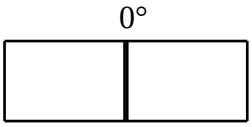
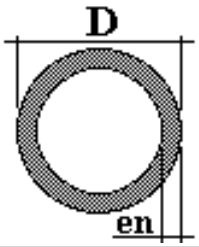
# Tabelle parametri di saldatura

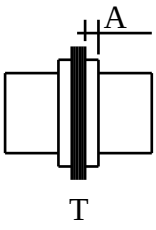
IMPORTANTE: si ricorda che le norme, di cui alle tabelle riprodotte nelle pagine successive, concernono il procedimento di saldatura e devono essere conosciute dal saldatore il quale, è sempre tenuto a verificare in opera autonomamente i relativi parametri sulla base delle stesse e ad essere aggiornato su eventuali evoluzioni delle norme medesime.
Ritmo S.p.A. declina ogni responsabilità con riferimento all?utilizzo delle tabelle, qui riportate a mero titolo esemplificativo.

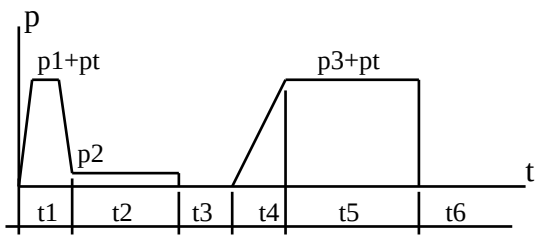
BASIC 250(V0,V1)
Sez. spinta = 5.89 cm2 (0.91 in2)
UNI10520(10/21) SINGLE LP
pi = 0.17MPa
PE 100

Temp. amb. = 5.0°C



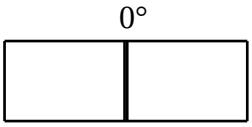

La macchina selezionata è in grado di saldare solo tubi che prevedono pressioni (p1+pt) entro il valore di pressione massima indicato dai dati tecnici del prodotto (vedere manuale d'uso).

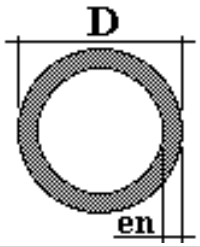
| Diametro | D | en | SDR | T min/nom/max | *p1 | A | p2 | t2 | t3max | t4 | *p3 | t5 | t6 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| mm | mm | mm | =D/en | °C | bar | mm | bar | s | s | s | bar | | |
| 75 | 75 | 1.83 | 41 | 215/225/235 | 1 | 0.7 | 0 | 25 | 5 | 5 | 1 | 3 min 32 s | 2 min 45 s |
| 75 | 75 | 2.27 | 33 | 215/225/235 | 1 | 0.7 | 0 | 31 | 5 | 5 | 1 | 3 min 51 s | 3 min 25 s |
| 75 | 75 | 2.31 | 32.5 | 215/225/235 | 2 | 0.7 | 0 | 31 | 5 | 5 | 2 | 3 min 52 s | 3 min 28 s |
| 75 | 75 | 2.9# | 26 | 215/225/235 | 2 | 0.8 | 0 | 39 | 5 | 5 | 2 | 4 min 18 s | 4 min 21 s |
| 75 | 75 | 3.6# | 21 | 215/225/235 | 2 | 0.9 | 0 | 49 | 5 | 5 | 2 | 4 min 49 s | 5 min 24 s |
| 75 | 75 | 3.95 | 19 | 215/225/235 | 3 | 0.9 | 0 | 53 | 5 | 5 | 3 | 5 min 4 s | 5 min 55 s |
| 75 | 75 | 4.26 | 17.6 | 215/225/235 | 3 | 0.9 | 0 | 58 | 5 | 5 | 3 | 5 min 18 s | 6 min 24 s |
| 75 | 75 | 4.5# | 17 | 215/225/235 | 3 | 1 | 0 | 61 | 5 | 5 | 3 | 5 min 29 s | 6 min 45 s |
| 75 | 75 | 4.84 | 15.5 | 215/225/235 | 3 | 1 | 0 | 65 | 6 | 5 | 3 | 5 min 43 s | 7 min 15 s |
| 75 | 75 | 5.6# | 13.6 | 215/225/235 | 4 | 1.1 | 0 | 76 | 6 | 5 | 4 | 6 min 17 s | 8 min 24 s |
| 75 | 75 | 5.56 | 13.5 | 215/225/235 | 3 | 1.1 | 0 | 75 | 6 | 5 | 3 | 6 min 14 s | 8 min 20 s |
| 75 | 75 | 6.52 | 11.5 | 215/225/235 | 4 | 1.2 | 0 | 88 | 6 | 5 | 4 | 6 min 57 s | 9 min 47 s |
| 75 | 75 | 6.8# | 11 | 215/225/235 | 4 | 1.2 | 0 | 92 | 6 | 5 | 4 | 7 min 9 s | 10 min 12 s |
| 75 | 75 | 8.06 | 9.3 | 215/225/235 | 5 | 1.3 | 0 | 109 | 8 | 5 | 5 | 8 min 5 s | 12 min 6 s |
| 75 | 75 | 8.4# | 9 | 215/225/235 | 5 | 1.3 | 0 | 113 | 8 | 5 | 5 | 8 min 19 s | 12 min 36 s |
| 75 | 75 | 10.3# | 7.4 | 215/225/235 | 6 | 1.5 | 0 | 139 | 8 | 5 | 6 | 9 min 43 s | 15 min 27 s |
| 75 | 75 | 10.27 | 7.3 | 215/225/235 | 6 | 1.5 | 0 | 139 | 8 | 5 | 6 | 9 min 41 s | 15 min 25 s |
| 75 | 75 | 10.71 | 7 | 215/225/235 | 6 | 1.6 | 0 | 145 | 8 | 5 | 6 | 10 min 1 s | 16 min 4 s |
| 75 | 75 | 12.5# | 6 | 215/225/235 | 7 | 1.8 | 0 | 169 | 10 | 5 | 7 | 11 min 19 s | 18 min 45 s |
| 90 | 90 | 2.2 | 41 | 215/225/235 | 2 | 0.7 | 0 | 30 | 5 | 6 | 2 | 3 min 48 s | 3 min 18 s |
| 90 | 90 | 2.73 | 33 | 215/225/235 | 2 | 0.8 | 0 | 37 | 5 | 6 | 2 | 4 min 11 s | 4 min 5 s |
| 90 | 90 | 2.77 | 32.5 | 215/225/235 | 2 | 0.8 | 0 | 37 | 5 | 6 | 2 | 4 min 13 s | 4 min 9 s |
| 90 | 90 | 3.5# | 26 | 215/225/235 | 3 | 0.9 | 0 | 47 | 5 | 6 | 3 | 4 min 45 s | 5 min 15 s |
| 90 | 90 | 4.3# | 21 | 215/225/235 | 3 | 0.9 | 0 | 58 | 5 | 6 | 3 | 5 min 20 s | 6 min 27 s |
| 90 | 90 | 4.74 | 19 | 215/225/235 | 4 | 1 | 0 | 64 | 6 | 6 | 4 | 5 min 39 s | 7 min 6 s |
| 90 | 90 | 5.11 | 17.6 | 215/225/235 | 4 | 1 | 0 | 69 | 6 | 6 | 4 | 5 min 56 s | 7 min 40 s |
| 90 | 90 | 5.4# | 17 | 215/225/235 | 4 | 1 | 0 | 73 | 6 | 6 | 4 | 6 min 8 s | 8 min 6 s |
| 90 | 90 | 5.81 | 15.5 | 215/225/235 | 4 | 1.1 | 0 | 78 | 6 | 6 | 4 | 6 min 25 s | 8 min 43 s |
| 90 | 90 | 6.7# | 13.6 | 215/225/235 | 5 | 1.2 | 0 | 90 | 6 | 6 | 5 | 7 min 5 s | 10 min 3 s |
| 90 | 90 | 6.67 | 13.5 | 215/225/235 | 5 | 1.2 | 0 | 90 | 6 | 6 | 5 | 7 min 3 s | 10 min |
| 90 | 90 | 7.83 | 11.5 | 215/225/235 | 6 | 1.3 | 0 | 106 | 8 | 6 | 6 | 7 min 55 s | 11 min 44 s |
| 90 | 90 | 8.2# | 11 | 215/225/235 | 6 | 1.3 | 0 | 111 | 8 | 6 | 6 | 8 min 11 s | 12 min 18 s |
| 90 | 90 | 9.68 | 9.3 | 215/225/235 | 7 | 1.5 | 0 | 131 | 8 | 6 | 7 | 9 min 16 s | 14 min 31 s |
| 90 | 90 | 10.1# | 9 | 215/225/235 | 7 | 1.5 | 0 | 136 | 8 | 6 | 7 | 9 min 34 s | 15 min 9 s |
| 90 | 90 | 12.3# | 7.4 | 215/225/235 | 9 | 1.7 | 0 | 166 | 10 | 6 | 9 | 11 min 10 s | 18 min 27 s |
| 90 | 90 | 12.33 | 7.3 | 215/225/235 | 9 | 1.7 | 0 | 166 | 10 | 6 | 9 | 11 min 12 s | 18 min 30 s |
| 90 | 90 | 12.86 | 7 | 215/225/235 | 9 | 1.8 | 0 | 174 | 10 | 6 | 9 | 11 min 34 s | 19 min 17 s |
| 90 | 90 | 15# | 6 | 215/225/235 | 10 | 2 | 0 | 203 | 10 | 6 | 10 | 13 min 8 s | 22 min 30 s |
| 110 | 110 | 2.68 | 41 | 215/225/235 | 3 | 0.8 | 0 | 36 | 5 | 6 | 3 | 4 min 9 s | 4 min 1 s |
| 110 | 110 | 3.33 | 33 | 215/225/235 | 3 | 0.8 | 0 | 45 | 5 | 6 | 3 | 4 min 37 s | 5 min |
| 110 | 110 | 3.38 | 32.5 | 215/225/235 | 3 | 0.8 | 0 | 46 | 5 | 6 | 3 | 4 min 40 s | 5 min 5 s |
| 110 | 110 | 4.2# | 26 | 215/225/235 | 4 | 0.9 | 0 | 57 | 5 | 6 | 4 | 5 min 15 s | 6 min 18 s |
| 110 | 110 | 5.3# | 21 | 215/225/235 | 5 | 1 | 0 | 72 | 6 | 6 | 5 | 6 min 4 s | 7 min 57 s |
| 110 | 110 | 5.79 | 19 | 215/225/235 | 5 | 1.1 | 0 | 78 | 6 | 6 | 5 | 6 min 25 s | 8 min 41 s |
| 110 | 110 | 6.25 | 17.6 | 215/225/235 | 6 | 1.1 | 0 | 84 | 6 | 6 | 6 | 6 min 45 s | 9 min 22 s |
| 110 | 110 | 6.6# | 17 | 215/225/235 | 6 | 1.2 | 0 | 89 | 6 | 6 | 6 | 7 min | 9 min 54 s |
| 110 | 110 | 7.1 | 15.5 | 215/225/235 | 7 | 1.2 | 0 | 96 | 8 | 6 | 7 | 7 min 22 s | 10 min 39 s |
| 110 | 110 | 8.1# | 13.6 | 215/225/235 | 7 | 1.3 | 0 | 109 | 8 | 6 | 7 | 8 min 6 s | 12 min 9 s |
| 110 | 110 | 8.15 | 13.5 | 215/225/235 | 8 | 1.3 | 0 | 110 | 8 | 6 | 8 | 8 min 8 s | 12 min 13 s |
| 110 | 110 | 9.57 | 11.5 | 215/225/235 | 9 | 1.5 | 0 | 129 | 8 | 6 | 9 | 9 min 10 s | 14 min 21 s |
| 110 | 110 | 10# | 11 | 215/225/235 | 9 | 1.5 | 0 | 135 | 8 | 6 | 9 | 9 min 29 s | 15 min |
| 110 | 110 | 11.83 | 9.3 | 215/225/235 | 11 | 1.7 | 0 | 160 | 8 | 6 | 11 | 10 min 50 s | 17 min 45 s |
| 110 | 110 | 12.3# | 9 | 215/225/235 | 11 | 1.7 | 0 | 166 | 10 | 6 | 11 | 11 min 10 s | 18 min 27 s |
| 110 | 110 | 15.1# | 7.4 | 215/225/235 | 13 | 2 | 0 | 204 | 10 | 6 | 13 | 13 min 13 s | 22 min 39 s |

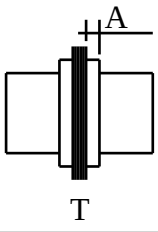
* Si ricorda di sommare a questo valore il valore della pressione di trascinamento pt precedentemente misurato.
# Spessore secondo la norma EN 12201-2:2011+A1:2013

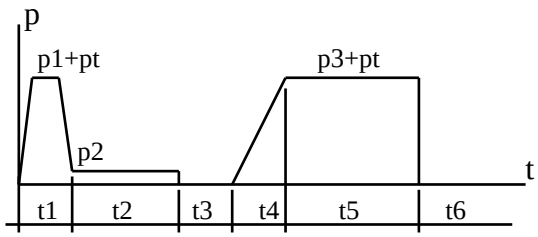
BASIC 250(V0,V1)
Sez. spinta = 5.89 cm2 (0.91 in2)
UNI10520(10/21) SINGLE LP
pi = 0.17MPa
PE 100

Temp. amb. = 5.0°C



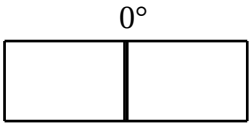

La macchina selezionata è in grado di saldare solo tubi che prevedono pressioni (p1+pt) entro il valore di pressione massima indicato dai dati tecnici del prodotto (vedere manuale d'uso).

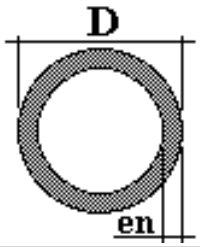
| Diametro | D | en | SDR | T min/nom/max | *p1 | A | p2 | t2 | t3max | t4 | *p3 | t5 | t6 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| mm | mm | mm | =D/en | °C | bar | mm | bar | s | s | s | bar | | |
| 110 | 110 | 15.07 | 7.3 | 215/225/235 | 13 | 2 | 0 | 203 | 10 | 6 | 13 | 13 min 11 s | 22 min 36 s |
| 110 | 110 | 15.71 | 7 | 215/225/235 | 13 | 2.1 | 0 | 212 | 10 | 6 | 13 | 13 min 40 s | 23 min 34 s |
| 110 | 110 | 18.3# | 6 | 215/225/235 | 15 | 2.3 | 0 | 247 | 10 | 6 | 15 | 11 min 59 s | 27 min 27 s |
| 125 | 125 | 3.05 | 41 | 215/225/235 | 3 | 0.8 | 0 | 41 | 5 | 7 | 3 | 4 min 25 s | 4 min 34 s |
| 125 | 125 | 3.79 | 33 | 215/225/235 | 4 | 0.9 | 0 | 51 | 5 | 7 | 4 | 4 min 57 s | 5 min 41 s |
| 125 | 125 | 3.85 | 32.5 | 215/225/235 | 4 | 0.9 | 0 | 52 | 5 | 7 | 4 | 5 min | 5 min 46 s |
| 125 | 125 | 4.8# | 26 | 215/225/235 | 5 | 1 | 0 | 65 | 6 | 7 | 5 | 5 min 42 s | 7 min 12 s |
| 125 | 125 | 6# | 21 | 215/225/235 | 6 | 1.1 | 0 | 81 | 6 | 7 | 6 | 6 min 34 s | 9 min |
| 125 | 125 | 6.58 | 19 | 215/225/235 | 7 | 1.2 | 0 | 89 | 6 | 7 | 7 | 7 min | 9 min 52 s |
| 125 | 125 | 7.1 | 17.6 | 215/225/235 | 8 | 1.2 | 0 | 96 | 8 | 7 | 8 | 7 min 22 s | 10 min 39 s |
| 125 | 125 | 7.4# | 17 | 215/225/235 | 8 | 1.2 | 0 | 100 | 8 | 7 | 8 | 7 min 36 s | 11 min 6 s |
| 125 | 125 | 8.06 | 15.5 | 215/225/235 | 9 | 1.3 | 0 | 109 | 8 | 7 | 9 | 8 min 5 s | 12 min 6 s |
| 125 | 125 | 9.2# | 13.6 | 215/225/235 | 10 | 1.4 | 0 | 124 | 8 | 7 | 10 | 8 min 54 s | 13 min 48 s |
| 125 | 125 | 9.26 | 13.5 | 215/225/235 | 10 | 1.4 | 0 | 125 | 8 | 7 | 10 | 8 min 57 s | 13 min 53 s |
| 125 | 125 | 10.87 | 11.5 | 215/225/235 | 11 | 1.6 | 0 | 147 | 8 | 7 | 11 | 10 min 7 s | 16 min 18 s |
| 125 | 125 | 11.4# | 11 | 215/225/235 | 12 | 1.6 | 0 | 154 | 8 | 7 | 12 | 10 min 31 s | 17 min 6 s |
| 125 | 125 | 13.44 | 9.3 | 215/225/235 | 14 | 1.8 | 0 | 181 | 10 | 7 | 14 | 12 min | 20 min 10 s |
| 125 | 125 | 14# | 9 | 215/225/235 | 14 | 1.9 | 0 | 189 | 10 | 7 | 14 | 12 min 25 s | 21 min |
| 125 | 125 | 17.1# | 7.4 | 215/225/235 | 17 | 2.2 | 0 | 231 | 10 | 7 | 17 | 14 min 40 s | 25 min 39 s |
| 125 | 125 | 17.12 | 7.3 | 215/225/235 | 17 | 2.2 | 0 | 231 | 10 | 7 | 17 | 14 min 41 s | 25 min 41 s |
| 125 | 125 | 17.86 | 7 | 215/225/235 | 17 | 2.3 | 0 | 241 | 10 | 7 | 17 | 15 min 13 s | 26 min 47 s |
| 125 | 125 | 20.8# | 6 | 215/225/235 | 20 | 2.6 | 0 | 281 | 12 | 7 | 20 | 12 min 12 s | 31 min 12 s |
| 140 | 140 | 3.41 | 41 | 215/225/235 | 4 | 0.8 | 0 | 46 | 5 | 7 | 4 | 4 min 41 s | 5 min 7 s |
| 140 | 140 | 4.24 | 33 | 215/225/235 | 5 | 0.9 | 0 | 57 | 5 | 7 | 5 | 5 min 18 s | 6 min 22 s |
| 140 | 140 | 4.31 | 32.5 | 215/225/235 | 5 | 0.9 | 0 | 58 | 5 | 7 | 5 | 5 min 20 s | 6 min 28 s |
| 140 | 140 | 5.4# | 26 | 215/225/235 | 7 | 1 | 0 | 73 | 6 | 7 | 7 | 6 min 8 s | 8 min 6 s |
| 140 | 140 | 6.7# | 21 | 215/225/235 | 8 | 1.2 | 0 | 90 | 6 | 7 | 8 | 7 min 5 s | 10 min 3 s |
| 140 | 140 | 7.37 | 19 | 215/225/235 | 9 | 1.2 | 0 | 99 | 8 | 7 | 9 | 7 min 34 s | 11 min 3 s |
| 140 | 140 | 7.95 | 17.6 | 215/225/235 | 10 | 1.3 | 0 | 107 | 8 | 7 | 10 | 8 min | 11 min 56 s |
| 140 | 140 | 8.3# | 17 | 215/225/235 | 10 | 1.3 | 0 | 112 | 8 | 7 | 10 | 8 min 15 s | 12 min 27 s |
| 140 | 140 | 9.03 | 15.5 | 215/225/235 | 11 | 1.4 | 0 | 122 | 8 | 7 | 11 | 8 min 47 s | 13 min 33 s |
| 140 | 140 | 10.3# | 13.6 | 215/225/235 | 12 | 1.5 | 0 | 139 | 8 | 7 | 12 | 9 min 43 s | 15 min 27 s |
| 140 | 140 | 10.37 | 13.5 | 215/225/235 | 12 | 1.5 | 0 | 140 | 8 | 7 | 12 | 9 min 45 s | 15 min 33 s |
| 140 | 140 | 12.17 | 11.5 | 215/225/235 | 14 | 1.7 | 0 | 164 | 10 | 7 | 14 | 11 min 4 s | 18 min 16 s |
| 140 | 140 | 12.7# | 11 | 215/225/235 | 15 | 1.8 | 0 | 171 | 10 | 7 | 15 | 11 min 28 s | 19 min 3 s |
| 140 | 140 | 15.05 | 9.3 | 215/225/235 | 17 | 2 | 0 | 203 | 10 | 7 | 17 | 13 min 11 s | 22 min 35 s |
| 140 | 140 | 15.7# | 9 | 215/225/235 | 18 | 2.1 | 0 | 212 | 10 | 7 | 18 | 13 min 39 s | 23 min 33 s |
| 140 | 140 | 19.2# | 7.4 | 215/225/235 | 21 | 2.4 | 0 | 259 | 12 | 7 | 21 | 12 min 3 s | 28 min 48 s |
| 140 | 140 | 19.18 | 7.3 | 215/225/235 | 21 | 2.4 | 0 | 259 | 12 | 7 | 21 | 12 min 3 s | 28 min 46 s |
| 140 | 140 | 20 | 7 | 215/225/235 | 22 | 2.5 | 0 | 270 | 12 | 7 | 22 | 12 min 7 s | 30 min |
| 140 | 140 | 23.3# | 6 | 215/225/235 | 25 | 2.8 | 0 | 315 | 12 | 7 | 25 | 12 min 33 s | 34 min 57 s |
| 160 | 160 | 3.9 | 41 | 215/225/235 | 6 | 0.9 | 0 | 53 | 5 | 8 | 6 | 5 min 2 s | 5 min 51 s |
| 160 | 160 | 4.85 | 33 | 215/225/235 | 7 | 1 | 0 | 65 | 6 | 8 | 7 | 5 min 44 s | 7 min 16 s |
| 160 | 160 | 4.92 | 32.5 | 215/225/235 | 7 | 1 | 0 | 66 | 6 | 8 | 7 | 5 min 47 s | 7 min 23 s |
| 160 | 160 | 6.2# | 26 | 215/225/235 | 9 | 1.1 | 0 | 84 | 6 | 8 | 9 | 6 min 43 s | 9 min 18 s |
| 160 | 160 | 7.7# | 21 | 215/225/235 | 11 | 1.3 | 0 | 104 | 8 | 8 | 11 | 7 min 49 s | 11 min 33 s |
| 160 | 160 | 8.42 | 19 | 215/225/235 | 12 | 1.3 | 0 | 114 | 8 | 8 | 12 | 8 min 20 s | 12 min 38 s |
| 160 | 160 | 9.09 | 17.6 | 215/225/235 | 12 | 1.4 | 0 | 123 | 8 | 8 | 12 | 8 min 49 s | 13 min 38 s |
| 160 | 160 | 9.5# | 17 | 215/225/235 | 13 | 1.5 | 0 | 128 | 8 | 8 | 13 | 9 min 8 s | 14 min 15 s |
| 160 | 160 | 10.32 | 15.5 | 215/225/235 | 14 | 1.5 | 0 | 139 | 8 | 8 | 14 | 9 min 43 s | 15 min 29 s |
| 160 | 160 | 11.8# | 13.6 | 215/225/235 | 16 | 1.7 | 0 | 159 | 8 | 8 | 16 | 10 min 48 s | 17 min 42 s |
| 160 | 160 | 11.85 | 13.5 | 215/225/235 | 16 | 1.7 | 0 | 160 | 8 | 8 | 16 | 10 min 50 s | 17 min 47 s |
| 160 | 160 | 13.91 | 11.5 | 215/225/235 | 18 | 1.9 | 0 | 188 | 10 | 8 | 18 | 12 min 21 s | 20 min 52 s |
| 160 | 160 | 14.6# | 11 | 215/225/235 | 19 | 2 | 0 | 197 | 10 | 8 | 19 | 12 min 51 s | 21 min 54 s |

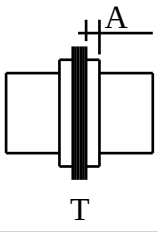
* Si ricorda di sommare a questo valore il valore della pressione di trascinamento pt precedentemente misurato.
# Spessore secondo la norma EN 12201-2:2011+A1:2013

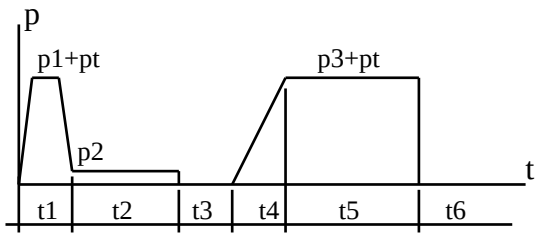
BASIC 250(V0,V1)
Sez. spinta = 5.89 cm2 (0.91 in2)
UNI10520(10/21) SINGLE LP
pi = 0.17MPa
PE 100

Temp. amb. = 5.0°C



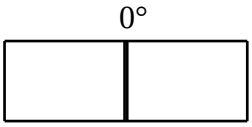

La macchina selezionata è in grado di saldare solo tubi che prevedono pressioni (p1+pt) entro il valore di pressione massima indicato dai dati tecnici del prodotto (vedere manuale d'uso).

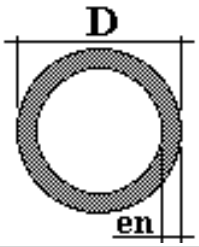
| Diametro | D | en | SDR | T min/nom/max | *p1 | A | p2 | t2 | t3max | t4 | *p3 | t5 | t6 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| mm | mm | mm | =D/en | °C | bar | mm | bar | s | s | s | bar | | |
| 160 | 160 | 17.2 | 9.3 | 215/225/235 | 22 | 2.2 | 0 | 232 | 10 | 8 | 22 | 14 min 45 s | 25 min 48 s |
| 160 | 160 | 17.9# | 9 | 215/225/235 | 23 | 2.3 | 0 | 242 | 10 | 8 | 23 | 15 min 15 s | 26 min 51 s |
| 160 | 160 | 21.9# | 7.4 | 215/225/235 | 27 | 2.7 | 0 | 296 | 12 | 8 | 27 | 12 min 20 s | 32 min 51 s |
| 160 | 160 | 21.92 | 7.3 | 215/225/235 | 27 | 2.7 | 0 | 296 | 12 | 8 | 27 | 12 min 20 s | 32 min 53 s |
| 160 | 160 | 22.86 | 7 | 215/225/235 | 28 | 2.8 | 0 | 309 | 12 | 8 | 28 | 12 min 29 s | 34 min 17 s |
| 160 | 160 | 26.6# | 6 | 215/225/235 | 32 | 3.2 | 0 | 359 | 16 | 8 | 32 | 13 min 14 s | 39 min 54 s |
| 180 | 180 | 4.39 | 41 | 215/225/235 | 7 | 0.9 | 0 | 59 | 5 | 8 | 7 | 5 min 23 s | 6 min 35 s |
| 180 | 180 | 5.45 | 33 | 215/225/235 | 9 | 1 | 0 | 74 | 6 | 8 | 9 | 6 min 10 s | 8 min 11 s |
| 180 | 180 | 5.54 | 32.5 | 215/225/235 | 9 | 1.1 | 0 | 75 | 6 | 8 | 9 | 6 min 14 s | 8 min 18 s |
| 180 | 180 | 6.9# | 26 | 215/225/235 | 11 | 1.2 | 0 | 93 | 6 | 8 | 11 | 7 min 14 s | 10 min 21 s |
| 180 | 180 | 8.6# | 21 | 215/225/235 | 13 | 1.4 | 0 | 116 | 8 | 8 | 13 | 8 min 28 s | 12 min 54 s |
| 180 | 180 | 9.47 | 19 | 215/225/235 | 15 | 1.4 | 0 | 128 | 8 | 8 | 15 | 9 min 6 s | 14 min 13 s |
| 180 | 180 | 10.23 | 17.6 | 215/225/235 | 16 | 1.5 | 0 | 138 | 8 | 8 | 16 | 9 min 40 s | 15 min 20 s |
| 180 | 180 | 10.7# | 17 | 215/225/235 | 16 | 1.6 | 0 | 144 | 8 | 8 | 16 | 10 min | 16 min 3 s |
| 180 | 180 | 11.61 | 15.5 | 215/225/235 | 18 | 1.7 | 0 | 157 | 8 | 8 | 18 | 10 min 40 s | 17 min 25 s |
| 180 | 180 | 13.3# | 13.6 | 215/225/235 | 20 | 1.8 | 0 | 180 | 10 | 8 | 20 | 11 min 54 s | 19 min 57 s |
| 180 | 180 | 13.33 | 13.5 | 215/225/235 | 20 | 1.8 | 0 | 180 | 10 | 8 | 20 | 11 min 55 s | 20 min |
| 180 | 180 | 15.65 | 11.5 | 215/225/235 | 23 | 2.1 | 0 | 211 | 10 | 8 | 23 | 13 min 37 s | 23 min 29 s |
| 180 | 180 | 16.4# | 11 | 215/225/235 | 24 | 2.1 | 0 | 221 | 10 | 8 | 24 | 14 min 10 s | 24 min 36 s |
| 180 | 180 | 19.35 | 9.3 | 215/225/235 | 28 | 2.4 | 0 | 261 | 12 | 8 | 28 | 12 min 3 s | 29 min 2 s |
| 180 | 180 | 20.1# | 9 | 215/225/235 | 29 | 2.5 | 0 | 271 | 12 | 8 | 29 | 12 min 8 s | 30 min 9 s |
| 180 | 180 | 24.6# | 7.4 | 215/225/235 | 35 | 3 | 0 | 332 | 12 | 8 | 35 | 12 min 47 s | 36 min 54 s |
| 180 | 180 | 24.66 | 7.3 | 215/225/235 | 35 | 3 | 0 | 333 | 12 | 8 | 35 | 12 min 48 s | 36 min 59 s |
| 180 | 180 | 25.71 | 7 | 215/225/235 | 36 | 3.1 | 0 | 347 | 12 | 8 | 36 | 13 min 1 s | 38 min 34 s |
| 180 | 180 | 29.9# | 6 | 215/225/235 | 41 | 3.5 | 0 | 404 | 16 | 8 | 41 | 14 min 8 s | 44 min 51 s |
| 200 | 200 | 4.88 | 41 | 215/225/235 | 9 | 1 | 0 | 66 | 6 | 9 | 9 | 5 min 45 s | 7 min 19 s |
| 200 | 200 | 6.06 | 33 | 215/225/235 | 11 | 1.1 | 0 | 82 | 6 | 9 | 11 | 6 min 37 s | 9 min 5 s |
| 200 | 200 | 6.15 | 32.5 | 215/225/235 | 11 | 1.1 | 0 | 83 | 6 | 9 | 11 | 6 min 41 s | 9 min 14 s |
| 200 | 200 | 7.7# | 26 | 215/225/235 | 13 | 1.3 | 0 | 104 | 8 | 9 | 13 | 7 min 49 s | 11 min 33 s |
| 200 | 200 | 9.6# | 21 | 215/225/235 | 17 | 1.5 | 0 | 130 | 8 | 9 | 17 | 9 min 12 s | 14 min 24 s |
| 200 | 200 | 10.53 | 19 | 215/225/235 | 18 | 1.6 | 0 | 142 | 8 | 9 | 18 | 9 min 53 s | 15 min 47 s |
| 200 | 200 | 11.36 | 17.6 | 215/225/235 | 19 | 1.6 | 0 | 153 | 8 | 9 | 19 | 10 min 29 s | 17 min 3 s |
| 200 | 200 | 11.9# | 17 | 215/225/235 | 20 | 1.7 | 0 | 161 | 8 | 9 | 20 | 10 min 53 s | 17 min 51 s |
| 200 | 200 | 12.9 | 15.5 | 215/225/235 | 22 | 1.8 | 0 | 174 | 10 | 9 | 22 | 11 min 36 s | 19 min 21 s |
| 200 | 200 | 14.7# | 13.6 | 215/225/235 | 25 | 2 | 0 | 198 | 10 | 9 | 25 | 12 min 55 s | 22 min 3 s |
| 200 | 200 | 14.81 | 13.5 | 215/225/235 | 25 | 2 | 0 | 200 | 10 | 9 | 25 | 13 min | 22 min 13 s |
| 200 | 200 | 17.39 | 11.5 | 215/225/235 | 29 | 2.2 | 0 | 235 | 10 | 9 | 29 | 14 min 53 s | 26 min 5 s |
| 200 | 200 | 18.2# | 11 | 215/225/235 | 30 | 2.3 | 0 | 246 | 10 | 9 | 30 | 11 min 59 s | 27 min 18 s |
| 200 | 200 | 21.51 | 9.3 | 215/225/235 | 35 | 2.7 | 0 | 290 | 12 | 9 | 35 | 12 min 17 s | 32 min 15 s |
| 200 | 200 | 22.4# | 9 | 215/225/235 | 36 | 2.7 | 0 | 302 | 12 | 9 | 36 | 12 min 25 s | 33 min 36 s |
| 200 | 200 | 27.4# | 7.4 | 215/225/235 | 43 | 3.2 | 0 | 370 | 16 | 9 | 43 | 13 min 25 s | 41 min 6 s |
| 200 | 200 | 27.4 | 7.3 | 215/225/235 | 43 | 3.2 | 0 | 370 | 16 | 9 | 43 | 13 min 25 s | 41 min 6 s |
| 200 | 200 | 28.57 | 7 | 215/225/235 | 44 | 3.4 | 0 | 386 | 16 | 9 | 44 | 13 min 44 s | 42 min 51 s |
| 200 | 200 | 33.2# | 6 | 215/225/235 | 50 | 3.8 | 0 | 448 | 16 | 9 | 50 | 15 min 17 s | 49 min 48 s |
| 225 | 225 | 5.49 | 41 | 215/225/235 | 11 | 1 | 0 | 74 | 6 | 10 | 11 | 6 min 12 s | 8 min 14 s |
| 225 | 225 | 6.82 | 33 | 215/225/235 | 13 | 1.2 | 0 | 92 | 6 | 10 | 13 | 7 min 10 s | 10 min 14 s |
| 225 | 225 | 6.92 | 32.5 | 215/225/235 | 14 | 1.2 | 0 | 93 | 6 | 10 | 14 | 7 min 14 s | 10 min 23 s |
| 225 | 225 | 8.6# | 26 | 215/225/235 | 17 | 1.4 | 0 | 116 | 8 | 10 | 17 | 8 min 28 s | 12 min 54 s |
| 225 | 225 | 10.8# | 21 | 215/225/235 | 21 | 1.6 | 0 | 146 | 8 | 10 | 21 | 10 min 4 s | 16 min 12 s |
| 225 | 225 | 11.84 | 19 | 215/225/235 | 23 | 1.7 | 0 | 160 | 8 | 10 | 23 | 10 min 50 s | 17 min 46 s |
| 225 | 225 | 12.78 | 17.6 | 215/225/235 | 25 | 1.8 | 0 | 173 | 10 | 10 | 25 | 11 min 31 s | 19 min 11 s |
| 225 | 225 | 13.4# | 17 | 215/225/235 | 26 | 1.8 | 0 | 181 | 10 | 10 | 26 | 11 min 58 s | 20 min 6 s |
| 225 | 225 | 14.52 | 15.5 | 215/225/235 | 28 | 2 | 0 | 196 | 10 | 10 | 28 | 12 min 47 s | 21 min 46 s |
| 225 | 225 | 16.6# | 13.6 | 215/225/235 | 31 | 2.2 | 0 | 224 | 10 | 10 | 31 | 14 min 18 s | 24 min 54 s |

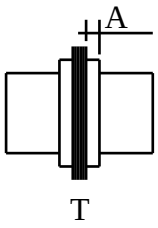
* Si ricorda di sommare a questo valore il valore della pressione di trascinamento pt precedentemente misurato.
# Spessore secondo la norma EN 12201-2:2011+A1:2013

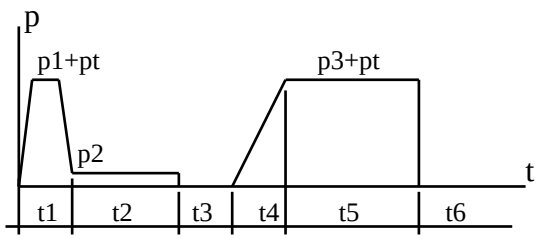
BASIC 250(V0,V1)
Sez. spinta = 5.89 cm2 (0.91 in2)
UNI10520(10/21) SINGLE LP
pi = 0.17MPa
PE 100

Temp. amb. = 5.0°C



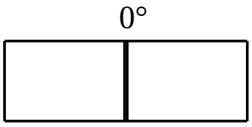

La macchina selezionata è in grado di saldare solo tubi che prevedono pressioni (p1+pt) entro il valore di pressione massima indicato dai dati tecnici del prodotto (vedere manuale d'uso).

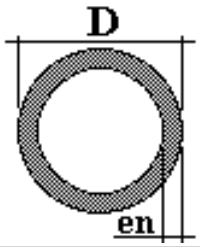
| Diametro | D | en | SDR | T min/nom/max | *p1 | A | p2 | t2 | t3max | t4 | *p3 | t5 | t6 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| mm | mm | mm | =D/en | °C | bar | mm | bar | s | s | s | bar | | |
| 225 | 225 | 16.67 | 13.5 | 215/225/235 | 31 | 2.2 | 0 | 225 | 10 | 10 | 31 | 14 min 21 s | 25 min |
| 225 | 225 | 19.57 | 11.5 | 215/225/235 | 36 | 2.5 | 0 | 264 | 12 | 10 | 36 | 12 min 5 s | 29 min 21 s |
| 225 | 225 | 20.5# | 11 | 215/225/235 | 38 | 2.6 | 0 | 277 | 12 | 10 | 38 | 12 min 10 s | 30 min 45 s |
| 225 | 225 | 24.19 | 9.3 | 215/225/235 | 44 | 2.9 | 0 | 327 | 12 | 10 | 44 | 12 min 43 s | 36 min 17 s |
| 225 | 225 | 25.2# | 9 | 215/225/235 | 46 | 3 | 0 | 340 | 12 | 10 | 46 | 12 min 55 s | 37 min 48 s |
| 225 | 225 | 30.8# | 7.4 | 215/225/235 | 54 | 3.6 | 0 | 416 | 16 | 10 | 54 | 14 min 25 s | 46 min 12 s |
| 225 | 225 | 30.82 | 7.3 | 215/225/235 | 54 | 3.6 | 0 | 416 | 16 | 10 | 54 | 14 min 26 s | 46 min 14 s |
| 225 | 225 | 32.14 | 7 | 215/225/235 | 56 | 3.7 | 0 | 434 | 16 | 10 | 56 | 14 min 53 s | 48 min 13 s |
| 225 | 225 | 37.4# | 6 | 215/225/235 | 64 | 4.2 | 0 | 505 | 20 | 10 | 64 | 17 min 5 s | 56 min 6 s |
| 250 | 250 | 6.1 | 41 | 215/225/235 | 13 | 1.1 | 0 | 82 | 6 | 11 | 13 | 6 min 39 s | 9 min 9 s |
| 250 | 250 | 7.58 | 33 | 215/225/235 | 17 | 1.3 | 0 | 102 | 8 | 11 | 17 | 7 min 44 s | 11 min 22 s |
| 250 | 250 | 7.69 | 32.5 | 215/225/235 | 17 | 1.3 | 0 | 104 | 8 | 11 | 17 | 7 min 49 s | 11 min 32 s |
| 250 | 250 | 9.6# | 26 | 215/225/235 | 21 | 1.5 | 0 | 130 | 8 | 11 | 21 | 9 min 12 s | 14 min 24 s |
| 250 | 250 | 11.9# | 21 | 215/225/235 | 26 | 1.7 | 0 | 161 | 8 | 11 | 26 | 10 min 53 s | 17 min 51 s |
| 250 | 250 | 13.16 | 19 | 215/225/235 | 28 | 1.8 | 0 | 178 | 10 | 11 | 28 | 11 min 47 s | 19 min 44 s |
| 250 | 250 | 14.2 | 17.6 | 215/225/235 | 30 | 1.9 | 0 | 192 | 10 | 11 | 30 | 12 min 33 s | 21 min 18 s |
| 250 | 250 | 14.8# | 17 | 215/225/235 | 32 | 2 | 0 | 200 | 10 | 11 | 32 | 13 min | 22 min 12 s |
| 250 | 250 | 16.13 | 15.5 | 215/225/235 | 34 | 2.1 | 0 | 218 | 10 | 11 | 34 | 13 min 58 s | 24 min 12 s |
| 250 | 250 | 18.4# | 13.6 | 215/225/235 | 39 | 2.3 | 0 | 248 | 10 | 11 | 39 | 12 min | 27 min 36 s |
| 250 | 250 | 18.52 | 13.5 | 215/225/235 | 39 | 2.4 | 0 | 250 | 10 | 11 | 39 | 12 min | 27 min 47 s |
| 250 | 250 | 21.74 | 11.5 | 215/225/235 | 45 | 2.7 | 0 | 293 | 12 | 11 | 45 | 12 min 19 s | 32 min 37 s |
| 250 | 250 | 22.7# | 11 | 215/225/235 | 47 | 2.8 | 0 | 306 | 12 | 11 | 47 | 12 min 28 s | 34 min 3 s |
| 250 | 250 | 26.88 | 9.3 | 215/225/235 | 54 | 3.2 | 0 | 363 | 16 | 11 | 54 | 13 min 17 s | 40 min 19 s |
| 250 | 250 | 27.9# | 9 | 215/225/235 | 56 | 3.3 | 0 | 377 | 16 | 11 | 56 | 13 min 33 s | 41 min 51 s |
| 250 | 250 | 34.2# | 7.4 | 215/225/235 | 67 | 3.9 | 0 | 462 | 16 | 11 | 67 | 15 min 40 s | 51 min 18 s |
| 250 | 250 | 34.25 | 7.3 | 215/225/235 | 67 | 3.9 | 0 | 462 | 16 | 11 | 67 | 15 min 42 s | 51 min 22 s |
| 250 | 250 | 35.71 | 7 | 215/225/235 | 69 | 4.1 | 0 | 482 | 16 | 11 | 69 | 16 min 19 s | 53 min 34 s |
| 250 | 250 | 41.5# | 6 | 215/225/235 | 78 | 4.7 | 0 | 560 | 20 | 11 | 78 | 19 min 13 s | 62 min 15 s |

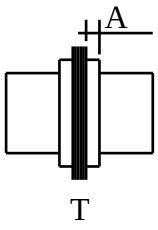
* Si ricorda di sommare a questo valore il valore della pressione di trascinamento pt precedentemente misurato.
# Spessore secondo la norma EN 12201-2:2011+A1:2013

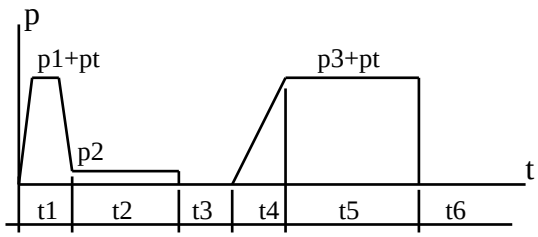
BASIC 250(V0,V1)
Sez. spinta = 5.89 cm2 (0.91 in2)
UNI10520(10/21) SINGLE LP
pi = 0.17MPa
PE 100

Temp. amb. = 5.0°C



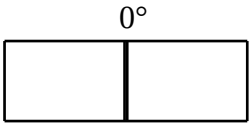

La macchina selezionata è in grado di saldare solo tubi che prevedono pressioni (p1+pt) entro il valore di pressione massima indicato dai dati tecnici del prodotto (vedere manuale d'uso).

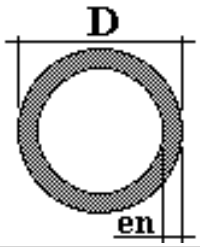
| Diametro | D | en | SDR | T min/nom/max | *p1 | A | p2 | t2 | t3max | t4 | *p3 | t5 | t6 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| IPS | mm | mm | =D/en | °C | bar | mm | bar | s | s | s | bar | | |
| 3 IPS | 88.9 | 2.16 | 41 | 215/225/235 | 2 | 0.7 | 0 | 29 | 5 | 6 | 2 | 3 min 46 s | 3 min 15 s |
| 3 IPS | 88.9 | 2.69 | 33 | 215/225/235 | 2 | 0.8 | 0 | 36 | 5 | 6 | 2 | 4 min 10 s | 4 min 2 s |
| 3 IPS | 88.9 | 2.74 | 32.5 | 215/225/235 | 2 | 0.8 | 0 | 37 | 5 | 6 | 2 | 4 min 11 s | 4 min 6 s |
| 3 IPS | 88.9 | 3.43 | 26 | 215/225/235 | 3 | 0.8 | 0 | 46 | 5 | 6 | 3 | 4 min 41 s | 5 min 8 s |
| 3 IPS | 88.9 | 4.24 | 21 | 215/225/235 | 3 | 0.9 | 0 | 57 | 5 | 6 | 3 | 5 min 17 s | 6 min 21 s |
| 3 IPS | 88.9 | 4.67 | 19 | 215/225/235 | 4 | 1 | 0 | 63 | 6 | 6 | 4 | 5 min 37 s | 7 min 1 s |
| 3 IPS | 88.9 | 5.05 | 17.6 | 215/225/235 | 4 | 1 | 0 | 68 | 6 | 6 | 4 | 5 min 53 s | 7 min 35 s |
| 3 IPS | 88.9 | 5.23 | 17 | 215/225/235 | 4 | 1 | 0 | 71 | 6 | 6 | 4 | 6 min 1 s | 7 min 51 s |
| 3 IPS | 88.9 | 5.74 | 15.5 | 215/225/235 | 4 | 1.1 | 0 | 77 | 6 | 6 | 4 | 6 min 23 s | 8 min 36 s |
| 3 IPS | 88.9 | 6.53 | 13.6 | 215/225/235 | 5 | 1.2 | 0 | 88 | 6 | 6 | 5 | 6 min 58 s | 9 min 48 s |
| 3 IPS | 88.9 | 6.58 | 13.5 | 215/225/235 | 5 | 1.2 | 0 | 89 | 6 | 6 | 5 | 7 min | 9 min 53 s |
| 3 IPS | 88.9 | 7.72 | 11.5 | 215/225/235 | 6 | 1.3 | 0 | 104 | 8 | 6 | 6 | 7 min 50 s | 11 min 36 s |
| 3 IPS | 88.9 | 8.08 | 11 | 215/225/235 | 6 | 1.3 | 0 | 109 | 8 | 6 | 6 | 8 min 5 s | 12 min 7 s |
| 3 IPS | 88.9 | 9.55 | 9.3 | 215/225/235 | 7 | 1.5 | 0 | 129 | 8 | 6 | 7 | 9 min 10 s | 14 min 20 s |
| 3 IPS | 88.9 | 9.88 | 9 | 215/225/235 | 7 | 1.5 | 0 | 133 | 8 | 6 | 7 | 9 min 24 s | 14 min 49 s |
| 3 IPS | 88.9 | 12.01 | 7.4 | 215/225/235 | 8 | 1.7 | 0 | 162 | 10 | 6 | 8 | 10 min 58 s | 18 min 1 s |
| 3 IPS | 88.9 | 12.17 | 7.3 | 215/225/235 | 8 | 1.7 | 0 | 164 | 10 | 6 | 8 | 11 min 5 s | 18 min 16 s |
| 3 IPS | 88.9 | 12.7 | 7 | 215/225/235 | 9 | 1.8 | 0 | 171 | 10 | 6 | 9 | 11 min 28 s | 19 min 3 s |
| 3 IPS | 88.9 | 14.81 | 6 | 215/225/235 | 10 | 2 | 0 | 200 | 10 | 6 | 10 | 13 min | 22 min 14 s |
| 4 IPS | 114.3 | 2.79 | 41 | 215/225/235 | 3 | 0.8 | 0 | 38 | 5 | 6 | 3 | 4 min 13 s | 4 min 11 s |
| 4 IPS | 114.3 | 3.45 | 33 | 215/225/235 | 3 | 0.8 | 0 | 47 | 5 | 6 | 3 | 4 min 43 s | 5 min 12 s |
| 4 IPS | 114.3 | 3.51 | 32.5 | 215/225/235 | 4 | 0.9 | 0 | 47 | 5 | 6 | 4 | 4 min 45 s | 5 min 17 s |
| 4 IPS | 114.3 | 4.39 | 26 | 215/225/235 | 4 | 0.9 | 0 | 59 | 5 | 6 | 4 | 5 min 24 s | 6 min 36 s |
| 4 IPS | 114.3 | 5.44 | 21 | 215/225/235 | 5 | 1 | 0 | 73 | 6 | 6 | 5 | 6 min 10 s | 8 min 10 s |
| 4 IPS | 114.3 | 6.02 | 19 | 215/225/235 | 6 | 1.1 | 0 | 81 | 6 | 6 | 6 | 6 min 35 s | 9 min 1 s |
| 4 IPS | 114.3 | 6.5 | 17.6 | 215/225/235 | 6 | 1.1 | 0 | 88 | 6 | 6 | 6 | 6 min 56 s | 9 min 44 s |
| 4 IPS | 114.3 | 6.73 | 17 | 215/225/235 | 7 | 1.2 | 0 | 91 | 6 | 6 | 7 | 7 min 6 s | 10 min 5 s |
| 4 IPS | 114.3 | 7.37 | 15.5 | 215/225/235 | 7 | 1.2 | 0 | 100 | 8 | 6 | 7 | 7 min 34 s | 11 min 4 s |
| 4 IPS | 114.3 | 8.41 | 13.6 | 215/225/235 | 8 | 1.3 | 0 | 113 | 8 | 6 | 8 | 8 min 19 s | 12 min 36 s |
| 4 IPS | 114.3 | 8.46 | 13.5 | 215/225/235 | 8 | 1.3 | 0 | 114 | 8 | 6 | 8 | 8 min 22 s | 12 min 42 s |
| 4 IPS | 114.3 | 9.93 | 11.5 | 215/225/235 | 9 | 1.5 | 0 | 134 | 8 | 6 | 9 | 9 min 26 s | 14 min 55 s |
| 4 IPS | 114.3 | 10.39 | 11 | 215/225/235 | 10 | 1.5 | 0 | 140 | 8 | 6 | 10 | 9 min 46 s | 15 min 35 s |
| 4 IPS | 114.3 | 12.29 | 9.3 | 215/225/235 | 11 | 1.7 | 0 | 166 | 10 | 6 | 11 | 11 min 9 s | 18 min 26 s |
| 4 IPS | 114.3 | 12.7 | 9 | 215/225/235 | 12 | 1.8 | 0 | 171 | 10 | 6 | 12 | 11 min 28 s | 19 min 3 s |
| 4 IPS | 114.3 | 15.44 | 7.4 | 215/225/235 | 14 | 2 | 0 | 209 | 10 | 6 | 14 | 13 min 28 s | 23 min 10 s |
| 4 IPS | 114.3 | 15.65 | 7.3 | 215/225/235 | 14 | 2.1 | 0 | 211 | 10 | 6 | 14 | 13 min 37 s | 23 min 29 s |
| 4 IPS | 114.3 | 16.33 | 7 | 215/225/235 | 14 | 2.1 | 0 | 220 | 10 | 6 | 14 | 14 min 7 s | 24 min 30 s |
| 4 IPS | 114.3 | 19.05 | 6 | 215/225/235 | 16 | 2.4 | 0 | 257 | 12 | 6 | 16 | 12 min 2 s | 28 min 35 s |
| 5 IPS | 141.3 | 3.45 | 41 | 215/225/235 | 4 | 0.8 | 0 | 47 | 5 | 7 | 4 | 4 min 43 s | 5 min 10 s |
| 5 IPS | 141.3 | 4.29 | 33 | 215/225/235 | 5 | 0.9 | 0 | 58 | 5 | 7 | 5 | 5 min 19 s | 6 min 25 s |
| 5 IPS | 141.3 | 4.34 | 32.5 | 215/225/235 | 5 | 0.9 | 0 | 59 | 5 | 7 | 5 | 5 min 22 s | 6 min 31 s |
| 5 IPS | 141.3 | 5.44 | 26 | 215/225/235 | 7 | 1 | 0 | 73 | 6 | 7 | 7 | 6 min 9 s | 8 min 9 s |
| 5 IPS | 141.3 | 6.73 | 21 | 215/225/235 | 8 | 1.2 | 0 | 91 | 6 | 7 | 8 | 7 min 6 s | 10 min 6 s |
| 5 IPS | 141.3 | 7.44 | 19 | 215/225/235 | 9 | 1.2 | 0 | 100 | 8 | 7 | 9 | 7 min 37 s | 11 min 9 s |
| 5 IPS | 141.3 | 8.03 | 17.6 | 215/225/235 | 10 | 1.3 | 0 | 108 | 8 | 7 | 10 | 8 min 3 s | 12 min 3 s |
| 5 IPS | 141.3 | 8.31 | 17 | 215/225/235 | 10 | 1.3 | 0 | 112 | 8 | 7 | 10 | 8 min 16 s | 12 min 28 s |
| 5 IPS | 141.3 | 9.12 | 15.5 | 215/225/235 | 11 | 1.4 | 0 | 123 | 8 | 7 | 11 | 8 min 51 s | 13 min 40 s |
| 5 IPS | 141.3 | 10.39 | 13.6 | 215/225/235 | 12 | 1.5 | 0 | 140 | 8 | 7 | 12 | 9 min 46 s | 15 min 35 s |
| 5 IPS | 141.3 | 10.46 | 13.5 | 215/225/235 | 12 | 1.5 | 0 | 141 | 8 | 7 | 12 | 9 min 50 s | 15 min 42 s |
| 5 IPS | 141.3 | 12.29 | 11.5 | 215/225/235 | 14 | 1.7 | 0 | 166 | 10 | 7 | 14 | 11 min 9 s | 18 min 26 s |
| 5 IPS | 141.3 | 12.85 | 11 | 215/225/235 | 15 | 1.8 | 0 | 173 | 10 | 7 | 15 | 11 min 34 s | 19 min 16 s |
| 5 IPS | 141.3 | 15.19 | 9.3 | 215/225/235 | 17 | 2 | 0 | 205 | 10 | 7 | 17 | 13 min 17 s | 22 min 47 s |
| 5 IPS | 141.3 | 15.7 | 9 | 215/225/235 | 18 | 2.1 | 0 | 212 | 10 | 7 | 18 | 13 min 39 s | 23 min 33 s |
| 5 IPS | 141.3 | 19.1 | 7.4 | 215/225/235 | 21 | 2.4 | 0 | 258 | 12 | 7 | 21 | 12 min 3 s | 28 min 39 s |

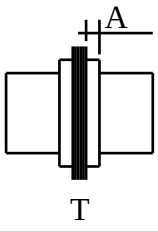
* Si ricorda di sommare a questo valore il valore della pressione di trascinamento pt precedentemente misurato.

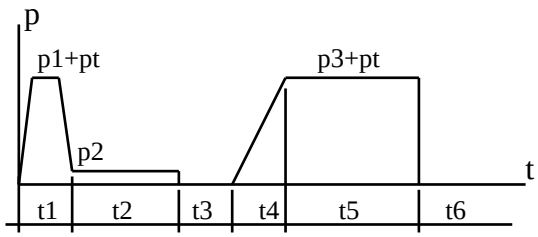
BASIC 250(V0,V1)
Sez. spinta = 5.89 cm2 (0.91 in2)
UNI10520(10/21) SINGLE LP
pi = 0.17MPa
PE 100

Temp. amb. = 5.0°C



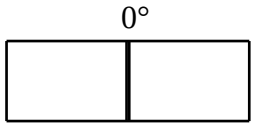

La macchina selezionata è in grado di saldare solo tubi che prevedono pressioni (p1+pt) entro il valore di pressione massima indicato dai dati tecnici del prodotto (vedere manuale d'uso).

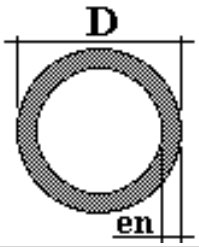
| Diametro | D | en | SDR | T min/nom/max | *p1 | A | p2 | t2 | t3max | t4 | *p3 | t5 | t6 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| IPS | mm | mm | =D/en | °C | bar | mm | bar | s | s | s | bar | | |
| 5 IPS | 141.3 | 19.35 | 7.3 | 215/225/235 | 21 | 2.4 | 0 | 261 | 12 | 7 | 21 | 12 min 3 s | 29 min 2 s |
| 5 IPS | 141.3 | 20.19 | 7 | 215/225/235 | 22 | 2.5 | 0 | 273 | 12 | 7 | 22 | 12 min 8 s | 30 min 17 s |
| 5 IPS | 141.3 | 23.55 | 6 | 215/225/235 | 25 | 2.9 | 0 | 318 | 12 | 7 | 25 | 12 min 36 s | 35 min 20 s |
| 6 IPS | 168.28 | 4.11 | 41 | 215/225/235 | 6 | 0.9 | 0 | 55 | 5 | 8 | 6 | 5 min 11 s | 6 min 9 s |
| 6 IPS | 168.28 | 5.11 | 33 | 215/225/235 | 8 | 1 | 0 | 69 | 6 | 8 | 8 | 5 min 55 s | 7 min 39 s |
| 6 IPS | 168.28 | 5.18 | 32.5 | 215/225/235 | 8 | 1 | 0 | 70 | 6 | 8 | 8 | 5 min 58 s | 7 min 46 s |
| 6 IPS | 168.28 | 6.48 | 26 | 215/225/235 | 9 | 1.1 | 0 | 87 | 6 | 8 | 9 | 6 min 55 s | 9 min 43 s |
| 6 IPS | 168.28 | 8 | 21 | 215/225/235 | 12 | 1.3 | 0 | 108 | 8 | 8 | 12 | 8 min 3 s | 12 min 1 s |
| 6 IPS | 168.28 | 8.86 | 19 | 215/225/235 | 13 | 1.4 | 0 | 120 | 8 | 8 | 13 | 8 min 39 s | 13 min 17 s |
| 6 IPS | 168.28 | 9.55 | 17.6 | 215/225/235 | 14 | 1.5 | 0 | 129 | 8 | 8 | 14 | 9 min 10 s | 14 min 21 s |
| 6 IPS | 168.28 | 9.91 | 17 | 215/225/235 | 14 | 1.5 | 0 | 134 | 8 | 8 | 14 | 9 min 25 s | 14 min 51 s |
| 6 IPS | 168.28 | 10.85 | 15.5 | 215/225/235 | 15 | 1.6 | 0 | 147 | 8 | 8 | 15 | 10 min 7 s | 16 min 17 s |
| 6 IPS | 168.28 | 12.37 | 13.6 | 215/225/235 | 17 | 1.7 | 0 | 167 | 10 | 8 | 17 | 11 min 13 s | 18 min 34 s |
| 6 IPS | 168.28 | 12.47 | 13.5 | 215/225/235 | 18 | 1.7 | 0 | 168 | 10 | 8 | 18 | 11 min 17 s | 18 min 42 s |
| 6 IPS | 168.28 | 14.63 | 11.5 | 215/225/235 | 20 | 2 | 0 | 198 | 10 | 8 | 20 | 12 min 52 s | 21 min 57 s |
| 6 IPS | 168.28 | 15.29 | 11 | 215/225/235 | 21 | 2 | 0 | 207 | 10 | 8 | 21 | 13 min 22 s | 22 min 57 s |
| 6 IPS | 168.28 | 18.08 | 9.3 | 215/225/235 | 25 | 2.3 | 0 | 244 | 10 | 8 | 25 | 11 min 58 s | 27 min 9 s |
| 6 IPS | 168.28 | 18.69 | 9 | 215/225/235 | 25 | 2.4 | 0 | 252 | 10 | 8 | 25 | 12 min 1 s | 28 min 3 s |
| 6 IPS | 168.28 | 22.73 | 7.4 | 215/225/235 | 30 | 2.8 | 0 | 307 | 12 | 8 | 30 | 12 min 28 s | 34 min 7 s |
| 6 IPS | 168.28 | 23.06 | 7.3 | 215/225/235 | 30 | 2.8 | 0 | 311 | 12 | 8 | 30 | 12 min 30 s | 34 min 35 s |
| 6 IPS | 168.28 | 24.03 | 7 | 215/225/235 | 31 | 2.9 | 0 | 325 | 12 | 8 | 31 | 12 min 41 s | 36 min 4 s |
| 6 IPS | 168.28 | 28.04 | 6 | 215/225/235 | 36 | 3.3 | 0 | 379 | 16 | 8 | 36 | 13 min 35 s | 42 min 4 s |
| 7 IPS | 180.98 | 4.42 | 41 | 215/225/235 | 7 | 0.9 | 0 | 60 | 5 | 8 | 7 | 5 min 25 s | 6 min 37 s |
| 7 IPS | 180.98 | 5.49 | 33 | 215/225/235 | 9 | 1 | 0 | 74 | 6 | 8 | 9 | 6 min 12 s | 8 min 14 s |
| 7 IPS | 180.98 | 5.56 | 32.5 | 215/225/235 | 9 | 1.1 | 0 | 75 | 6 | 8 | 9 | 6 min 15 s | 8 min 21 s |
| 7 IPS | 180.98 | 6.96 | 26 | 215/225/235 | 11 | 1.2 | 0 | 94 | 6 | 8 | 11 | 7 min 17 s | 10 min 26 s |
| 7 IPS | 180.98 | 8.61 | 21 | 215/225/235 | 13 | 1.4 | 0 | 116 | 8 | 8 | 13 | 8 min 29 s | 12 min 56 s |
| 7 IPS | 180.98 | 9.52 | 19 | 215/225/235 | 15 | 1.5 | 0 | 129 | 8 | 8 | 15 | 9 min 9 s | 14 min 17 s |
| 7 IPS | 180.98 | 10.29 | 17.6 | 215/225/235 | 16 | 1.5 | 0 | 139 | 8 | 8 | 16 | 9 min 42 s | 15 min 25 s |
| 7 IPS | 180.98 | 10.64 | 17 | 215/225/235 | 16 | 1.6 | 0 | 144 | 8 | 8 | 16 | 9 min 58 s | 15 min 58 s |
| 7 IPS | 180.98 | 11.68 | 15.5 | 215/225/235 | 18 | 1.7 | 0 | 158 | 8 | 8 | 18 | 10 min 43 s | 17 min 31 s |
| 7 IPS | 180.98 | 13.31 | 13.6 | 215/225/235 | 20 | 1.8 | 0 | 180 | 10 | 8 | 20 | 11 min 54 s | 19 min 58 s |
| 7 IPS | 180.98 | 13.41 | 13.5 | 215/225/235 | 20 | 1.8 | 0 | 181 | 10 | 8 | 20 | 11 min 58 s | 20 min 7 s |
| 7 IPS | 180.98 | 15.75 | 11.5 | 215/225/235 | 24 | 2.1 | 0 | 212 | 10 | 8 | 24 | 13 min 41 s | 23 min 36 s |
| 7 IPS | 180.98 | 16.46 | 11 | 215/225/235 | 25 | 2.1 | 0 | 222 | 10 | 8 | 25 | 14 min 12 s | 24 min 41 s |
| 7 IPS | 180.98 | 19.46 | 9.3 | 215/225/235 | 28 | 2.4 | 0 | 263 | 12 | 8 | 28 | 12 min 4 s | 29 min 11 s |
| 7 IPS | 180.98 | 20.12 | 9 | 215/225/235 | 29 | 2.5 | 0 | 271 | 12 | 8 | 29 | 12 min 8 s | 30 min 10 s |
| 7 IPS | 180.98 | 24.46 | 7.4 | 215/225/235 | 35 | 2.9 | 0 | 330 | 12 | 8 | 35 | 12 min 46 s | 36 min 41 s |
| 7 IPS | 180.98 | 24.79 | 7.3 | 215/225/235 | 35 | 3 | 0 | 335 | 12 | 8 | 35 | 12 min 49 s | 37 min 11 s |
| 7 IPS | 180.98 | 25.86 | 7 | 215/225/235 | 36 | 3.1 | 0 | 349 | 12 | 8 | 36 | 13 min 3 s | 38 min 47 s |
| 7 IPS | 180.98 | 30.18 | 6 | 215/225/235 | 41 | 3.5 | 0 | 407 | 16 | 8 | 41 | 14 min 13 s | 45 min 15 s |
| 8 IPS | 219.08 | 5.33 | 41 | 215/225/235 | 10 | 1 | 0 | 72 | 6 | 10 | 10 | 6 min 6 s | 8 min 1 s |
| 8 IPS | 219.08 | 6.63 | 33 | 215/225/235 | 13 | 1.2 | 0 | 90 | 6 | 10 | 13 | 7 min 2 s | 9 min 57 s |
| 8 IPS | 219.08 | 6.73 | 32.5 | 215/225/235 | 13 | 1.2 | 0 | 91 | 6 | 10 | 13 | 7 min 6 s | 10 min 7 s |
| 8 IPS | 219.08 | 8.43 | 26 | 215/225/235 | 16 | 1.3 | 0 | 114 | 8 | 10 | 16 | 8 min 21 s | 12 min 38 s |
| 8 IPS | 219.08 | 10.44 | 21 | 215/225/235 | 20 | 1.5 | 0 | 141 | 8 | 10 | 20 | 9 min 48 s | 15 min 39 s |
| 8 IPS | 219.08 | 11.53 | 19 | 215/225/235 | 22 | 1.7 | 0 | 156 | 8 | 10 | 22 | 10 min 37 s | 17 min 18 s |
| 8 IPS | 219.08 | 12.45 | 17.6 | 215/225/235 | 23 | 1.7 | 0 | 168 | 10 | 10 | 23 | 11 min 17 s | 18 min 40 s |
| 8 IPS | 219.08 | 12.88 | 17 | 215/225/235 | 24 | 1.8 | 0 | 174 | 10 | 10 | 24 | 11 min 36 s | 19 min 20 s |
| 8 IPS | 219.08 | 14.12 | 15.5 | 215/225/235 | 26 | 1.9 | 0 | 191 | 10 | 10 | 26 | 12 min 30 s | 21 min 12 s |
| 8 IPS | 219.08 | 16.1 | 13.6 | 215/225/235 | 30 | 2.1 | 0 | 217 | 10 | 10 | 30 | 13 min 57 s | 24 min 10 s |
| 8 IPS | 219.08 | 16.23 | 13.5 | 215/225/235 | 30 | 2.1 | 0 | 219 | 10 | 10 | 30 | 14 min 2 s | 24 min 21 s |
| 8 IPS | 219.08 | 19.05 | 11.5 | 215/225/235 | 35 | 2.4 | 0 | 257 | 12 | 10 | 35 | 12 min 2 s | 28 min 35 s |
| 8 IPS | 219.08 | 19.91 | 11 | 215/225/235 | 36 | 2.5 | 0 | 269 | 12 | 10 | 36 | 12 min 6 s | 29 min 52 s |

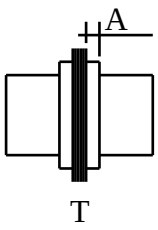
* Si ricorda di sommare a questo valore il valore della pressione di trascinamento pt precedentemente misurato.

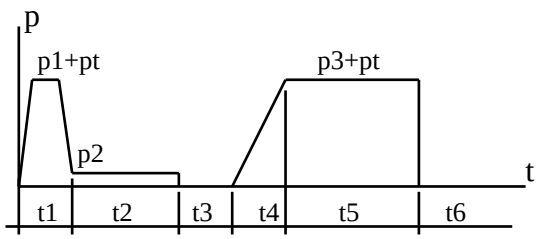
BASIC 250(V0,V1)
Sez. spinta = 5.89 cm2 (0.91 in2)
UNI10520(10/21) SINGLE LP
pi = 0.17MPa
PE 100

Temp. amb. = 5.0°C



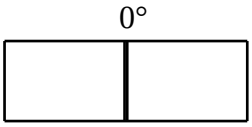

La macchina selezionata è in grado di saldare solo tubi che prevedono pressioni (p1+pt) entro il valore di pressione massima indicato dai dati tecnici del prodotto (vedere manuale d'uso).

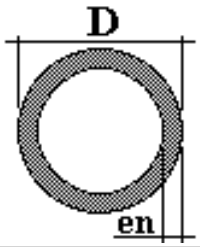
| Diametro | D | en | SDR | T min/nom/max | *p1 | A | p2 | t2 | t3max | t4 | *p3 | t5 | t6 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| IPS | mm | mm | =D/en | °C | bar | mm | bar | s | s | s | bar | | |
| 8 IPS | 219.08 | 23.55 | 9.3 | 215/225/235 | 42 | 2.9 | 0 | 318 | 12 | 10 | 42 | 12 min 36 s | 35 min 20 s |
| 8 IPS | 219.08 | 24.33 | 9 | 215/225/235 | 43 | 2.9 | 0 | 329 | 12 | 10 | 43 | 12 min 44 s | 36 min 31 s |
| 8 IPS | 219.08 | 29.62 | 7.4 | 215/225/235 | 51 | 3.5 | 0 | 400 | 16 | 10 | 51 | 14 min 2 s | 44 min 24 s |
| 8 IPS | 219.08 | 30.02 | 7.3 | 215/225/235 | 51 | 3.5 | 0 | 405 | 16 | 10 | 51 | 14 min 10 s | 45 min 1 s |
| 8 IPS | 219.08 | 31.29 | 7 | 215/225/235 | 53 | 3.6 | 0 | 423 | 16 | 10 | 53 | 14 min 35 s | 46 min 57 s |
| 8 IPS | 219.08 | 36.53 | 6 | 215/225/235 | 60 | 4.2 | 0 | 493 | 16 | 10 | 60 | 16 min 40 s | 54 min 46 s |

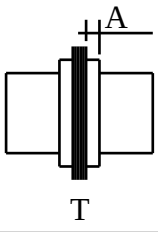
* Si ricorda di sommare a questo valore il valore della pressione di trascinamento pt precedentemente misurato.

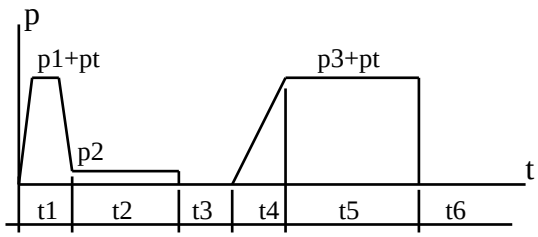
BASIC 250(V0,V1)
Sez. spinta = 5.89 cm2 (0.91 in2)
UNI10520(10/21) SINGLE LP
pi = 0.17MPa
PE 100

Temp. amb. = 5.0°C



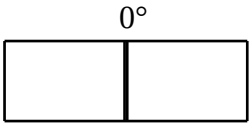

La macchina selezionata è in grado di saldare solo tubi che prevedono pressioni (p1+pt) entro il valore di pressione massima indicato dai dati tecnici del prodotto (vedere manuale d'uso).

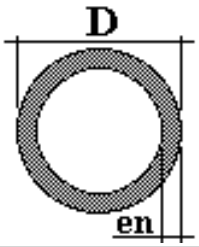
| Diametro | D | en | SDR | T min/nom/max | *p1 | A | p2 | t2 | t3max | t4 | *p3 | t5 | t6 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| DIPS | mm | mm | =D/en | °C | bar | mm | bar | s | s | s | bar | | |
| 3 DIPS | 100.58 | 2.46 | 41 | 215/225/235 | 2 | 0.7 | 0 | 33 | 5 | 6 | 2 | 3 min 59 s | 3 min 41 s |
| 3 DIPS | 100.58 | 3.05 | 33 | 215/225/235 | 3 | 0.8 | 0 | 41 | 5 | 6 | 3 | 4 min 25 s | 4 min 34 s |
| 3 DIPS | 100.58 | 3.1 | 32.5 | 215/225/235 | 3 | 0.8 | 0 | 42 | 5 | 6 | 3 | 4 min 27 s | 4 min 39 s |
| 3 DIPS | 100.58 | 3.86 | 26 | 215/225/235 | 3 | 0.9 | 0 | 52 | 5 | 6 | 3 | 5 min 1 s | 5 min 48 s |
| 3 DIPS | 100.58 | 4.8 | 21 | 215/225/235 | 4 | 1 | 0 | 65 | 6 | 6 | 4 | 5 min 41 s | 7 min 11 s |
| 3 DIPS | 100.58 | 5.28 | 19 | 215/225/235 | 5 | 1 | 0 | 71 | 6 | 6 | 5 | 6 min 4 s | 7 min 56 s |
| 3 DIPS | 100.58 | 5.72 | 17.6 | 215/225/235 | 5 | 1.1 | 0 | 77 | 6 | 6 | 5 | 6 min 22 s | 8 min 34 s |
| 3 DIPS | 100.58 | 5.92 | 17 | 215/225/235 | 5 | 1.1 | 0 | 80 | 6 | 6 | 5 | 6 min 31 s | 8 min 52 s |
| 3 DIPS | 100.58 | 6.48 | 15.5 | 215/225/235 | 6 | 1.1 | 0 | 88 | 6 | 6 | 6 | 6 min 55 s | 9 min 44 s |
| 3 DIPS | 100.58 | 7.39 | 13.6 | 215/225/235 | 6 | 1.2 | 0 | 100 | 8 | 6 | 6 | 7 min 36 s | 11 min 6 s |
| 3 DIPS | 100.58 | 7.44 | 13.5 | 215/225/235 | 6 | 1.2 | 0 | 101 | 8 | 6 | 6 | 7 min 38 s | 11 min 11 s |
| 3 DIPS | 100.58 | 8.74 | 11.5 | 215/225/235 | 7 | 1.4 | 0 | 118 | 8 | 6 | 7 | 8 min 35 s | 13 min 7 s |
| 3 DIPS | 100.58 | 9.14 | 11 | 215/225/235 | 8 | 1.4 | 0 | 123 | 8 | 6 | 8 | 8 min 52 s | 13 min 43 s |
| 3 DIPS | 100.58 | 10.82 | 9.3 | 215/225/235 | 9 | 1.6 | 0 | 146 | 8 | 6 | 9 | 10 min 5 s | 16 min 13 s |
| 3 DIPS | 100.58 | 11.18 | 9 | 215/225/235 | 9 | 1.6 | 0 | 151 | 8 | 6 | 9 | 10 min 21 s | 16 min 46 s |
| 3 DIPS | 100.58 | 13.59 | 7.4 | 215/225/235 | 11 | 1.9 | 0 | 183 | 10 | 6 | 11 | 12 min 7 s | 20 min 23 s |
| 3 DIPS | 100.58 | 13.77 | 7.3 | 215/225/235 | 11 | 1.9 | 0 | 186 | 10 | 6 | 11 | 12 min 15 s | 20 min 40 s |
| 3 DIPS | 100.58 | 14.38 | 7 | 215/225/235 | 11 | 1.9 | 0 | 194 | 10 | 6 | 11 | 12 min 41 s | 21 min 33 s |
| 3 DIPS | 100.58 | 16.76 | 6 | 215/225/235 | 13 | 2.2 | 0 | 226 | 10 | 6 | 13 | 14 min 26 s | 25 min 9 s |
| 4 DIPS | 121.92 | 2.97 | 41 | 215/225/235 | 3 | 0.8 | 0 | 40 | 5 | 7 | 3 | 4 min 21 s | 4 min 28 s |
| 4 DIPS | 121.92 | 3.68 | 33 | 215/225/235 | 4 | 0.9 | 0 | 50 | 5 | 7 | 4 | 4 min 53 s | 5 min 33 s |
| 4 DIPS | 121.92 | 3.76 | 32.5 | 215/225/235 | 4 | 0.9 | 0 | 51 | 5 | 7 | 4 | 4 min 56 s | 5 min 38 s |
| 4 DIPS | 121.92 | 4.7 | 26 | 215/225/235 | 5 | 1 | 0 | 63 | 6 | 7 | 5 | 5 min 37 s | 7 min 2 s |
| 4 DIPS | 121.92 | 5.82 | 21 | 215/225/235 | 6 | 1.1 | 0 | 78 | 6 | 7 | 6 | 6 min 25 s | 8 min 43 s |
| 4 DIPS | 121.92 | 6.43 | 19 | 215/225/235 | 7 | 1.1 | 0 | 87 | 6 | 7 | 7 | 6 min 52 s | 9 min 38 s |
| 4 DIPS | 121.92 | 6.93 | 17.6 | 215/225/235 | 7 | 1.2 | 0 | 94 | 6 | 7 | 7 | 7 min 15 s | 10 min 23 s |
| 4 DIPS | 121.92 | 7.16 | 17 | 215/225/235 | 7 | 1.2 | 0 | 97 | 8 | 7 | 7 | 7 min 25 s | 10 min 45 s |
| 4 DIPS | 121.92 | 7.87 | 15.5 | 215/225/235 | 8 | 1.3 | 0 | 106 | 8 | 7 | 8 | 7 min 56 s | 11 min 48 s |
| 4 DIPS | 121.92 | 8.97 | 13.6 | 215/225/235 | 9 | 1.4 | 0 | 121 | 8 | 7 | 9 | 8 min 44 s | 13 min 27 s |
| 4 DIPS | 121.92 | 9.04 | 13.5 | 215/225/235 | 9 | 1.4 | 0 | 122 | 8 | 7 | 9 | 8 min 47 s | 13 min 33 s |
| 4 DIPS | 121.92 | 10.59 | 11.5 | 215/225/235 | 11 | 1.6 | 0 | 143 | 8 | 7 | 11 | 9 min 56 s | 15 min 54 s |
| 4 DIPS | 121.92 | 11.07 | 11 | 215/225/235 | 11 | 1.6 | 0 | 150 | 8 | 7 | 11 | 10 min 17 s | 16 min 38 s |
| 4 DIPS | 121.92 | 13.11 | 9.3 | 215/225/235 | 13 | 1.8 | 0 | 177 | 10 | 7 | 13 | 11 min 46 s | 19 min 40 s |
| 4 DIPS | 121.92 | 13.54 | 9 | 215/225/235 | 13 | 1.9 | 0 | 183 | 10 | 7 | 13 | 12 min 5 s | 20 min 19 s |
| 4 DIPS | 121.92 | 16.48 | 7.4 | 215/225/235 | 16 | 2.1 | 0 | 222 | 10 | 7 | 16 | 14 min 13 s | 24 min 43 s |
| 4 DIPS | 121.92 | 16.71 | 7.3 | 215/225/235 | 16 | 2.2 | 0 | 225 | 10 | 7 | 16 | 14 min 23 s | 25 min 3 s |
| 4 DIPS | 121.92 | 17.42 | 7 | 215/225/235 | 16 | 2.2 | 0 | 235 | 10 | 7 | 16 | 14 min 54 s | 26 min 8 s |
| 4 DIPS | 121.92 | 20.32 | 6 | 215/225/235 | 19 | 2.5 | 0 | 274 | 12 | 7 | 19 | 12 min 9 s | 30 min 29 s |
| 6 DIPS | 175.26 | 4.27 | 41 | 215/225/235 | 7 | 0.9 | 0 | 58 | 5 | 8 | 7 | 5 min 18 s | 6 min 25 s |
| 6 DIPS | 175.26 | 5.31 | 33 | 215/225/235 | 8 | 1 | 0 | 72 | 6 | 8 | 8 | 6 min 4 s | 7 min 58 s |
| 6 DIPS | 175.26 | 5.38 | 32.5 | 215/225/235 | 8 | 1 | 0 | 73 | 6 | 8 | 8 | 6 min 8 s | 8 min 5 s |
| 6 DIPS | 175.26 | 6.73 | 26 | 215/225/235 | 10 | 1.2 | 0 | 91 | 6 | 8 | 10 | 7 min 6 s | 10 min 7 s |
| 6 DIPS | 175.26 | 8.36 | 21 | 215/225/235 | 13 | 1.3 | 0 | 113 | 8 | 8 | 13 | 8 min 17 s | 12 min 31 s |
| 6 DIPS | 175.26 | 9.22 | 19 | 215/225/235 | 14 | 1.4 | 0 | 125 | 8 | 8 | 14 | 8 min 55 s | 13 min 50 s |
| 6 DIPS | 175.26 | 9.96 | 17.6 | 215/225/235 | 15 | 1.5 | 0 | 134 | 8 | 8 | 15 | 9 min 27 s | 14 min 56 s |
| 6 DIPS | 175.26 | 10.31 | 17 | 215/225/235 | 15 | 1.5 | 0 | 139 | 8 | 8 | 15 | 9 min 43 s | 15 min 28 s |
| 6 DIPS | 175.26 | 11.3 | 15.5 | 215/225/235 | 17 | 1.6 | 0 | 153 | 8 | 8 | 17 | 10 min 26 s | 16 min 58 s |
| 6 DIPS | 175.26 | 12.88 | 13.6 | 215/225/235 | 19 | 1.8 | 0 | 174 | 10 | 8 | 19 | 11 min 36 s | 19 min 20 s |
| 6 DIPS | 175.26 | 12.98 | 13.5 | 215/225/235 | 19 | 1.8 | 0 | 175 | 10 | 8 | 19 | 11 min 40 s | 19 min 28 s |
| 6 DIPS | 175.26 | 15.24 | 11.5 | 215/225/235 | 22 | 2 | 0 | 206 | 10 | 8 | 22 | 13 min 19 s | 22 min 52 s |
| 6 DIPS | 175.26 | 15.93 | 11 | 215/225/235 | 23 | 2.1 | 0 | 215 | 10 | 8 | 23 | 13 min 49 s | 23 min 54 s |
| 6 DIPS | 175.26 | 18.85 | 9.3 | 215/225/235 | 27 | 2.4 | 0 | 254 | 10 | 8 | 27 | 12 min 1 s | 28 min 16 s |
| 6 DIPS | 175.26 | 19.48 | 9 | 215/225/235 | 27 | 2.4 | 0 | 263 | 12 | 8 | 27 | 12 min 4 s | 29 min 13 s |
| 6 DIPS | 175.26 | 23.67 | 7.4 | 215/225/235 | 33 | 2.9 | 0 | 320 | 12 | 8 | 33 | 12 min 37 s | 35 min 32 s |

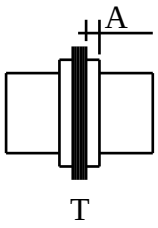
* Si ricorda di sommare a questo valore il valore della pressione di trascinamento pt precedentemente misurato.

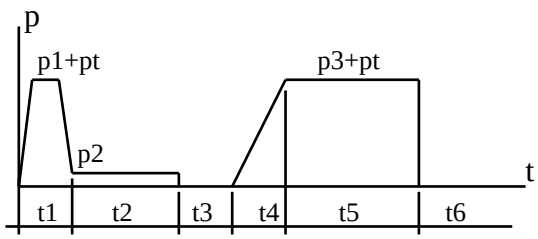
BASIC 250(V0,V1)
Sez. spinta = 5.89 cm2 (0.91 in2)
UNI10520(10/21) SINGLE LP
pi = 0.17MPa
PE 100

Temp. amb. = 5.0°C




La macchina selezionata è in grado di saldare solo tubi che prevedono pressioni (p1+pt) entro il valore di pressione massima indicato dai dati tecnici del prodotto (vedere manuale d'uso).

| Diametro | D | en | SDR | T min/nom/max | *p1 | A | p2 | t2 | t3max | t4 | *p3 | t5 | t6 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| DIPS | mm | mm | =D/en | °C | bar | mm | bar | s | s | s | bar | | |
| 6 DIPS | 175.26 | 24 | 7.3 | 215/225/235 | 33 | 2.9 | 0 | 324 | 12 | 8 | 33 | 12 min 41 s | 36 min 1 s |
| 6 DIPS | 175.26 | 25.04 | 7 | 215/225/235 | 34 | 3 | 0 | 338 | 12 | 8 | 34 | 12 min 52 s | 37 min 33 s |
| 6 DIPS | 175.26 | 29.21 | 6 | 215/225/235 | 39 | 3.4 | 0 | 394 | 16 | 8 | 39 | 13 min 55 s | 43 min 49 s |
| 8 DIPS | 229.87 | 5.61 | 41 | 215/225/235 | 11 | 1.1 | 0 | 76 | 6 | 10 | 11 | 6 min 17 s | 8 min 25 s |
| 8 DIPS | 229.87 | 6.96 | 33 | 215/225/235 | 14 | 1.2 | 0 | 94 | 6 | 10 | 14 | 7 min 17 s | 10 min 27 s |
| 8 DIPS | 229.87 | 7.06 | 32.5 | 215/225/235 | 14 | 1.2 | 0 | 95 | 8 | 10 | 14 | 7 min 21 s | 10 min 37 s |
| 8 DIPS | 229.87 | 8.84 | 26 | 215/225/235 | 18 | 1.4 | 0 | 119 | 8 | 10 | 18 | 8 min 38 s | 13 min 16 s |
| 8 DIPS | 229.87 | 10.95 | 21 | 215/225/235 | 22 | 1.6 | 0 | 148 | 8 | 10 | 22 | 10 min 11 s | 16 min 25 s |
| 8 DIPS | 229.87 | 12.09 | 19 | 215/225/235 | 24 | 1.7 | 0 | 163 | 10 | 10 | 24 | 11 min 1 s | 18 min 9 s |
| 8 DIPS | 229.87 | 13.06 | 17.6 | 215/225/235 | 26 | 1.8 | 0 | 176 | 10 | 10 | 26 | 11 min 44 s | 19 min 35 s |
| 8 DIPS | 229.87 | 13.51 | 17 | 215/225/235 | 27 | 1.9 | 0 | 183 | 10 | 10 | 27 | 12 min 3 s | 20 min 17 s |
| 8 DIPS | 229.87 | 14.83 | 15.5 | 215/225/235 | 29 | 2 | 0 | 200 | 10 | 10 | 29 | 13 min 1 s | 22 min 15 s |
| 8 DIPS | 229.87 | 16.89 | 13.6 | 215/225/235 | 33 | 2.2 | 0 | 228 | 10 | 10 | 33 | 14 min 32 s | 25 min 21 s |
| 8 DIPS | 229.87 | 17.02 | 13.5 | 215/225/235 | 33 | 2.2 | 0 | 230 | 10 | 10 | 33 | 14 min 37 s | 25 min 32 s |
| 8 DIPS | 229.87 | 19.99 | 11.5 | 215/225/235 | 38 | 2.5 | 0 | 270 | 12 | 10 | 38 | 12 min 7 s | 29 min 59 s |
| 8 DIPS | 229.87 | 20.9 | 11 | 215/225/235 | 40 | 2.6 | 0 | 282 | 12 | 10 | 40 | 12 min 13 s | 31 min 21 s |
| 8 DIPS | 229.87 | 24.71 | 9.3 | 215/225/235 | 46 | 3 | 0 | 334 | 12 | 10 | 46 | 12 min 49 s | 37 min 5 s |
| 8 DIPS | 229.87 | 25.55 | 9 | 215/225/235 | 47 | 3.1 | 0 | 345 | 12 | 10 | 47 | 12 min 59 s | 38 min 19 s |
| 8 DIPS | 229.87 | 31.06 | 7.4 | 215/225/235 | 56 | 3.6 | 0 | 419 | 16 | 10 | 56 | 14 min 30 s | 46 min 36 s |
| 8 DIPS | 229.87 | 31.5 | 7.3 | 215/225/235 | 57 | 3.6 | 0 | 425 | 16 | 10 | 57 | 14 min 39 s | 47 min 14 s |
| 8 DIPS | 229.87 | 32.84 | 7 | 215/225/235 | 59 | 3.8 | 0 | 443 | 16 | 10 | 59 | 15 min 8 s | 49 min 15 s |
| 8 DIPS | 229.87 | 38.3 | 6 | 215/225/235 | 67 | 4.3 | 0 | 517 | 20 | 10 | 67 | 17 min 32 s | 57 min 28 s |

* Si ricorda di sommare a questo valore il valore della pressione di trascinamento pt precedentemente misurato.