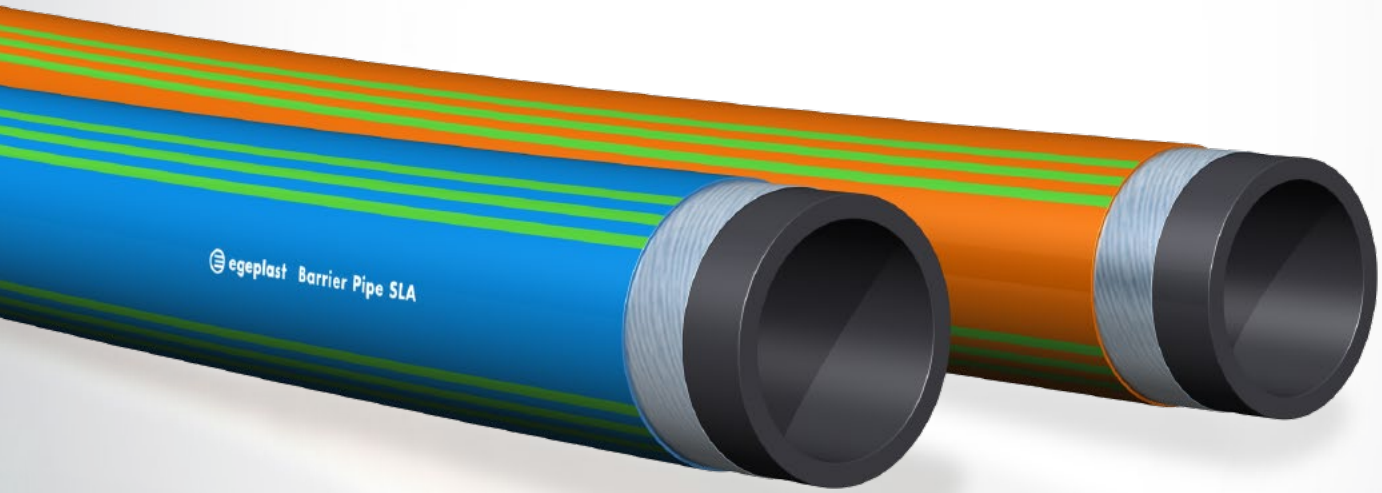
egeplast

Barrier Pipe SLA®

Processing Guidelines



egeplast

Foreword

Details given in this brochure reflect the state of the art. No claim is made with regard to their completeness, they are intended for instruction and guidance; no obligation may be derived from it. Mistake and subject to change reserved.

Our customer service will be pleased to answer any further questions regarding the installation or use of our products, or any other questions. In addition, our customer and applications engineering services are pleased to be at your disposal to provide any technical guidance that you may want.

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1 | Processing Guidelines Barrier Pipe SLA®

Supplement to the installation instructions for PE pressure pipes A 135 and A 435 from the Kunststoffrohrverband e.V. in Bonn

1.1 General information

The egeplast Barrier Pipe SLA® consists of a core pipe according to DIN 8074/75, upon which a protective layer is additionally extruded in order to increase its scratch and abrasion resistance. An aluminium barrier layer is applied between the medium-bearing pipe and the protective layer. The green stripes serve to identify it as a multilayer pipe.

Scope of application

The processing guidelines apply to buried egeplast Barrier Pipes SLA® with inner pipes made of PE 100-RC. The pipe connections and pipeline components must comply with the respective operating pressure.

Installation, open trench



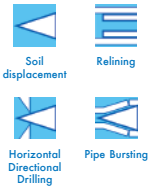
egeplast Barrier Pipes SLA® are suited for installation without a sand bed due to the highly stress crack resistant material PE 100-RC. The excavated soil is suitable for backfilling, as long as it can be compacted.
In order to assess the filling soil, the DIN 18196, inter alia, is relevant. The pipe trench is to be constructed, among others, according to DIN 4124 (Excavation Pits and Trenches). The minimum covering for gas pipelines is 0.6 to 1.0 m, by which covering can be reduced to 0.5 m for sections up to a length of approximately 2.0 m, that do not have to bear any particular load (front yards, walkways). Potable water pipes must be laid frost-resistant by covering them at depths of 1.0 to 1.8 m (according to climate and soil conditions). Apart from this, DVGW Worksheet W400-2 shall apply for the Construction of Water Mains.

Installation, ploughing and milling



The egeplast Barrier Pipe SLA® is quite flexible. This makes installation using the ploughing or milling procedures possible. The minimum allowable bending radius should be observed. If the radius falls below the minimum permissible bending radii because of the installation method chosen, any damage like kinking or overstretching must be constructively ruled out.

Installation, trenchless method



Multilayer pipes such as egeplast Barrier Pipe SLA® is a practical solution in the case of trenchless installation and rehabilitation, as the outer surface of the pipe is securely protected against wear. The DVGW Worksheets GW 321 (horizontal directional drilling) and GW 323 (pipe bursting) recommend the application of such protective layer pipes.

- The DVGW rules define the maximum permissible tensile forces. Exceeding the permissible tensile forces will cause permanent damage to the new pipeline and shall be prevented by taking the appropriate measures. The tensile forces are to be measured and recorded.
- The minimum permissible bending radius is to be observed.
- In the case of protective layer pipes, special pulling heads with an outer sleeve, that surrounds the protective layer, are recommended. Alternatively, the joint edge is to be constructively protected (refer to Figures 1-1 and 1-2).
- The axially force-locking connection must be established according to applicable rules of DVGW and DVS.
- In order to prevent protruding edges at the joints, the egeplast processing guidelines must be observed.



Fig 1-1



Fig 1-2

1.2 Permissible bending radii

The bending radius must not fall below any of the following bending radii. Pipe elbows or fittings are to be used in the case of smaller radii.

Pipe wall temperatures [°C]	Minimum permissible bending radius R_{min} [in mm]				
	SDR 33	SDR 26	SDR 17/17.6	SDR 11	SDR 7.4
0	150.0 x OD	112.5 x OD	75.0 x OD	75.0 x OD	75.0 x OD
10	100.0 x OD	75.0 x OD	52.5 x OD	52.5 x OD	52.5 x OD
20	60.0 x OD	45.0 x OD	30.0 x OD	30.0 x OD	30.0 x OD

Tab1-1: Following KRV Installation Instructions A 135/99-15 und A 435/96-10, DVGW Worksheet GW 320, GW 321, GW 324, GW 325 and DVGW Data Sheet GW 323

OD = Outer diameter core pipe [in mm]

$$R_{interpolated} = R_{20°C} + \left[\frac{R_{0°C} - R_{20°C}}{20°C}\right] \cdot (20°C - \vartheta_{pipe\ wall})$$

with:

$R_{interpolated}$ = required bending radius [mm]
$R_{0°C}$ = Bending radius of the pipe at 0 °C [mm]
$R_{20°C}$ = Bending radius of the pipe at 20 °C [mm]
$\vartheta_{pipe\ wall}$ [°C] = Temperature of the pipe wall during installation

In the case of pipe wall temperatures between 0 °C und 20 °C, the respective permissible bending radius can be determined by linear interpolation.

Temporary permissible bending radii for e.g. trenchless installation methods

Pipe wall temperatures [°C]	Temporary permissible, construction-related bending radii R_{min} [in mm] for e.g. trenchless installation methods	
	SDR 17	SDR 11
0	56.0 x OD	37.0 x OD
20	22.0 x OD	15.0 x OD

Tab1-2: In conformity with DVGW Worksheet GW 320-1

OD = Outer diameter core pipe [in mm]

ⓘ In the case of a temporary, process-related reduction of the permissible bending radii, damage caused by buckling when bending or overexpanding must be constructively ruled out.

ⓘ The above-mentioned bending radii do not apply to pipes, whose joints were post-factory coated with a mechanical protective coating, as e.g. two-component polyurethane coatings.

1.3 Permissible Tensile Forces

The values apply to pipes made of PE 100, PE 100-RC as well as to egeplast protective layer pipes such as the Barrier Pipe SLA® (since only the medium-carrying pressure pipe will be burdened during pipe installation). They are to be measured and recorded. Exceeding the permissible tensile forces will lead to permanent damage to the pipeline, appropriate measures shall be taken to avoid this.

Special pulling heads are to be used. In order to prevent protruding edges and to ensure that the protective layer is no additional obstacle when installing, pulling heads with an outer sleeve that surrounds the protective outer layer are commonly used. As an alternative, the protruding edge is to be constructively protected.

Tensile force: Permissible tensile force in kN for pipes of PE 100 and PE 100-RC at 20 °C pipe wall temperature

Note: Values are to be reduced by 10% for pulling periods of > 30 min. and 25% for a pulling period of > 20 h.

Outer diameter	Permissible tensile force Barrier Pipe SLA®			
OD [mm]	SDR 17.6 [kN]	SDR 17 [kN]	SDR 11 [kN]	SDR 7.4 [kN]
25		1.31	1.64	2.36
32	1.71	1.80	2.65	3.81
40	2.72	2.83	4.22	5.96
50	4.29	4.43	6.56	9.34
63	6.71	7.06	10.42	14.69
75	9.55	9.96	14.56	20.93
90	13.60	14.34	21.06	30.01
110	20.51	21.43	31.40	45.00
125	26.28	27.33	40.66	57.94
140	33.16	34.32	50.76	72.83
160	43.12	44.89	66.66	94.97
180	54.38	56.88	84.25	120.04
200	67.51	70.29	103.90	148.50
225	85.29	89.03	131.64	187.81
250	105.14	109.30	162.01	231.74
280	131.85	137.29	203.06	290.67
315	166.99	173.98	257.20	367.97
355	211.37	221.22	326.38	466.77
400	268.93	280.03	414.55	593.08
450	339.90	354.89	525.39	750.23
500	420.55	438.59	648.06	925.83
560	525.86	549.18	812.24	
630	666.20	695.93	1028.79	

Tab 1-3: See also DVGW Worksheets GW 320, GW 321, GW 324, GW 325 and DVGW Code of practice GW 323



Fig 1-3



Fig 1-4

1.4 Joining techniques

1.4.1 **Electrofusion welding**

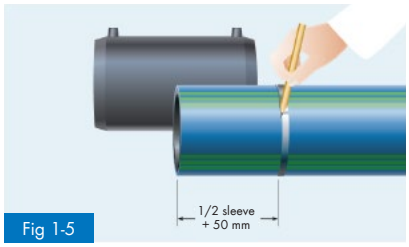


Fig 1-5

Marking the area from which the protective layer is to be peeled



Fig 1-6

Removal of the protective layer with the egeplast M10 / M10 maxi peeling tool

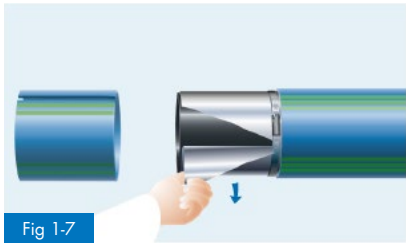


Fig 1-7

Removal of the aluminium barrier layer by means of a hose clip

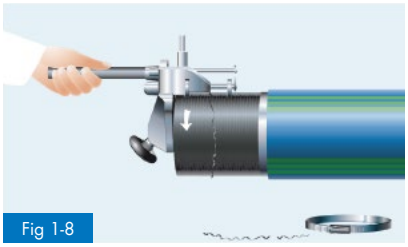


Fig 1-8

Removal of the oxide layer using a rotary scraper

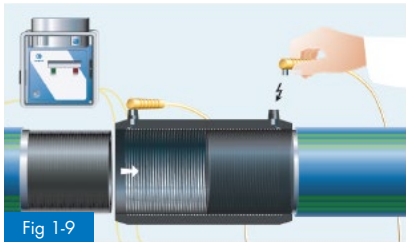


Fig 1-9

Welding procedure acc. to DVS 2207, Part 1



Fig 1-10

Removal of the contact plugs

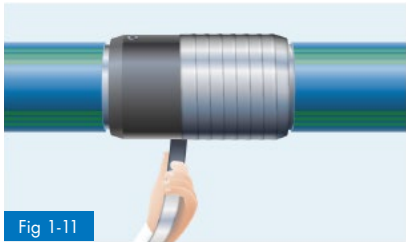


Fig 1-11

Wrapping of the welded fittings with aluminium adhesive tape

Before electrofusion welding of egeplast Barrier Pipes SLA® the protective layer must be removed residuefree, using an egeplast peeling tool (M10 / M10 maxi). The length of outer layer to be peeled corresponds to at least half the length of the electrofusion coupler plus 50 mm (see Fig 1-5 and 1-6).

After removal of the protective layer, the aluminium barrier is removed. A hose clip, or similar, can simplify the process. This is fastened on the barrier layer in such a way so as to enable approximately 20 mm aluminium to remain on the core pipe. After this, the aluminium is carefully removed from the core pipe, in such a way that it tears at the hose clip (Figure 1-7). Refer also to Table 1-5 „Reference Values for Layer cutback" on Page 10 for the lengths of the cutback.

The contact surfaces must be prepared by scraping and cleaning before welding (Fig 1-8).

After mounting of the fittings, welding is carried out according to DVS 2207, Part 1. Mounting and processing instructions of the respective manufacturers are to be observed.

After welding, the contact plugs of the fittings are removed. An aluminium adhesive tape of egeplast is now wrapped around the exposed aluminium threefold, beginning at one end, with an overlap of at least 50%. The aluminium adhesive tape is to be pressed firmly and smoothened by rolling over it (Figures 1-10 and 1-11).

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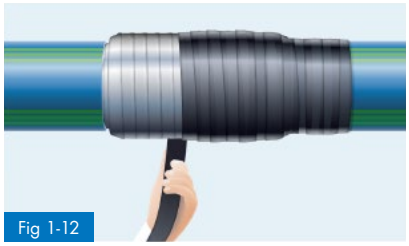


Fig 1-12

Wrapping of the fitting with Densolen tape AS 40

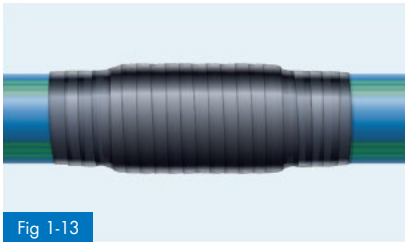


Fig 1-13

Joint, protected with Densolen tape AS 40

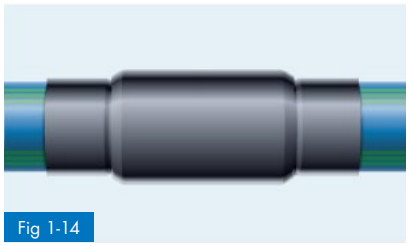


Fig 1-14

Joint, protected with a shrinking sleeve

For **installation in open trenches**, egeplast recommends for mechanical protection of the aluminium layer

1. to wrap it with a sealing tape with 50% overlap (e.g. Densolen tape AS 40 Plus)
2. shrinkable products that are customary in the market

Refer also to Table 1-4 on Page 9 for material requirements of the post-factory coating

With regard to **trenchless installation**, egeplast is to be consulted concerning the selection of appropriate materials for mechanical protection.

ⓘ egeplast Barrier Pipes SLA® may be welded to all the commonly used fittings made from PE 100 and PE 80 after removal of the outer layer from the pipe ends. The guidelines and specifications given by the fittings manufacturers must also be followed.

ⓘ Removing the outer layer on the pipe ends can be carried out by egeplast on request.

Material requirements of electrofusion welding for post-factory coating

After electrofusion welding of the Barrier Pipes SLA®, the jointings are wrapped with aluminium adhesive tape. Wrapping with sealing tapes, e.g. Densolen AS 40 Plus or shrinkable products that are customary in the market ensures subsequent mechanical protection. The following table shows a summary of the requirements of the necessary post-factory coating material.

Material requirements for post-factory coating of electrofusion welds of Barrier Pipes SLA®*		
Medium-Bearing pipe DIN 8074 OD [mm]	Aluminium adhesive tape Width 50 mm Estimated quantity/connection [in m]	Densolen AS 40 Plus Width 50 mm Estimated quantity/connection [in m]
25	1.5	0.7
32	2.5	1.0
40	4.0	1.5
50	5.0	2.0
63	6.0	2.5
75	8.0	3.0
90	10.0	4.0
110	12.0	5.0
125	15.0	6.0
140	18.0	7.0
160	25.0	9.0
180	28.0	10.0
200	30.0	12.0
225	35.0	13.5
250	45.0	16.5
280	50.0	20.0
315	60.0	23.0
355	70.0	25.0
400	80.0	30.0
450	100.0	38.0
500	110.0	40.0
560	120.0	45.0
630	140.0	55.0

Tab 1-4 * Reference values for layer cutback of the Barrier Pipes SLA®, Table 1-5, are the basis of the requirements.

Reference values for layer cutback – Electrofusion welding

Before electrofusion welding of egeplast Barrier Pipes SLA® can take place, the protective outer layer must be removed with egeplast peeling tools. Peeling of the pipe ends can be carried out by egeplast on request.

Layer Cutback for Barrier Pipes SLA®		
Medium-Bearing pipe DIN 8074 OD [mm]	Electrofusion welding* [mm]	
	Protective layer	Aluminium
25	90	70
32	95	75
40	100	80
50	105	85
63	115	95
75	120	100
90	130	110
110	140	120
125	145	125
140	150	130
160	155	135
180	160	140
200	165	145
225	175	155
250	185	165
280	190	170
315	200	180
355	205	185
400	215	195
450	225	205
500	235	215
560	240	220
630	255	235

Tab 1-5 * Dimensions specified for the product ranges of the Georg Fischer, Friatec and Plasson companies. Long electrofusion couplers are not considered.

1.4.2 **Butt welding**

ⓘ In the case of the egeplast Barrier Pipes SLA®, the protective outer layer is extruded onto the medium pipe. Prior to butt welding, this layer must be removed completely by at least 50 mm by means of the egeplast peeling tools (M10 / M10 maxi) – peel-off lengths adapted to an outer debeader are recommended.

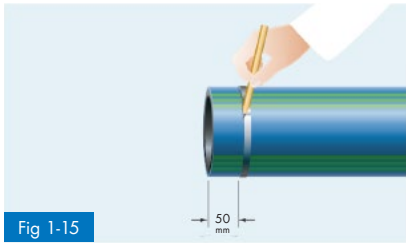


Fig 1-15

Marking the area from which the layer is to be peeled


Fig 1-16

Removal of the protective layer with suitable peeling tools

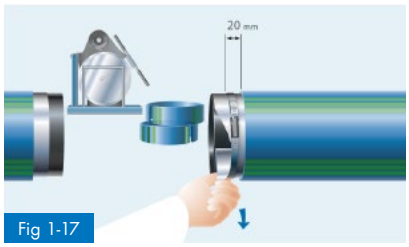
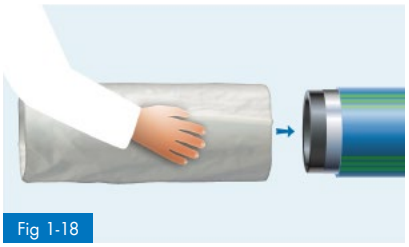
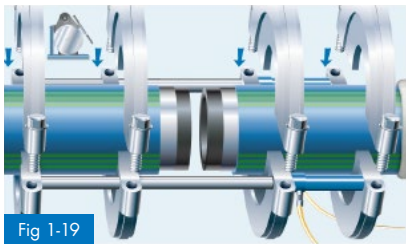


Fig 1-17

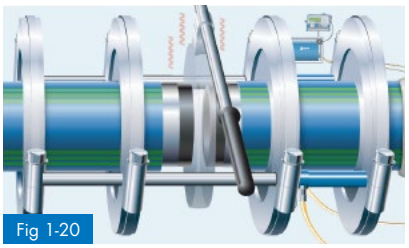
Removal of the aluminium barrier layer


Fig 1-18

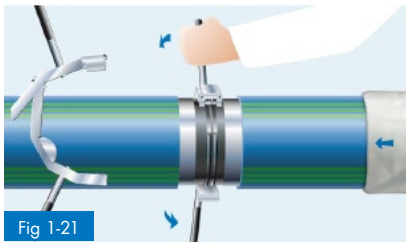
Mount shrinking sleeve prior to manufacture of the pipe joint, do not remove the protective foil


Fig 1-19

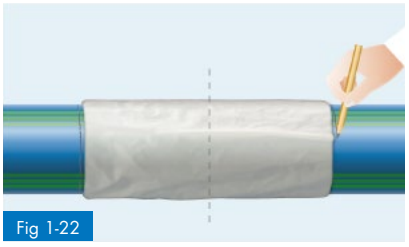
Mount the special clamping jaws


Fig 1-20

Welding according to DVS 2207, Part 1


Fig 1-21

Removal of weld bead with an outer debeader


Fig 1-22

Positioning of the shrinking sleeve

After removal of the protective layer, the aluminium barrier is removed. A hose clip, or similar, can simplify the process. This is fastened on the barrier layer in such a way so as to enable approximately 20 mm aluminium to remain on the core pipe. After this, the aluminium is carefully removed from the core pipe, in such a way that it tears at the hose clip (Figure 1-17). Refer also to Table 1-7 „Reference Values for Layer cutback" on Page 14 for the lengths of the cutback.

For mechanical protection of the connecting joint, egeplast recommends the use of egeFit® shrinking sleeve. The sleeve is packed in a protective foil for delivery. This foil protects it from humidity and contamination. The sleeve must be pushed onto the pipeline to be welded while it is still in its packed condition, prior to establishing the pipe connection.

Welding is to take place according to DVS 2207, Part 1 by applying the machined clamping jaws adapted to the outer diameter. The clamping jaws can be made available by egeplast (refer to Table 1-9, Page 18).

After welding, the weld bead is to be removed with an outer debeader.

Position the shrinking sleeve in the center above the weld seam and mark the shrink area. Slide back the sleeve afterwards and remove from the shrink area.

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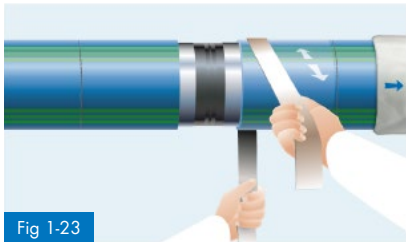


Fig 1-23

Roughen the shrink area of the sleeve radially using emery cloth.

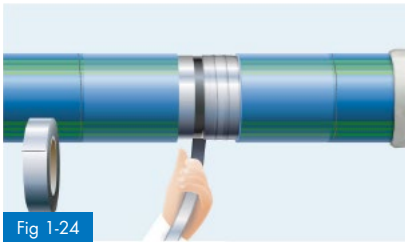


Fig 1-24

Wrapping of the welding area with aluminium adhesive tape

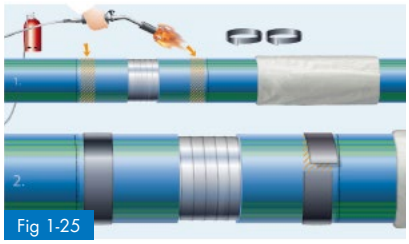


Fig 1-25

Preheating the pipe surface and applying the hot-melt adhesive

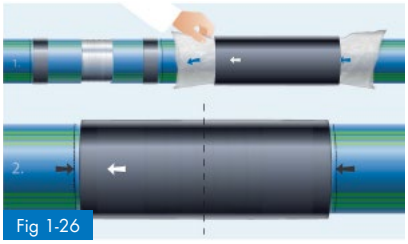


Fig 1-26

Removal of the protective foil and alignment of the shrinking sleeve



Fig 1-27

Shrinking of the sleeve by means of a soft gas flame

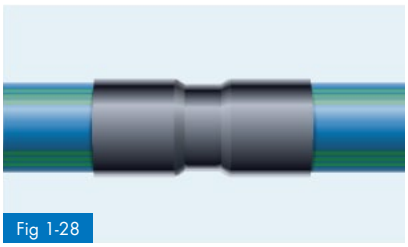


Fig 1-28

Welded joint protected by shrinking sleeve

Note:
After shrinking, the joint should cool down to ambient temperature in order for the material to achieve sufficient consistency.

The protective layer is to be roughened with an emery cloth (P60) in the area of the shrinking sleeve to be positioned later, in order to achieve better adhesion.
In order to establish the diffusion barrier of the joint, the aluminium layer is fabricated continuously. An aluminium adhesive tape of egeplast is wrapped around threefold, beginning at one end, with an overlap of at least 50% (Figure 1-24). The aluminium adhesive tape is to be pressed firmly and smoothened by rolling over it.
The aluminium layer is protected mechanically by means of an egeFit® shrinking sleeve. Drying and cleaning of the shrink area. Preheat the pipe surface and apply the enclosed hot-melt adhesive, approx. 5 cm from the end of the shrinking sleeve on either side (Fig. 1-25). Subsequently remove the protective foil into a single direction. Align shrinking sleeve to the center and position above the weld seam.
Prior to the shrinking process, the protective layer must be protected by suitable heat protection mats at the edge zone of the shrinking sleeve. Shrinking of the sleeve by means of a „soft" gas flame. Processing from the center towards the outside. Keep propane gas burner constantly circulating (Figure 1-27). When the shrinking sleeve fits closely, installation is complete.

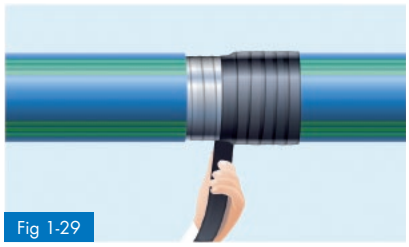


Fig 1-29

Wrapping of the joint with Densolen tape AS 40

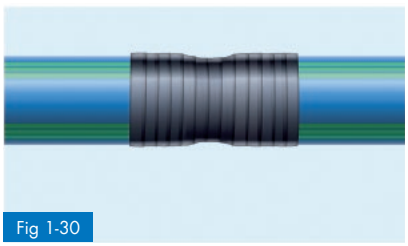


Fig 1-30

Weld area protected with Densolen tape AS 40

Note:
For installation in open trench, a sealing tape with a 50% overlap can be wrapped for mechanical protection of the aluminium tape instead as an alternative to shrinking sleeves.

For material requirement for the post-factory coating of joints in trenchless installations, refer also to Table 1-16, Page 13.

Material requirement for post-factory coating – Butt welding

After butt welding of the Barrier Pipes SLA®, the jointings are wrapped with aluminium adhesive tape. The subsequent mechanical protection ensures:
- Wrapping with sealing tape Densolen AS 40 Plus or shrinking sleeve as customary in the market in case of **open trench installation**.
- in the case of **trenchless installation**, post-factory coating with egeplast egeFit® shrinking sleeve

The following table shows a summary of the requirements of the necessary post-factory coating material.

Material requirements for post-factory coating of Barrier Pipes SLA® – Butt welding*					
	trenchless installation		open trench installation		
OD [mm]	egeFit® shrinking sleeve	aluminium adhesive tape estimated quantity/connection [in m]	egeFit® shrinking sleeve	aluminium adhesive tape estimated quantity/connection [in m]	Densolen AS 40 Plus estimated quantity/connection [in m]
25	on request	on request	on request	1.0	0.5
32	on request	on request	on request	1.5	0.5
40	on request	on request	on request	2.0	0.5
50	on request	on request	on request	2.5	0.8
63	on request	on request	on request	3.0	1.0
75	on request	on request	on request	4.0	1.2
90	●	5.0	●	5.0	1.5
110	●	6.0	●	6.0	2.0
125	●	7.0	●	7.0	2.2
140	●	8.0	●	8.0	2.5
160	●	9.0	●	9.0	3.0
180	●	10.0	●	10.0	3.5
200	●	12.0	●	12.0	4.0
225	●	13.0	●	13.0	4.5
250	●	15.0	●	15.0	5.0
280	●	17.5	●	17.5	6.0
315	●	20.0	●	20.0	7.0
355	●	22.5	●	22.5	8.0
400	●	25.0	●	25.0	9.0
450	●	28.5	●	28.5	10.0
500	●	35.0	●	35.0	12.0
560	●	40.0	●	40.0	13.5
630	●	45.0	●	45.0	15.0

Width of aluminium adhesive tape and Densolen AS 40 Plus = 50 mm

Tab 1-6: * Basis for the requirements is the recommended cutback width of egeplast protective layer pipes using WIDOS outer debeaders, refer to Table 1-7

Reference values for layer cutback – Butt welding

Before butt fusion welding of egeplast Barrier Pipes SLA® can take place, the protective layer must be removed with egeplast peeling tools.

Layer Cutback for Barrier Pipes SLA®			
Medium-Bearing pipe DIN 8074 OD [mm]	Butt welding [mm]		optimized for WIDOS external debeaders
	Protective layer	Aluminium	
25	40	20	-
32	40	20	-
40	40	20	-
50	40	20	-
63	40	20	-
75	40	20	-
90	40	20	-
110	40	20	Size 1
125	40	20	Size 1
140	50	30	Size 1 / Size 2
160	50	30	Size 1 / Size 2
180	50	30	Size 2 / Size 3
200	50	30	Size 2 / Size 3
225	50	30	Size 2 / Size 3
250	50	30	Size 2 / Size 3
280	60	40	Size 3 / Size 4
315	60	40	Size 3 / Size 4
355	60	40	Size 4
400	60	40	Size 4
450	60	40	Size 4
500	70	50	Size 6
560	70	50	Size 6
630	70	50	Size 6 / Size 8

Tab 1-7

1.4.3 Tapping

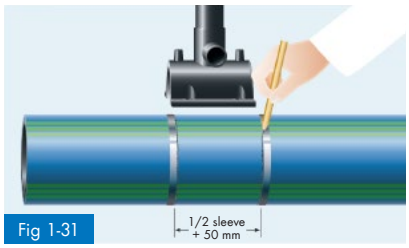


Fig 1-31

Marking the area from which the outer layer is to be peeled

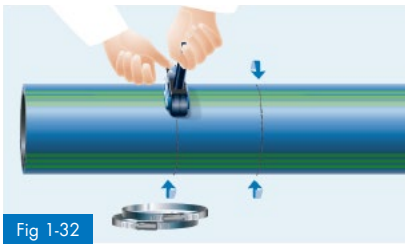


Fig 1-32

Removal of the protective layer with the egeplast M10 / M10 maxi peeling tool

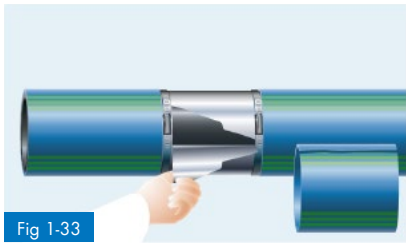


Fig 1-33

Removal of the aluminium barrier by means of a hose clip

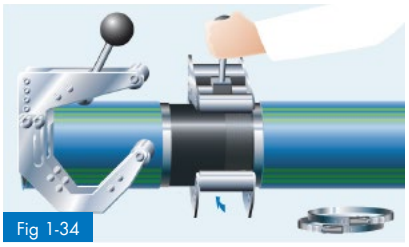


Fig 1-34

Removal of the oxide layer using a suitable scraping tool

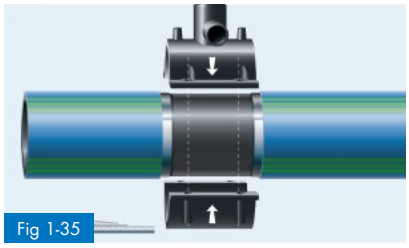


Fig 1-35

Mounting the tapping fitting

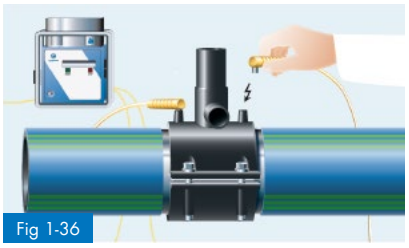


Fig 1-36

Welding process acc. to DVS 2207 Part 1

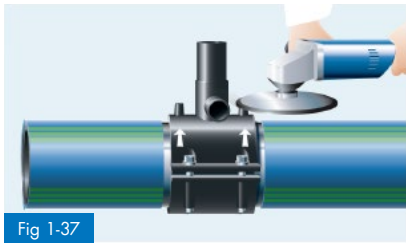


Fig 1-37

Removal of the contact plugs

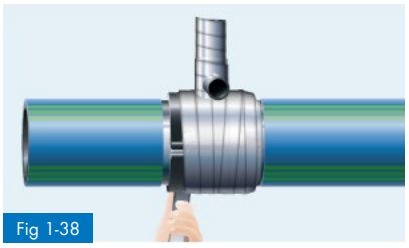


Fig 1-38

Wrapping the tapping fitting with aluminium adhesive tape

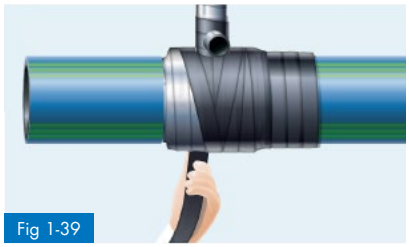


Fig 1-39

Wrapping the tapping fitting with Densolen Tape AS 40

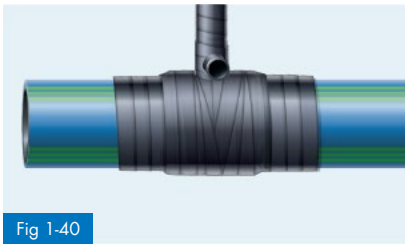


Fig 1-40

Tapping fitting protected with Densolen Tape AS 40

When processing tapping saddles, clamps etc. the protective layer and the aluminium must be removed residue-free so that installation can take place on the core pipe. The processing instructions of the respective fitting manufacturer should be observed.

Use of the egeplast peeling tools

Removal of the outer layer can be carried out with the egeplast peeling tools M10 / M10 maxi.

Note on processing weldable tapping saddles (see Fig. 1-34 to 1-40)

The welding area on the surface of the pipe must be machined completely prior to welding. Subsequent welding of the tapping fitting must take place according to DVS 2207, Part 1 and technical instructions of the fitting manufacturers.

After removal of the contact plugs, the continuity of the aluminium layer must be reconstituted. To do this, egeplast aluminium adhesive tape is wrapped around the fitting threefold, with an overlap of at least 50%. egeplast recommends using a sealing tape (e.g. Densolen Tape AS 40 plus, or equivalent) to protect the aluminium layer.

1.4.4 Flanged joints

The following types of design are commonly used for making flanged joints:

- Stub end for electrofusion
- Stub end for butt fusion

RC pipes are handled in the same way as PE 100 pipes.

1.4.5 Push-fit connections / Compression fittings

egeplast Barrier Pipes SLA® can be handled in the same way as PE 100 pipes using commercially available push-fit connectors and compression fittings. The protective layer and the aluminium layer must be removed in the joint area.

The processing recommendations of the respective manufacturer must be observed separately.

Diffusion resistant compression fittings

Diffusion resistant compression fittings are available at egeplast, adapted to the Barrier Pipe SLA®-System

The diffusion resistance of the connection was confirmed with KIWA Attest No. K5156/03.

Mounting onto the egeplast Barrier Pipe SLA® is carried out using suitably matched hydraulic pressing tools.

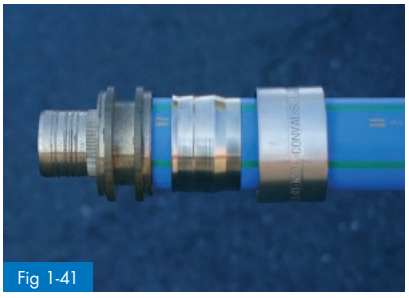


Fig 1-41

Coupler with press ring

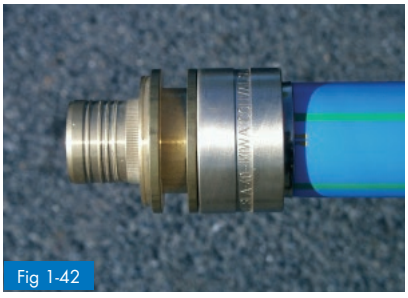


Fig 1-42

Barrier Pipe SLA® brass coupler

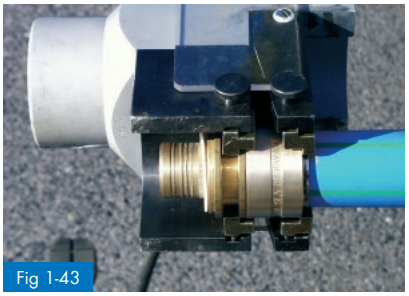


Fig 1-43

Pressing on using press tool type B



Fig 1-45: KIWA certificatet

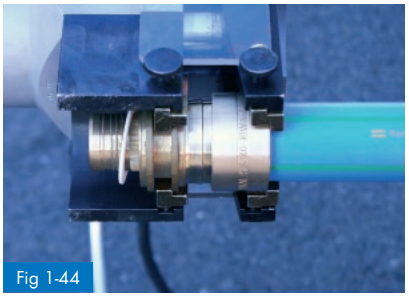
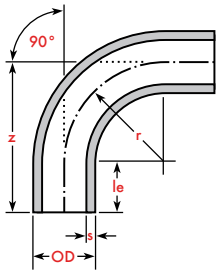
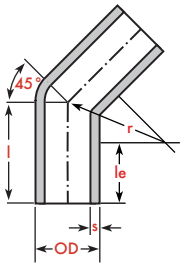
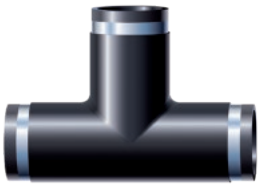
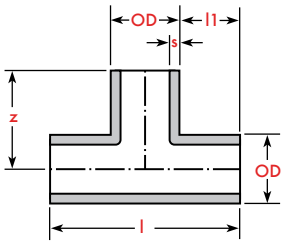


Fig 1-44

Pressing on using press tool type B

1.5 System Components

egeplast offers a fitting programme which is adapted to the Barrier Pipe SLA®, with integrated aluminium barrier layer. The respective documentation is available separately. We will gladly provide you with the respective documentation. Integration of the fittings is done in line with Section1.4.

Seamless bends made from egeplast PE 100-RC pipe with aluminium barrier layer different versions		
Segmented fittings made from egeplast PE 100-RC pipe with aluminium barrier layer different versions		
Fittings, compliant with pressure class, made from PE 100 with aluminium barrier layer different versions		

Tab 1-8 Fitting Programme (Extract)

1.6 Overview of outer and medium pipe diameters / Butt welding Machines / Clamping Jaws

In the case of a welding connection by means of butt-welding, the pipe ends are gripped with clamping jaws that have been specially adjusted to the outer diameter, so that the pipe ends to be welded can be firmly secured. Special clamping jaws and the required adapters for WIDOS welding machines are available at egeplast on request.

The following list contains the outer diameter of the pipes as well as the applicable versions of WIDOS machines that may be used, depending on the pipe dimensions.

Medium-Bearing pipe DIN 8074 OD [mm]	Outer diameter Barrier Pipe SLA® [mm]	WIDOS Butt Fusion Machines – Area of Application				
		WIDOS 4600	WIDOS 4800	WIDOS 4900	WIDOS 5100	WIDOS 6100
25	27.0					
32	34.5					
40	43.0					
50	53.2					
63	66.5	●	●*	●*		
75	79.0	●	●*	●*		
90	94.1	●	●*	●*		
110	114.8	●	●*	●*		
125	130.1	●	●*	●*		
140	145.4	●	●*	●*		
160	166.3	●	●*	●*		
180	187.3	●	●*	●*		
200	207.0	●	●*	●*		
225	232.0	●	●*	●*		
250	257.0		●	●	●*	
280	287.0				●*	
315	322.4				●*	
355	362.5				●	
400	407.6				●	
450	460.0					●
500	510.8					●
560	571.2					●
630	641.4					
Manufacturing tolerances possible		* Appropriate adapter required				

Tab 1-9

Notices

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