

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 / ASM315 / ASM355

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.

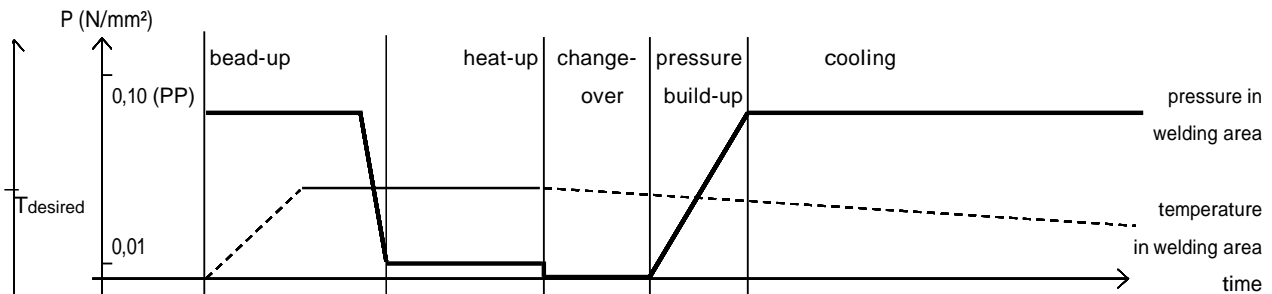
The maximum force of the welding machine is to be respected.



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 [Lbs.]	circular bead height min. [mm]	heat-up time [min:s]	max. change-over time [s]	force ramp time [s]	welding force [Lbs.]	cooling time for ambient temperature			special cooling time [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											
1,9	11	3	0,5	00:24	5	6	3	04:00	05:00	06:30	03:30
2,3	9	4	0,5	00:27	5	6	4	04:00	05:00	06:30	03:30
2,8	7,4	4	0,5	00:33	5	6	4	04:00	05:00	06:30	03:30
3,4	6	4	0,5	00:40	5	6	4	04:00	05:00	06:30	03:30
4,1	5	5	0,5	00:48	5	6	5	04:00	05:00	06:30	03:30
DA 25											
2,3	11	4	0,5	00:27	5	6	4	04:00	05:00	06:30	03:30
2,8	9	4	0,5	00:33	5	6	4	04:00	05:00	06:30	03:30
3,5	7,4	7	0,5	00:41	5	6	7	04:00	05:00	06:30	03:30
4,2	6	7	0,5	00:49	5	6	7	04:00	05:00	06:30	03:30
5,1	5	9	0,5	01:00	5	6	9	04:29	05:36	07:13	03:52
DA 32											
1,8	17,6	4	0,5	00:24	5	6	4	04:00	05:00	06:30	03:30
1,9	17	4	0,5	00:24	5	6	4	04:00	05:00	06:30	03:30
2,9	11	6	0,5	00:34	5	6	6	04:00	05:00	06:30	03:30
3,6	9	7	0,5	00:42	5	6	7	04:00	05:00	06:30	03:30
4,4	7,4	8	0,5	00:52	5	6	8	04:00	05:00	06:30	03:30
5,4	6	10	0,5	01:03	5	6	10	04:43	05:54	07:35	04:02
6,5	5	11	0,5	01:15	6	7	11	05:36	07:00	08:54	04:42

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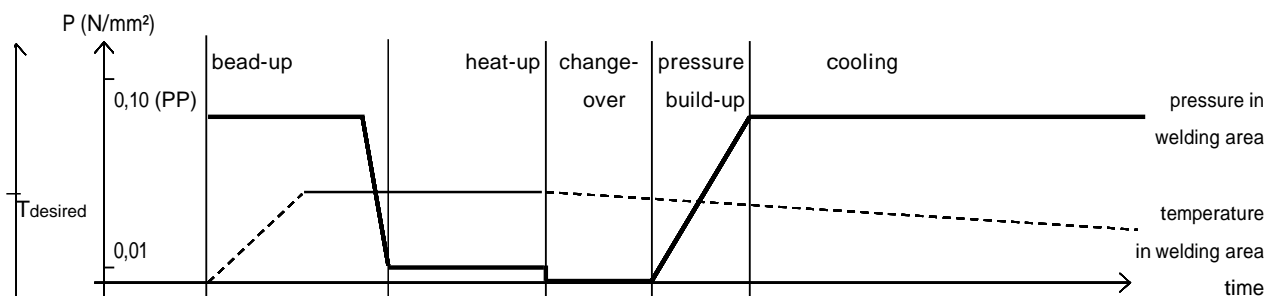
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								< 15°C < 59°F	15-25°C 59-77°F	> 25°C > 77°F	
[mm]		[daN]		[min:s]	[s]	[s]	[daN]	[min:s]	[min:s]	[min:s]	[min:s]
DA 40											
1,8	26	6	0,5	00:24	5	6	6	04:00	05:00	06:30	03:30
2,3	17,6	7	0,5	00:27	5	6	7	04:00	05:00	06:30	03:30
2,4	17	7	0,5	00:28	5	6	7	04:00	05:00	06:30	03:30
3,7	11	9	0,5	00:44	5	6	9	04:00	05:00	06:30	03:30
4,5	9	11	0,5	00:53	5	6	11	04:00	05:00	06:30	03:30
5,5	7,4	13	0,5	01:04	5	6	13	04:48	06:00	07:42	04:06
6,7	6	15	0,5	01:18	6	7	15	05:46	07:12	09:08	04:49
8,1	5	18	1	01:33	6	8	18	06:46	08:29	10:49	05:40
DA 50											
1,8	33	5	0,5	00:24	5	6	5	04:00	05:00	06:30	03:30
2,0	26	6	0,5	00:24	5	6	6	04:00	05:00	06:30	03:30
2,9	17,6	9	0,5	00:34	5	6	9	04:00	05:00	06:30	03:30
3,0	17	10	0,5	00:35	5	6	10	04:00	05:00	06:30	03:30
4,6	11,0	14	0,5	00:54	5	6	14	04:05	05:06	06:37	03:34
5,6	9	17	0,5	01:05	5	6	17	04:53	06:06	07:49	04:10
6,9	7,4	20	0,5	01:20	6	7	20	05:55	07:24	09:23	04:56
8,3	6	24	1	01:35	6	8	24	06:55	08:40	11:04	05:47
10,1	5	28	1	01:54	7	9	28	08:10	10:17	13:13	06:52

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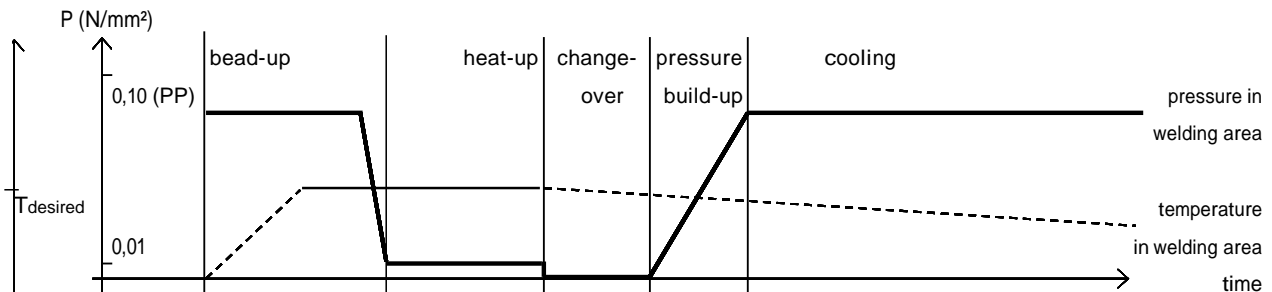
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								< 15°C < 59°F	15-25°C 59-77°F	> 25°C > 77°F	
[mm]		[daN]		[min:s]	[s]	[s]	[daN]	[min:s]	[min:s]	[min:s]	
DA 63											
1,8	41	7	0,5	00:24	5	6	7	04:00	05:00	06:30	03:30
2,0	33	8	0,5	00:24	5	6	8	04:00	05:00	06:30	03:30
2,5	26	11	0,5	00:29	5	6	11	04:00	05:00	06:30	03:30
3,6	17,6	15	0,5	00:42	5	6	15	04:00	05:00	06:30	03:30
3,8	17	18	0,5	00:45	5	6	18	04:00	05:00	06:30	03:30
5,8	11	24	0,5	01:08	6	7	24	05:02	06:18	08:04	04:17
7,1	9	29	1	01:22	6	7	29	06:04	07:35	09:37	05:04
8,6	7,4	33	1	01:38	6	8	33	07:07	08:56	11:25	05:58
10,5	6	40	1	01:59	7	10	40	08:27	10:39	13:42	07:06
12,7	5	46	1	02:22	7	12	46	09:57	12:36	16:21	08:24
DA 75											
1,9	41	11	0,5	00:24	5	6	11	04:00	05:00	06:30	03:30
2,3	33	13	0,5	00:27	5	6	13	04:00	05:00	06:30	03:30
2,9	26	15	0,5	00:34	5	6	15	04:00	05:00	06:30	03:30
4,3	17,6	22	0,5	00:51	5	6	22	04:00	05:00	06:30	03:30
4,5	17	22	0,5	00:53	5	6	22	04:00	05:00	06:30	03:30
6,8	11	33	0,5	01:19	6	7	33	05:50	07:18	09:16	04:53
8,4	9	40	1	01:36	6	8	40	06:59	08:46	11:11	05:50
10,3	7,4	46	1	01:57	7	10	46	08:19	10:28	13:28	06:59
12,5	6	55	1	02:20	7	11	55	09:49	12:26	16:06	08:17
15,1	5	64	1	02:46	8	14	64	11:30	14:39	19:16	09:46

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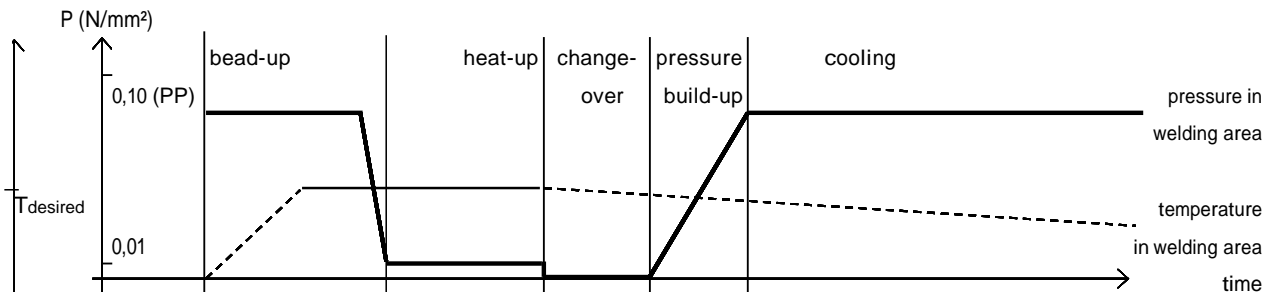
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
[mm]		[daN]					[daN]				
DA 90											
2,2	41	15	0,5	00:26	5	6	15	04:00	05:00	06:30	03:30
2,8	33	18	0,5	00:33	5	6	18	04:00	05:00	06:30	03:30
3,5	26	22	0,5	00:41	5	6	22	04:00	05:00	06:30	03:30
5,1	17,6	31	0,5	01:00	5	6	31	04:29	05:36	07:13	03:52
5,4	17	33	0,5	01:03	5	6	33	04:43	05:54	07:35	04:02
8,2	11	49	1	01:34	6	8	49	06:50	08:35	10:56	05:43
10,1	9	57	1	01:54	7	9	57	08:10	10:17	13:13	06:52
12,3	7,4	68	1	02:18	7	11	68	09:42	12:15	15:52	08:10
15,0	6	79	1	02:45	8	14	79	11:26	14:34	19:09	09:43
18,1	5	90	1	03:17	9	16	90	13:25	17:14	22:54	11:29
DA 110											
2,7	41	22	0,5	00:32	5	6	22	04:00	05:00	06:30	03:30
3,4	33	26	0,5	00:40	5	6	26	04:00	05:00	06:30	03:30
4,2	26	31	0,5	00:49	5	6	31	04:00	05:00	06:30	03:30
6,3	17,6	46	0,5	01:13	6	7	46	05:26	06:48	08:40	04:35
6,6	17	49	0,5	01:17	6	7	49	05:41	07:06	09:01	04:46
10,0	11	71	1	01:53	7	9	71	08:06	10:12	13:06	06:48
12,3	9	84	1	02:18	7	11	84	09:42	12:15	15:52	08:10
15,1	7,4	101	1	02:46	8	14	101	11:30	14:39	19:16	09:46
18,3	6	117	1	03:19	9	16	117	13:33	17:24	23:09	11:36
22,1	5	137	1,5	03:55	10	19	137	16:13	20:39	27:33	13:46

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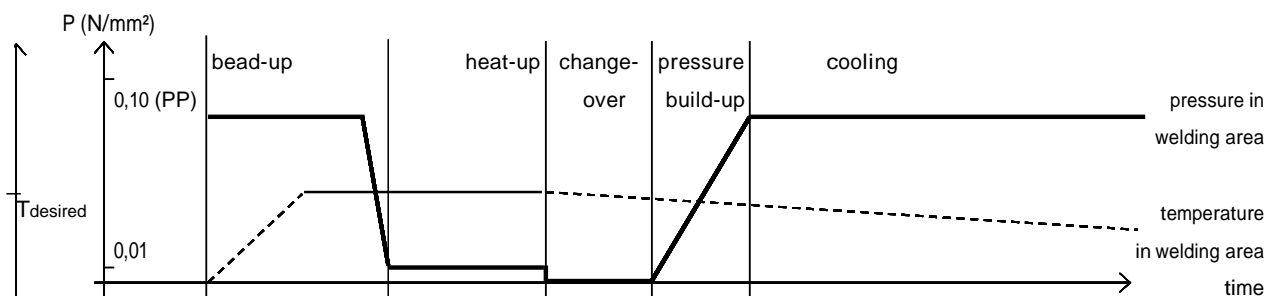
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[mm]		[daN]		[min:s]	[s]	[s]	[daN]	[min:s]	[min:s]	[min:s]	
DA 125											
3,1	41	26	0,5	00:37	5	6	26	04:00	05:00	06:30	03:30
3,9	33	33	0,5	00:46	5	6	33	04:00	05:00	06:30	03:30
4,8	26	42	0,5	00:56	5	6	42	04:14	05:18	06:52	03:41
7,1	17,6	60	1	01:22	6	7	60	06:04	07:35	09:37	05:04
7,4	17	62	1	01:25	6	7	62	06:17	07:52	09:59	05:14
11,4	11	90	1	02:09	7	11	90	09:05	11:28	14:47	07:38
14,0	9	108	1	02:35	8	13	108	10:47	13:43	17:56	09:09
17,1	7,4	128	1	03:07	8	15	128	12:47	16:22	21:42	10:55
20,8	6	152	1,5	03:43	10	18	152	15:17	19:33	26:03	13:02
25,1	5	174	1,5	04:23	11	21	174	18:21	23:14	30:58	15:29
DA 140											
3,5	41	35	0,5	00:41	5	6	35	04:00	05:00	06:30	03:30
4,3	33	42	0,5	00:51	5	6	42	04:00	05:00	06:30	03:30
5,4	26	51	0,5	01:03	5	6	51	04:43	05:54	07:35	04:02
8,0	17,6	75	1	01:32	6	8	75	06:42	08:24	10:42	05:36
8,3	17	77	1	01:35	6	8	77	06:55	08:40	11:04	05:47
12,7	11	112	1	02:22	7	12	112	09:57	12:36	16:21	08:24
15,7	9	137	1	02:53	8	14	137	11:53	15:10	20:00	10:07
19,2	7,4	161	1,5	03:28	9	17	161	14:09	18:10	24:14	12:07
23,3	6	190	1,5	04:06	10	20	190	17:04	21:41	28:55	14:27
28,1	5	218	2	04:48	12	24	218	20:32	25:55	34:29	17:20

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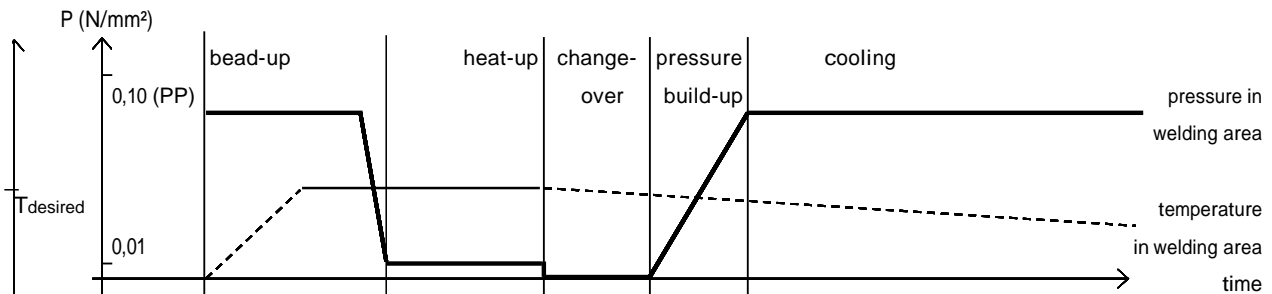
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[mm]		[daN]		[min:s]	[s]	[s]	[daN]	[min:s]	[min:s]	[min:s]	
DA 160											
4,0	41	44	0,5	00:47	5	6	44	04:00	05:00	06:30	03:30
4,9	33	53	0,5	00:57	5	6	53	04:19	05:24	06:59	03:44
6,2	26	66	0,5	01:12	6	7	66	05:22	06:42	08:32	04:31
9,1	17,6	97	1	01:44	6	9	97	07:28	09:23	12:01	06:16
9,5	17	99	1	01:48	6	9	99	07:45	09:45	12:30	06:30
14,6	11	148	1	02:41	8	13	148	11:10	14:14	18:39	09:29
17,9	9	176	1	03:15	9	16	176	13:18	17:03	22:40	11:22
21,9	7,4	212	1,5	03:53	10	19	212	16:04	20:29	27:19	13:39
26,6	6	247	2	04:36	11	23	247	19:26	24:33	32:43	16:23
32,1	5	284	2	05:21	13	28	284	23:26	29:33	39:13	19:53
DA 180											
4,4	41	55	0,5	00:52	5	6	55	04:00	05:00	06:30	03:30
5,5	33	68	0,5	01:04	5	6	68	04:48	06:00	07:42	04:06
6,9	26	84	0,5	01:20	6	7	84	05:55	07:24	09:23	04:56
10,2	17,6	121	1	01:56	7	10	121	08:14	10:23	13:20	06:55
10,7	17	126	1	02:01	7	10	126	08:35	10:50	13:56	07:13
16,4	11	187	1	03:00	8	15	187	12:20	15:46	20:51	10:31
20,1	9	223	1,5	03:36	9	18	223	14:47	18:57	25:15	12:38
24,6	7,4	267	1,5	04:18	11	21	267	18:00	22:48	30:24	15:12
29,0	6	304	2	04:56	12	25	304	21:11	26:44	35:33	17:55
36,1	5	362	2	05:55	14	31	362	26:21	33:11	43:56	22:26

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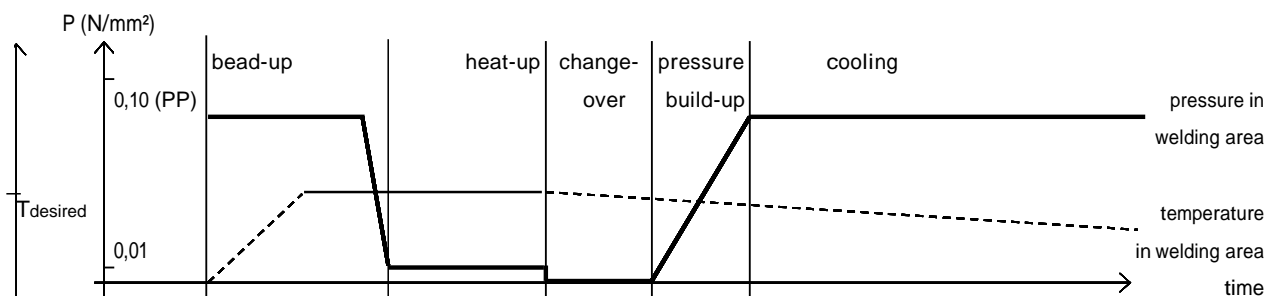
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pipe wall (s)	SDR degree	bead-up force [Lbs]	circular bead height min. [mm]	heat-up time [min:s]	max. change-over time [s]	force ramp time [s]	welding force [Lbs]	cooling time for ambient temperature			special cooling time [min:s]
								< 15°C < 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]	<input type="checkbox"/>
DA 200											
4,9	41	68	0,5	00:57	5	6	68	04:19	05:24	06:59	03:44
6,2	33	84	0,5	01:12	6	7	84	05:22	06:42	08:32	04:31
7,7	26	104	1	01:29	6	8	104	06:29	08:08	10:20	05:25
11,4	17,6	150	1	02:09	7	11	150	09:05	11:28	14:47	07:38
11,9	17	157	1	02:14	7	11	157	09:26	11:55	15:23	07:56
18,2	11	229	1	03:18	9	16	229	13:29	17:19	23:02	11:33
22,4	9	276	1,5	03:58	10	19	276	16:26	20:55	27:53	13:57
27,4	7,4	328	2	04:43	11	23	328	20:01	25:16	33:39	16:53
33,2	6	384	2	05:31	13	29	384	24:14	30:33	40:31	20:35
DA 225											
5,5	41	84	0,5	01:04	5	6	84	04:48	06:00	07:42	04:06
6,9	33	106	0,5	01:20	6	7	106	05:55	07:24	09:23	04:56
8,6	26	130	1	01:38	6	8	130	07:07	08:56	11:25	05:58
12,8	17,6	190	1	02:23	7	12	190	10:01	12:41	16:28	08:27
13,4	17	198	1	02:29	7	12	198	10:24	13:12	17:12	08:48
20,5	11	291	1,5	03:40	9	18	291	15:04	19:17	25:43	12:51
25,2	9	351	1,5	04:24	11	21	351	18:26	23:19	31:05	15:33
30,8	7,4	414	2	05:11	12	26	414	22:29	28:22	37:40	19:03
37,4	6	487	2,5	06:05	14	32	487	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 / ASM315 / ASM355

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!

$$1 \text{ kp} = 10 \text{ N}$$

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.

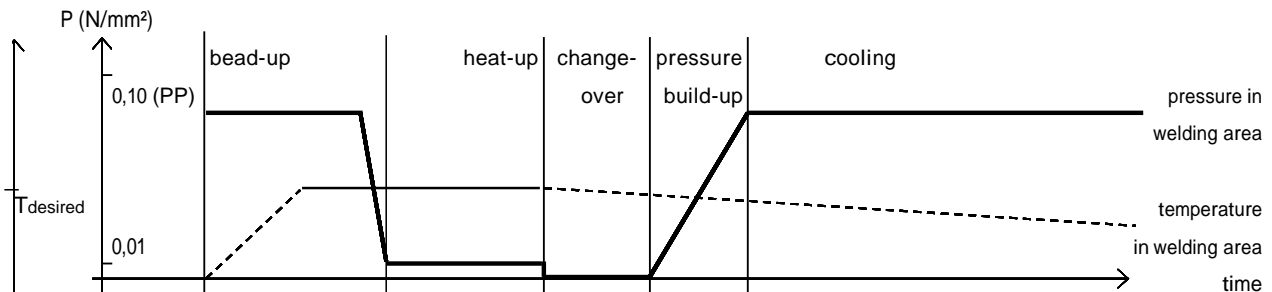
The maximum force of the welding machine is to be respected.



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 [Lbs]	circular bead height min. [mm]	heat-up time [min:s]	max. change-over time [s]	force ramp time [s]	welding force [Lbs]	cooling time for ambient temperature			special cooling time [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]				<input type="checkbox"/>
DA 250											
6,2	41	106	0,5	01:12	6	7	106	05:22	06:42	08:32	04:31
7,7	33	130	1	01:29	6	8	130	06:29	08:08	10:20	05:25
9,6	26	161	1	01:49	7	9	161	07:49	09:50	12:37	06:34
14,2	17,6	234	1	02:37	8	13	234	10:55	13:53	18:10	09:15
14,8	17	243	1	02:43	8	13	243	11:18	14:24	18:54	09:36
22,7	11	359	1,5	04:00	10	20	359	16:39	21:10	28:14	14:07
27,9	9	430	2	04:47	12	24	430	20:23	25:44	34:15	17:13
34,2	7,4	511	2	05:39	13	29	511	24:58	31:27	41:41	21:13
DA 280											
6,9	41	132	0,5	01:20	6	7	132	05:55	07:24	09:23	04:56
8,6	33	163	1	01:38	6	8	163	07:07	08:56	11:25	05:58
10,7	26	201	1	02:01	7	10	201	08:35	10:50	13:56	07:13
15,9	17,6	291	1	02:55	8	14	291	12:00	15:21	20:14	10:14
16,6	17	304	1	03:02	8	15	304	12:27	15:57	21:05	10:38
25,4	11	450	1,5	04:25	11	22	450	18:34	23:29	31:19	15:39
31,3	9	540	2	05:15	12	27	540	22:51	28:49	38:16	19:22
38,3	7,4	642	2,5	06:11	14	33	642	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 / ASM315 / ASM355

Heating element temperature is $210^{\circ}\text{C} \pm 10^{\circ}\text{C}$ / $410^{\circ}\text{F} \pm 18^{\circ}$

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

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

$$1 \text{ kp} = 10 \text{ N}$$

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.

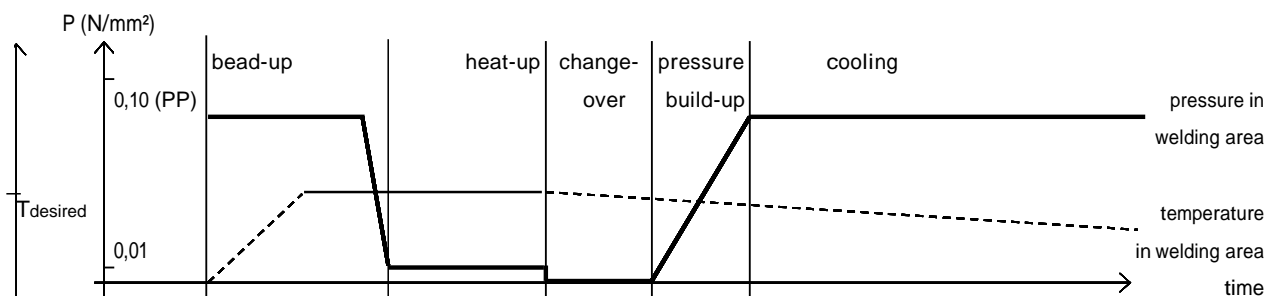
The maximum force of the welding machine is to be respected.



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 [Lbs]	circular bead height min. [mm]	heat-up time [min:s]	max. change-over time [s]	force ramp time [s]	welding force [Lbs]	cooling time for ambient temperature			special cooling time <input type="checkbox"/> [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 315											
7,7	41	165	1	01:29	6	8	165	06:29	08:08	10:20	05:25
9,7	33	207	1	01:50	7	9	207	07:53	09:56	12:44	06:37
12,1	26	256	1	02:16	7	11	256	09:34	12:05	15:37	08:03
17,9	17,6	370	1	03:15	9	16	370	13:18	17:03	22:40	11:22
18,7	17	386	1	03:23	9	17	386	13:48	17:45	23:38	11:50
28,6	11	569	2	04:53	12	24	569	20:53	26:22	35:04	17:39
35,2	9	683	2	05:47	14	30	683	25:41	32:22	42:52	21:51