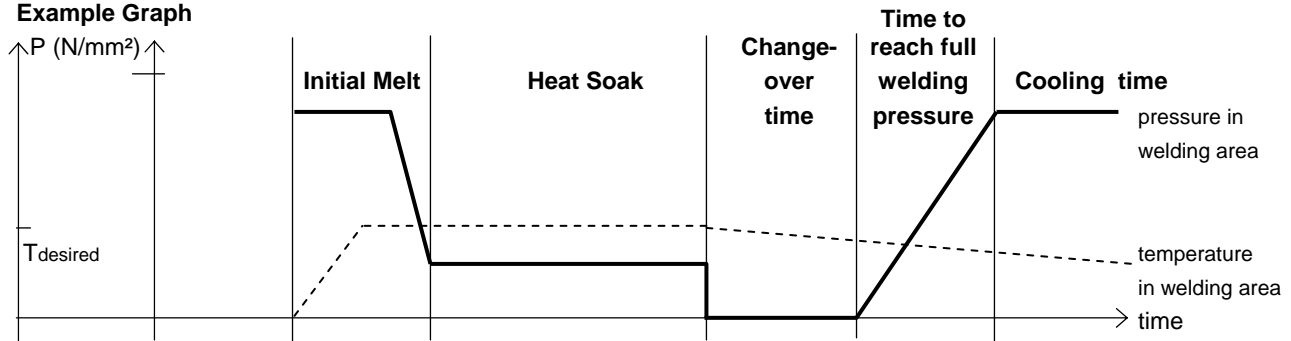


Section V - Maxioplast Welding Parameters

Example Graph



Single Wall Butt Fusion

PIPE SIZE (INCHES)	INITIAL MELT PRESSURE (LBS)	MELT PRESSURE (LBS)	HEATSOAK TIME (SEC)	CHANGE OVER TIME (SEC)	WELDING PRESSURE (LBS)	COOLING TIME (MIN)
Pro 150						
1 ½	14		35	4	14	6
2	23	Almost	45	5	23	7
2 ½	33		55	7	33	9
3	46	Zero	60	8	46	10
4	69		80	9	69	13
6	148		100	10	148	16
Pro 45						
4	26	Almost	35	5	26	5
6	54	Zero	45	5	54	5
Air Pro						
4 (230 psi)	70	Almost	100	9	70	13
6 (150 psi)	220	Zero	200	10	220	15
PVDF						
1 ½ (230 psi)	12		30	4	12	5
2 (230 psi)	16	Almost	35	4	16	5
2 ½ (230 psi)	16		40	4	16	5
3 (150 psi)	22	Zero	30	4	22	6
4 (150 psi)	34		40	4	34	7
6 (150 psi)	70		60	4	70	10
Halar						
1 ½	9		14	3	9	4
2	11	Almost	15	3	11	5
3	23		25	3	23	6
4	33	Zero	40	4	33	7
6	70		50	4	70	10

Welding Temperatures

PP	393°F-410°F	200°C-210°C
HDPE	420°F-446°F	215°C-230°C
PVDF	436°F-446°F	225°C-230°C
Halar	527°F-536°F	275°C-280°C

Maxiplast
Single Wall Butt Fusion

PIPE SIZE (INCHES)	INITIAL MELT PRESSURE (LBS)	MELT PRESSURE (LBS)	HEATSOAK TIME (SEC)	CHANGE OVER TIME (SEC)	WELDING PRESSURE (LBS)	COOLING TIME (MIN)
HDPE SDR 11 (IPS PE 80)						
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 SDR 17 (IPS PE 80)						
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 SDR 26						
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 SDR 32.5						
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
HDPE	420°F-446°F	215°C-230°C
PVDF	436°F-446°F	225°C-230°C

Maxiplast
Double Containment Butt Fusion

PIPE SIZE (INCHES)	INITIAL MELT PRESSURE (LBS)	MELT PRESSURE (LBS)	HEATSOAK TIME (SEC)	CHANGE OVER TIME (SEC)	WELDING PRESSURE (LBS)	COOLING TIME (MIN)
Pro 150 x Pro 45						
2 x 4	49	Almost	60	4	49	7
3 x 6	100	Zero	80	4	100	9
Pro 150 x Pro 150						
1 x 3	52	Almost	80	3	52	10
2 x 4	92	Zero	100	4	92	13
3 x 6	194		130	4	194	16
PVDF x PVDF						
2 x 4	50	Almost	50	4	50	10
3 x 6	92	Zero	70	4	92	12
Poly-Flo Polypropylene						
1 x 2	15	Almost	40	4	15	5
2 x 3	30	Zero	70	7	30	9
4 x 6	95		80	8	95	10
Poly-Flo HDPE						
1 x 2	17	Almost	30	4	17	5
2 x 3	17	Zero	30	7	17	9
4 x 6	168		62	8	168	15
Poly-Flo PVDF						
1 x 2	16	Almost	65	4	16	5
2 x 3	30	Zero	72	4	30	8
HDPE SDR 11 x SDR 11 (IPS PE 80)						
2 x 4	146	Almost	104	6	146	16
3 x 6	317	Zero	153	6	317	24
HDPE SDR 11 x SDR 17 (IPS PE 80)						
2 x 4	108	Almost	67	3	108	10
3 x 6	235	Zero	99	5	235	16
HDPE SDR 17 x SDR 17 (IPS PE 80)						
2 x 4	96	Almost	67	3	96	10
3 x 6	212	Zero	99	5	212	16

Welding Temperatures

PP	393°F-410°F	200°C-210°C
HDPE	420°F-446°F	215°C-230°C
PVDF	436°F-446°F	225°C-230°C