

Acrobat 250 Welding Parameters

CURRENT AS OF
12/11/2025

Product Line & Material	Pipe Size	Initial Melt Pressure (psi)	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure (psi)	Cooling Time
Air-Pro® (PE)	2" (63mm) SDR7	56.6 psi	1.5 mm	Almost Zero	86 seconds	7 seconds	56.6 psi	8.9 min
Air-Pro® (PE)	3" (90mm) SDR7	117.1 psi	2 mm	Almost Zero	123 seconds	8 seconds	117.1 psi	12.3 min
Air-Pro® (PE)	4" (110mm) SDR7	176 psi	2 mm	Almost Zero	151 seconds	9 seconds	170	14.7 min
Air-Pro® (PE)	6" (160mm) SDR11	257.7 psi	2 mm	Almost Zero	146 seconds	9 seconds	257.7 psi	14.2 min
Air-Pro® (PE)	8" (200mm) SDR11	381.9 psi	2 mm	Almost Zero	182 seconds	10 seconds	381.9 psi	17.3 min
Air-Pro® (PE)	10" (250mm) SDR11	598.4 psi	2.5 mm	Almost Zero	227 seconds	11 seconds	598.4 psi	21.2 min
Chem Proline® (PE)	2" (63mm) SDR11	44.0 psi	1 mm	Almost Zero	58 seconds	6 seconds	44.0 psi	6.3 min
Chem Proline® (PE)	3" (90mm) SDR11	89.1 psi	1.5 mm	Almost Zero	82 seconds	6 seconds	89.1 psi	8.6 min
Chem Proline® (PE)	4" (110mm) SDR11	122 psi	1.5 mm	Almost Zero	100 seconds	7 seconds	127.3 psi	10.2 min
Chem Proline® (PE)	6" (160mm) SDR11	257.7 psi	2 mm	Almost Zero	146 seconds	9 seconds	257.7 psi	14.2 min
Chem Proline® (PE)	8" (200mm) SDR11	381.9 psi	2 mm	Almost Zero	182 seconds	10 seconds	381.9 psi	17.3 min
Chem Proline® (PE)	10" (250mm) SDR11	598.4 psi	2.5 mm	Almost Zero	227 seconds	11 seconds	598.4 psi	21.2 min

Welding Temperatures

PP: 393°F - 410°F (200°C - 210°C)
 PE: 420°F - 446°F (215°C - 230°C)
 PVDF: 436°F - 446°F (225°C - 230°C)
 ECTFE: 527°F - 536°F (275°C - 280°C)

A reduction in the cooling time of up to 50%, i.e. removal of the welded part from the welding machine, is permitted in the following circumstances:

- the joint connection was created under workshop conditions and
- the removal of the part from the welding machine and its temporary storage until the complete cooling time according to the Cooling Time column causes negligible loading of the joint

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Product Line & Material	Pipe Size	Initial Melt Pressure (psi)	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure (psi)	Cooling Time
Proline® PRO150 (PP)	2" (63mm) SDR11	31.4 psi	0.5 mm	Almost Zero	68 seconds	6 seconds	31.4 psi	6.3 min
Proline® PRO150 (PP)	2-1/2" (75mm) SDR11	38.2 psi	0.5 mm	Almost Zero	79 seconds	6 seconds	38.2 psi	7.3 min
Proline® PRO150 (PP)	3" (90mm) SDR11	63.7 psi	1 mm	Almost Zero	94 seconds	6 seconds	63.7 psi	8.6 min
Proline® PRO150 (PP)	4" (110mm) SDR11	89.1 psi	1 mm	Almost Zero	113 seconds	7 seconds	89.1 psi	10.2 min
Proline® PRO150 (PP)	4-1/2" (125mm) SDR11	101.8 psi	1 mm	Almost Zero	129 seconds	7 seconds	101.8 psi	11.5 min
Proline® PRO150 (PP)	5" (140mm) SDR11	127.3 psi	1 mm	Almost Zero	142 seconds	7 seconds	127.3 psi	12.6 min
Proline® PRO150 (PP)	6" (160mm) SDR11	165.5 psi	1 mm	Almost Zero	161 seconds	8 seconds	165.5 psi	14.2 min
Proline® PRO150 (PP)	7" (180mm) SDR11	216.4 psi	1 mm	Almost Zero	180 seconds	8 seconds	216.4 psi	15.8 min
Proline® PRO150 (PP)	8" (200mm) SDR11	254.6 psi	1 mm	Almost Zero	198 seconds	9 seconds	254.6 psi	17.3 min
Proline® PRO150 (PP)	9" (225mm) SDR11	331.0 psi	1.5 mm	Almost Zero	220 seconds	9 seconds	331.0 psi	19.3 min
Proline® PRO150 (PP)	10" (250mm) SDR11	407.4 psi	1.5 mm	Almost Zero	240 seconds	10 seconds	407.4 psi	21.2 min
Proline® PRO90 (PP)	2" (63mm) SDR17.6	18.9 psi	0.5 mm	Almost Zero	42 seconds	5 seconds	18.9 psi	5.0 min

Welding Temperatures

PP: 393°F - 410°F (200°C - 210°C)
 PE: 420°F - 446°F (215°C - 230°C)
 PVDF: 436°F - 446°F (225°C - 230°C)
 ECTFE: 527°F - 536°F (275°C - 280°C)

A reduction in the cooling time of up to 50%, i.e. removal of the welded part from the welding machine, is permitted in the following circumstances:

- the joint connection was created under workshop conditions and
- the removal of the part from the welding machine and its temporary storage until the complete cooling time according to the Cooling Time column causes negligible loading of the joint

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Product Line & Material	Pipe Size	Initial Melt Pressure (psi)	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure (psi)	Cooling Time
Proline® PRO90 (PP)	2-1/2" (75mm) SDR17.6	25.5 psi	0.5 mm	Almost Zero	51 seconds	5 seconds	25.5 psi	5.0 min
Proline® PRO90 (PP)	3" (90mm) SDR17.6	38.2 psi	0.5 mm	Almost Zero	60 seconds	5 seconds	38.2 psi	5.4 min
Proline® PRO90 (PP)	4" (110mm) SDR17.6	50.9 psi	0.5 mm	Almost Zero	73 seconds	6 seconds	50.9 psi	6.5 min
Proline® PRO90 (PP)	4-1/2" (125mm) SDR17.6	76.4 psi	1 mm	Almost Zero	82 seconds	6 seconds	76.4 psi	7.4 min
Proline® PRO90 (PP)	5" (140mm) SDR17.6	89.1 psi	1 mm	Almost Zero	92 seconds	6 seconds	89.1 psi	8.2 min
Proline® PRO90 (PP)	6" (160mm) SDR17.6	114.6 psi	1 mm	Almost Zero	104 seconds	6 seconds	114.6 psi	9.2 min
Proline® PRO90 (PP)	7" (180mm) SDR17.6	140.0 psi	1 mm	Almost Zero	116 seconds	7 seconds	140.0 psi	10.2 min
Proline® PRO90 (PP)	8" (200mm) SDR17.6	165.5 psi	1 mm	Almost Zero	129 seconds	7 seconds	165.5 psi	11.3 min
Proline® PRO90 (PP)	9" (225mm) SDR17.6	216.4 psi	1 mm	Almost Zero	143 seconds	7 seconds	216.4 psi	12.4 min
Proline® PRO90 (PP)	10" (250mm) SDR17.6	267.4 psi	1 mm	Almost Zero	157 seconds	8 seconds	267.4 psi	13.5 min
Proline® PRO45 (PP)	4" (110mm) SDR33	38.2 psi	0.5 mm	Almost Zero	40 seconds	5 seconds	38.2 psi	5.0 min
Proline® PRO45 (PP)	4-1/2" (125mm) SDR33	38.2 psi	0.5 mm	Almost Zero	46 seconds	5 seconds	38.2 psi	5.0 min

Welding Temperatures

PP: 393°F - 410°F (200°C - 210°C)
 PE: 420°F - 446°F (215°C - 230°C)
 PVDF: 436°F - 446°F (225°C - 230°C)
 ECTFE: 527°F - 536°F (275°C - 280°C)

A reduction in the cooling time of up to 50%, i.e. removal of the welded part from the welding machine, is permitted in the following circumstances:

- the joint connection was created under workshop conditions and
- the removal of the part from the welding machine and its temporary storage until the complete cooling time according to the Cooling Time column causes negligible loading of the joint

Acrobat 250 Welding Parameters

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Product Line & Material	Pipe Size	Initial Melt Pressure (psi)	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure (psi)	Cooling Time
Proline® PRO45 (PP)	5" (140mm) SDR33	50.9 psi	0.5 mm	Almost Zero	51 seconds	5 seconds	50.9 psi	5.0 min
Proline® PRO45 (PP)	6" (160mm) SDR33	63.7 psi	0.5 mm	Almost Zero	57 seconds	5 seconds	63.7 psi	5.4 min
Proline® PRO45 (PP)	7" (180mm) SDR33	76.4 psi	0.5 mm	Almost Zero	64 seconds	5 seconds	76.4 psi	6.0 min
Proline® PRO45 (PP)	8" (200mm) SDR33	101.8 psi	0.5 mm	Almost Zero	72 seconds	6 seconds	101.8 psi	6.7 min
Proline® PRO45 (PP)	9" (225mm) SDR33	127.3 psi	0.5 mm	Almost Zero	80 seconds	6 seconds	127.3 psi	7.4 min
Proline® PRO45 (PP)	10" (250mm) SDR33	152.8 psi	1 mm	Almost Zero	89 seconds	6 seconds	152.8 psi	8.1 min
Super Proline® (PVDF)	2" (63mm) SDR21	18.9 psi	0.5 mm	Almost Zero	70 seconds	3 seconds	18.9 psi	5.5 min
Super Proline® (PVDF)	2-1/2" (75mm) SDR21	25.5 psi	0.5 mm	Almost Zero	76 seconds	3 seconds	25.5 psi	6.5 min
Super Proline® (PVDF)	3" (90mm) SDR21	38.2 psi	0.5 mm	Almost Zero	83 seconds	3 seconds	38.2 psi	7.0 min
Super Proline® (PVDF)	4" (110mm) SDR21	50.9 psi	0.5 mm	Almost Zero	93 seconds	3 seconds	50.9 psi	8.5 min
Super Proline® (PVDF)	6" (160mm) SDR21	101.8 psi	0.7 mm	Almost Zero	117 seconds	4 seconds	101.8 psi	11.0 min
Super Proline® (PVDF)	8" (200mm) SDR21	152.8 psi	1 mm	Almost Zero	136 seconds	4 seconds	152.8 psi	13.5 min

Welding Temperatures

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 PE: 420°F - 446°F (215°C - 230°C)
 PVDF: 436°F - 446°F (225°C - 230°C)
 ECTFE: 527°F - 536°F (275°C - 280°C)

A reduction in the cooling time of up to 50%, i.e. removal of the welded part from the welding machine, is permitted in the following circumstances:

- the joint connection was created under workshop conditions and
- the removal of the part from the welding machine and its temporary storage until the complete cooling time according to the Cooling Time column causes negligible loading of the joint

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Super Proline® (PVDF)	10" (250mm) SDR21	229.2 psi	1.1 mm	Almost Zero	159 seconds	4 seconds	229.2 psi	16.5 min
Super Proline® (PVDF)	3" (90mm) SDR33	25.5 psi	0.5 mm	Almost Zero	68 seconds	3 seconds	25.5 psi	5.5 min
Super Proline® (PVDF)	4" (110mm) SDR33	38.2 psi	0.5 mm	Almost Zero	74 seconds	3 seconds	38.2 psi	6.0 min
Super Proline® (PVDF)	6" (160mm) SDR33	63.7 psi	0.5 mm	Almost Zero	89 seconds	3 seconds	63.7 psi	8.0 min
Super Proline® (PVDF)	8" (200mm) SDR33	101.8 psi	0.6 mm	Almost Zero	102 seconds	4 seconds	101.8 psi	9.5 min
Super Proline® (PVDF)	10" (250mm) SDR33	152.8 psi	0.7 mm	Almost Zero	117 seconds	4 seconds	152.8 psi	11.0 min
Chem Prolok® (PE)	2" X 4" (63mm X 110mm) SDR11X33	90.1 psi	0.5 mm	Almost Zero	34 seconds	6 seconds	90.1 psi	6.3 min
Chem Prolok® (PE)	2" X 6" (63mm X 160mm) SDR11X33	132.0 psi	1 mm	Almost Zero	49 seconds	5 seconds	132.0 psi	6.3 min
Chem Prolok® (PE)	3" X 6" (90mm X 160mm) SDR11X33	116.7 psi	1 mm	Almost Zero	82 seconds	6 seconds	116.7 psi	8.6 min
Chem Prolok® (PE)	4" X 8" (110mm X 200mm) SDR11X33	233.4 psi	1 mm	Almost Zero	100 seconds	7 seconds	233.4 psi	10.2 min
Chem Prolok® (PE)	6" X 10" (160mm X 250mm) SDR11X33	404.0 psi	1.5 mm	Almost Zero	146 seconds	9 seconds	404.0 psi	14.2 min
Duo-Pro® PRO150X150 (PP)	2" X 4" (63mm X 110mm) SDR11X11	104.0 psi	1 mm	Almost Zero	113 seconds	5 seconds	104.0 psi	10.2 min

Welding Temperatures

PP: 393°F - 410°F (200°C - 210°C)
 PE: 420°F - 446°F (215°C - 230°C)
 PVDF: 436°F - 446°F (225°C - 230°C)
 ECTFE: 527°F - 536°F (275°C - 280°C)

A reduction in the cooling time of up to 50%, i.e. removal of the welded part from the welding machine, is permitted in the following circumstances:

- the joint connection was created under workshop conditions and
- the removal of the part from the welding machine and its temporary storage until the complete cooling time according to the Cooling Time column causes negligible loading of the joint

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Product Line & Material	Pipe Size	Initial Melt Pressure (psi)	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure (psi)	Cooling Time
Duo-Pro® PRO150X150 (PP)	2" X 6" (63mm X 160mm) SDR11X11	192.3 psi	1 mm	Almost Zero	161 seconds	8 seconds	192.3 psi	14.2 min
Duo-Pro® PRO150X150 (PP)	3" X 6" (90mm X 160mm) SDR11X11	219.4 psi	1 mm	Almost Zero	161 seconds	8 seconds	219.4 psi	14.2 min
Duo-Pro® PRO150X150 (PP)	4" X 8" (110mm X 200mm) SDR11X11	343.7 psi	1 mm	Almost Zero	198 seconds	9 seconds	343.7 psi	17.3 min
Duo-Pro® PRO150X150 (PP)	6" X 10" (160mm X 250mm) SDR11X11	572.9 psi	1.5 mm	Almost Zero	240 seconds	10 seconds	572.9 psi	21.2 min
Duo-Pro® PRO150X45 (PP)	2" X 4" (63mm X 110mm) SDR11X33	54.4 psi	0.5 mm	Almost Zero	94 seconds	6 seconds	54.4 psi	6.3 min
Duo-Pro® PRO150X45 (PP)	2" X 6" (63mm X 160mm) SDR11X33	94.3 psi	0.5 mm	Almost Zero	68 seconds	6 seconds	94.3 psi	6.3 min
Duo-Pro® PRO150X45 (PP)	3" X 6" (90mm X 160mm) SDR11X33	112.4 psi	0.5 mm	Almost Zero	94 seconds	6 seconds	112.4 psi	8.6 min
Duo-Pro® PRO150X45 (PP)	4" X 8" (110mm X 200mm) SDR11X33	191.0 psi	0.5 mm	Almost Zero	113 seconds	7 seconds	191.0 psi	10.2 min
Duo-Pro® PRO150X45 (PP)	6" X 10" (160mm X 250mm) SDR11X33	318.3 psi	1 mm	Almost Zero	161 seconds	8 seconds	318.3 psi	14.2 min
Duo-Pro® PRO45X45 (PP)	4" X 8" (110mm X 200mm) SDR33X33	140.0 psi	0.5 mm	Almost Zero	72 seconds	6 seconds	140.0 psi	6.7 min
Duo-Pro® PRO45X45 (PP)	6" X 10" (160mm X 250mm) SDR33X33	216.4 psi	1 mm	Almost Zero	89 seconds	6 seconds	216.4 psi	8.1 min
Duo-Pro® PVDFXPVDF (PVDF)	2" X 4" (63mm X 110mm) SDR21X33	42.1 psi	0.5 mm	Almost Zero	74 seconds	6 seconds	42.1 psi	6.0 min

Welding Temperatures

PP:	393°F - 410°F (200°C - 210°C)
PE:	420°F - 446°F (215°C - 230°C)
PVDF:	436°F - 446°F (225°C - 230°C)
ECTFE:	527°F - 536°F (275°C - 280°C)

A reduction in the cooling time of up to 50%, i.e. removal of the welded part from the welding machine, is permitted in the following circumstances:

- the joint connection was created under workshop conditions and
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Duo-Pro® PVDFXPVDF (PVDF)	2" X 6" (63mm X 160mm) SDR21X33	72.9 psi	0.5 mm	Almost Zero	89 seconds	6 seconds	72.9 psi	8.0 min
Duo-Pro® PVDFXPVDF (PVDF)	3" X 6" (90mm X 160mm) SDR33X33	89.1 psi	0.5 mm	Almost Zero	89 seconds	6 seconds	89.1 psi	8.0 min
Duo-Pro® PVDFXPVDF (PVDF)	4" X 8" (110mm X 200mm) SDR33X33	140.0 psi	0.6 mm	Almost Zero	102 seconds	8 seconds	140.0 psi	9.5 min
Duo-Pro® PVDFXPVDF (PVDF)	6" X 10" (160mm X 250mm) SDR33X33	216.4 psi	0.7 mm	Almost Zero	117 seconds	8 seconds	216.4 psi	11.0 min
Fluidlok (IPS) (PE)	3" X 6" SDR11X17	173.3 psi	mm	Almost Zero	65 seconds	5 seconds	173.3 psi	10.0 min
Fluidlok (IPS) (PE)	4" X 8" SDR11X17	303.3 psi	mm	Almost Zero	86 seconds	5 seconds	303.3 psi	12.0 min
Poly-Flo® PE100RC (PE)	2" X 3" (63mm X 90mm) SDR11X17	87.8 psi	1 mm	Almost Zero	35 seconds	5 seconds	87.8 psi	8.0 min
Poly-Flo® PE100RC (PE)	4" X 6" (110mm X 160mm) SDR11X17	243.2 psi	1.5 mm	Almost Zero	80 seconds	7 seconds	243.2 psi	14.0 min
Poly-Flo® PE100RC (PE)	6" X 9" (160mm X 225mm) SDR11X17	658 psi	1 mm	Almost Zero	146 seconds	8 seconds	658 psi	18.5 min
Poly-Flo® PPR (PP)	2" X 3" (63mm X 90mm) SDR11X17	61.4 psi	0.5 mm	Almost Zero	80 seconds	6 seconds	61.4 psi	9.0 min
Poly-Flo® PPR (PP)	4" X 6" (110mm X 160mm) SDR11X17	201.2 psi	1 mm	Almost Zero	150 seconds	7 seconds	201.2 psi	17.0 min
Poly-Flo® PPR (PP)	6" X 9" (160mm X 225mm) SDR11X17	437 psi	1 mm	Almost Zero	161 seconds	7 seconds	437 psi	20.5 min

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 PE: 420°F - 446°F (215°C - 230°C)
 PVDF: 436°F - 446°F (225°C - 230°C)
 ECTFE: 527°F - 536°F (275°C - 280°C)

A reduction in the cooling time of up to 50%, i.e. removal of the welded part from the welding machine, is permitted in the following circumstances:

- the joint connection was created under workshop conditions and
- the removal of the part from the welding machine and its temporary storage until the complete cooling time according to the Cooling Time column causes negligible loading of the joint