

Table for PE



Basis: DVS data sheets 2207, 2208 - State 2016

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 220° C ± 10° C / 428° F ± 18° F

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

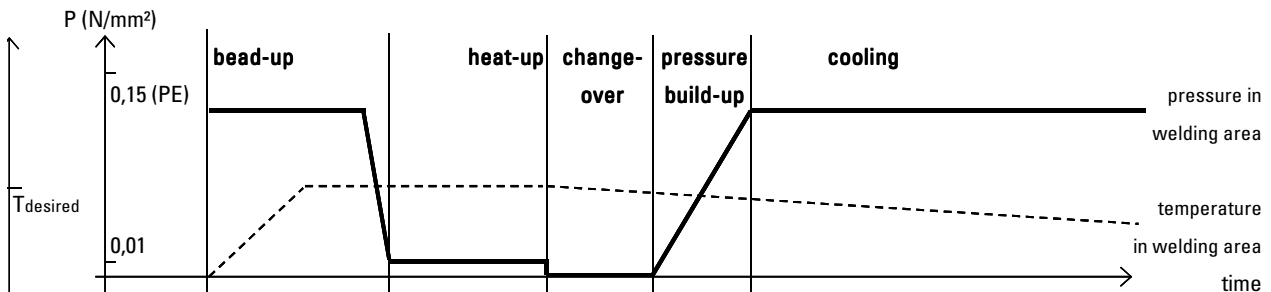
Values apply to butt welding of pipes according to DVS 2207, 2208 DIN 16932. They are standards for saddle welding, they can vary and must be calculated once again if necessary.

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 [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
[mm]		[daN]					[daN]				
DA 20											
2,0	11	2	0,5	00:20	5	5	2	04:00	05:00	06:30	03:30
2,3	9	2	0,5	00:23	5	5	2	04:00	05:00	06:30	03:30
3,0	7,4	3	0,5	00:30	5	5	3	04:00	05:00	06:30	03:30
DA 25											
2,3	11	3	0,5	00:23	5	5	3	04:00	05:00	06:30	03:30
3,0	9	4	0,5	00:30	5	5	4	04:00	05:00	06:30	03:30
3,5	7,4	4	0,5	00:35	5	5	4	04:00	05:00	06:30	03:30
DA 32											
2,0	17,6	4	0,5	00:20	5	5	4	04:00	05:00	06:30	03:30
2,0	17	4	0,5	00:20	5	5	4	04:00	05:00	06:30	03:30
2,4	13,6	5	0,5	00:24	5	5	5	04:00	05:00	06:30	03:30
3,0	11	6	0,5	00:30	5	5	6	04:00	05:00	06:30	03:30
3,6	9	7	0,5	00:36	5	5	7	04:00	05:00	06:30	03:30
4,4	7,4	8	0,5	00:44	5	5	8	04:00	05:00	06:30	03:30
5,4	6	9	1	00:54	5	5	9	04:43	05:54	07:35	04:02
6,5	5	11	1	01:05	6	6	11	05:36	07:00	08:54	04:42

Table for PE



Basis: DVS data sheets 2207, 2208 - State 2016

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 220° C ± 10° C / 428° F ± 18° F

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!

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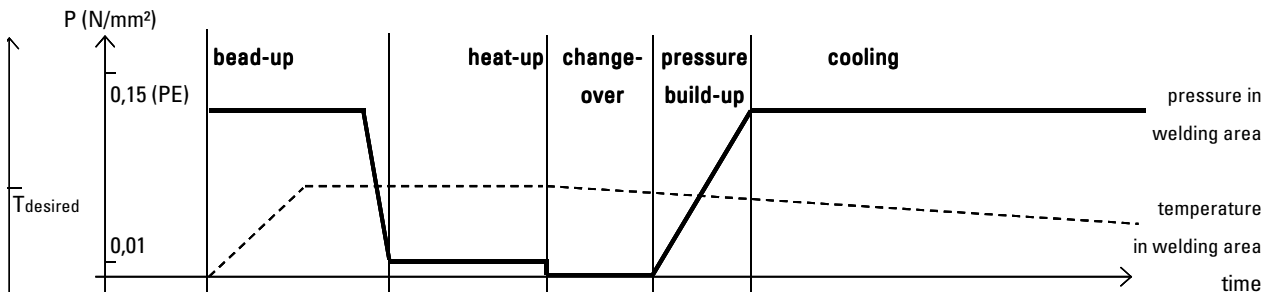
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All information without guarantee



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]	
DA 40											
1,8	26	4	0,5	00:20	5	5	4	04:00	05:00	06:30	03:30
2,0	21	4	0,5	00:20	5	5	4	04:00	05:00	06:30	03:30
2,3	17,6	5	0,5	00:23	5	5	5	04:00	05:00	06:30	03:30
2,4	17	5	0,5	00:24	5	5	5	04:00	05:00	06:30	03:30
3,0	11	6	0,5	00:30	5	5	6	04:00	05:00	06:30	03:30
3,6	9	7	0,5	00:36	5	5	7	04:00	05:00	06:30	03:30
5,5	7,4	9	1	00:55	5	5	9	04:48	06:00	07:42	04:06
DA 50											
1,8	33	5	0,5	00:20	5	5	5	04:00	05:00	06:30	03:30
2,0	26	5	0,5	00:20	5	5	5	04:00	05:00	06:30	03:30
2,4	21	6	0,5	00:24	5	5	6	04:00	05:00	06:30	03:30
2,9	17,6	7	0,5	00:29	5	5	7	04:00	05:00	06:30	03:30
3,0	17	7	0,5	00:30	5	5	7	04:00	05:00	06:30	03:30
3,7	13,6	9	0,5	00:37	5	5	9	04:00	05:00	06:30	03:30
4,6	11,0	10	1	00:46	5	5	10	04:05	05:06	06:37	03:34
5,6	9	12	1	00:56	5	5	12	04:53	06:06	07:49	04:10
6,9	7,4	15	1	01:09	6	6	15	05:55	07:24	09:23	04:56

Table for PE



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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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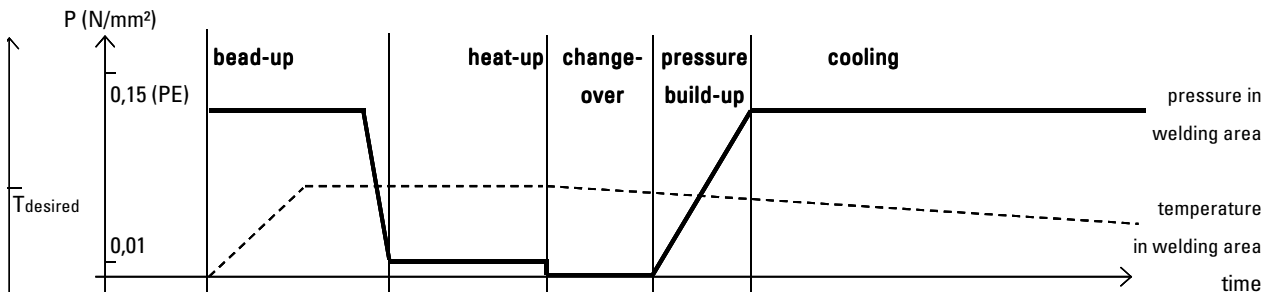
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								< 15°C	15-25°C	> 25°C	
[mm]		[daN]	[mm]	[min:s]	[s]	[s]	[daN]	< 59°F	59-77°F	> 77°F	[min:s]
DA 63											
1,8	41	6	0,5	00:20	5	5	6	04:00	05:00	06:30	03:30
2,0	33	6	0,5	00:20	5	5	6	04:00	05:00	06:30	03:30
2,5	26	8	0,5	00:25	5	5	8	04:00	05:00	06:30	03:30
3,0	21	9	0,5	00:30	5	5	9	04:00	05:00	06:30	03:30
3,6	17,6	11	0,5	00:36	5	5	11	04:00	05:00	06:30	03:30
3,8	17	11	0,5	00:38	5	5	11	04:00	05:00	06:30	03:30
4,7	13,6	13	1	00:47	5	5	13	04:10	05:12	06:44	03:37
5,8	11	16	1	00:58	6	6	16	05:02	06:18	08:04	04:17
7,1	9	19	1,5	01:11	6	6	19	06:04	07:35	09:37	05:04
8,6	7,4	23	1,5	01:26	7	7	23	07:07	08:56	11:25	05:58
DA 75											
1,9	41	7	0,5	00:20	5	5	7	04:00	05:00	06:30	03:30
2,3	33	8	0,5	00:23	5	5	8	04:00	05:00	06:30	03:30
2,9	26	10	0,5	00:29	5	5	10	04:00	05:00	06:30	03:30
3,6	21	13	0,5	00:36	5	5	13	04:00	05:00	06:30	03:30
4,3	17,6	15	0,5	00:43	5	5	15	04:00	05:00	06:30	03:30
4,5	17	15	1	00:45	5	5	15	04:00	05:00	06:30	03:30
5,6	13,6	19	1	00:56	5	5	19	04:53	06:06	07:49	04:10
6,8	11	22	1	01:08	6	6	22	05:50	07:18	09:16	04:53
8,4	9	27	1,5	01:24	7	7	27	06:59	08:46	11:11	05:50
10,3	7,4	32	1,5	01:43	7	7	32	08:19	10:28	13:28	06:59

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Basis: DVS data sheets 2207, 2208 - State 2016

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 220° C ± 10° C / 428° F ± 18° F

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

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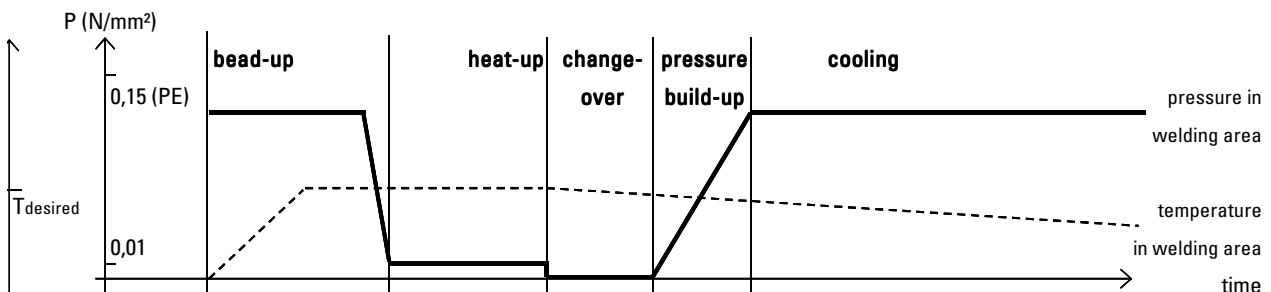
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pipe wall (s)	SDR degree	bead-up force [kp]	circular bead height min.	heat-up time	max. change-over time	force ramp time	welding force [kp]	cooling time for ambient temperature			special cooling time 1
								< 15°C	15-25°C	> 25°C	
[mm]		[daN]	[mm]	[min:s]	[s]	[s]	[daN]	[min:s]	[min:s]	[min:s]	[min:s]
DA 90											
2,2	41	10	0,5	00:22	5	5	10	04:00	05:00	06:30	03:30
2,8	33	12	0,5	00:28	5	5	12	04:00	05:00	06:30	03:30
3,5	26	15	0,5	00:35	5	5	15	04:00	05:00	06:30	03:30
4,3	21	18	0,5	00:43	5	5	18	04:00	05:00	06:30	03:30
5,1	17,6	21	1	00:51	5	5	21	04:29	05:36	07:13	03:52
5,4	17	22	1	00:54	5	5	22	04:43	05:54	07:35	04:02
6,7	13,6	27	1	01:07	6	6	27	05:46	07:12	09:08	04:49
8,2	11	32	1,5	01:22	6	6	32	06:50	08:35	10:56	05:43
10,1	9	39	1,5	01:41	7	7	39	08:10	10:17	13:13	06:52
12,3	7,4	46	2	02:03	8	8	46	09:42	12:15	15:52	08:10
DA 110											
2,7	41	14	0,5	00:27	5	5	14	04:00	05:00	06:30	03:30
3,4	33	18	0,5	00:34	5	5	18	04:00	05:00	06:30	03:30
4,2	26	21	0,5	00:42	5	5	21	04:00	05:00	06:30	03:30
5,3	21	27	1	00:53	5	5	27	04:38	05:48	07:28	03:59
6,3	17,6	31	1	01:03	6	6	31	05:26	06:48	08:40	04:35
6,6	17	33	1	01:06	6	6	33	05:41	07:06	09:01	04:46
8,1	13,6	39	1,5	01:21	6	6	39	06:46	08:29	10:49	05:40
10,0	11	48	1,5	01:40	7	7	48	08:06	10:12	13:06	06:48
12,3	9	57	2	02:03	8	8	57	09:42	12:15	15:52	08:10
15,1	7,4	68	2	02:31	9	9	68	11:30	14:39	19:16	09:46

Table for PE



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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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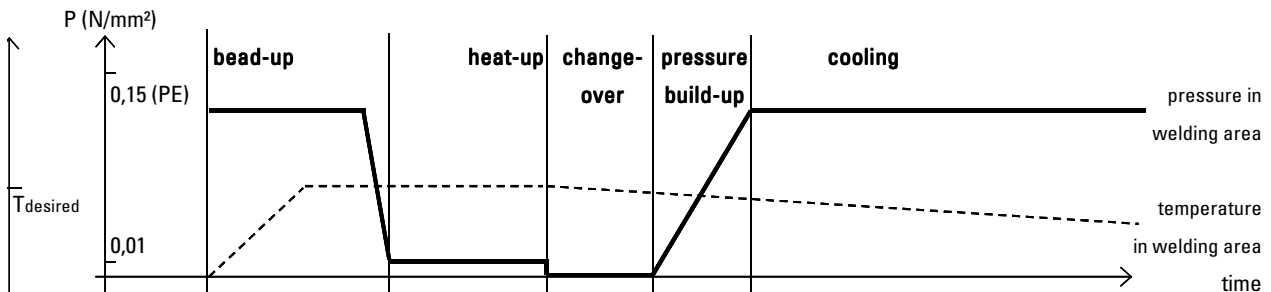
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
[mm]		[daN]					[daN]				
DA 125											
3,1	41	18	0,5	00:31	5	5	18	04:00	05:00	06:30	03:30
3,9	33	23	0,5	00:39	5	5	23	04:00	05:00	06:30	03:30
4,8	26	28	1	00:48	5	5	28	04:14	05:18	06:52	03:41
6,0	21	34	1	01:00	6	6	34	05:12	06:30	08:18	04:24
7,1	17,6	40	1,5	01:11	6	6	40	06:04	07:35	09:37	05:04
7,4	17	42	1,5	01:14	6	6	42	06:17	07:52	09:59	05:14
9,2	13,6	51	1,5	01:32	7	7	51	07:32	09:29	12:08	06:19
11,4	11	62	1,5	01:54	8	8	62	09:05	11:28	14:47	07:38
14,0	9	74	2	02:20	9	9	74	10:47	13:43	17:56	09:09
17,1	7,4	87	2	02:51	9	10	87	12:47	16:22	21:42	10:55
DA 140											
3,5	41	23	0,5	00:35	5	5	23	04:00	05:00	06:30	03:30
4,3	33	28	0,5	00:43	5	5	28	04:00	05:00	06:30	03:30
5,4	26	35	1	00:54	5	5	35	04:43	05:54	07:35	04:02
6,7	21	43	1	01:07	6	6	43	05:46	07:12	09:08	04:49
8,0	17,6	50	1,5	01:20	6	6	50	06:42	08:24	10:42	05:36
8,3	17	52	1,5	01:23	7	7	52	06:55	08:40	11:04	05:47
10,3	13,6	63	1,5	01:43	7	7	63	08:19	10:28	13:28	06:59
12,7	11	77	2	02:07	8	8	77	09:57	12:36	16:21	08:24
15,7	9	92	2	02:37	9	10	92	11:53	15:10	20:00	10:07
19,2	7,4	110	2,5	03:12	10	11	110	14:09	18:10	24:14	12:07

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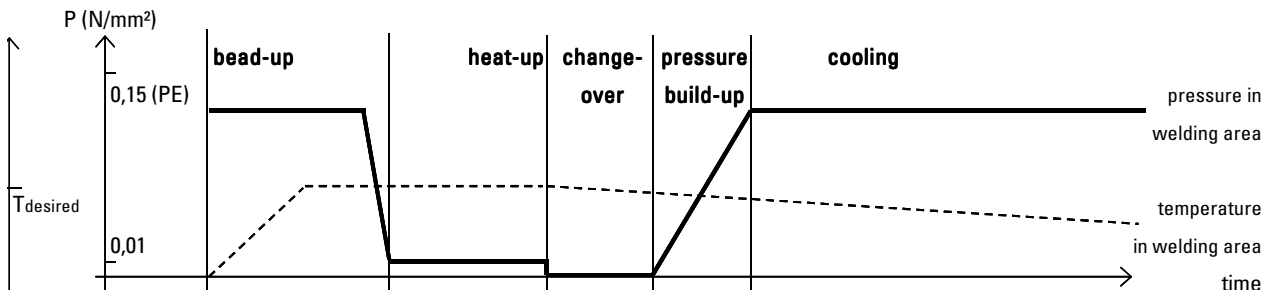
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
[mm]		[daN]					[daN]				
DA 160											
4,0	41	30	0,5	00:40	5	5	30	04:00	05:00	06:30	03:30
4,9	33	36	1	00:49	5	5	36	04:19	05:24	06:59	03:44
6,2	26	45	1	01:02	6	6	45	05:22	06:42	08:32	04:31
7,7	21	56	1,5	01:17	6	6	56	06:29	08:08	10:20	05:25
9,1	17,6	65	1,5	01:31	7	7	65	07:28	09:23	12:01	06:16
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14,6	11	101	2	02:26	9	9	101	11:10	14:14	18:39	09:29
17,9	9	120	2	02:59	10	11	120	13:18	17:03	22:40	11:22
21,9	7,4	143	2,5	03:39	11	12	143	16:04	20:29	27:19	13:39
DA 180											
4,4	41	37	0,5	00:44	5	5	37	04:00	05:00	06:30	03:30
5,5	33	46	1	00:55	5	5	46	04:48	06:00	07:42	04:06
6,9	26	57	1	01:09	6	6	57	05:55	07:24	09:23	04:56
8,6	21	70	1,5	01:26	7	7	70	07:07	08:56	11:25	05:58
10,2	17,6	82	1,5	01:42	7	7	82	08:14	10:23	13:20	06:55
10,7	17	86	1,5	01:47	7	7	86	08:35	10:50	13:56	07:13
13,3	13,6	105	2	02:13	8	9	105	10:20	13:07	17:05	08:45
16,4	11	127	2	02:44	9	10	127	12:20	15:46	20:51	10:31
20,1	9	152	2,5	03:21	10	11	152	14:47	18:57	25:15	12:38
24,6	7,4	181	2,5	04:06	12	13	181	18:00	22:48	30:24	15:12

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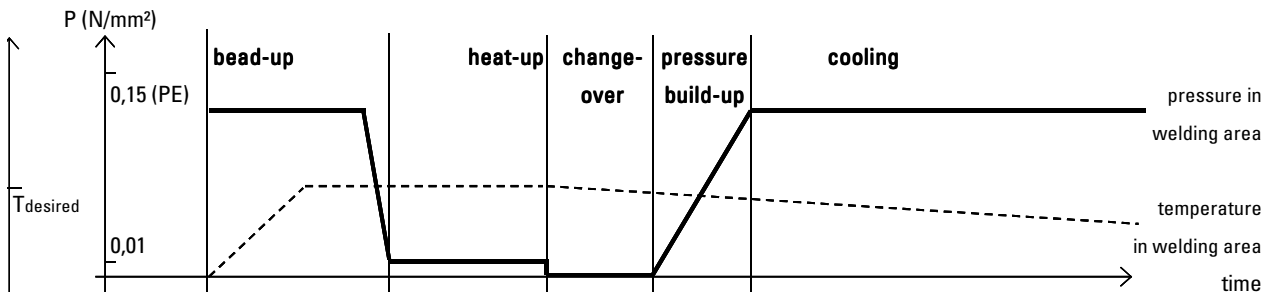
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								< 15°C < 59°F	15-25°C 59-77°F	> 25°C > 77°F	
[mm]		[daN]	[mm]	[min:s]	[s]	[s]	[daN]	[min:s]	[min:s]	[min:s]	[min:s]
DA 200											
4,9	41	46	1	00:49	5	5	46	04:19	05:24	06:59	03:44
6,2	33	57	1	01:02	6	6	57	05:22	06:42	08:32	04:31
7,7	26	70	1,5	01:17	6	6	70	06:29	08:08	10:20	05:25
9,6	21	87	1,5	01:36	7	7	87	07:49	09:50	12:37	06:34
11,4	17,6	102	1,5	01:54	8	8	102	09:05	11:28	14:47	07:38
11,9	17	106	1,5	01:59	8	8	106	09:26	11:55	15:23	07:56
14,7	13,6	129	2	02:27	9	9	129	11:14	14:19	18:47	09:33
18,2	11	156	2	03:02	10	11	156	13:29	17:19	23:02	11:33
22,4	9	188	2,5	03:44	11	12	188	16:26	20:55	27:53	13:57
27,4	7,4	223	3	04:34	13	15	223	20:01	25:16	33:39	16:53
DA 225											
5,5	41	57	1	00:55	5	5	57	04:48	06:00	07:42	04:06
6,9	33	71	1	01:09	6	6	71	05:55	07:24	09:23	04:56
8,6	26	88	1,5	01:26	7	7	88	07:07	08:56	11:25	05:58
10,8	21	110	1,5	01:48	8	8	110	08:40	10:55	14:04	07:17
12,8	17,6	128	2	02:08	8	8	128	10:01	12:41	16:28	08:27
13,4	17	134	2	02:14	8	9	134	10:24	13:12	17:12	08:48
16,6	13,6	164	2	02:46	9	10	164	12:27	15:57	21:05	10:38
20,5	11	198	2,5	03:25	10	12	198	15:04	19:17	25:43	12:51
25,2	9	238	2,5	04:12	12	14	238	18:26	23:19	31:05	15:33
30,8	7,4	282	3	05:08	14	16	282	22:29	28:22	37:40	19:03

Table for PE



Basis: DVS data sheets 2207, 2208 - State 2016

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 220° C ± 10° C / 428° F ± 18° F

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

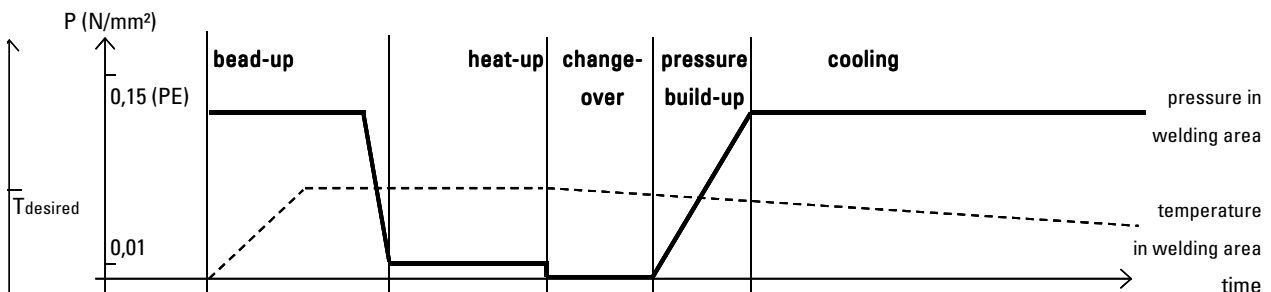
Values apply to butt welding of pipes according to DVS 2207, 2208 DIN 16932. They are standards for saddle welding, they can vary and must be calculated once again if necessary.

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.	heat-up time	max. change-over time	force ramp time	welding force [kp]	cooling time for ambient temperature			special cooling time 1
								< 15°C < 59°F	15-25°C 59-77°F	> 25°C > 77°F	
[mm]		[daN]	[mm]	[min:s]	[s]	[s]	[daN]	[min:s]	[min:s]	[min:s]	[min:s]
DA 250											
6,2	41	72	1	01:02	6	6	72	05:22	06:42	08:32	04:31
7,7	33	88	1,5	01:17	6	6	88	06:29	08:08	10:20	05:25
9,6	26	109	1,5	01:36	7	7	109	07:49	09:50	12:37	06:34
11,9	21	134	1,5	01:59	8	8	134	09:26	11:55	15:23	07:56
14,2	17,6	158	2	02:22	9	9	158	10:55	13:53	18:10	09:15
14,8	17	165	2	02:28	9	9	165	11:18	14:24	18:54	09:36
18,4	13,6	201	2	03:04	10	11	201	13:37	17:29	23:16	11:39
22,7	11	244	2,5	03:47	11	13	244	16:39	21:10	28:14	14:07
27,9	9	293	3	04:39	13	15	293	20:23	25:44	34:15	17:13
34,2	7,4	348	3	05:42	15	18	348	24:58	31:27	41:41	21:13
DA 280											
6,9	41	89	1	01:09	6	6	89	05:55	07:24	09:23	04:56
8,6	33	110	1,5	01:26	7	7	110	07:07	08:56	11:25	05:58
10,7	26	136	1,5	01:47	7	7	136	08:35	10:50	13:56	07:13
13,4	21	169	2	02:14	8	9	169	10:24	13:12	17:12	08:48
15,9	17,6	198	2	02:39	9	10	198	12:00	15:21	20:14	10:14
16,6	17	207	2	02:46	9	10	207	12:27	15:57	21:05	10:38
20,6	13,6	252	2,5	03:26	10	12	252	15:09	19:22	25:50	12:55
25,4	11	305	2,5	04:14	12	14	305	18:34	23:29	31:19	15:39
31,3	9	367	3	05:13	14	16	367	22:51	28:49	38:16	19:22
38,3	7,4	437	3,5	06:23	16	20	437	27:54	35:12	46:36	23:48

Table for PE



Basis: DVS data sheets 2207, 2208 - State 2016

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 220° C ± 10° C / 428° F ± 18° F

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1 kp = 10 N

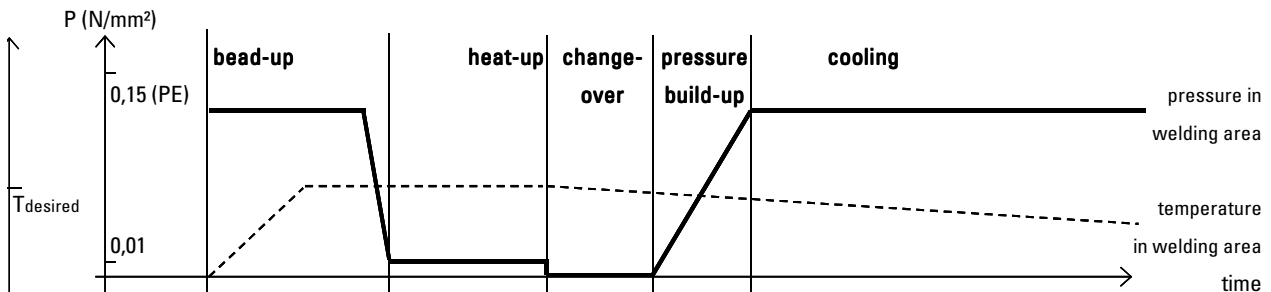
Values apply to butt welding of pipes according to DVS 2207, 2208 DIN 16932. They are standards for saddle welding, they can vary and must be calculated once again if necessary.

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
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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	15-25°C 59-77°F	> 25°C > 77°F	
[mm]		[daN]		[min:s]	[s]	[s]	[daN]	[min:s]	[min:s]	[min:s]	
DA 315											
7,7	41	112	1,5	01:17	6	6	112	06:29	08:08	10:20	05:25
9,7	33	140	1,5	01:37	7	7	140	07:53	09:56	12:44	06:37
12,1	26	173	2	02:01	8	8	173	09:34	12:05	15:37	08:03
15,0	21	213	2	02:30	9	9	213	11:26	14:34	19:09	09:43
17,9	17,6	251	2	02:59	10	11	251	13:18	17:03	22:40	11:22
18,7	17	262	2	03:07	10	11	262	13:48	17:45	23:38	11:50
23,2	13,6	320	2,5	03:52	11	13	320	17:00	21:36	28:48	14:24
28,6	11	386	3	04:46	13	15	386	20:53	26:22	35:04	17:39
35,2	9	465	3	05:52	15	18	465	25:41	32:22	42:52	21:51
43,1	7,4	553	3,5	07:11	18	22	553	31:13	39:38	52:30	26:45