

Acrobat™ Quickfit Welding Parameters

CURRENT AS OF
09/01/2023

Product Line & Material	Pipe Size	Initial Melt Pressure	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure	Cooling Time
Asahitec™ Solid Wall (PP-RCT)	14" (355mm) SDR11	393	2 mm	Almost Zero	322 seconds	13 seconds	393	29.6 min
Asahitec™ Solid Wall (PP-RCT)	16" (400mm) SDR11	500	2 mm	Almost Zero	356 seconds	14 seconds	500	33.4 min
Climatec™ (PP-RCT)	14" (355mm) SDR17	264	1.5 mm	Almost Zero	225 seconds	10 seconds	264	19.8 min
Climatec™ (PP-RCT)	16" (400mm) SDR17	335	1.5 mm	Almost Zero	250 seconds	10 seconds	335	22.0 min
Proline® PRO150 (PP)	14" (355mm) SDR11	393	2 mm	Almost Zero	322 seconds	13 seconds	393	29.6 min
Proline® PRO150 (PP)	16" (400mm) SDR11	500	2 mm	Almost Zero	356 seconds	14 seconds	500	33.4 min
Proline® PRO90 (PP)	14" (355mm) SDR17.6	255	1.5 mm	Almost Zero	201 seconds	10 seconds	255	18.6 min
Proline® PRO90 (PP)	16" (400mm) SDR17.6	340	1.5 mm	Almost Zero	240 seconds	10 seconds	340	21.1 min
Proline® PRO45 (PP)	14" (355mm) SDR33	153	1 mm	Almost Zero	123 seconds	7 seconds	153	11.0 min
Proline® PRO45 (PP)	16" (400mm) SDR33	187	1 mm	Almost Zero	138 seconds	7 seconds	187	12.3 min
Watertec™ (PP-RCT)	14" (355mm) SDR11	393	2 mm	Almost Zero	322 seconds	13 seconds	393	29.6 min
Watertec™ (PP-RCT)	16" (400mm) SDR11	500	2 mm	Almost Zero	356 seconds	14 seconds	500	33.4 min
Asahitec™ Solid Wall (PP-RCT)	18" (450mm) SDR11	645	2.5 mm	Almost Zero	388 seconds	15 seconds	645	37.6 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	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure	Cooling Time
Climatec™ (PP-RCT)	18" (450mm) SDR17	442	2 mm	Almost Zero	277 seconds	11 seconds	442	24.6 min
Climatec™ (PP-RCT)	20" (500mm) SDR17	544	2 mm	Almost Zero	302 seconds	12 seconds	544	27.4 min
Proline® PRO150 (PP)	18" (450mm) SDR11	645	2.5 mm	Almost Zero	388 seconds	15 seconds	645	37.6 min
Proline® PRO90 (PP)	18" (450mm) SDR17.6	340	1.5 mm	Almost Zero	266 seconds	11 seconds	340	23.3 min
Proline® PRO90 (PP)	20" (500mm) SDR17.6	425	2 mm	Almost Zero	291 seconds	12 seconds	425	26.1 min
Proline® PRO45 (PP)	18" (450mm) SDR33	238	1 mm	Almost Zero	153 seconds	8 seconds	238	13.6 min
Proline® PRO45 (PP)	20" (500mm) SDR33	289	1 mm	Almost Zero	168 seconds	8 seconds	289	14.8 min
Watertec™ (PP-RCT)	18" (450mm) SDR11	645	2.5 mm	Almost Zero	388 seconds	15 seconds	645	37.6 min
Proline® PRO150 (PP)	22" (560mm) SDR11	998	3 mm	Almost Zero	455 seconds	17 seconds	998	46.9 min
Proline® PRO150 (PP)	24" (630mm) SDR11	1247	3 mm	Almost Zero	485 seconds	19 seconds	1247	52.6 min
Proline® PRO90 (PP)	22" (560mm) SDR17.6	635	2 mm	Almost Zero	318 seconds	13 seconds	635	29.1 min
Proline® PRO90 (PP)	24" (630mm) SDR17.6	803	2 mm	Almost Zero	351 seconds	13 seconds	803	32.5 min
Proline® PRO45 (PP)	22" (560mm) SDR33	353	1 mm	Almost Zero	188 seconds	8 seconds	353	16.5 min
Proline® PRO45 (PP)	24" (630mm) SDR33	457	1.5 mm	Almost Zero	209 seconds	9 seconds	457	18.3 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