

## Table for PVDF

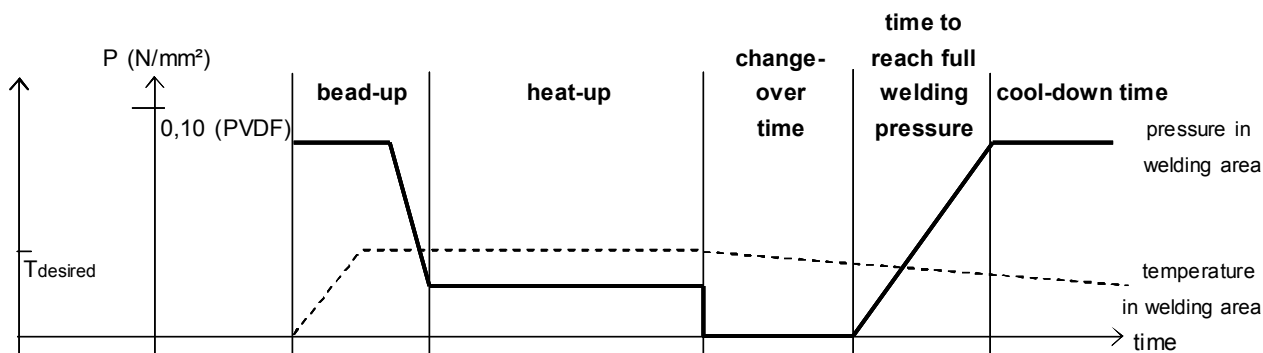


Foundation: 2208, 2207 Part 15 German association for welding  
Use for: **4400**

1 bar on manometer: **25 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 !



| 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] |
|-----------------------|--------------------|------------------------|-------------------------|------------------|---------------------------|------------------------------------|------------------------|----------------------|
| <b>50</b>             | 3,0                | 2                      | 0,5                     | 70               | 3                         | 4                                  | 2                      | 5,5                  |
| <b>63</b>             | 2,0                | 2                      | 0,5                     | 60               | 3                         | 3                                  | 2                      | 4,5                  |
|                       | 3,0                | 3                      | 0,5                     | 70               | 3                         | 4                                  | 3                      | 5,5                  |
|                       | 3,8                | 3                      | 0,5                     | 78               | 3                         | 4                                  | 3                      | 6,5                  |
| <b>75</b>             | 2,3                | 3                      | 0,5                     | 63               | 3                         | 3                                  | 3                      | 5,0                  |
|                       | 3,6                | 4                      | 0,5                     | 76               | 3                         | 4                                  | 4                      | 6,5                  |
|                       | 4,5                | 4                      | 0,5                     | 85               | 3                         | 5                                  | 4                      | 7,5                  |
| <b>90</b>             | 2,8                | 4                      | 0,5                     | 68               | 3                         | 4                                  | 4                      | 5,5                  |
|                       | 4,3                | 5                      | 0,5                     | 83               | 3                         | 4                                  | 5                      | 7,0                  |
|                       | 5,4                | 6                      | 0,5                     | 94               | 3                         | 5                                  | 6                      | 8,5                  |
| <b>110</b>            | 3,4                | 5                      | 0,5                     | 74               | 3                         | 4                                  | 5                      | 6,0                  |
|                       | 5,3                | 7                      | 0,5                     | 93               | 3                         | 5                                  | 7                      | 8,5                  |
|                       | 6,6                | 9                      | 0,6                     | 106              | 4                         | 5                                  | 9                      | 10,0                 |
| <b>125</b>            | 3,9                | 6                      | 0,5                     | 79               | 3                         | 4                                  | 6                      | 6,5                  |
|                       | 6,0                | 9                      | 0,6                     | 100              | 4                         | 5                                  | 9                      | 9,0                  |
| <b>140</b>            | 4,3                | 8                      | 0,5                     | 83               | 3                         | 4                                  | 8                      | 7,0                  |
|                       | 6,7                | 12                     | 0,6                     | 107              | 4                         | 6                                  | 12                     | 10,0                 |
| <b>160</b>            | 4,9                | 10                     | 0,5                     | 89               | 3                         | 5                                  | 10                     | 8,0                  |
|                       | 7,7                | 15                     | 0,7                     | 117              | 4                         | 6                                  | 15                     | 11,0                 |