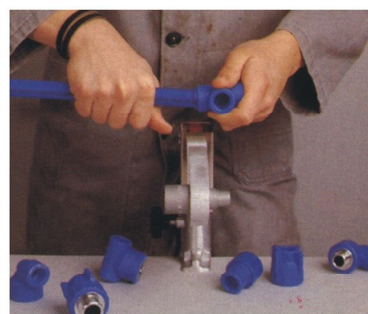
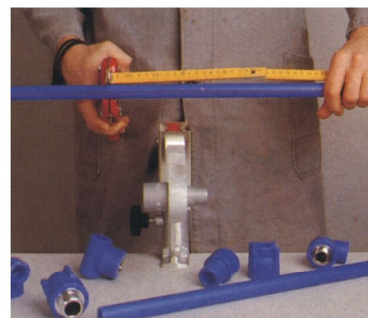


INSTALLATION GUIDELINE

HEATING ELEMENT SOCKET WELDING OF PP-R (PN 10)



1. Mount the welding plate and bring it to operating temperature (approx. 240 °C). The welding tools must be free of dirt and damage.
2. Cut the pipe end straight with pliers suitable for cutting plastic pipes, clean it from dust and dirt and mark the insertion depth with a pen (see table).
3. Clean fitting from dust and dirt.
4. First push fitting onto the corresponding welding insert and warm it up.
5. Fitting remains on the welding insert.
6. Then push the pipe onto the corresponding welding insert up to the mark and warm it up. Depending on the diameter, the warm-up times must be respected (see table).
7. Pull fitting and pipe simultaneously from the welding inserts.
8. Push fitting and pipe into each other quickly and without twisting and hold for several seconds, the holding times must be respected (see table).
9. The cooling-off time has to be respected (see table).



The welded connections are fully loadable after approx. 30 minutes.

STANDARD VALUES FOR HEATING ELEMENT SOCKET WELDING						
outer pipe diameter	weld-in depth	warm-up time fitting	warm-up time pipe	max. processing time	holding time	cooling-off time
16 mm	10,0 mm	6 s	5 s	4 s	10 s	4 min
20 mm	10,0 mm	10 s	5 s	4 s	10 s	4 min
25 mm	15,0 mm	10 s	7 s	4 s	10 s	4 min
32 mm	16,5 mm	11 s	8 s	6 s	15 s	6 min
40 mm	18,0 mm	15 s	12 s	6 s	15 s	6 min
50 mm	20,0 mm	25 s	18 s	6 s	20 s	6 min
63 mm	24,0 mm	30 s	24 s	8 s	30 s	8 min

Standard values for heating element socket welding of PP pipes at an outside temperature of 20 °C and with moderate air movement. The minimum room and material temperature required for processing polypropylene is + 5 °C.