

Acrobat™ 160 Welding Parameters

CURRENT AS OF
09/01/2023

Product Line & Material	Pipe Size	Initial Melt Pressure (psi)	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure (psi)	Cooling Time
Air-Pro® (PE)	2" (63mm) SDR7	57	1.5 mm	Almost Zero	86 seconds	7 seconds	57	8.9 min
Air-Pro® (PE)	3" (90mm) SDR7	119	2 mm	Almost Zero	123 seconds	8 seconds	119	12.3 min
Air-Pro® (PE)	4" (110mm) SDR7	176	2 mm	Almost Zero	151 seconds	9 seconds	176	14.8 min
Air-Pro® (PE)	6" (160mm) SDR11	258	2 mm	Almost Zero	146 seconds	9 seconds	258	14.2 min
Asahitec™ Solid Wall (PP-RCT)	2" (63mm) SDR11	31	0.5 mm	Almost Zero	68 seconds	6 seconds	31	6.3 min
Asahitec™ Solid Wall (PP-RCT)	2-1/2" (75mm) SDR11	38	0.5 mm	Almost Zero	79 seconds	6 seconds	38	7.3 min
Asahitec™ Solid Wall (PP-RCT)	3" (90mm) SDR11	57	1 mm	Almost Zero	94 seconds	6 seconds	57	8.6 min
Asahitec™ Solid Wall (PP-RCT)	4" (110mm) SDR11	82	1 mm	Almost Zero	113 seconds	7 seconds	82	10.2 min
Asahitec™ Solid Wall (PP-RCT)	5" (125mm) SDR11	107	1 mm	Almost Zero	129 seconds	7 seconds	107	11.5 min
Asahitec™ Solid Wall (PP-RCT)	6" (160mm) SDR11	170	1 mm	Almost Zero	161 seconds	8 seconds	170	14.2 min
Asahitec™ Solid Wall (PP-RCT)	2" (63mm) SDR7	38	1 mm	Almost Zero	98 seconds	6 seconds	38	8.9 min
Asahitec™ Solid Wall (PP-RCT)	2-1/2" (75mm) SDR7	57	1 mm	Almost Zero	117 seconds	7 seconds	57	10.5 min
Asahitec™ Solid Wall (PP-RCT)	3" (90mm) SDR7	82	1 mm	Almost Zero	138 seconds	7 seconds	82	12.3 min
Asahitec™ Solid Wall (PP-RCT)	4" (110mm) SDR7	119	1 mm	Almost Zero	166 seconds	8 seconds	119	14.7 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)

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Asahitec™ Solid Wall (PP-RCT)	5" (125mm) SDR7	151	1 mm	Almost Zero	187 seconds	8 seconds	151	16.4 min
Chem Proline® (PE)	2" (63mm) SDR11	44	1 mm	Almost Zero	58 seconds	6 seconds	44	6.3 min
Chem Proline® (PE)	3" (90mm) SDR11	82	1.5 mm	Almost Zero	82 seconds	6 seconds	82	8.6 min
Chem Proline® (PE)	4" (110mm) SDR11	119	1.5 mm	Almost Zero	100 seconds	7 seconds	119	10.2 min
Chem Proline® (PE)	6" (160mm) SDR11	258	2 mm	Almost Zero	146 seconds	9 seconds	258	14.2 min
Climatec™ (PP-RCT)	2" (63mm) SDR11	31.0	0.5 mm	Almost Zero	68 seconds	6 seconds	31	6.3 min
Climatec™ (PP-RCT)	2-1/2" (75mm) SDR11	38.0	0.5 mm	Almost Zero	79 seconds	6 seconds	38	7.3 min
Climatec™ (PP-RCT)	3" (90mm) SDR11	57.0	1 mm	Almost Zero	94 seconds	6 seconds	57	8.6 min
Climatec™ (PP-RCT)	4" (110mm) SDR11	82.0	1 mm	Almost Zero	113 seconds	7 seconds	82	10.2 min
Climatec™ (PP-RCT)	5" (125mm) SDR11	107.0	1 mm	Almost Zero	129 seconds	7 seconds	107	11.5 min
Climatec™ (PP-RCT)	6" (160mm) SDR17	113.0	1 mm	Almost Zero	108 seconds	6 seconds	113	9.8 min
Proline® PRO150 (PP)	2" (63mm) SDR11	31	0.5 mm	Almost Zero	68 seconds	6 seconds	31	6.3 min
Proline® PRO150 (PP)	2-1/2" (75mm) SDR11	38	0.5 mm	Almost Zero	79 seconds	6 seconds	38	7.3 min
Proline® PRO150 (PP)	3" (90mm) SDR11	57	1 mm	Almost Zero	94 seconds	6 seconds	57	8.6 min



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Product Line & Material	Pipe Size	Initial Melt Pressure (psi)	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure (psi)	Cooling Time
Proline® PRO150 (PP)	4" (110mm) SDR11	82	1 mm	Almost Zero	113 seconds	7 seconds	82	10.2 min
Proline® PRO150 (PP)	4-1/2" (125mm) SDR11	107	1 mm	Almost Zero	129 seconds	7 seconds	107	11.5 min
Proline® PRO150 (PP)	5" (140mm) SDR11	132	1 mm	Almost Zero	142 seconds	7 seconds	132	12.6 min
Proline® PRO150 (PP)	6" (160mm) SDR11	170	1 mm	Almost Zero	161 seconds	8 seconds	170	14.2 min
Proline® PRO90 (PP)	2" (63mm) SDR17.6	19	0.5 mm	Almost Zero	42 seconds	5 seconds	19	5.0 min
Proline® PRO90 (PP)	2-1/2" (75mm) SDR17.6	25	0.5 mm	Almost Zero	51 seconds	5 seconds	25	5.0 min
Proline® PRO90 (PP)	3" (90mm) SDR17.6	38	0.5 mm	Almost Zero	60 seconds	5 seconds	38	5.4 min
Proline® PRO90 (PP)	4" (110mm) SDR17.6	57	0.5 mm	Almost Zero	73 seconds	6 seconds	57	6.5 min
Proline® PRO90 (PP)	4-1/2" (125mm) SDR17.6	69	0.5 mm	Almost Zero	82 seconds	6 seconds	69	7.4 min
Proline® PRO90 (PP)	5" (140mm) SDR17.6	88	0.5 mm	Almost Zero	92 seconds	6 seconds	88	8.2 min
Proline® PRO90 (PP)	6" (160mm) SDR17.6	113	0.5 mm	Almost Zero	104 seconds	6 seconds	113	9.2 min
Proline® PRO45 (PP)	4" (110mm) SDR33	31	0.5 mm	Almost Zero	40 seconds	5 seconds	31	5.0 min
Proline® PRO45 (PP)	4-1/2" (125mm) SDR33	38	0.5 mm	Almost Zero	46 seconds	5 seconds	38	5.0 min
Proline® PRO45 (PP)	5" (140mm) SDR33	50	0.5 mm	Almost Zero	51 seconds	5 seconds	50	5.0 min



Welding Temperatures

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 ECTFE: 527°F - 536°F (275°C - 280°C)

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Proline® PRO45 (PP)	6" (160mm) SDR33	63	0.5 mm	Almost Zero	57 seconds	5 seconds	63	5.0 min
Super Proline® (PVDF)	2" (63mm) SDR21	19	0.5 mm	Almost Zero	70 seconds	3 seconds	19	5.5 min
Super Proline® (PVDF)	2-1/2" (75mm) SDR21	25	0.5 mm	Almost Zero	76 seconds	3 seconds	25	6.5 min
Super Proline® (PVDF)	3" (90mm) SDR21	31	0.5 mm	Almost Zero	83 seconds	3 seconds	31	7.0 min
Super Proline® (PVDF)	4" (110mm) SDR21	44	0.5 mm	Almost Zero	93 seconds	3 seconds	44	8.5 min
Super Proline® (PVDF)	6" (160mm) SDR21	94	0.7 mm	Almost Zero	117 seconds	4 seconds	94	11.0 min
Super Proline® (PVDF)	3" (90mm) SDR33	25	0.5 mm	Almost Zero	68 seconds	3 seconds	25	5.5 min
Super Proline® (PVDF)	4" (110mm) SDR33	31	0.5 mm	Almost Zero	74 seconds	3 seconds	31	6.0 min
Super Proline® (PVDF)	6" (160mm) SDR33	63	0.5 mm	Almost Zero	89 seconds	3 seconds	63	8.0 min
Watertec™ (PP-RCT)	2" (63mm) SDR9	31	1 mm	Almost Zero	82 seconds	6 seconds	31	7.6 min
Watertec™ (PP-RCT)	2-1/2" (75mm) SDR9	50	1 mm	Almost Zero	96 seconds	6 seconds	50	8.7 min
Watertec™ (PP-RCT)	3" (90mm) SDR9	69	1 mm	Almost Zero	114 seconds	7 seconds	69	10.3 min
Watertec™ (PP-RCT)	4" (110mm) SDR9	101	1 mm	Almost Zero	138 seconds	7 seconds	101	12.3 min
Watertec™ (PP-RCT)	5" (125mm) SDR9	126	1 mm	Almost Zero	155 seconds	8 seconds	126	13.7 min



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 ECTFE: 527°F - 536°F (275°C - 280°C)

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Watertec™ (PP-RCT)	6" (160mm) SDR11	170	1 mm	Almost Zero	161 seconds	8 seconds	170	14.2 min
Chem Prolok® (PE)	2" X 4" (63mm X 110mm) SDR11X33	88	0.5 mm	Almost Zero	34 seconds	58 seconds	88	7.0 min
Chem Prolok® (PE)	3" X 6" (90mm X 160mm) SDR11X33	176	1 mm	Almost Zero	49 seconds	82 seconds	176	13.0 min
Chem Prolok® (PE)	2" X 6" (63mm X 160mm) SDR11X33	138	1 mm	Almost Zero	49 seconds	58 seconds	138	7.0 min
Duo-Pro® PRO150X150 (PP)	2" X 4" (63mm X 110mm) SDR11X11	113	1 mm	Almost Zero	113 seconds	68 seconds	113	10.2 min
Duo-Pro® PRO150X150 (PP)	3" X 6" (90mm X 160mm) SDR11X11	226	1 mm	Almost Zero	161 seconds	94 seconds	226	14.2 min
Duo-Pro® PRO150X150 (PP)	2" X 6" (63mm X 160mm) SDR11X11	201	1 mm	Almost Zero	161 seconds	68 seconds	201	14.2 min
Duo-Pro® PRO150X45 (PP)	2" X 4" (63mm X 110mm) SDR11X33	63	0.5 mm	Almost Zero	68 seconds	68 seconds	63	5.0 min
Duo-Pro® PRO150X45 (PP)	3" X 6" (90mm X 160mm) SDR11X33	119	0.5 mm	Almost Zero	94 seconds	94 seconds	119	9.0 min
Duo-Pro® PRO150X45 (PP)	2" X 6" (63mm X 160mm) SDR11X33	94	0.5 mm	Almost Zero	68 seconds	68 seconds	94	5.0 min
Duo-Pro® PVDFXPVDF (PVDF)	2" X 4" (63mm X 110mm) SDR21X33	50	0.5 mm	Almost Zero	74 seconds	70 seconds	50	6.0 min
Duo-Pro® PVDFXPVDF (PVDF)	3" X 6" (90mm X 160mm) SDR33X33	88	0.5 mm	Almost Zero	89 seconds	68 seconds	88	8.0 min
Duo-Pro® PVDFXPVDF (PVDF)	2" X 6" (63mm X 160mm) SDR21X33	82	0.5 mm	Almost Zero	89 seconds	70 seconds	82	8.0 min
Poly-Flo® PE100RC (PE)	2" X 3" (63mm X 90mm) SDR11X17	41	1 mm	Almost Zero	35 seconds	5 seconds	41	8.0 min



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Poly-Flo® PE100RC (PE)	4" X 6" (110mm X 160mm) SDR11X17	141	1.5 mm	Almost Zero	80 seconds	7 seconds	141	14.0 min
Poly-Flo® PPR (PP)	2" X 3" (63mm X 90mm) SDR11X17	38	0.5 mm	Almost Zero	80 seconds	6 seconds	38	9.0 min
Poly-Flo® PPR (PP)	4" X 6" (110mm X 160mm) SDR11X17	118	1 mm	Almost Zero	150 seconds	7 seconds	118	17.0 min



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