

# PP-R WELDING PROCESS



- ① **Step 1.** Mark the pipe to desired length.
- ② **Step 2.** Cut the pipe with plastic pipe cutters
- ③ **Step 3.** Insert the pipe and fitting into the heating plates of the fusion welding machine. Observe the correct depth and heating time for size pipe used.
- ④ **Step 4.** Remove the pipe and fitting from the fusion welder and insert the pipe into the fitting taking care not to twist the pipe or fitting. Align joint and observe cooling time.

**It takes +- 15 seconds to make a 20mm fusion joint that forms a homogenous piece of plastic that can not leak!!**

# WELDING PARAMETERS

Outer Diameter (mm)	Melting Depth (mm)	Heating Time (sec)	Processing Time (sec)	Cooling time (min)
20	14	5	4	3
25	15.5	7	4	3
32	17.5	8	4	4
40	20	12	6	4
50	23	18	6	5
63	26	24	6	6
75	28.5	30	8	8
90	33	40	8	8
110	39	50	10	10
125	41	58	11	10
160	46	80	15	15

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