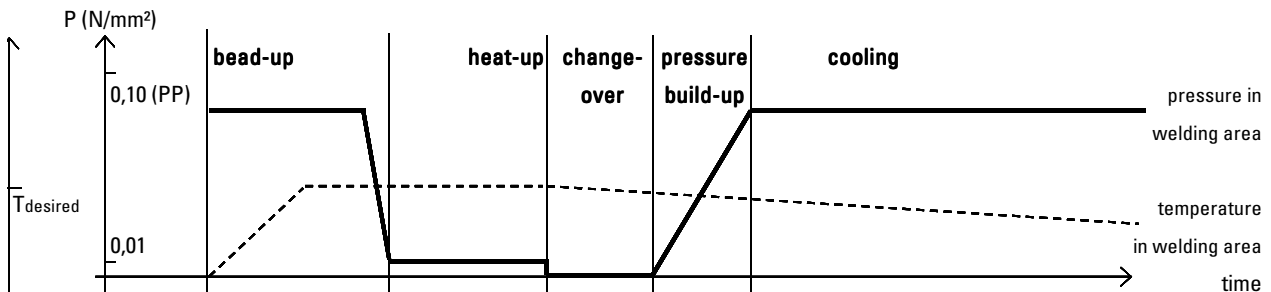
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[mm]		[daN]	[mm]	[min:s]	[s]	[s]	[daN]	[min:s]	[min:s]	[min:s]	[min:s]
<b>DA 200</b>											
4,9	41	31	0,5	00:57	5	6	31	04:19	05:24	06:59	03:44
6,2	33	38	0,5	01:12	6	7	38	05:22	06:42	08:32	04:31
7,7	26	47	1	01:29	6	8	47	06:29	08:08	10:20	05:25
11,4	17,6	68	1	02:09	7	11	68	09:05	11:28	14:47	07:38
11,9	17	71	1	02:14	7	11	71	09:26	11:55	15:23	07:56
18,2	11	104	1	03:18	9	16	104	13:29	17:19	23:02	11:33
22,4	9	125	1,5	03:58	10	19	125	16:26	20:55	27:53	13:57
27,4	7,4	149	2	04:43	11	23	149	20:01	25:16	33:39	16:53
33,2	6	174	2	05:31	13	29	174	24:14	30:33	40:31	20:35
<b>DA 225</b>											
5,5	41	38	0,5	01:04	5	6	38	04:48	06:00	07:42	04:06
6,9	33	48	0,5	01:20	6	7	48	05:55	07:24	09:23	04:56
8,6	26	59	1	01:38	6	8	59	07:07	08:56	11:25	05:58
12,8	17,6	86	1	02:23	7	12	86	10:01	12:41	16:28	08:27
13,4	17	90	1	02:29	7	12	90	10:24	13:12	17:12	08:48
20,5	11	132	1,5	03:40	9	18	132	15:04	19:17	25:43	12:51
25,2	9	159	1,5	04:24	11	21	159	18:26	23:19	31:05	15:33
30,8	7,4	188	2	05:11	12	26	188	22:29	28:22	37:40	19:03
37,4	6	221	2,5	06:05	14	32	221	27:17	34:22	45:30	23:15



# Table for PP



Basis: DVS data sheets 2207, 2208 - State 2017

Field of application: **Miniplast 2 /110 ; Maxiplast /501/900 /955 ; Instaweld 160 ; 2000/ 3000 Combi ; 2500 DE 160 / 250 / 315 ; ASM160 / ASM 315 / ASM 355**

Heating element temperature is 210° C ± 10° C / 410° F ± 18°

Change-over time should be kept as low as possible.

Joining force ramp time is to be seen as maximum value and may be underrun by up to 50%.

The individual motion force of each welding machine must be added to the indicated bead-up and welding force!

1 kp = 10 N

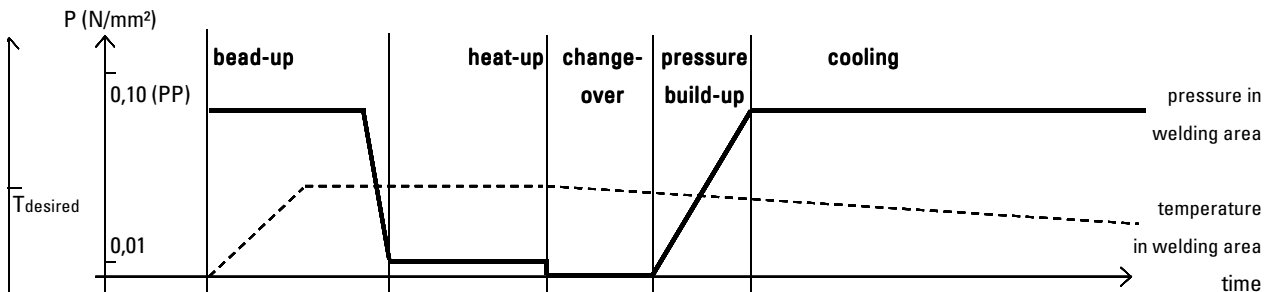
Values apply to butt welding of pipes according to DVS 2207, 2208 DIN 15494. They are standards for saddle welding, they can vary and must be calculated once again if necessary.

The maximum force of the welding machine is to be respected.

**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 force [kp]	circular bead height min. [mm]	heat-up time [min:s]	max. change-over time [s]	force ramp time [s]	welding force [kp]	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	
[mm]		[daN]		[min:s]	[s]	[s]	[daN]	[min:s]	[min:s]	[min:s]	
<b>DA 250</b>											
6,2	41	48	0,5	01:12	6	7	48	05:22	06:42	08:32	04:31
7,7	33	59	1	01:29	6	8	59	06:29	08:08	10:20	05:25
9,6	26	73	1	01:49	7	9	73	07:49	09:50	12:37	06:34
14,2	17,6	106	1	02:37	8	13	106	10:55	13:53	18:10	09:15
14,8	17	110	1	02:43	8	13	110	11:18	14:24	18:54	09:36
22,7	11	163	1,5	04:00	10	20	163	16:39	21:10	28:14	14:07
27,9	9	195	2	04:47	12	24	195	20:23	25:44	34:15	17:13
34,2	7,4	232	2	05:39	13	29	232	24:58	31:27	41:41	21:13
<b>DA 280</b>											
6,9	41	60	0,5	01:20	6	7	60	05:55	07:24	09:23	04:56
8,6	33	74	1	01:38	6	8	74	07:07	08:56	11:25	05:58
10,7	26	91	1	02:01	7	10	91	08:35	10:50	13:56	07:13
15,9	17,6	132	1	02:55	8	14	132	12:00	15:21	20:14	10:14
16,6	17	138	1	03:02	8	15	138	12:27	15:57	21:05	10:38
25,4	11	204	1,5	04:25	11	22	204	18:34	23:29	31:19	15:39
31,3	9	245	2	05:15	12	27	245	22:51	28:49	38:16	19:22
38,3	7,4	291	2,5	06:11	14	33	291	27:54	35:12	46:36	23:48



# Table for PP



Basis: DVS data sheets 2207, 2208 - State 2017

Field of application: **Miniplast 2 /110 ; Maxiplast /501/900 /955 ; Instaweld 160 ; 2000/ 3000 Combi ; 2500 DE 160 / 250 / 315 ; ASM160 / ASM 315 / ASM 355**

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1 kp = 10 N

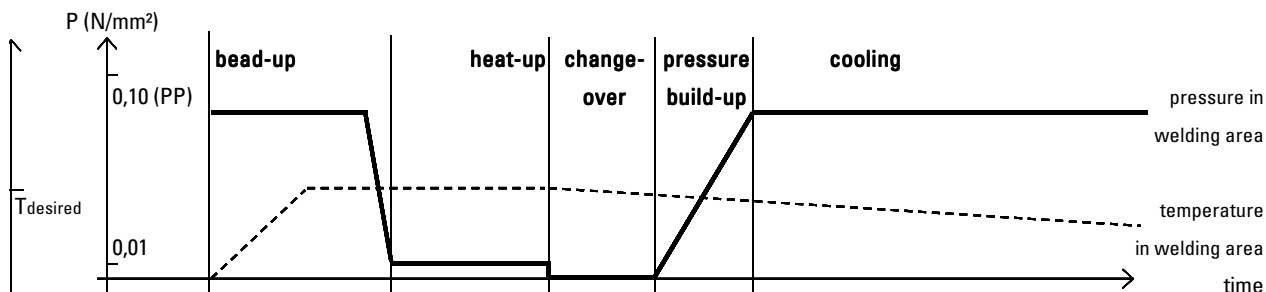
Values apply to butt welding of pipes according to DVS 2207, 2208 DIN 15494. They are standards for saddle welding, they can vary and must be calculated once again if necessary.

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

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All information without guarantee



pipe wall (s)	SDR degree	bead-up force [kp]	circular bead height min. [mm]	heat-up time [min:s]	max. change-over time [s]	force ramp time [s]	welding force [kp]	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]	
[mm]		[daN]		[min:s]	[s]	[s]	[daN]				
<b>DA 315</b>											
7,7	41	75	1	01:29	6	8	75	06:29	08:08	10:20	05:25
9,7	33	94	1	01:50	7	9	94	07:53	09:56	12:44	06:37
12,1	26	116	1	02:16	7	11	116	09:34	12:05	15:37	08:03
17,9	17,6	168	1	03:15	9	16	168	13:18	17:03	22:40	11:22
18,7	17	175	1	03:23	9	17	175	13:48	17:45	23:38	11:50
28,6	11	258	2	04:53	12	24	258	20:53	26:22	35:04	17:39
35,2	9	310	2	05:47	14	30	310	25:41	32:22	42:52	21:51