

Acrobat 180 Welding Parameters

CURRENT AS OF
09/06/2023

Product Line & Material	Pipe Size	Initial Melt Pressure	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure	Cooling Time
PE4710 IPS	2" SDR17	82	1/16 in	Almost Zero	38 sec	4 sec	82	1.5 mins
PE4710 IPS	2" SDR11	122	1/16 in	Almost Zero	58 sec	8 sec	122	2.5 mins
PE4710 IPS	3" SDR17	178	1/16 in	Almost Zero	56 sec	8 sec	178	2.25 mins
PE4710 IPS	3" SDR11	265	1/16 in	Almost Zero	86 sec	8 sec	265	3.5 mins
PE4710 IPS	4" SDR17	294	3/16 in	Almost Zero	71 sec	8 sec	294	3 mins
PE4710 IPS	4" SDR11	438	3/16 in	Almost Zero	110 sec	10 sec	438	4.5 mins
PE4710 IPS	5" SDR17	449	3/16 in	Almost Zero	88 sec	8 sec	449	3.5 mins
PE4710 IPS	5" SDR11	670	3/16 in	Almost Zero	137 sec	10 sec	670	5.5 mins
PE4710 IPS	6" SDR17	636	3/16 in	Almost Zero	105 sec	10 sec	636	4.5 mins
PE4710 IPS	6" SDR11	950	3/16 in	Almost Zero	163 sec	15 sec	950	6.75 mins
FluidLok SDR11x17	2 x 4"	416	3/16 in	Almost Zero	58 sec	8 sec	416	2.5 mins
FluidLok SDR11x17	3 x 6"	901	3/16 in	Almost Zero	86 sec	8 sec	901	3.5 mins



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