

Table for PVDF

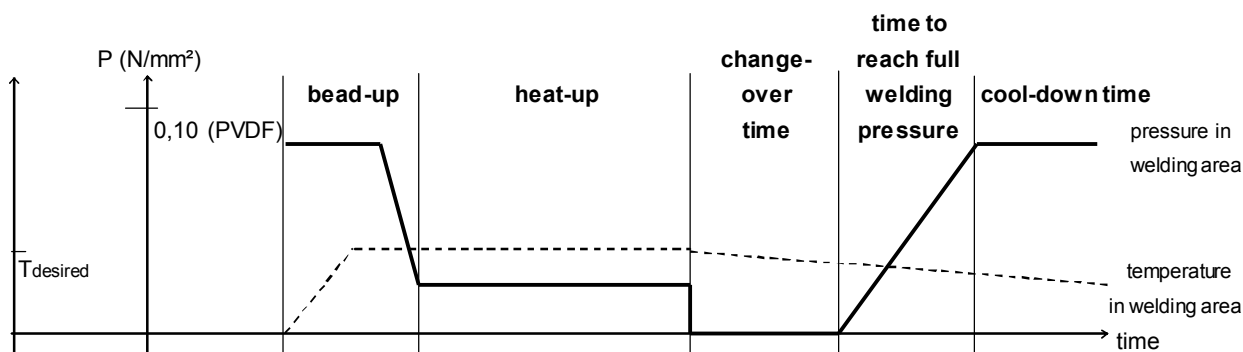


Foundation: 2208, 2207 Part 15 German association for welding

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 OD 160 / 250 / 315 OD 50 - 315
ASM 160 / ASM 315 OD 50 - 315

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

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]	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]
20	1,9	2	0,5	59	3	3	2	4,5
25	1,9	2	0,5	59	3	3	2	4,5
32	2,4	3	0,5	64	3	3	3	5,0
40	2,4	3	0,5	64	3	3	3	5,0
50	3,0	5	0,5	70	3	4	5	5,5
63	2,0	4	0,5	60	3	3	4	4,5
	3,0	6	0,5	70	3	4	6	5,5
	3,8	8	0,5	78	3	4	8	6,5
75	2,3	6	0,5	63	3	3	6	5,0
	3,6	9	0,5	76	3	4	9	6,5
	4,5	10	0,5	85	3	5	10	7,5
90	2,8	8	0,5	68	3	4	8	5,5
	4,3	12	0,5	83	3	4	12	7,0
	5,4	15	0,5	94	3	5	15	8,5
110	3,4	12	0,5	74	3	4	12	6,0
	5,3	18	0,5	93	3	5	18	8,5
	6,6	22	0,6	106	4	5	22	10,0
125	3,9	15	0,5	79	3	4	15	6,5
	6,0	23	0,6	100	4	5	23	9,0
140	4,3	19	0,5	83	3	4	19	7,0
	6,7	29	0,6	107	4	6	29	10,0

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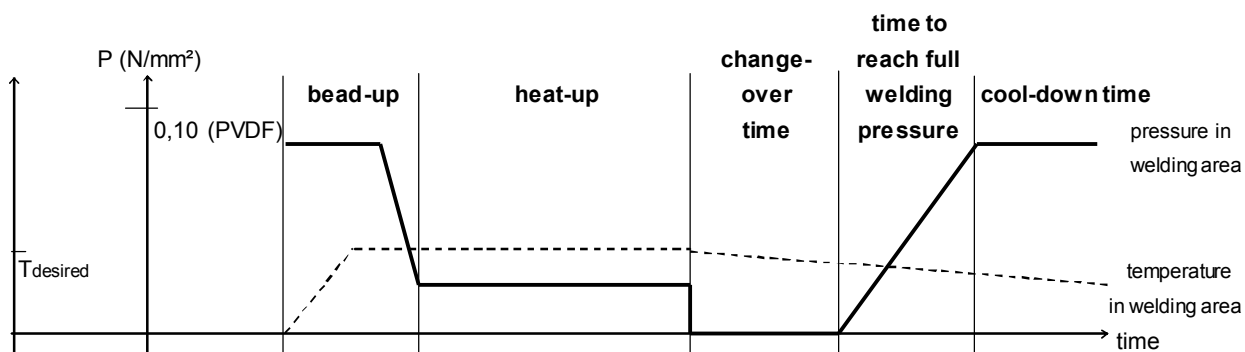
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	Maxiplast / 501 / 900 / 955	OD 50 - 160
	Instaweld 160	OD 50 - 160
	2000 / 3000 Kombi	OD 50 - 250
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160	4,9	24	0,5	89	3	5	24	8,0
	7,7	37	0,7	117	4	6	37	11,0
180	5,5	31	0,5	95	4	5	31	8,5
	8,6	47	0,8	126	4	6	47	12,5
200	6,2	38	0,6	102	4	5	38	9,5
	9,6	58	1,0	136	4	7	58	13,5
225	6,9	48	0,7	109	4	6	48	10,5
	10,8	73	1,0	148	4	7	73	15,0
250	7,7	59	0,7	117	4	6	59	11,0
	11,9	90	1,1	159	4	8	90	16,5
280	8,6	74	0,8	126	4	6	74	12,5
315	9,7	94	1,0	137	4	7	94	13,5