

Acrobat 315 Welding Parameters

CURRENT AS OF
09/07/2023

Product Line & Material	Pipe Size	Initial Melt Pressure (psi)	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure	Cooling Time
Air-Pro® (PE)	8" (200mm) SDR11	242	2 mm	Almost Zero	182 seconds	10 seconds	242	17.3 min
Air-Pro® (PE)	10" (250mm) SDR11	377	2.5 mm	Almost Zero	227 seconds	11 seconds	377	21.2 min
Air-Pro® (PE)	12" (315mm) SDR11	593	3 mm	Almost Zero	286 seconds	13 seconds	593	26.4 min
Asahitec™ Solid Wall (PP-RCT)	8" (200mm) SDR11	162	1 mm	Almost Zero	198 seconds	9 seconds	162	17.3 min
Asahitec™ Solid Wall (PP-RCT)	10" (250mm) SDR11	251	1.5 mm	Almost Zero	240 seconds	10 seconds	251	21.2 min
Asahitec™ Solid Wall (PP-RCT)	12" (315mm) SDR11	395	2 mm	Almost Zero	293 seconds	12 seconds	395	26.4 min
Chem Proline® (PE)	8" (200mm) SDR11	242	2 mm	Almost Zero	182 seconds	10 seconds	242	17.3 min
Chem Proline® (PE)	10" (250mm) SDR11	377	2.5 mm	Almost Zero	227 seconds	11 seconds	377	21.2 min
Chem Proline® (PE)	12" (315mm) SDR11	593	3 mm	Almost Zero	286 seconds	13 seconds	593	26.4 min
Climatec™ (PP-RCT)	8" (200mm) SDR17	108	1 mm	Almost Zero	134 seconds	7 seconds	108	11.9 min
Climatec™ (PP-RCT)	10" (250mm) SDR17	171	1 mm	Almost Zero	163 seconds	8 seconds	171	14.4 min
Climatec™ (PP-RCT)	12" (315mm) SDR17	269	1 mm	Almost Zero	203 seconds	9 seconds	269	17.8 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

Acrobat 315 Welding Parameters

CURRENT AS OF
09/07/2023

Product Line & Material	Pipe Size	Initial Melt Pressure (psi)	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure	Cooling Time
Proline® PRO150 (PP)	8" (200mm) SDR11	162	1 mm	Almost Zero	198 seconds	9 seconds	162	17.3 min
Proline® PRO150 (PP)	9" (225mm) SDR11	207	1.5 mm	Almost Zero	220 seconds	9 seconds	207	19.3 min
Proline® PRO150 (PP)	10" (250mm) SDR11	251	1.5 mm	Almost Zero	240 seconds	10 seconds	251	21.2 min
Proline® PRO150 (PP)	11" (280mm) SDR11	314	1.5 mm	Almost Zero	265 seconds	11 seconds	314	23.5 min
Proline® PRO150 (PP)	12" (315mm) SDR11	395	2 mm	Almost Zero	293 seconds	12 seconds	395	26.4 min
Proline® PRO90 (PP)	8" (200mm) SDR17.6	108	1 mm	Almost Zero	129 seconds	7 seconds	108	11.3 min
Proline® PRO90 (PP)	9" (225mm) SDR17.6	135	1 mm	Almost Zero	143 seconds	7 seconds	135	12.4 min
Proline® PRO90 (PP)	10" (250mm) SDR17.6	162	1 mm	Almost Zero	157 seconds	8 seconds	162	17.0 min
Proline® PRO90 (PP)	11" (280mm) SDR17.6	207	1 mm	Almost Zero	175 seconds	8 seconds	207	17.0 min
Proline® PRO90 (PP)	12" (315mm) SDR17.6	260	1 mm	Almost Zero	195 seconds	9 seconds	260	17.0 min
Proline® PRO45 (PP)	8" (200mm) SDR33	63	0.5 mm	Almost Zero	72 seconds	6 seconds	63	6.7 min
Proline® PRO45 (PP)	9" (225mm) SDR33	81	0.5 mm	Almost Zero	80 seconds	6 seconds	81	7.4 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

Acrobat 315 Welding Parameters

CURRENT AS OF
09/07/2023

Product Line & Material	Pipe Size	Initial Melt Pressure (psi)	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure	Cooling Time
Proline® PRO45 (PP)	10" (250mm) SDR33	90	1 mm	Almost Zero	89 seconds	6 seconds	90	8.1 min
Proline® PRO45 (PP)	11" (280mm) SDR33	117	1 mm	Almost Zero	98 seconds	6 seconds	117	8.9 min
Proline® PRO45 (PP)	12" (315mm) SDR33	144	1 mm	Almost Zero	110 seconds	7 seconds	144	9.9 min
Super Proline® (PVDF)	8" (200mm) SDR21	90	1 mm	Almost Zero	136 seconds	4 seconds	90	13.5 min
Super Proline® (PVDF)	10" (250mm) SDR21	144	1.1 mm	Almost Zero	159 seconds	4 seconds	144	16.5 min
Super Proline® (PVDF)	8" (200mm) SDR33	63	0.6 mm	Almost Zero	102 seconds	4 seconds	63	9.5 min
Super Proline® (PVDF)	10" (250mm) SDR33	90	0.7 mm	Almost Zero	117 seconds	4 seconds	90	11.0 min
Super Proline® (PVDF)	12" (315mm) SDR33	144	1 mm	Almost Zero	137 seconds	4 seconds	144	13.5 min
Fluidlok (IPS) (PE)	4" X 8" SDR11X17	189	mm	Almost Zero	86 seconds	5 seconds	189	12.0 min
Fluidlok (IPS) (PE)	6" X 10" SDR11X17	314	mm	Almost Zero	105 seconds	6 seconds	314	14.0 min
Duo-Pro® PRO150X150 (PP)	4" X 8" (110mm X 200mm) SDR11X11	216	1 mm	Almost Zero	198 seconds	9 seconds	216	17.3 min
Duo-Pro® PRO150X150 (PP)	6" X 10" (160mm X 250mm) SDR11X11	360	1.5 mm	Almost Zero	240 seconds	10 seconds	360	21.2 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

Acrobat 315 Welding Parameters

CURRENT AS OF
09/07/2023

Product Line & Material	Pipe Size	Initial Melt Pressure (psi)	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure	Cooling Time
Duo-Pro® PRO150X45 (PP)	4" X 8" (110mm X 200mm) SDR11X33	117	0.5 mm	Almost Zero	113 seconds	7 seconds	117	10.2 min
Duo-Pro® PRO150X45 (PP)	6" X 10" (160mm X 250mm) SDR11X33	198	1 mm	Almost Zero	161 seconds	8 seconds	198	14.2 min
Duo-Pro® PRO150X45 (PP)	8" X 12" (200mm X 315mm) SDR11X33	305	1 mm	Almost Zero	198 seconds	9 seconds	305	17.3 min
Duo-Pro® PRO45X45 (PP)	4" X 8" (110mm X 200mm) SDR33X33	81	0.5 mm	Almost Zero	72 seconds	6 seconds	81	6.7 min
Duo-Pro® PRO45X45 (PP)	6" X 10" (160mm X 250mm) SDR33X33	135	1 mm	Almost Zero	89 seconds	6 seconds	135	8.1 min
Duo-Pro® PRO45X45 (PP)	8" X 12" (200mm X 315mm) SDR33X33	207	1 mm	Almost Zero	110 seconds	7 seconds	207	9.9 min
Poly-Flo® PE100RC	4" X 6" (110mm X 160mm) SDR11X17	151	1.5 mm	Almost Zero	80 seconds	7 seconds	151	14 min
Poly-Flo® PPR	4" X 6" (110mm X 160mm) SDR11X17	125	1 mm	Almost Zero	150 seconds	7 seconds	125	17 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