

TECHNICAL INFORMATION

t1: Basıncı ısıtma yaparken oluşacak dudak kalınlığı için gereken zaman.
t2: Basıncısız ısıtma için gereken zaman.
t3: Isıtıcıyı boruların arasından alma zamanı.
t4: Basıncı artırma zamanı.
t5: Kaynak yapılan boruların soğumaya bırakıldığı zaman.
P1: Dudak kalınlığı için gereken basınç.
P2: Devamlı ısıtma için gereken basınç.
P5: Soğuma esnasında gereken basınç.

t1: Required time for the lips at the pressure heating moment.
t2: Required time for the heating without pressure.
t3: Required time to taking the heater from pipes.
t4: Pressure increase time.
t5: After welding cooling time.
P1: Required time for the lips.
P2: Required pressure for increasing heating.
P5: At the cooling time required pressure.

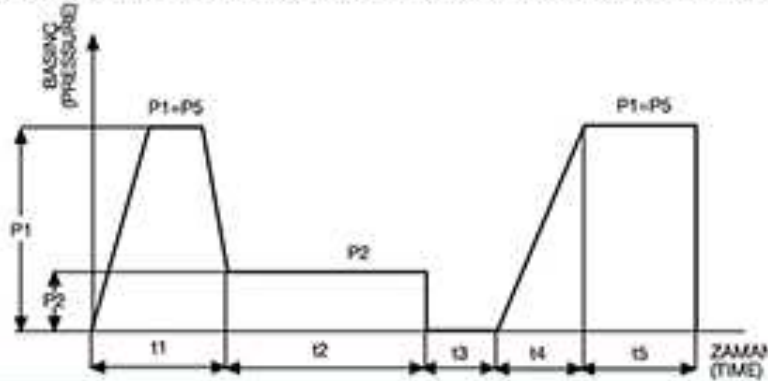
250-315-400-500 KAYNAK MAKİNALARININ PARAMETRE ÖLÇÜLERİ

250-315-400-500 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PE 100			SDR 41 PN 4		Silindir alanı/Cylinder area 14.13 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	1,8	0,5	0,7	25 sn/sec	10	10	3	3
90	2,3	1	0,7	30 sn/sec	10	10	3	4
110	2,7	1	0,8	35 sn/sec	10	10	4	5
125	3,1	2	0,8	40 sn/sec	10	10	5	6
140	3,5	2	0,9	45 sn/sec	10	10	5	6
160	4,0	2	0,9	50 sn/sec	10	10	6	7
180	4,4	3	0,9	55 sn/sec	10	10	7	8
200	4,9	3	1,0	1 dk/min	10	10	7	9
225	5,5	4	1,1	1.10 sn/sec	10	10	8	10
250	6,2	5	1,1	1.15 sn/sec	10	10	9	11
280	6,9	7	1,2	1.20 sn/sec	10	10	10	12
315	7,7	8	1,3	1.30 sn/sec	10	10	12	13
355	8,7	10	1,4	1.45 sn/sec	10	10	13	15
400	9,8	13	1,5	2 dk/min	10	10	15	17
450	11,0	15	1,6	2.15 sn/sec	10	10	17	19
500	12,3	20	1,7	2.30 sn/sec	10	10	18	21

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 33 PN 5		Silindir alanı/Cylinder area 14.13 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	2,3	1	0,7	30 sn/sec	10	10	3	4
90	2,8	1	0,8	35 sn/sec	10	10	4	5
110	3,4	2	0,8	45 sn/sec	10	10	5	6
125	3,9	2	0,9	50 sn/sec	10	10	6	7
140	4,3	2	0,9	55 sn/sec	10	10	6	8
160	4,9	3	1,0	1 dk/min	10	10	7	9
180	5,5	3	1,1	1.10 sn/sec	10	10	8	10
200	6,2	4	1,1	1.15 sn/sec	10	10	9	11
225	6,9	5	1,2	1.25 sn/sec	10	10	10	12
250	7,7	6	1,3	1.30 sn/sec	10	10	12	13
280	8,6	8	1,4	1.45 sn/sec	10	10	13	15
315	9,7	10	1,5	2 dk/min	10	10	15	17
355	10,9	13	1,6	2.15 sn/sec	10	10	16	19
400	12,3	16	1,7	2.30 sn/sec	10	10	18	21
450	13,8	20	1,9	2.45 sn/sec	10	10	21	24
500	15,3	25	2,0	3 dk/min	10	10	23	27

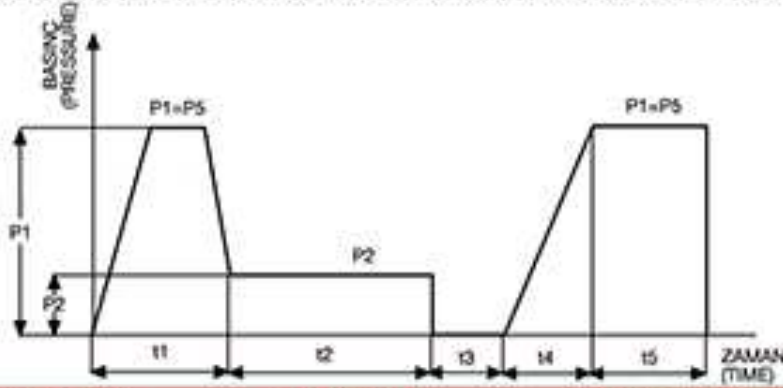
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 100				SDR 26 PN 6		Silindir alanı/Cylinder area 14.13 cm²			
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm		mm	dk/sn/min/sec	sn/sec	sn/sec	dk/min	dk/min	
75	2,9	1	0,8	35 sn/sec	10	10	4	5	
90	3,5	1	0,8	40 sn/sec	10	10	5	6	
110	4,2	2	0,9	50 sn/sec	10	10	6	7	
125	4,8	2	1,0	55 sn/sec	10	10	7	8	
140	5,4	2	1,0	1 dk/min	10	10	8	9	
160	6,2	3	1,1	1.10 sn/sec	10	10	9	10	
180	6,9	4	1,2	1.20 sn/sec	10	10	10	11	
200	7,7	5	1,2	1.30 sn/sec	10	10	11	13	
225	8,6	6	1,3	1.40 sn/sec	10	10	12	14	
250	9,6	7	1,4	1.50 sn/sec	10	10	14	16	
280	10,7	10	1,5	2 dk/min	10	10	15	18	
315	12,1	12	1,6	2.20sn/sec	10	10	17	20	
355	13,6	15	1,8	2.35 sn/sec	10	10	19	22	
400	15,3	20	2,0	3 dk/min	10	10	22	25	
450	17,2	25	2,1	3.15 sn/sec	10	10	24	28	
500	19,1	30	2,3	3.40 sn/sec	10	10	27	31	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 21 PN 8		Silindir alanı/Cylinder area 14.13 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	3,6	1	0,9	45 sn/sec	10	10	5	6
90	4,3	2	0,9	55 sn/sec	10	10	6	8
110	5,3	2	1,0	1.5 sn/sec	10	10	8	9
125	6	3	1,1	1.15 sn/sec	10	10	9	11
140	6,7	3	1,2	1.20 sn/sec	10	10	10	12
160	7,7	4	1,3	1.30 sn/sec	10	10	12	13
180	8,6	5	1,4	1.45 sn/sec	10	10	13	15
200	9,6	6	1,5	2 dk/min	10	10	14	17
225	10,8	8	1,6	2.10 sn/sec	10	10	16	19
250	11,9	9	1,7	2.25 sn/sec	10	10	18	21
280	13,4	12	1,8	2.40 sn/sec	10	10	20	23
315	15,0	15	2,0	3 dk/min	10	10	23	26
355	16,9	20	2,2	3.25 sn/sec	10	10	25	29
400	19,1	25	2,4	3.50 sn/sec	10	10	29	33
450	21,5	30	2,7	4.20 sn/sec	10	10	32	37
500	23,9	38	2,9	4.40 sn/sec	10	10	36	41

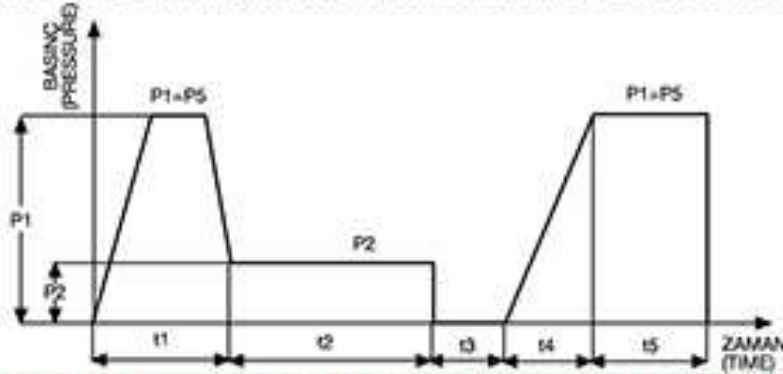
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 100			SDR 17 PN 10		Silindir alanı/Cylinder area 14.13 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2	t3	t4	t5	Toplam/Total
75	4,5	1	1,0	55 sn/sec	10	10	7	8
90	5,4	2	1,0	1.5 sn/sec	10	10	8	10
110	6,6	2	1,2	1.20 sn/sec	10	10	10	12
125	7,4	3	1,2	1.40 sn/sec	10	10	11	13
140	8,3	4	1,3	1.50 sn/sec	10	10	12	14
160	9,5	5	1,5	2 dk/min	10	10	14	16
180	10,7	6	1,6	2.10 sn/sec	10	10	16	19
200	11,9	8	1,7	2.25 sn/sec	10	10	18	21
225	13,4	10	1,8	2.40 sn/sec	10	10	20	23
250	14,8	12	2,0	3 dk/min	10	10	22	25
280	16,6	15	2,2	3.20 sn/sec	10	10	25	29
315	18,7	20	2,4	3.45 sn/sec	10	10	28	32
355	21,1	25	2,6	4.15 sn/sec	10	10	32	36
400	23,7	30	2,9	4.45 sn/sec	10	10	36	41
450	26,7	40	3,2	5.20 sn/sec	10	10	40	46
500	29,7	50	3,5	6 dk/min	10	10	45	51

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 13,6 PN 12,5		Silindir alanı/Cylinder area 14.13 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2	t3	t4	t5	Toplam/Total
75	5,6	1	1,1	1.10 sn/sec	10	10	8	10
90	6,7	2	1,2	1.20 sn/sec	10	10	10	12
110	8,1	3	1,3	1.45 sn/sec	10	10	12	14
125	9,2	4	1,4	1.50 sn/sec	10	10	14	16
140	10,3	5	1,5	2.5 sn/sec	10	10	15	18
160	11,8	6	1,7	2.25 sn/sec	10	10	18	20
180	13,3	8	1,8	2.40 sn/sec	10	10	20	23
200	14,7	9	2,0	3 dk/min	10	10	22	25
225	16,6	12	2,2	3.20 sn/sec	10	10	25	29
250	18,4	15	2,3	3.40 sn/sec	10	10	28	32
280	20,6	18	2,6	4.10 sn/sec	10	10	31	35
315	23,2	23	2,8	4.40 sn/sec	10	10	35	40
355	26,1	30	3,1	5.15 sn/sec	10	10	39	45
400	29,4	35	3,4	6 dk/min	10	10	44	50
450	33,1	45	3,8	6.40 sn/sec	10	10	50	57
500	36,8	60	4,2	7.25 sn/sec	10	10	55	63

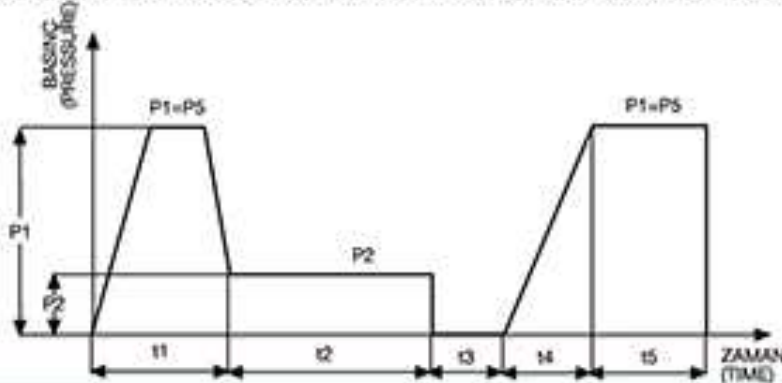
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MALZEME/MATERIAL PE 100			SDR 11 PN 16		Silindir alanı/Cylinder area 14.13 cm²			
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total
mm	mm		mm	dk/sn/min/sec	sn/sec	sn/sec	dk/min	dk/min
75	6,8	2	1,2	1.25 sn/sec	10	10	10	12
90	8,2	3	1,3	1.50 sn/sec	10	10	12	14
110	10,0	4	1,5	2 dk/min	10	10	15	17
125	11,4	5	1,6	2.20 sn/sec	10	10	17	20
140	12,7	6	1,8	2.35 sn/sec	10	10	19	22
160	14,6	7	2,0	3 dk/min	10	10	22	25
180	16,4	9	2,1	3.15 sn/sec	10	10	25	28
200	18,2	11	2,3	3.40 sn/sec	10	10	27	31
225	20,5	15	2,6	4 dk/min	10	10	31	35
250	22,7	18	2,8	4.35 sn/sec	10	10	34	39
280	25,4	22	3,0	5 dk/min	10	10	38	44
315	28,6	28	3,4	5.45 sn/sec	10	10	43	49
355	32,2	35	3,7	6.25 sn/sec	10	10	48	55
400	36,3	45	4,1	7.15 sn/sec	10	10	54	62
450	40,9	55	4,6	8.15 sn/sec	10	10	61	70
500	45,4	70	5,0	9 dk/min	10	10	68	78

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 9 PN 20		Silindir alanı/Cylinder area 14.13 cm²			
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total
mm	mm		mm	dk/sn/min/sec	sn/sec	sn/sec	dk/min	dk/min
75	8,4	2	1,3	1.40 sn/sec	10	10	13	15
90	10,1	3	1,5	2 dk/min	10	10	15	18
110	12,3	4	1,7	2.30 sn/sec	10	10	18	21
125	14,0	5	1,9	2.50 sn/sec	10	10	21	24
140	15,7	7	2,1	3.10 sn/sec	10	10	24	27
160	17,9	10	2,3	3.40 sn/sec	10	10	27	31
180	20,1	11	2,5	4 dk/min	10	10	30	35
200	22,4	15	2,7	4.30 sn/sec	10	10	34	38
225	25,2	17	3,0	5 dk/min	10	10	38	43
250	27,9	20	3,3	5.35 sn/sec	10	10	42	48
280	31,3	25	3,6	6.15 sn/sec	10	10	47	54
315	35,2	35	4,0	7 dk/min	10	10	53	60
355	39,7	40	4,5	8 dk/min	10	10	60	68
400	44,7	55	5,0	9 dk/min	10	10	67	76
450	50,3	70	5,5	10 dk/min	10	10	75	86
500	55,8	85	6,1	11.10 sn/sec	10	10	84	95

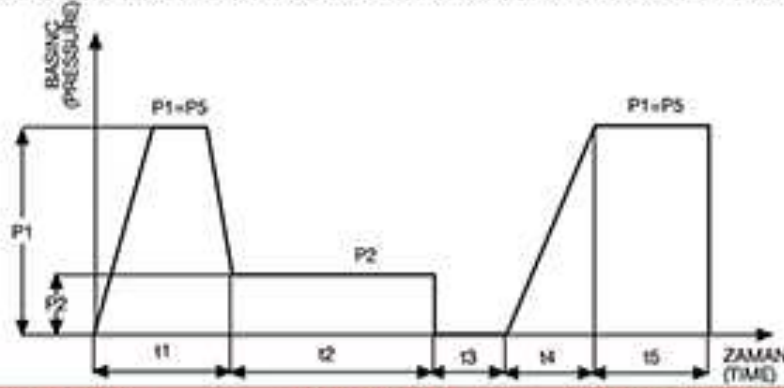
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

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MALZEME/MATERIAL PE 100			SDR 7,4 PN 25		Silindir alanı/Cylinder area 14.13 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	10,3	2	1,5	2 dk/min	10	10	15	18
90	12,3	3	1,7	2.30 sn/sec	10	10	18	21
110	15,1	5	2,0	3 dk/min	10	10	23	26
125	17,1	6	2,2	3.25 sn/sec	10	10	26	29
140	19,2	8	2,4	3.50 sn/sec	10	10	29	33
160	21,9	10	2,7	4.25 sn/sec	10	10	33	38
180	24,6	13	3,0	5 dk/min	10	10	37	42
200	27,4	15	3,2	5.30 sn/sec	10	10	41	47
225	30,8	20	3,6	6.10 sn/sec	10	10	46	53
250	34,2	25	3,9	6.50 sn/sec	10	10	51	58
280	38,3	30	4,3	7.40 sn/sec	10	10	57	65
315	43,1	40	4,8	8.40 sn/sec	10	10	65	74
355	48,5	50	5,4	9.40 sn/sec	10	10	73	83
400	54,7	65	6,0	11 dk/min	10	10	82	93
450	61,5	80	6,7	12.20 sn/sec	10	10	92	105
500								

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 6 PN 32		Silindir alanı/Cylinder area 14.13 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	12,5	3	1,8	2.30 sn/sec	10	10	19	22
90	15,0	4	2,0	3 dk/min	10	10	23	26
110	18,3	6	2,3	3.40 sn/sec	10	10	27	31
125	20,8	7	2,6	4.10 sn/sec	10	10	31	36
140	23,3	10	2,8	4.40 sn/sec	10	10	35	40
160	26,6	12	3,2	5.20 sn/sec	10	10	40	46
180	29,9	15	3,5	6 dk/min	10	10	45	51
200	33,2	20	3,8	6.40 sn/sec	10	10	50	57
225	37,4	25	4,2	7.30 sn/sec	10	10	56	64
250	41,5	30	4,7	8.20 sn/sec	10	10	62	71
280	46,5	35	5,2	9.20 sn/sec	10	10	70	79
315	52,3	45	5,7	10.30 sn/sec	10	10	78	89
355	59,0	60	6,4	11.50 sn/sec	10	10	89	101
400	66,7	75	7,2	13.20 sn/sec	10	10	100	114
450								
500								

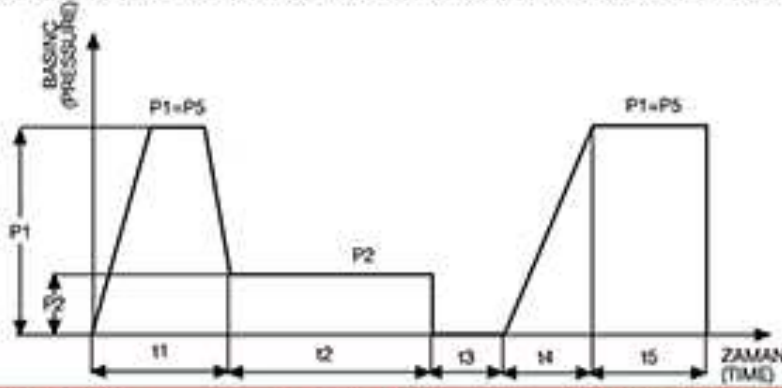
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MALZEME/MATERIAL PE 80			SDR 41 PN 3.2		Silindir alanı/Cylinder area 14.13 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75								
90	2,3	1	0,7	30 sn/sec	10	10	3	4
110	2,7	1	0,8	35 sn/sec	10	10	4	5
125	3,1	2	0,8	40 sn/sec	10	10	5	6
140	3,5	2	0,9	45 sn/sec	10	10	5	6
160	4,0	2	0,9	50 sn/sec	10	10	6	7
180	4,4	3	0,9	55 sn/sec	10	10	7	8
200	4,9	3	1,0	1 dk/min	10	10	7	9
225	5,5	4	1,1	1.5 sn/sec	10	10	8	10
250	6,2	5	1,1	1.15 sn/sec	10	10	9	11
280	6,9	6	1,2	1.25 sn/sec	10	10	10	12
315	7,7	8	1,3	1.35 sn/sec	10	10	12	13
355	8,7	10	1,4	1.45 sn/sec	10	10	13	15
400	9,8	13	1,5	2 dk/min	10	10	15	17
450	11,0	15	1,6	2.15 sn/sec	10	10	17	19
500	12,3	20	1,7	2.3 sn/sec	10	10	1	21

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 80			SDR 33 PN 4		Silindir alanı/Cylinder area 14.13 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	2,3	1	0,7	30 sn/sec	10	10	3	4
90	2,8	1	0,8	35 sn/sec	10	10	4	5
110	3,4	2	0,8	40 sn/sec	10	10	5	6
125	3,9	2	0,9	45 sn/sec	10	10	6	7
140	4,3	2	0,9	55 sn/sec	10	10	6	8
160	4,9	3	1,0	1 dk/min	10	10	7	9
180	5,5	3	1,1	1.5 sn/sec	10	10	8	10
200	6,2	4	1,1	1.15 sn/sec	10	10	9	11
225	6,9	5	1,2	1.25 sn/sec	10	10	10	12
250	7,7	6	1,3	1.35 sn/sec	10	10	12	13
280	8,6	8	1,4	1.45 sn/sec	10	10	13	15
315	9,7	10	1,5	2 dk/min	10	10	15	17
355	10,9	13	1,6	2.10 sn/sec	10	10	16	19
400	12,3	15	1,7	2.30 sn/sec	10	10	18	21
450	13,8	20	1,9	2.45 sn/sec	10	10	21	24
500	15,3	25	2,0	3 dk/min	10	10	23	26

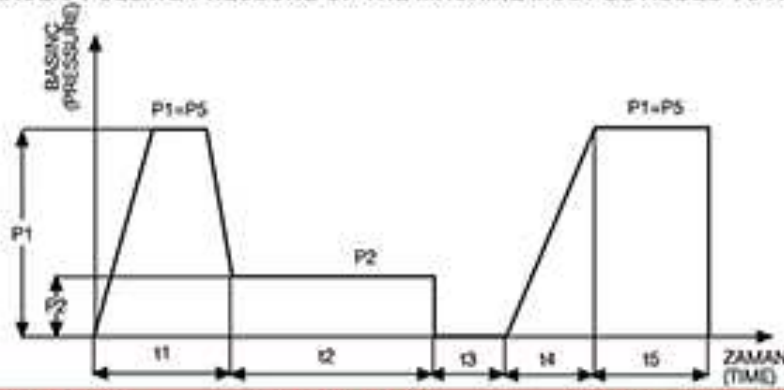
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 80			SDR 26 PN 5		Silindir alanı/Cylinder area 14.13 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	2,9	1	0,8	35 sn/sec	10	10	4	5
90	3,5	1	0,9	45 sn/sec	10	10	5	6
110	4,2	1	0,9	50 sn/sec	10	10	6	7
125	4,8	2	1,0	1 dk/min	10	10	7	8
140	5,4	3	1,0	1.5 sn/sec	10	10	8	9
160	6,2	3	1,1	1.15 sn/sec	10	10	9	11
180	6,9	4	1,2	1.25 sn/sec	10	10	10	12
200	7,7	5	1,3	1.30 sn/sec	10	10	12	13
225	8,6	6	1,4	1.45 sn/sec	10	10	13	15
250	9,6	8	1,5	2 dk/min	10	10	14	17
280	10,7	10	1,6	2.10 sn/sec	10	10	16	19
315	12,1	12	1,7	2.25 sn/sec	10	10	18	21
355	13,6	15	1,9	2.45 sn/sec	10	10	20	23
400	15,3	20	2,0	3.5 sn/sec	10	10	23	26
450	17,2	25	2,2	3.25 sn/sec	10	10	26	30
500	19,1	30	2,4	3.50 sn/sec	10	10	29	33

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 80			SDR 21 PN 6		Silindir alanı/Cylinder area 14.13 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	3,4	1	0,8	40 sn/sec	10	10	5	6
90	4,1	1	0,9	50 sn/sec	10	10	6	7
110	5,0	2	1,0	1 dk/min	10	10	8	9
125	5,7	3	1,1	1.10 sn/sec	10	10	9	10
140	6,4	3	1,1	1.20 sn/sec	10	10	10	11
160	7,3	4	1,2	1.30 sn/sec	10	10	11	13
180	8,2	5	1,3	1.40 sn/sec	10	10	12	14
200	9,1	6	1,4	1.50 sn/sec	10	10	14	16
225	10,2	7	1,5	2 dk/min	10	10	15	18
250	11,4	9	1,6	2.20 sn/sec	10	10	17	20
280	12,7	10	1,8	2.30 sn/sec	10	10	19	22
315	14,3	15	1,9	2.50 sn/sec	10	10	21	25
355	16,1	20	2,1	3.15 sn/sec	10	10	24	28
400	18,2	25	2,3	3.40 sn/sec	10	10	27	31
450	20,5	30	2,6	4.5 sn/sec	10	10	31	35
500	22,7	35	2,8	4.30 sn/sec	10	10	34	39

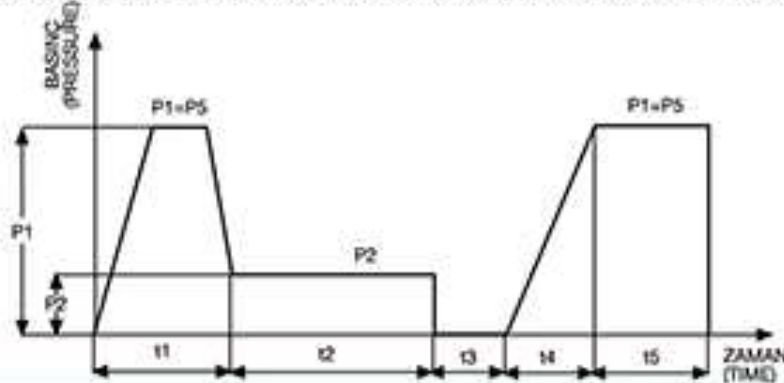
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 80			SDR 17 PN 8		Silindir alanı/Cylinder area 14.13 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	4,5	1	1,0	55 sn/sec	10	10	7	8
90	5,4	2	1,0	1.5 sn/sec	10	10	8	9
110	6,6	2	1,2	1.20 sn/sec	10	10	10	11
125	7,4	3	1,2	1.30 sn/sec	10	10	11	13
140	8,3	4	1,3	1.40 sn/sec	10	10	12	14
160	9,5	5	1,5	1.55 sn/sec	10	10	14	16
180	10,7	6	1,6	2.10 sn/sec	10	10	16	18
200	11,9	8	1,7	2.25 sn/sec	10	10	18	20
225	13,4	10	1,8	2.40 sn/sec	10	10	20	23
250	14,8	12	2,0	3 dk/min	10	10	22	25
280	16,6	15	2,2	3.20 sn/sec	10	10	25	29
315	18,7	20	2,4	3.45 sn/sec	10	10	28	32
355	21,1	25	2,6	4.15 sn/sec	10	10	32	36
400	23,7	30	2,9	4.45 sn/sec	10	10	36	41
450	26,7	40	3,2	5.20 sn/sec	10	10	40	46
500	29,7	50	3,5	6 dk/min	10	10	45	51

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 80			SDR 13,6 PN 10		Silindir alanı/Cylinder area 14.13 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	5,6	1	1,1	1.10 sn/sec	10	10	8	10
90	6,7	2	1,2	1.20 sn/sec	10	10	10	12
110	8,1	3	1,3	1.40 sn/sec	10	10	12	14
125	9,2	4	1,4	1.50 sn/sec	10	10	14	16
140	10,3	5	1,5	2 dk/min	10	10	15	18
160	11,8	6	1,7	2.25 sn/sec	10	10	18	20
180	13,3	7	1,8	2.40 sn/sec	10	10	20	23
200	14,7	8	2,0	3 dk/min	10	10	22	25
225	16,6	9	2,2	3.20 sn/sec	10	10	25	29
250	18,4	10	2,3	3.40 sn/sec	10	10	28	32
280	20,6	11	2,6	4.10 sn/sec	10	10	31	35
315	23,2	14	2,8	4.40 sn/sec	10	10	35	40
355	26,1	18	3,1	5.15 sn/sec	10	10	39	45
400	29,4	22	3,4	6 dk/min	10	10	44	50
450	33,1	28	3,8	6.40 sn/sec	10	10	50	57
500	36,8	35	4,2	7.25 sn/sec	10	10	55	63

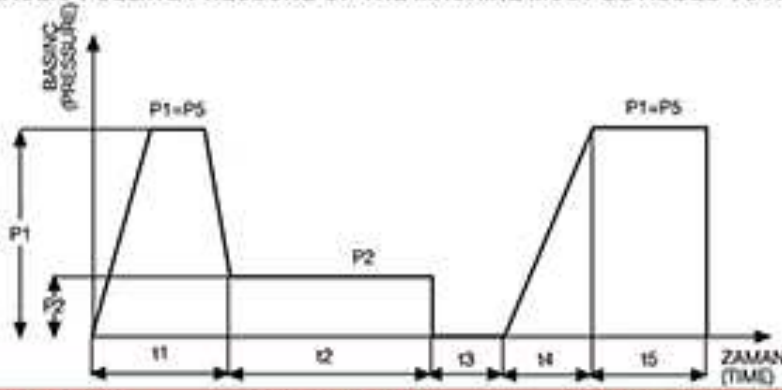
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 80			SDR 11 PN 12.5		Silindir alanı/Cylinder area 14.13 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	6,8	1	1,2	1.25 sn/sec	10	10	10	12
90	8,2	2	1,3	1.40 sn/sec	10	10	12	14
110	10,0	3	1,5	2 dk/min	10	10	15	17
125	11,4	4	1,6	2.20 sn/sec	10	10	17	20
140	12,7	5	1,8	2.35 sn/sec	10	10	19	22
160	14,6	7	2,0	3 dk/min	10	10	22	25
180	16,4	9	2,1	3.20 sn/sec	10	10	25	28
200	18,2	10	2,3	3.40 sn/sec	10	10	27	31
225	20,5	15	2,6	4 dk/min	10	10	31	35
250	22,7	17	2,8	4.30 sn/sec	10	10	34	39
280	25,4	22	3,0	5 dk/min	10	10	38	44
315	28,6	27	3,4	5.45 sn/sec	10	10	43	49
355	32,2	35	3,7	6.25 sn/sec	10	10	48	55
400	36,3	45	4,1	7.15 sn/sec	10	10	54	62
450	40,9	55	4,6	8.10 sn/sec	10	10	61	70
500	45,4	70	5,0	9 dk/min	10	10	68	78

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 80			SDR 9 PN 16		Silindir alanı/Cylinder area 14.13 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	8,4	2	1,3	1.40 sn/sec	10	10	13	14
90	10,1	3	1,5	2 dk/min	10	10	15	17
110	12,3	4	1,7	2.30 sn/sec	10	10	18	21
125	14,0	5	1,9	2.50 sn/sec	10	10	21	24
140	15,7	7	2,1	3.10 sn/sec	10	10	24	27
160	17,9	9	2,3	3.35 sn/sec	10	10	27	31
180	20,1	10	2,5	4 dk/min	10	10	30	34
200	22,4	13	2,7	4.30 sn/sec	10	10	34	38
225	25,2	17	3,0	5 dk/min	10	10	38	43
250	27,9	20	3,3	5.35 sn/sec	10	10	42	48
280	31,3	25	3,6	6.15 sn/sec	10	10	47	54
315	35,2	35	4,0	7 dk/min	10	10	53	60
355	39,7	40	4,5	8 dk/min	10	10	60	68
400	44,7	55	5,0	9 dk/min	10	10	67	76
450	50,3	70	5,5	10 dk/min	10	10	75	86
500	55,8	85	6,1	11.10 sn/sec	10	10	84	95

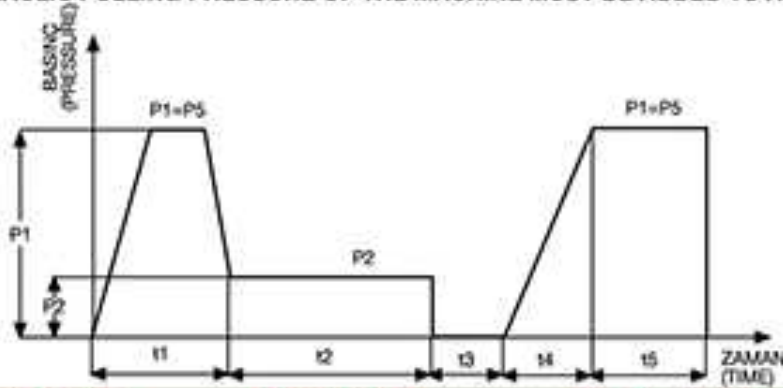
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 80			SDR 7,4 PN 20		Silindır alanı/Cylinder area 14.13 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	10,3	2	1,5	2 dk/min	10	10	15	18
90	12,3	3	1,7	2.30 sn/sec	10	10	18	21
110	15,1	5	2,0	3 dk/min	10	10	23	26
125	17,1	6	2,2	3.25 sn/sec	10	10	26	29
140	19,2	8	2,4	3.50 sn/sec	10	10	29	33
160	21,9	10	2,7	4.25 sn/sec	10	10	33	37
180	24,6	13	3,0	5 dk/min	10	10	37	42
200	27,4	15	3,2	5.30 sn/sec	10	10	41	47
225	30,8	20	3,6	6.10 sn/sec	10	10	46	53
250	34,2	25	3,9	6.50 sn/sec	10	10	51	58
280	38,3	30	4,3	7.40 sn/sec	10	10	57	65
315	43,1	40	4,8	8.40 sn/sec	10	10	65	74
355	48,5	50	5,4	9.40 sn/sec	10	10	73	83
400	54,7	65	6,0	11 dk/min	10	10	82	93
450	61,5	80	6,7	12.20 sn/sec	10	10	92	105
500								

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 80			SDR 6 PN 25		Silindır alanı/Cylinder area 14.13 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
75	12,5	3	1,8	2.30 sn/sec	10	10	19	21
90	15,0	5	2,0	3 dk/min	10	10	23	26
110	18,3	6	2,3	3.40 sn/sec	10	10	27	31
125	20,8	7	2,6	4.10 sn/sec	10	10	31	36
140	23,3	10	2,8	4.40 sn/sec	10	10	35	40
160	26,6	12	3,2	5.20 sn/sec	10	10	40	46
180	29,9	15	3,5	6 dk/min	10	10	45	51
200	33,2	20	3,8	6.40 sn/sec	10	10	50	57
225	37,4	25	4,2	7.30 sn/sec	10	10	56	64
250	41,5	30	4,7	8.20 sn/sec	10	10	62	71
280	46,5	40	5,2	9.20 sn/sec	10	10	70	79
315	52,3	45	5,7	10.30 sn/sec	10	10	78	89
355	59,0	60	6,4	11.50 sn/sec	10	10	89	101
400	66,7	75	7,2	13.20 sn/sec	10	10	100	114
450								
500								

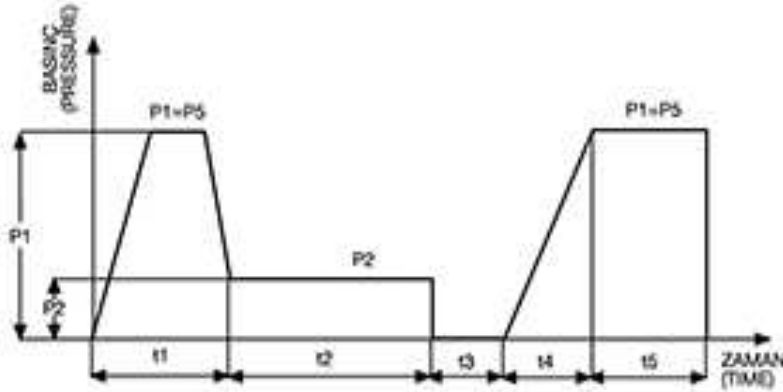
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PP		PN 2.5		Silindir alanı/Cylinder area 14.13 cm²				
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
90	2,2	0,5	0,7	25 sn/sec	10	10	3	4
110	2,7	0,5	0,8	30 sn/sec	10	10	4	5
125	3,1	1	0,8	40 sn/sec	10	10	5	6
140	3,5	1	0,9	45 sn/sec	10	10	5	6
160	4,0	2	0,9	50 sn/sec	10	10	6	7
180	4,4	2	0,9	55 sn/sec	10	10	7	8
200	4,9	2	1,0	1 dk/min	10	10	7	9
225	5,5	3	1,1	1.5 sn/sec	10	10	8	10
250	6,2	3	1,1	1.15 sn/sec	10	10	9	11
280	6,9	4	1,2	1.25 sn/sec	10	10	10	12
315	7,7	5	1,3	1.30 sn/sec	10	10	12	13
355	8,7	7	1,4	145 sn/sec	10	10	13	15
400	9,8	9	1,5	2 dk/min	10	10	15	17
450	11,0	10	1,6	2.15 sn/sec	10	10	17	19
500	12,3	13	1,7	2.30 sn/sec	10	10	18	21

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PP		PN 4		Silindir alanı/Cylinder area 14.13 cm²				
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
90	3,5	0,5	0,9	45 sn/sec	10	10	5	6
110	4,3	1	0,9	55 sn/sec	10	10	6	8
125	4,9	1	1,0	1 dk/min	10	10	7	9
140	5,4	2	1,0	1.5 sn/sec	10	10	8	9
160	6,2	2	1,1	1.15 sn/sec	10	10	9	11
180	7,0	3	1,2	1.25 sn/sec	10	10	11	12
200	7,7	3	1,3	1.35 sn/sec	10	10	12	13
225	8,7	4	1,4	1.45 sn/sec	10	10	13	15
250	9,7	5	1,5	2 dk/min	10	10	15	17
280	10,8	7	1,6	2.10 sn/sec	10	10	16	19
315	12,2	8	1,7	2.25 sn/sec	10	10	18	21
355	13,7	10	1,9	2.45 sn/sec	10	10	21	24
400	15,4	15	2,0	3 dk/min	10	10	23	27
450	17,4	17	2,2	3.30 sn/sec	10	10	26	30
500	19,3	20	2,4	4 dk/min	10	10	29	33

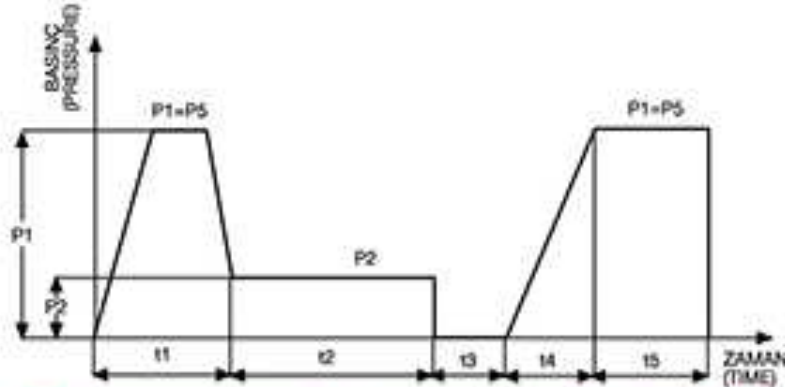
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PP		PN 6		Silindır alanı/Cylinder area 14.13 cm²				
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
90	5,1	1	1,0	1 dk/min	10	10	8	9
110	6,3	1,5	1,1	1.15 sn/sec	10	10	9	11
125	7,1	2	1,2	1.25 sn/sec	10	10	11	12
140	8,0	2	1,3	1.35 sn/sec	10	10	12	14
160	9,1	3	1,4	1.50 sn/sec	10	10	14	16
180	10,2	4	1,5	2 dk/min	10	10	15	18
200	11,4	5	1,6	2.20 sn/sec	10	10	17	20
225	12,8	6	1,8	2.35 sn/sec	10	10	19	22
250	14,2	7	1,9	2.50 sn/sec	10	10	21	24
280	15,9	10	2,1	3.10 sn/sec	10	10	24	27
315	17,9	12	2,3	3.35 sn/sec	10	10	27	31
355	20,1	15	2,5	4 dk/min	10	10	30	35
400	22,7	20	2,8	4.30 sn/sec	10	10	34	39
450	25,5	25	3,1	5 dk/min	10	10	38	44
500	28,3	30	3,3	5.40 sn/sec	10	10	42	48

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PP		PN 10		Silindır alanı/Cylinder area 14.13 cm²				
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
90	8,2	1	1,3	1.40 sn/sec	10	10	12	14
110	10,0	2	1,5	2 dk/min	10	10	15	17
125	11,4	3	1,6	2.20 sn/sec	10	10	17	20
140	12,7	4	1,8	2.30 sn/sec	10	10	19	22
160	14,6	5	2,0	3 dk/min	10	10	22	25
180	16,4	6	2,1	3.20 sn/sec	10	10	25	28
200	18,2	7	2,3	3.40 sn/sec	10	10	27	31
225	20,5	10	2,6	4 dk/min	10	10	31	35
250	22,7	12	2,8	4.30 sn/sec	10	10	34	39
280	25,4	15	3,0	5 dk/min	10	10	38	43
315	28,6	20	3,4	5.45 sn/sec	10	10	43	49
355	32,2	25	3,7	6.30 sn/sec	10	10	48	55
400	36,3	30	4,1	7.15 sn/sec	10	10	54	62
450	40,9	40	4,6	8.10 sn/sec	10	10	61	70
500	45,4	45	5,0	9 dk/min	10	10	68	78

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

250-315-400-500

Kullanma Kılavuzu
Technical Information

250-315-400-500 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ
250-315-400-500 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PP				PN 12.5		Silindır alanı/Cylinder area 14.13 cm²		
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure P1uP5(BAR)	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total
mm	mm		mm	dk/sn/min/sec	sn/sec	sn/sec	dk/min	dk/min
90	10,0	2	1,5	2 dk/min	10	10	15	17
110	12,3	3	1,7	2.30 sn/sec	10	10	18	21
125	14,0	4	1,9	2.50 sn/sec	10	10	21	24
140	15,7	4	2,1	3.10 sn/sec	10	10	24	27
160	17,9	5	2,3	3.35 sn/sec	10	10	27	31
180	20,1	7	2,5	4 dk/min	10	10	30	34
200	22,4	9	2,7	4.30 sn/sec	10	10	34	38
225	25,2	10	3,0	5 dk/min	10	10	38	43
250	27,9	15	3,3	6.35 sn/sec	10	10	42	48
280	31,3	18	3,6	6.45 sn/sec	10	10	47	54
315	35,2	22	4,0	7 dk/min	10	10	53	60
355	39,7	30	4,5	8 dk/min	10	10	60	68
400								
450								
500								

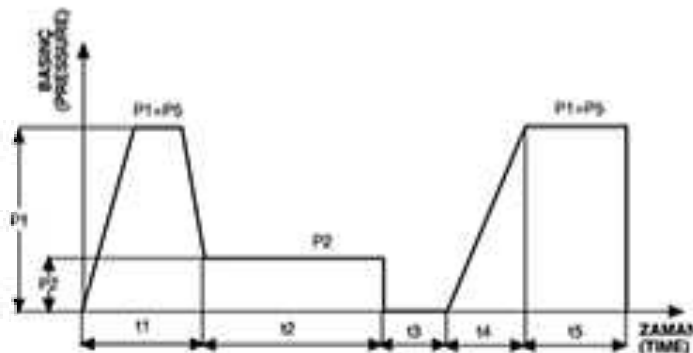
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PP				PN 16		Silindır alanı/Cylinder area 14.13 cm²			
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm		mm	dk/sn/min/sec	sn/sec	sn/sec	dk/min	dk/min	
90	12,5	2	1,8	2.30 sn/sec	10	10	19	22	
110	15,2	3	2,0	3 dk/min	10	10	23	26	
125	17,3	4	2,2	3.30 sn/sec	10	10	26	30	
140	19,4	5	2,4	4 dk/min	10	10	29	33	
160	22,1	7	2,7	4.25 sn/sec	10	10	33	38	
180	24,9	9	3,0	5 dk/min	10	10	37	43	
200	27,6	10	3,3	5.30 sn/sec	10	10	41	47	
225	31,1	15	3,6	6.15 sn/sec	10	10	47	53	
250	34,5	17	4,0	7 dk/min	10	10	52	59	
280	38,7	20	4,4	7.45 sn/sec	10	10	58	66	
315									
355									
400									
450									
500									

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



$$BAR = \frac{(D1 \text{ alanı} - D2 \text{ alanı}) \times \text{itme katsayısı}}{\text{silindirin alanı}}$$

D1 - Dış çap
D2 - İç çap
e - et kalınlığı
Malzeme PE ise itme katsayısı 1.5 kg/cm²
Malzeme PP ise itme katsayısı 1 kg/cm²
250-315-500 silindir alanı = 14.13 cm²
630-800 silindir alanı = 23.06 cm²

t1: Basıncılı ısıtma yaparken oluşacak dudak kalınlığı için gereken zaman.
t2: Basıncısız ısıtma için gereken zaman.
t3: Isıtıcıyı boruların arasından alma zamanı.
t4: Basıncı artırma zamanı.
t5: Kaynak yapılan boruların soğumaya bırakıldığı zaman.
P1: Dudak kalınlığı için gereken basınç.
P2: Devamlı ısıtma için gereken basınç.
P5: Soğuma esnasında gereken basınç.

t1: Required time for the lips at the pressure heating moment.
t2: Required time for the heating without pressure.
t3: Required time to taking the heater from pipes.
t4: Pressure increase time.
t5: After welding cooling time.
P1: Required time for the lips.
P2: Required pressure for increasing heating.
P5: At the cooling time required pressure.

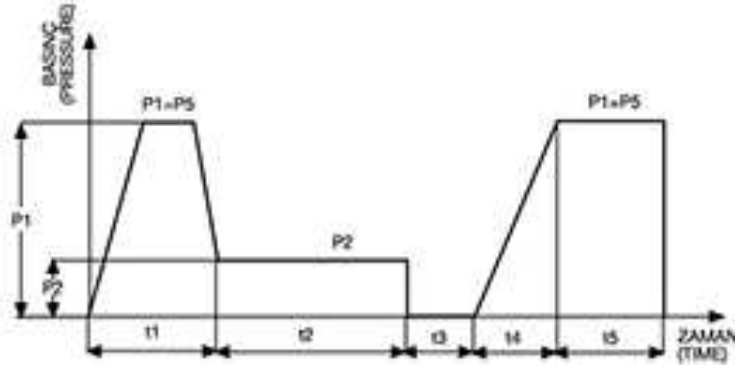
630 - 800 KAYNAK MAKİNELERİNİN PARAMETRE ÖLÇÜLERİ

630 - 800 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PE 100			SDR 41 PN 4		Silindir alanı/Cylinder area 23.06 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	4,4	1,5	0,9	55 sn/sec	10	10	7	8
200	4,9	2	1,0	1 dk/min	10	10	7	9
225	5,5	2,5	1,1	1.10 sn/sec	10	10	8	10
250	6,2	3	1,1	1.15 sn/sec	10	10	9	11
280	6,9	4	1,2	1.20 sn/sec	10	10	10	12
315	7,7	5	1,3	1.30 sn/sec	10	10	12	14
355	8,7	6	1,4	1.45 sn/sec	10	10	13	15
400	9,8	8	1,5	2 dk/min	10	10	15	17
450	11,0	10	1,6	2.15 sn/sec	10	10	17	19
500	12,3	13	1,7	2.30 sn/sec	10	10	18	21
560	13,7	15	1,8	2.45 sn/sec	10	10	21	24
630	15,4	20	1,9	3 dk/min	10	10	23	27
710	17,4	25	1,9	3.30 sn/sec	10	10	26	30
800	19,6	30	1,9	4 dk/min	10	10	29	34

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 33 PN 5		Silindir alanı/Cylinder area 23.06 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	5,5	2	1,1	1.10 sn/sec	10	10	8	10
200	6,2	2,5	1,1	1.15 sn/sec	10	10	9	11
225	6,9	3	1,2	1.25 sn/sec	10	10	10	12
250	7,7	4	1,3	1.30 sn/sec	10	10	12	14
280	8,6	5	1,4	1.45 sn/sec	10	10	13	15
315	9,7	6	1,5	2 dk/min	10	10	15	17
355	10,9	8	1,6	2.15 sn/sec	10	10	16	19
400	12,3	10	1,7	2.30 sn/sec	10	10	18	21
450	13,8	13	1,8	2.45 sn/sec	10	10	21	24
500	15,3	15	1,9	3 dk/min	10	10	23	26
560	17,2	20	2,2	3.25 sn/sec	10	10	26	30
630	19,3	25	2,4	4 dk/min	10	10	29	33
710	21,8	30	2,2	4.25 sn/sec	10	10	33	37
800	24,5	40	2,4	5 dk/min	10	10	37	42

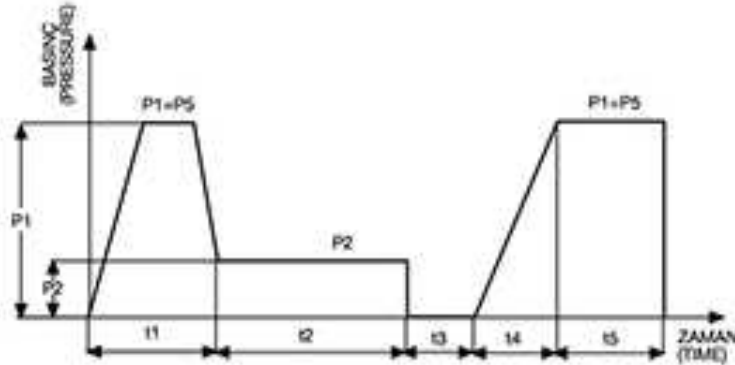
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 100			SDR 26 PN 6		Silindir alanı/Cylinder area 23.06 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	6,5	2	1,2	1.20 sn/sec	10	10	10	11
200	7,2	3	1,2	1.30 sn/sec	10	10	11	13
225	8,2	4	1,3	1.40 sn/sec	10	10	12	14
250	9,1	5	1,4	1.50 sn/sec	10	10	14	16
280	10,1	6	1,5	2 dk/min	10	10	15	18
315	11,4	7	1,6	2.20 sn/sec	10	10	17	20
355	12,9	10	1,8	2.35 sn/sec	10	10	19	22
400	14,5	12	2,0	3 dk/min	10	10	22	25
450	16,3	15	2,1	3.15 sn/sec	10	10	24	28
500	18,1	20	2,3	3.40 sn/sec	10	10	27	31
560	20,3	25	2,5	4 dk/min	10	10	30	35
630	22,8	30	2,9	4.35 sn/sec	10	10	34	39
710	25,7	35	3,4	5.10 sn/sec	10	10	39	44
800	29,0	45	3,9	5.50 sn/sec	10	10	44	50

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 21 PN 8		Silindir alanı/Cylinder area 23.06 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	8,6	3	1,4	1.45 sn/sec	10	10	13	15
200	9,6	4	1,5	2 dk/min	10	10	14	17
225	10,8	5	1,6	2.10 sn/sec	10	10	16	19
250	11,9	6	1,7	2.25 sn/sec	10	10	18	21
280	13,4	7	1,8	2.40 sn/sec	10	10	20	23
315	15,0	10	2,0	3 dk/min	10	10	23	26
355	16,9	12	2,2	3.25 sn/sec	10	10	25	29
400	19,1	15	2,4	3.50 sn/sec	10	10	29	33
450	21,5	20	2,7	4.20 sn/sec	10	10	32	37
500	23,9	25	2,9	4.40 sn/sec	10	10	36	41
560	26,7	30	3,2	5.20 sn/sec	10	10	40	46
630	30,0	35	3,7	6 dk/min	10	10	45	51
710	33,9	45	4,1	6.45 sn/sec	10	10	51	58
800	38,1	60	4,5	7.30 sn/sec	10	10	57	65

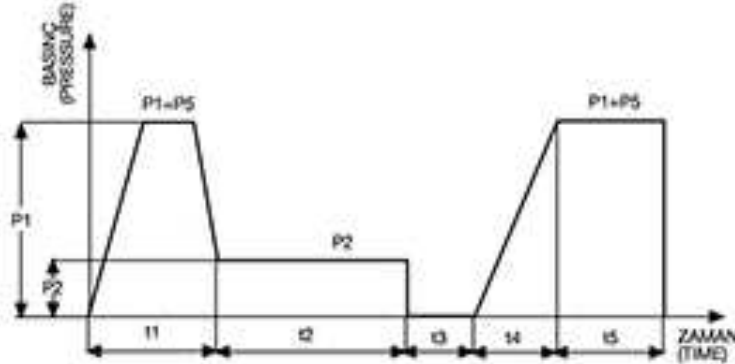
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 100			SDR 17 PN 10		Silindir alanı/Cylinder area 23.06 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	10,7	4	1,6	2.10 sn/sec	10	10	10	19
200	11,9	5	1,7	2.25 sn/sec	10	10	18	21
225	13,4	6	1,8	2.40 sn/sec	10	10	20	23
250	14,8	7	2,0	3 dk/min	10	10	22	26
280	16,6	10	2,2	3.20 sn/sec	10	10	25	29
315	18,7	12	2,4	3.45 sn/sec	10	10	28	32
355	21,1	15	2,6	4.15 sn/sec	10	10	32	36
400	23,7	20	2,9	4.45 sn/sec	10	10	36	41
450	26,7	25	3,2	5.20 sn/sec	10	10	40	46
500	29,7	30	3,5	6 dk/min	10	10	45	51
560	33,2	35	3,8	6.40 sn/sec	10	10	50	57
630	37,4	45	4,1	7.30 sn/sec	10	10	56	64
710	42,1	60	4,7	8.25 sn/sec	10	10	63	72
800	47,4	70	5,3	9.30 sn/sec	10	10	71	81

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 13,6 PN 12.5		Silindir alanı/Cylinder area 23.06 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	13,3	5	1,8	2.40 sn/sec	10	10	20	23
200	14,7	6	2,0	3 dk/min	10	10	22	25
225	16,6	7	2,2	3.20 sn/sec	10	10	25	29
250	18,4	9	2,3	3.40 sn/sec	10	10	28	32
280	20,6	10	2,6	4.10 sn/sec	10	10	31	35
315	23,2	15	2,8	4.40 sn/sec	10	10	35	40
355	26,1	20	3,1	5.15 sn/sec	10	10	39	45
400	29,4	25	3,4	6 dk/min	10	10	44	50
450	33,1	30	3,8	6.40 sn/sec	10	10	50	57
500	36,8	35	4,2	7.25 sn/sec	10	10	55	63
560	41,2	45	4,7	8.15 sn/sec	10	10	62	70
630	46,3	55	5,5	9 dk/min	10	10	69	79
710	52,2	70	5,9	10.25 sn/sec	10	10	78	89
800	58,8	90	6,5	11.45 sn/sec	10	10	88	100

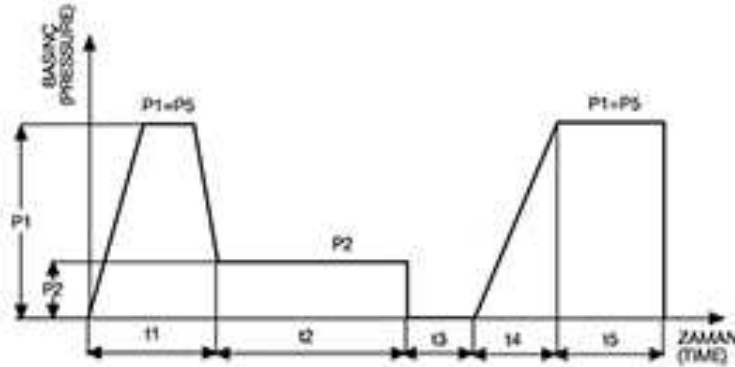
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 100			SDR 11 PN 16		Silindir alanı/Cylinder area 23.06 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	16,4	6	2,3	3.15 sn/sec	10	10	25	28
200	18,2	7	2,6	3.40 sn/sec	10	10	27	31
225	20,5	8	2,8	4 dk/min	10	10	31	35
250	22,7	10	3,0	4.35 sn/sec	10	10	34	39
280	25,4	15	3,4	5 dk/min	10	10	38	44
315	28,6	18	3,7	5.45 sn/sec	10	10	43	49
355	32,2	20	4,1	6.25 sn/sec	10	10	48	55
400	36,3	30	4,6	7.15 sn/sec	10	10	54	62
450	40,9	35	5,0	8.15 sn/sec	10	10	61	70
500	45,4	45	5,2	9 dk/min	10	10	68	78
560	50,8	50	5,5	10.10 sn/sec	10	10	76	87
630	57,2	65	6,0	11.25 sn/sec	10	10	86	98
710	64,5	85	6,9	13 dk/min	10	10	97	110
800	72,6	108	7,8	15 dk/min	10	10	109	124

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 9 PN 20		Silindir alanı/Cylinder area 23.06 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	20,1	7	2,5	4 dk/min	10	10	30	35
200	22,4	8	2,7	4.30 sn/sec	10	10	34	38
225	25,2	10	3,0	5 dk/min	10	10	38	43
250	27,9	13	3,3	5.35 sn/sec	10	10	42	48
280	31,3	15	3,6	6.15 sn/sec	10	10	47	54
315	35,2	20	4,0	7 dk/min	10	10	53	60
355	39,7	25	4,5	8 dk/min	10	10	60	68
400	44,7	35	5,0	9 dk/min	10	10	67	76
450	50,3	40	5,5	10 dk/min	10	10	75	86
500	55,8	50	6,1	11.10 sn/sec	10	10	84	95
560	62,5	29,2	6,8	13 dk/min	10	10	94	106
630	70,3	80,4	7,5	14 dk/min	10	10	105	120
710	79,3	102,2	8,4	16 dk/min	10	10	119	135
800	89,3	129,6	9,4	18 dk/min	10	10	134	152

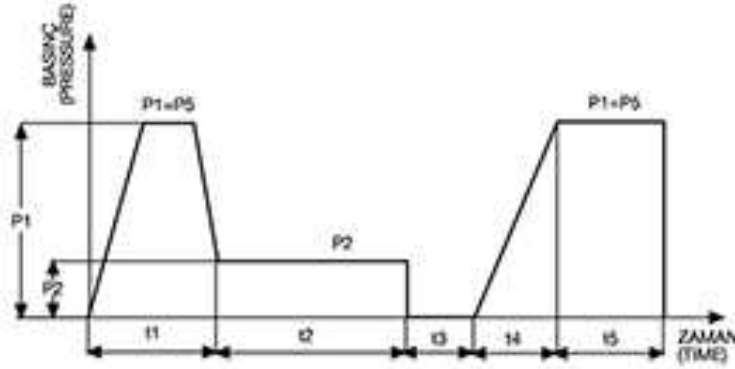
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 100			SDR 7,4 PN 25		Silindir alanı/Cylinder area 23.06 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	24,6	8,0	3,0	5 dk/min	10	10	37	42
200	27,4	10,0	3,2	5.30 sn/sec	10	10	41	47
225	30,8	12,0	3,6	6.10 sn/sec	10	10	46	53
250	34,2	15,0	3,9	6.50 sn/sec	10	10	51	59
280	38,3	20,0	4,3	7.40 sn/sec	10	10	57	66
315	43,1	25,0	4,8	8.40 sn/sec	10	10	65	74
355	48,5	30,0	5,4	9.40 sn/sec	10	10	73	83
400	54,7	40,0	6,0	11 dk/min	10	10	82	93
450	61,5	50,0	6,7	12.20 sn/sec	10	10	92	105
500								
560								
630								
710								
800								

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 6 PN 32		Silindir alanı/Cylinder area 23.06 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	29,9	10	3,0	6 dk/min	10	10	45	51
200	33,2	12	3,8	6.40 sn/sec	10	10	50	57
225	37,4	15	4,2	7.30 sn/sec	10	10	56	64
250	41,5	20	4,7	8.20 sn/sec	10	10	62	71
280	46,5	25	5,2	9.20 sn/sec	10	10	70	79
315	52,3	30	5,7	10.30 sn/sec	10	10	78	89
355	59,0	35	6,4	11.50 sn/sec	10	10	89	101
400	66,7	45	7,1	13.20 sn/sec	10	10	100	114
450								
500								
560								
630								
710								
800								

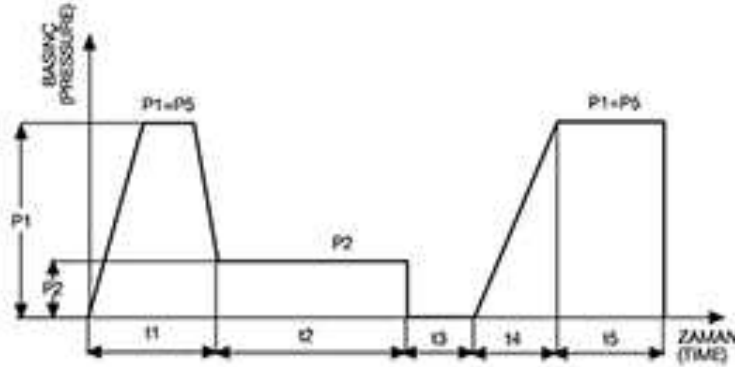
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 80			SDR 41 PN 3.2		Silindir alanı/Cylinder area 23.06 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	4,4	1,5	0,9	55 sn/sec	10	10	7	8
200	4,9	2	1,0	1 dk/min	10	10	7	9
225	5,5	2,5	1,1	1.5 sn/sec	10	10	8	10
250	6,2	3	1,1	1.15 sn/sec	10	10	9	11
280	6,9	4	1,2	1.25 sn/sec	10	10	10	12
315	7,7	5	1,3	1.35 sn/sec	10	10	12	14
355	8,7	6	1,5	1.45 sn/sec	10	10	13	15
400	9,8	8	1,5	2 dk/min	10	10	15	17
450	11,0	10	1,5	2.15 sn/sec	10	10	17	19
500	12,3	13	2,0	2.30 sn/sec	10	10	18	21
560	13,7	15	2,2	2.45 sn/sec	10	10	21	24
630	15,4	20	2,5	3 dk/min	10	10	23	27
710	17,4	25	3,0	3.30 sn/sec	10	10	26	30
800	19,6	30	3,6	4 dk/min	10	10	29	34

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 80			SDR 33 PN 4		Silindir alanı/Cylinder area 23.06 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	5,5	2	1,1	1.5 sn/sec	10	10	8	10
200	6,2	2,5	1,1	1.15 sn/sec	10	10	9	11
225	6,9	3	1,2	1.25 sn/sec	10	10	10	12
250	7,7	4	1,3	1.35 sn/sec	10	10	12	14
280	8,6	5	1,4	1.45 sn/sec	10	10	13	15
315	9,7	6	1,5	2 dk/min	10	10	15	17
355	10,9	8	1,6	2.10 sn/sec	10	10	16	19
400	12,3	10	1,7	2.30 sn/sec	10	10	18	21
450	13,8	13	1,8	2.45 sn/sec	10	10	21	24
500	15,3	15	2,0	3 dk/min	10	10	23	26
560	17,2	20	2,3	3.25 sn/sec	10	10	26	30
630	19,3	25	2,8	4 dk/min	10	10	29	33
710	21,8	30	3,4	4.25 sn/sec	10	10	33	37
800	24,5	40	3,9	5 dk/min	10	10	37	42

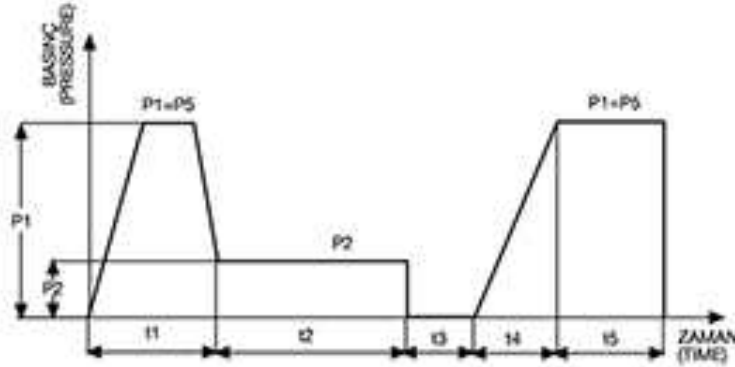
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 80			SDR 26 PN 5		Silindir alanı/Cylinder area 23.06 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	6,9	2	1,2	1.25 sn/sec	10	10	10	12
200	7,7	3	1,3	1.30 sn/sec	10	10	12	14
225	8,6	4	1,4	1.45 sn/sec	10	10	13	15
250	9,6	5	1,5	2 dk/min	10	10	14	17
280	10,7	6	1,7	2.10 sn/sec	10	10	16	19
315	12,1	8	1,8	2.25 sn/sec	10	10	18	21
355	13,6	10	1,9	2.45 sn/sec	10	10	20	24
400	15,3	12	2,0	3.5 sn/sec	10	10	23	26
450	17,2	15	2,2	3.25 sn/sec	10	10	26	30
500	19,1	20	2,4	3.50 sn/sec	10	10	29	33
560	21,4	25	2,6	4.20 sn/sec	10	10	32	37
630	24,1	30	2,8	4.50 sn/sec	10	10	36	41
710	27,2	40	3,2	5.25 sn/sec	10	10	41	47
800	30,6	50	3,8	6 dk/min	10	10	46	52

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 80			SDR 21 PN 6		Silindir alanı/Cylinder area 23.06 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	8,2	3	1,3	1.40 sn/sec	10	10	12	14
200	9,1	4	1,4	1.50 sn/sec	10	10	14	16
225	10,2	5	1,5	2 dk/min	10	10	15	18
250	11,4	6	1,6	2.20 sn/sec	10	10	17	20
280	12,7	7	1,8	2.30 sn/sec	10	10	19	22
315	14,3	9	1,9	2.50 sn/sec	10	10	21	25
355	16,1	10	2,0	3.15 sn/sec	10	10	24	28
400	18,2	15	2,3	3.40 sn/sec	10	10	27	31
450	20,5	20	2,6	4.5 sn/sec	10	10	31	35
500	22,7	25	2,8	4.30 sn/sec	10	10	34	39
560	25,5	30	3,0	5 dk/min	10	10	38	44
630	28,6	35	3,4	5.45 sn/sec	10	10	43	49
710	32,3	45	3,9	6.30 sn/sec	10	10	48	55
800	36,4	55	4,5	7.15 sn/sec	10	10	55	62

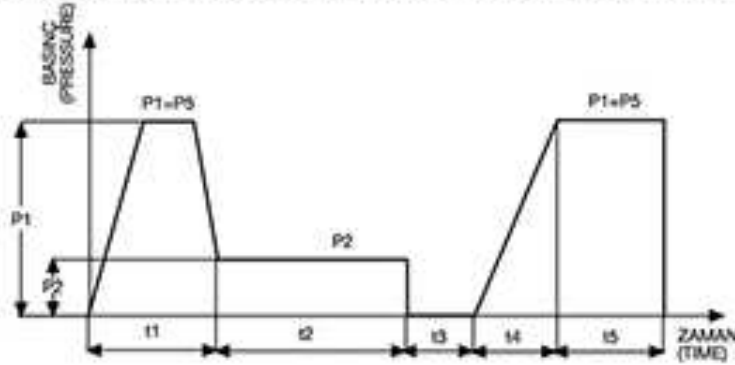
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 80			SDR 17 PN 8		Silindır alanı/Cylinder area 23.06 cm ²			
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total
mm	mm		mm	dk/sn/min/sec	sn/sec	sn/sec	dk/min	dk/min
180	10,7	4,0	1,6	2.10 sn/sec	10	10	16	19
200	11,9	5,0	1,7	2.25 sn/sec	10	10	18	21
225	13,4	6,0	1,8	2.40 sn/sec	10	10	20	23
250	14,8	7,0	2,0	3 dk/min	10	10	22	26
280	16,6	9,0	2,2	3.20 sn/sec	10	10	25	29
315	18,7	10,0	2,4	3.45 sn/sec	10	10	28	32
355	21,1	15,0	2,6	4.15 sn/sec	10	10	32	36
400	23,7	20,0	2,8	4.45 sn/sec	10	10	36	41
450	26,7	25,0	3,2	5.20 sn/sec	10	10	40	46
500	29,7	30,0	3,5	6 dk/min	10	10	45	51
560	33,2	35,0	4,0	6.40 sn/sec	10	10	50	57
630	37,4	45,0	4,6	7.30 sn/sec	10	10	56	64
710	42,1	60,0	5,3	8.25 sn/sec	10	10	63	72
800	47,4	70,0	5,9	10.10 sn/sec	10	10	71	81

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 80			SDR 13,6 PN 10		Silindır alanı/Cylinder area 23.06 cm ²			
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total
mm	mm		mm	dk/sn/min/sec	sn/sec	sn/sec	dk/min	dk/min
180	13,3	5	1,8	2.40 sn/sec	10	10	20	23
200	14,7	6	2,0	3 dk/min	10	10	22	25
225	16,6	7	2,2	3.20 sn/sec	10	10	25	29
250	18,4	9	2,4	3.40 sn/sec	10	10	28	32
280	20,6	10	2,6	4.10 sn/sec	10	10	31	35
315	23,2	15	2,8	4.40 sn/sec	10	10	35	40
355	26,1	20	3,1	5.15 sn/sec	10	10	39	45
400	29,4	25	3,4	6 dk/min	10	10	44	50
450	33,1	30	3,8	6.40 sn/sec	10	10	50	57
500	36,8	35	4,3	7.25 sn/sec	10	10	55	63
560	41,2	45	4,9	8.15 sn/sec	10	10	62	70
630	46,3	55	5,6	9.15 sn/sec	10	10	69	79
710	52,2	70	6,2	10.25 sn/sec	10	10	78	89
800	58,8	90	6,8	11.45 sn/sec	10	10	88	100

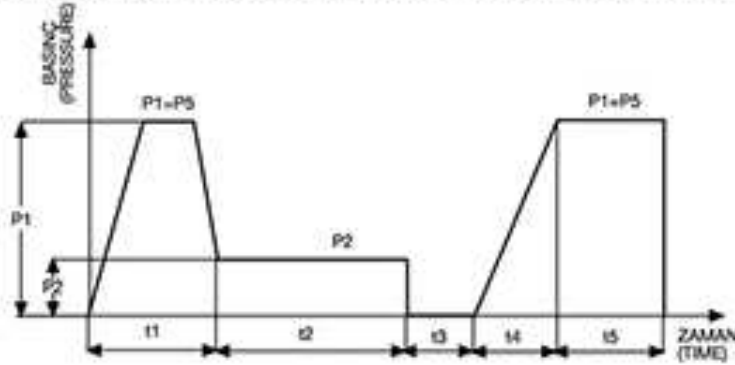
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 80			SDR 11 PN 12.5		Silindir alanı/Cylinder area 23.06 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	16,4	6	2,1	3.20 sn/sec	10	10	25	28
200	18,2	7	2,3	3.40 sn/sec	10	10	27	31
225	20,5	8	2,6	4 dk/min	10	10	31	35
250	22,7	10	2,8	4.30 sn/sec	10	10	34	39
280	25,4	13	3,0	5 dk/min	10	10	38	44
315	28,6	15	3,4	5.45 sn/sec	10	10	43	49
355	32,2	20	3,9	6.25 sn/sec	10	10	48	55
400	36,3	30	4,3	7.15 sn/sec	10	10	54	62
450	40,9	35	4,6	8.10 sn/sec	10	10	61	70
500	45,4	45	5,1	9 dk/min	10	10	68	78
560	50,8	55	5,7	10.10 sn/sec	10	10	76	87
630	57,2	65	6,4	11.25 sn/sec	10	10	86	98
710	64,5	85	7,1	13 dk/min	10	10	97	110
800	72,6	108	7,8	15 dk/min	10	10	109	124

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 80			SDR 9 PN 16		Silindir alanı/Cylinder area 23.06 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	20,1	6	2,5	4 dk/min	10	10	30	35
200	22,4	8	2,8	4.30 sn/sec	10	10	34	38
225	25,2	10	3,0	5 dk/min	10	10	38	43
250	27,9	13	3,3	5.35 sn/sec	10	10	42	48
280	31,3	15	3,6	6.15 sn/sec	10	10	47	54
315	35,2	20	4,0	7 dk/min	10	10	53	60
355	39,7	25	4,5	8 dk/min	10	10	60	68
400	44,7	35	5,0	9 dk/min	10	10	67	76
450	50,3	40	5,5	10 dk/min	10	10	75	86
500	55,8	50	6,1	11.10 sn/sec	10	10	84	95
560	62,5	29	6,8	13 dk/min	10	10	94	106
630	70,3	80	7,5	14 dk/min	10	10	105	120
710	79,3	102	8,4	16 dk/min	10	10	119	135
800	89,3	130	9,4	18 dk/min	10	10	134	152

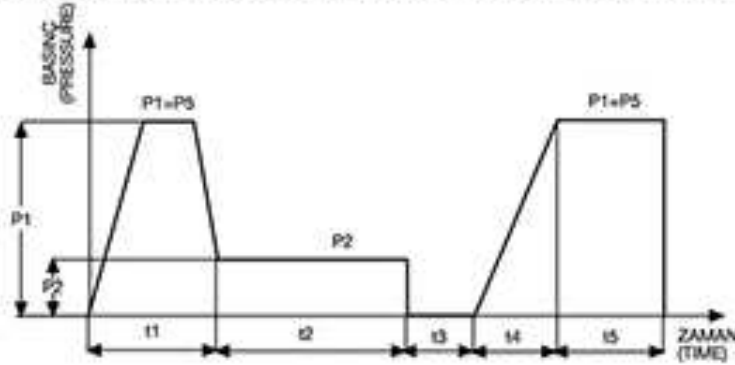
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IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PE 80			SDR 7,4 PN 20		Silindır alanı/Cylinder area 23.06 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	24,6	8	3,0	5 dk/min	10	10	37	42
200	27,4	10	3,2	5.30 sn/sec	10	10	41	47
225	30,8	12	3,6	6.10 sn/sec	10	10	46	53
250	34,2	15	3,9	6.50 sn/sec	10	10	51	59
280	38,3	20	4,3	7.40 sn/sec	10	10	57	66
315	43,1	25	4,8	8.40 sn/sec	10	10	65	74
355	48,5	30	5,4	9.40 sn/sec	10	10	73	83
400	54,7	40	6,1	11 dk/min	10	10	82	93
450	61,5	50	6,9	12.20 sn/sec	10	10	92	105
500								
560								
630								
710								
800								

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 80			SDR 6 PN 25		Silindır alanı/Cylinder area 23.06 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
180	29,9	10	3,5	6 dk/min	10	10	45	51
200	33,2	12	3,8	6.40 sn/sec	10	10	50	57
225	37,4	15	4,2	7.30 sn/sec	10	10	56	64
250	41,5	20	4,7	8.20 sn/sec	10	10	62	71
280	46,5	25	5,2	9.20 sn/sec	10	10	70	79
315	52,3	30	5,7	10.30 sn/sec	10	10	78	89
355	59,0	35	6,3	11.50 sn/sec	10	10	89	101
400	66,7	45	6,9	13.20 sn/sec	10	10	100	114
450								
500								
560								
630								
710								
800								

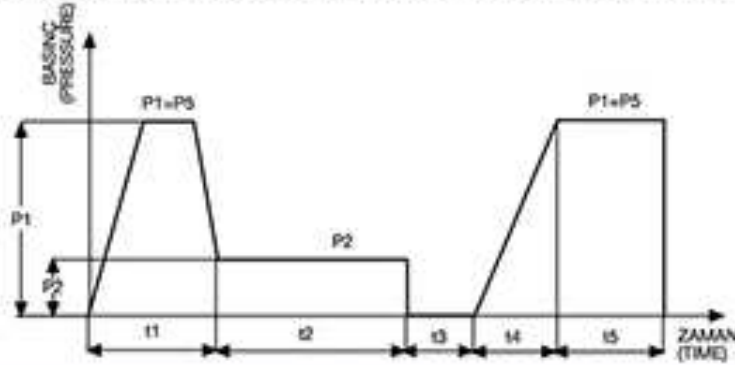
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PP		PN 2.5		Silindir alanı/Cylinder area 23.06 cm ²				
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüklüklüğü Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
90	2,2	0,5	0,7	25 sn/sec	10	10	3	4
110	2,7	0,5	0,8	30 sn/sec	10	10	4	5
125	3,1	0,5	0,8	40 sn/sec	10	10	5	6
140	3,5	1	0,9	45 sn/sec	10	10	5	6
160	4,0	1	0,9	50 sn/sec	10	10	6	7
180	4,4	1	0,9	55 sn/sec	10	10	7	8
200	4,9	1,5	1,0	1 dk/min	10	10	7	9
225	5,5	1,5	1,1	1.5 sn/sec	10	10	8	10
250	6,2	2	1,1	1.15 sn/sec	10	10	9	11
280	6,9	2,5	1,2	1.25 sn/sec	10	10	10	12
315	7,7	3	1,3	1.30 sn/sec	10	10	12	14
355	8,7	4	1,5	1.45 sn/sec	10	10	13	15
400	9,8	5	1,5	2 dk/min	10	10	15	17
450	11,0	7	1,5	2.15 sn/sec	10	10	17	19
500	12,3	8	2,0	2.30 sn/sec	10	10	18	21

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PP		PN 4		Silindir alanı/Cylinder area 23.06 cm ²				
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüklüklüğü Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
90	3,5	0,5	0,9	45 sn/sec	10	10	5	6
110	4,3	0,5	0,9	55 sn/sec	10	10	6	8
125	4,9	1	1,0	1 dk/min	10	10	7	9
140	5,4	1	1,0	1.5 sn/sec	10	10	8	10
160	6,2	1,5	1,1	1.15 sn/sec	10	10	9	11
180	7,0	1,5	1,2	1.25 sn/sec	10	10	11	12
200	7,7	2	1,3	1.35 sn/sec	10	10	12	14
225	8,7	2,5	1,4	1.45 sn/sec	10	10	13	15
250	9,7	3	1,5	2 dk/min	10	10	15	17
280	10,8	4	1,6	2.10 sn/sec	10	10	16	19
315	12,2	5	1,7	2.25 sn/sec	10	10	18	21
355	13,7	7	1,9	2.45 sn/sec	10	10	21	24
400	15,4	8	2,0	3 dk/min	10	10	23	27
450	17,4	10	2,2	3.30 sn/sec	10	10	26	30
500	19,3	13	2,4	4 dk/min	10	10	29	33

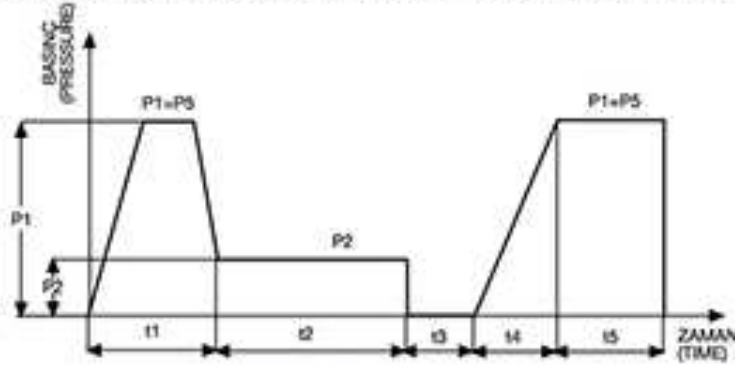
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PP		PN 6		Silindir alanı/Cylinder area 23.06 cm²				
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
90	5,1	0,5	0,8	1 dk/min	10	10	8	9
110	6,3	1	0,8	1.15 sn/sec	10	10	9	11
125	7,1	1	0,9	1.25 sn/sec	10	10	11	12
140	8,0	1,5	0,9	1.35 sn/sec	10	10	12	14
160	9,1	2	1,0	1.50 sn/sec	10	10	14	16
180	10,2	2,5	1,1	2 dk/min	10	10	15	18
200	11,4	3	1,1	2.20 sn/sec	10	10	17	20
225	12,8	4	1,2	2.35 sn/sec	10	10	19	22
250	14,2	5	1,3	2.50 sn/sec	10	10	21	25
280	15,9	6	1,4	3.10 sn/sec	10	10	24	27
315	17,9	7	1,5	3.35 sn/sec	10	10	27	31
355	20,1	10	1,7	4 dk/min	10	10	30	35
400	22,7	12	1,9	4.30 sn/sec	10	10	34	39
450	25,5	15	2,2	5 dk/min	10	10	38	44
500	28,3	20	2,5	5.40 sn/sec	10	10	42	49

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PP		PN 10		Silindir alanı/Cylinder area 23.06 cm²				
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
90	8,2	1	1,3	1.40 sn/sec	10	10	12	14
110	10,0	1,5	1,5	2 dk/min	10	10	15	17
125	11,4	2	1,8	2.20 sn/sec	10	10	17	20
140	12,7	2,5	2,0	2.30 sn/sec	10	10	19	22
160	14,6	3	2,1	3 dk/min	10	10	22	25
180	16,4	4	2,3	3.20 sn/sec	10	10	25	28
200	18,2	4,5	2,6	3.40 sn/sec	10	10	27	31
225	20,5	6	2,8	4 dk/min	10	10	31	35
250	22,7	7	3,0	4.30 sn/sec	10	10	34	39
280	25,4	9	3,4	5 dk/min	10	10	38	44
315	28,6	11	3,7	5.45 sn/sec	10	10	43	49
355	32,2	15	4,1	6.30 sn/sec	10	10	48	55
400	36,3	20	4,6	7.15 sn/sec	10	10	54	62
450	40,9	25	5,0	8.10 sn/sec	10	10	61	70
500	45,4	30	5,2	9 dk/min	10	10	68	78

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PP		PN 12.5		Silindir alanı/Cylinder area 23.06 cm²				
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
90	10,0	1	1,5	2 dk/min	10	10	15	17
110	12,3	1,5	1,7	2.30 sn/sec	10	10	18	21
125	14,0	2	1,9	2.50 sn/sec	10	10	21	24
140	15,7	3	2,1	3.10 sn/sec	10	10	24	27
160	17,9	3,5	2,3	3.35 sn/sec	10	10	27	31
180	20,1	4,5	2,5	4 dk/min	10	10	30	35
200	22,4	5	2,7	4.30 sn/sec	10	10	34	38
225	25,2	7	3,0	5 dk/min	10	10	38	43
250	27,9	9	3,3	6.35 sn/sec	10	10	42	48
280	31,3	10	3,6	6.45 sn/sec	10	10	47	54
315	35,2	15	4,0	7 dk/min	10	10	53	60
355	39,7	20	4,5	8 dk/min	10	10	60	68
400								
450								
500								

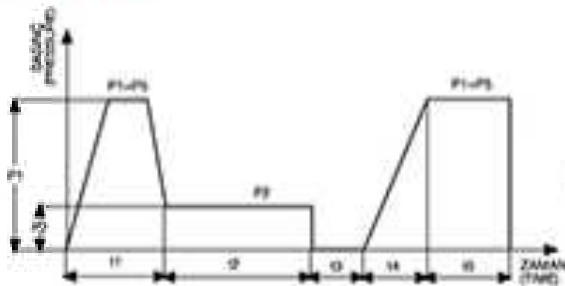
ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

MALZEME/MATERIAL PP		PN 16		Silindir alanı/Cylinder area 23.06 cm²				
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
90	12,5	1	1,2	2.30 sn/sec	10	10	19	22
110	15,2	2	1,3	3 dk/min	10	10	23	26
125	17,3	2,5	1,4	3.30 sn/sec	10	10	26	30
140	19,4	3	1,5	4 dk/min	10	10	29	33
160	22,1	4	1,7	4.25 sn/sec	10	10	33	38
180	24,9	5	1,8	5 dk/min	10	10	37	43
200	27,6	7	2,0	5.30 sn/sec	10	10	41	47
225	31,1	8	2,2	6.15 sn/sec	10	10	47	53
250	34,5	10	2,3	7 dk/min	10	10	52	59
280	38,7	15	2,6	7.45 sn/sec	10	10	58	66
315								
355								
400								
450								
500								

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



Pressure= (D1 area - D2 area) x fixed number
cylinder area

D1 -Outside diameter
D2 - The inside diameter
e- thickness
Material PE if fixed number= 1.5 kg /cm²
Material PP if fixed number= 1 kg /cm²
250-315-500 cylinder area = 14,13 cm²
630-800 cylinder area = 23.06 cm²

**1000-1200-1600
KAYNAK MAKİNALARININ
PARAMETRE ÖLÇÜLERİ**

**1000-1200-1600
MACHINE PRESSURE
AND TIME PARAMETERS**

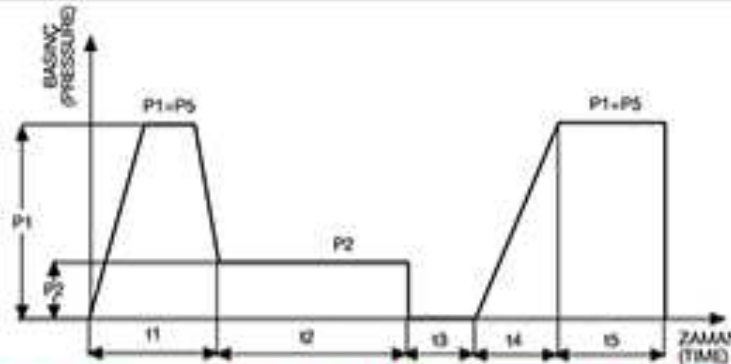
1000-1200-1600

Kullanma Kılavuzu
Technical Information

1000-1200-1600 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ
1000-1200-1600 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PE 100			SDR 41 PN 4		Silindir alanı/Cylinder area 50,24 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüklülüğü Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
500	12,3	6	1,7	2 dk/min	10	10	18	21
560	13,7	7	1,9	3 dk/min	10	10	21	24
630	15,4	9	2,0	3 dk/min	10	10	23	27
710	17,4	11	2,2	3 dk/min	10	10	26	30
800	19,6	14	2,5	4 dk/min	10	10	29	34
900	22,0	18	2,7	4 dk/min	10	10	33	38
1000	24,5	22	3,0	5 dk/min	10	10	37	42
1200	29,4	32	3,4	6 dk/min	10	10	44	50
1400	34,3	44	3,9	7 dk/min	10	10	51	59
1600	39,2	57	4,4	8 dk/min	10	10	59	67

MALZEME/MATERIAL PE 100			SDR 33 PN 5		Silindir alanı/Cylinder area 50,24 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüklülüğü Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
500	15,3	7	2,0	3 dk/min	10	10	23	26
560	17,2	9	2,2	3 dk/min	10	10	26	30
630	19,2	11	2,4	4 dk/min	10	10	29	33
710	21,3	14	2,6	4 dk/min	10	10	32	37
800	24,5	18	3,0	5 dk/min	10	10	37	42
900	27,6	23	3,3	6 dk/min	10	10	41	47
1000	30,6	28	3,6	6 dk/min	10	10	46	53
1200	36,7	40	4,2	7 dk/min	10	10	55	63
1400	42,9	55	4,8	9 dk/min	10	10	64	73
1600	49,0	71	5,4	10 dk/min	10	10	74	84



MALZEME/MATERIAL PE 100			SDR 26 PN 6		Silindir alanı/Cylinder area 50,24 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüklülüğü Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
500	19,1	8,6	2,4	4 dk/min	10	10	29	33
560	21,4	10,8	2,6	4 dk/min	10	10	32	37
630	24,1	13,7	2,9	5 dk/min	10	10	36	41
710	27,2	17,4	3,2	5 dk/min	10	10	41	46
800	30,6	22,1	3,6	6 dk/min	10	10	46	52
900	34,4	27,9	3,9	7 dk/min	10	10	52	59
1000	38,2	34,4	4,3	8 dk/min	10	10	57	65
1200	45,9	49,7	5,1	9 dk/min	10	10	69	78
1400	53,5	67,5	5,9	11 dk/min	10	10	80	91
1600	61,2	88,3	6,6	12 dk/min	10	10	92	104

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

1000-1200-1600

1000-1200-1600 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ
1000-1200-1600 MACHINE PRESSURE AND TIME PARAMETERS

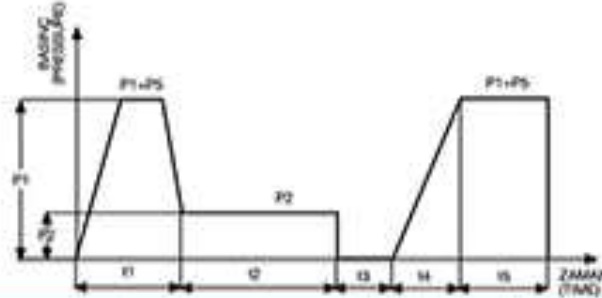
Kullanma Kılavuzu
Technical Information

MALZEME/MATERIAL PE 100			SDR 21 PN 8		Silindir alanı/Cylinder area 50,24 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
500	23,9	11	2,9	5 dk/min	10	10	36	41
560	26,7	13	3,2	5 dk/min	10	10	40	46
630	30,0	17	3,5	6 dk/min	10	10	45	51
710	33,9	21	3,9	7 dk/min	10	10	51	58
800	38,1	27	4,3	8 dk/min	10	10	57	65
900	42,9	34	4,8	9 dk/min	10	10	64	73
1000	47,7	43	5,3	10 dk/min	10	10	72	81
1200	57,2	61	6,2	11 dk/min	10	10	86	98
1400	66,7	83	7,2	13 dk/min	10	10	100	114
1600	76,2	127	9,5	18 dk/min	10	10	135	154

MALZEME/MATERIAL PE 100			SDR 17 PN 10		Silindir alanı/Cylinder area 50,24 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
500	29,7	13	3,5	6 dk/min	10	10	45	51
560	33,2	16	3,8	7 dk/min	10	10	50	57
630	37,4	21	4,2	7 dk/min	10	10	56	64
710	42,1	26	4,7	8 dk/min	10	10	63	72
800	47,4	33	5,2	9 dk/min	10	10	71	81
900	53,3	42	5,8	11 dk/min	10	10	80	91
1000	59,3	52	6,4	12 dk/min	10	10	89	101
1200	71,1	75	7,6	14 dk/min	10	10	107	121
1400	83	102	8,8	17 dk/min	10	10	125	141
1600	94,84	134	10,0	19 dk/min	10	10	142	161

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES



MALZEME/MATERIAL PE 100			SDR 13,6 PN 12,5		Silindir alanı/Cylinder area 14,13 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
500	36,3	16	4,1	7 dk/min	10	10	54	62
560	41,2	20	4,6	8 dk/min	10	10	62	70
630	46,3	25	5,1	9 dk/min	10	10	69	79
710	52,2	32	5,7	10 dk/min	10	10	78	89
800	58,8	41	6,4	12 dk/min	10	10	88	100
900	66,2	52	7,1	13 dk/min	10	10	99	113
1000	73,5	64	7,9	15 dk/min	10	10	100	125
1200	71,1	75	7,6	14 dk/min	10	10	107	121
1400	83	102	8,8	17 dk/min	10	10	125	141
1600	94,84	134	10,0	19 dk/min	10	10	142	161

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

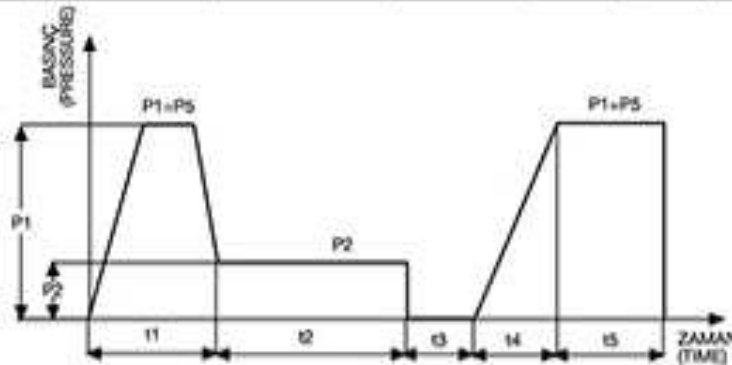
1000-1200-1600

Kullanma Kılavuzu
Technical Information

1000-1200-1600 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ
1000-1200-1600 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PE 100			SDR 11 PN 16		Silindır alanı/Cylinder area 50,24 cm²				
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm	P1=P5(BAR)	mm	dk/sn/min/sec	sn/sec	sn/sec	dk/min	dk/min	
500	45,4	19	5,0	9 dk/min	10	10	68	78	
560	50,8	24	5,6	10 dk/min	10	10	76	87	
630	57,2	31	6,2	11 dk/min	10	10	86	98	
710	64,5	39	7,0	13 dk/min	10	10	97	110	
800	72,6	108	7,8	15 dk/min	10	10	109	124	
900	81,7	137	8,7	16 dk/min	10	10	123	139	
1000	90,8	77	9,6	18 dk/min	10	10	136	155	
1200									
1600									

MALZEME/MATERIAL PE 100			SDR 9 PN 20		Silindir alanı/Cylinder area 50,24 cm²				
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min	
500	55,8	23	6,1	11 dk/min	10	10	84	95	
560	62,2	29	6,7	12 dk/min	10	10	93	106	
630									
710									
800									
900									
1000									
1200									
1600									



MALZEME/MATERIAL PE 80			SDR 41 PN 3.2		Silindir alanı/Cylinder area 50,24 cm²				
Dış Çap Outer Dia.	Et Kalınlığı Wall Thickness	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness	t2	t3	t4	t5	Toplam/Total	
mm	mm		mm	dk/sn/min/sec	sn/sec	sn/sec	dk/min	dk/min	
500	12,3	6	1,7	2 dk/min	10	10	18	21	
560	13,7	7	1,9	3 dk/min	10	10	21	24	
630	15,4	9	2,0	3 dk/min	10	10	23	27	
710	17,4	11	2,2	3 dk/min	10	10	26	30	
800	19,6	14	2,5	4 dk/min	10	10	29	34	
900	22,0	18	2,7	4 dk/min	10	10	33	38	
1000	24,5	22	3,0	5 dk/min	10	10	37	42	
1200	29,4	32	3,4	6 dk/min	10	10	44	50	
1400	34,3	44	3,9	7 dk/min	10	10	51	59	
1600	39,2	57	4,4	8 dk/min	10	10	59	67	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

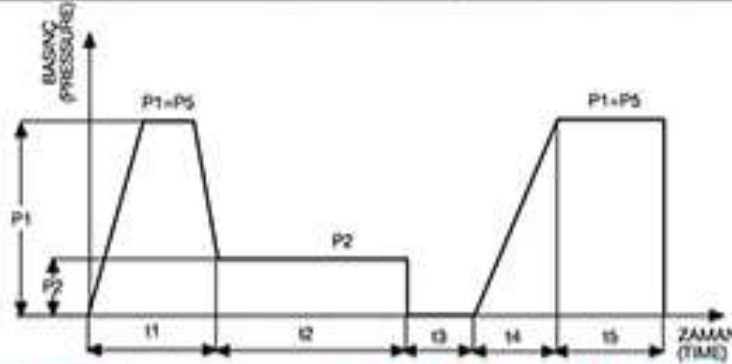
1000-1200-1600

Kullanma Kılavuzu
Technical Information

1000-1200-1600 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ
1000-1200-1600 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PE 80				SDR 33 PN 4		Silindir alanı/Cylinder area 50,24 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min	
500	15,3	7	2,0	3 dk/min	10	10	23	26	
560	17,2	9	2,2	3 dk/min	10	10	26	30	
630	19,3	11	2,4	4 dk/min	10	10	29	33	
710	21,8	14	2,7	4 dk/min	10	10	33	37	
800	24,5	18	3,0	5 dk/min	10	10	37	42	
900	27,5	22	3,3	6 dk/min	10	10	41	47	
1000	30,6	28	3,6	6 dk/min	10	10	46	53	
1200	36,70	40	4,2	7 dk/min	10	10	55	63	
1400	42,9	55	4,8	9 dk/min	10	10	64	73	
1600	49	71	5,4	10 dk/min	10	10	74	84	

MALZEME/MATERIAL PE 80				SDR 26 PN 5		Silindir alanı/Cylinder area 50,24 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min	
500	19,1	9	2,4	4 dk/min	10	10	29	33	
560	21,4	11	2,6	4 dk/min	10	10	32	37	
630	24,1	14	2,9	5 dk/min	10	10	36	41	
710	27,2	17	3,2	5 dk/min	10	10	41	47	
800	30,6	22	3,6	6 dk/min	10	10	46	52	
900	34,4	28	3,9	7 dk/min	10	10	52	59	
1000	38,2	34	4,1	7 dk/min	10	10	54	62	
1200	45,9	47	4,9	9 dk/min	10	10	65	74	
1400	59,8	64	5,6	10 dk/min	10	10	76	87	
1600	58,0	84	6,3	12 dk/min	10	10	87	99	



MALZEME/MATERIAL PE 80				SDR 21 PN 6		Silindir alanı/Cylinder area 50,24 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min	
500	23,9	10,7	2,9	5 dk/min	10	10	36	41	
560	26,7	13,3	3,2	5 dk/min	10	10	40	46	
630	30,0	16,9	3,5	6 dk/min	10	10	45	51	
710	33,9	21,5	3,9	7 dk/min	10	10	51	58	
800	38,1	27,2	4,3	8 dk/min	10	10	57	65	
900	42,9	34,5	4,8	9 dk/min	10	10	64	73	
1000	47,7	42,6	5,3	10 dk/min	10	10	72	81	
1200	57,2	61,3	6,2	11 dk/min	10	10	86	97	
1400	66,7	83,4	7,2	13 dk/min	10	10	100	114	
1600	76,2	108,9	8,1	15 dk/min	10	10	114	130	

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

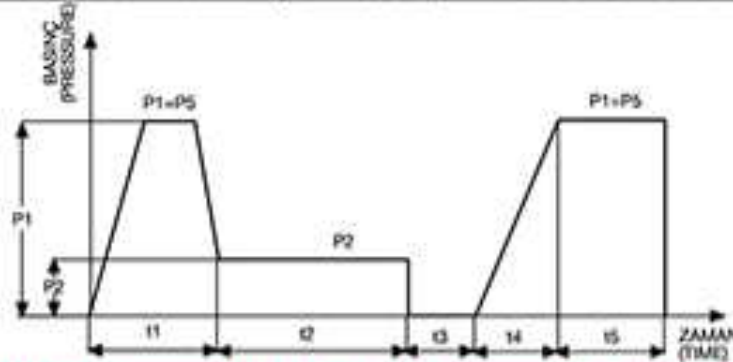
1000-1200-1600

Kullanma Kılavuzu
Technical Information

1000-1200-1600 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ
1000-1200-1600 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PE 80			SDR 17 PN 8		Silindır alanı/Cylinder area 50,24 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
500	29,7	13	3,5	6 dk/min	10	10	45	51
560	33,2	16	3,8	7 dk/min	10	10	50	57
630	37,4	21	4,2	7 dk/min	10	10	56	64
710	42,1	26	4,7	8 dk/min	10	10	63	72
800	47,4	33	5,2	9 dk/min	10	10	71	81
900	53,3	42	5,8	11 dk/min	10	10	80	91
1000	59,3	52	6,4	12 dk/min	10	10	89	101
1200								
1400								
1600								

MALZEME/MATERIAL PE 80			SDR 13,6 PN 10		Silindır alanı/Cylinder area 50,24 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
500	36,8	16	4,2	7 dk/min	10	10	55	63
560	41,2	20	4,6	8 dk/min	10	10	62	70
630	46,3	25	5,1	9 dk/min	10	10	69	79
710	52,2	32	5,7	10 dk/min	10	10	78	89
800	58,8	41	6,4	12 dk/min	10	10	88	100
900	66,2	52	7,1	13 dk/min	10	10	99	113
1000	73,5	64	7,9	15 dk/min	10	10	110	125
1200	71,1	75	7,6	14 dk/min	10	10	107	121
1400	83	102	8,8	17 dk/min	10	10	125	141
1600	94,84	134	10,0	19 dk/min	10	10	142	161



MALZEME/MATERIAL PE 80			SDR 11 PN 12.5		Silindır alanı/Cylinder area 50,24 cm ²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüksekliği Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
500	45,4	19	5,0	9 dk/min	10	10	68	78
560	50,8	24	5,6	10 dk/min	10	10	76	87
630	57,2	31	6,2	11 dk/min	10	10	86	98
710	64,5	39	7,0	13 dk/min	10	10	97	110
800	72,6	108	7,8	15 dk/min	10	10	109	124
900	81,7	137	8,7	16 dk/min	10	10	123	139
1000	90,8	77	9,6	18 dk/min	10	10	136	155
1200								
1400								
1600								

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES

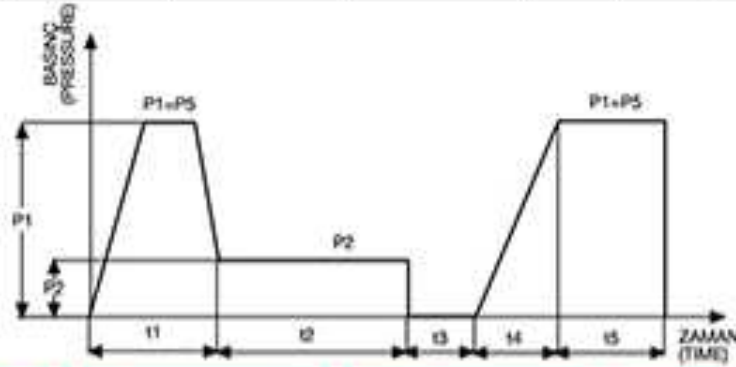
1000-1200-1600

Kullanma Kılavuzu
Technical Information

1000-1200-1600 MAKİNA BASINÇ VE SÜRE PARAMETRELERİ
1000-1200-1600 MACHINE PRESSURE AND TIME PARAMETERS

MALZEME/MATERIAL PE 80			SDR 9 PN 16		Silindir alanı/Cylinder area 50,24 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüklüklüğü Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
500	23,9	11	2,9	5 dk/min	10	10	36	41
560	62,5	29	6,8	13 dk/min	10	10	94	106
630	70,3	80	7,5	14 dk/min	10	10	105	120
710	79,3	102	8,4	16 dk/min	10	10	119	135
800	89,3	130	9,4	18 dk/min	10	10	134	152
900								
1000								
1200								
1400								
1600								

MALZEME/MATERIAL PE 80			SDR 7,4 PN 20		Silindir alanı/Cylinder area 50,24 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüklüklüğü Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
500								
560								
630								
710								
800								
900								
1000								
1200								



MALZEME/MATERIAL PE 80			SDR 6 PN 25		Silindir alanı/Cylinder area 50,24 cm²			
Dış Çap Outer Dia. mm	Et Kalınlığı Wall Thickness mm	Kaynak Basıncı Welding Pressure P1=P5(BAR)	Dudak Yüklüklüğü Lip Thickness mm	t2 dk/sn/min/sec	t3 sn/sec	t4 sn/sec	t5 dk/min	Toplam/Total dk/min
500								
560								
630								
710								
800								
900								
1000								
1200								
1400								
1600								

ÖNEMLİ: KAYNAK BASINCI UYGULANIRKEN YÜRÜME BASINCI EKLENİR.

IMPORTANT: FREE HYDRAULIC PULLING PRESSURE OF THE MACHINE MUST BE ADDED TO ABOVE WELDING PRESSURES