

MAXIPLAST 6

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Butt Fusion Welding Parameters Single Wall Pipe

Nominal Pipe Size (inches)	Initial Melt Pressure lbs	Melt Pressure lbs	Heat Soak Time (sec)	Change Over Time (sec)	Welding Pressure lbs	Cooling Time (min)
Pro 150						
1-1/2	14	1	35	4	14	6
2	23	2	45	5	23	7
2-1/2	33	2	55	7	33	9
3	46	3	60	8	46	10
4	69	3	80	9	69	13
6	148	10	100	10	148	16
Pro 45						
4	26	1	35	5	26	5
6	54	4	45	5	54	5
Air Pro						
4" (230 psi)	70	3	100	9	70	13
6" (150 psi)	220	10	200	10	220	15

Super Pro						
1-1/2 (230)	12	2	30	4	12	5
2 (230)	16	2	35	4	16	5
2-1/2 (230)	16	3	40	4	16	5
3 (150)	22	3	30	4	22	6
4 (150)	34	4	40	4	34	7
6 (150)	70	5	60	4	70	10
Halar						
1-1/2	9	1	14	4	9	4
2	11	1	15	4	11	5
3	23	1	25	4	23	6

Welding Temperatures:

HDPE	420°F-446°F	215°C-230°C
PP	393°F-410°F	200°C-210°C
PVDF	446°F-10°F	230°C- 5°C
Halar	536°F	280°C

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Duo Pro Welding Parameters

Nominal Pipe Size (inches)	Initial Melt Pressure lbs	Melt Pressure lbs	Heat Soak Time (sec)	Change Over Time (sec)	Welding Pressure lbs	Cooling Time (min)
Pro 150x45						
2x4	49	5	60	4	49	7
3x6	100	6	80	4	100	9
Pro 150x150						
2x4	92	6	100	4	92	13
3x6	194	9	130	4	194	16
PVDF x PVDF						
2x4	50	6	50	4	50	10
3x6	92	8	70	4	92	12

Welding Temperatures:

HDPE	420°F-446°F
PP	393°F-410°F
PVDF	436°F-456°F

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PolyFlo Welding Data

Nominal Pipe Size (inches)	Initial Melt Pressure lbs	Melt Pressure lbs	Heat Soak Time (sec)	Change Over Time (sec)	Welding Pressure lbs	Cooling Time (min)
1x2 PVDF	16	3	50	4	16	5
1x2 PP	9	1	40	4	9	5
2x3 PVDF	50	5	60	4	50	8
2x3 PP	33	2	70	7	33	9
2x3 HDPE	20	2	36	7	20	9
4x6 PVDF	172	15	120	8	172	14
4x6 PP	132	10	80	8	132	10

Welding Temperatures:

PP	393°F-410°F	200°C-210°C
PVDF	440°F-450°F	227°C-232°C
HDPE	420°F-446°F	215°C-230°C

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HDPE Single Wall welding data						
SDR 11						
Size (Inches)	Initial melt pressure Lbs	Melt Pressure	Heat soak time (Sec)	Change over time (Sec)	Welding pressure Lbs	Cooling time (Minutes)
2	32		55	5	32	10
3	69	Almost	81	5	69	16
4	114	Zero	104	6	114	16
6	248		153	8	248	24

HDPE Single Wall welding data						
SDR 17						
Size (Inches)	Initial melt pressure Lbs	Melt Pressure	Heat soak time (Sec)	Change over time (Sec)	Welding pressure Lbs	Cooling time (Minutes)
2	21		35	3	21	5
3	46	Almost	52	5	46	7
4	77	Zero	67	5	77	10
6	166		99	6	166	16

HDPE Single Wall welding data						
SDR 26						
Size (Inches)	Initial melt pressure Lbs	Melt Pressure	Heat soak time (Sec)	Change over time (Sec)	Welding pressure Lbs	Cooling time (Minutes)
2	14		23	3	14	5
3	31	Almost	34	3	31	6
4	51	Zero	44	4	51	6
6	111		65	5	111	10

HDPE Single Wall welding data						
SDR 32.5						
Size (Inches)	Initial melt pressure Lbs	Melt Pressure	Heat soak time (Sec)	Change over time (Sec)	Welding pressure Lbs	Cooling time (Minutes)
2	11		19	3	11	5
3	25	Almost	27	3	25	5
4	41	Zero	35	3	41	5
6	89		52	5	89	6

Welding Temperatures:

PP	393°F-410°F	200°C-210°C
PVDF	440°F-450°F	227°C-232°C
HDPE	420°F-446°F	215°C-230°C

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HDPE Double wall welding data						
SDR 11 x SDR 11						
Size (Inches)	Initial melt pressure Lbs	Melt Pressure	Heat soak time (Sec)	Change over time (Sec)	Welding pressure Lbs	Cooling time (Minutes)
1 x 3	79	Almost	81	5	79	16
2 x 4	146		104	6	146	16
3 x 6	317	Zero	153	5	317	24

HDPE Double wall welding data						
SDR 11 x SDR 17						
Size (Inches)	Initial melt pressure Lbs	Melt Pressure	Heat soak time (Sec)	Change over time (Sec)	Welding pressure Lbs	Cooling time (Minutes)
1 x 3	56	Almost	52	3	56	7
2 x 4	108		67	3	108	10
3 x 6	235	Zero	99	5	235	16

HDPE Double wall welding data						
SDR 17 x SDR 17						
Size (Inches)	Initial melt pressure Lbs	Melt Pressure	Heat soak time (Sec)	Change over time (Sec)	Welding pressure Lbs	Cooling time (Minutes)
2 x 4	98	Almost	67	3	98	10
3 x 6	212	Zero	99	5	212	16

HDPE Double wall welding data						
SDR 17 x SDR 26						
Size (Inches)	Initial melt pressure Lbs	Melt Pressure	Heat soak time (Sec)	Change over time (Sec)	Welding pressure Lbs	Cooling time (Minutes)
2 x 4	72	Almost	44	3	72	6
3 x 6	157	Zero	65	5	157	10

HDPE Double wall welding data						
SDR 26 x SDR 26						
Size (Inches)	Initial melt pressure Lbs	Melt Pressure	Heat soak time (Sec)	Change over time (Sec)	Welding pressure Lbs	Cooling time (Minutes)
2 x 4	65	Almost	44	3	65	6
3 x 6	142	Zero	65	3	142	10

Welding Temperatures:

PP	393°F-410°F	200°C-210°C
PVDF	440°F-450°F	227°C-232°C
HDPE	420°F-446°F	215°C-230°C

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HDPE Double wall welding data						
SDR 26 x SDR 32.5						
Size (Inches)	Initial melt pressure Lbs	Melt Pressure	Heat soak time (Sec)	Change over time (Sec)	Welding pressure Lbs	Cooling time (Minutes)
2 x 4	56	Almost	35	3	56	5
3 x 6	120	Zero	52	5	120	6

Welding Temperatures:

PP	393°F-410°F	200°C-210°C
PVDF	440°F-450°F	227°C-232°C
HDPE	420°F-446°F	215°C-230°C

HDPE SDR 11 x SDR 11 (IPS PE 80)						
1 x 3	79	Almost Zero	81	5	79	16
HDPE SDR 11 x SDR 17 (IPS PE 80)						
1 x 3	56	Almost Zero	52	3	56	7