

Technical Data

Table 1 Fusion Tools

Specification and Model no.	Input volt	Frequency	Rated watt	Surface temperature of welding sockets & spigots	Time to specified temperature
	V~	Hz	W	°C	<min
RJQ-40	(110)220/230	(60) 50	600/650	260	10
RJQ-63	(110)220/230	(60) 50	800/870	260	10
RJQ-110	(110)220/230	(60) 50	1200/1300	260	15
ZRJQ-40	(110)220/230	(60) 50	600/650	200-279	10
ZRJQ-63	(110)220/230	(60) 50	800/870	200-279	10
ZRJQ-110	(110)220/230	(60) 50	1200/1300	200-279	10

Table 2 Welding Sockets & Spigots

Specifications of pipes (φ)	Internal diameter of concave head---Spigots (φ)		Internal diameter of convex head---Sockets (φ)		Heat-fusing depth	
	A	B	A	B	A	B
16	16.04	15.84 \pm 0.04	15.54	15.44 \pm 0.04	13	13
20	20.05	19.78 \pm 0.04	19.53	19.38 \pm 0.04	14	14
25	25.04	24.77 \pm 0.04	24.51	24.32 \pm 0.04	15	16
32	32.03	31.75 \pm 0.04	31.50	31.26 \pm 0.04	16.5	18
40	40.02	39.76 \pm 0.04	39.48	39.20 \pm 0.04	18	20
50	50.02	49.68 \pm 0.06	49.46	49.19 \pm 0.06	20	23
63	62.99	62.60 \pm 0.06	62.46	62.10 \pm 0.06	24	27
75	74.91	74.59 \pm 0.06	74.32	74.00 \pm 0.06	26	31
90	89.92	89.57 \pm 0.06	89.33	88.93 \pm 0.06	29	35
110	109.88	109.49 \pm 0.06	109.29	108.80 \pm 0.06	32.5	41
125*	124.70		124.00		35	
140*	139.65		138.85		39	
160*	159.50		158.60		42	

*Note: Above mentioned technical data only for your reference. The exact data must refer to the size of the plastic pipes & fittings.

Table 3 Fusing Standards for Plastic Pipes & Fittings

External diameter of pipes (mm)	Fusing depth (mm)		Heating time (s)	Processing time (s)	Cooling time (min)
	A	B			
16	13	13	5	4	3
20	14	14	5	4	3
25	15	16	7	4	3
32	16.5	18	8	4	4
40	18.0	20	12	6	4
50	20.0	23	18	6	5
63	24.0	27	24	6	6
75	26.0	31	30	8	8
90	29.0	35	40	8	8
110	32.5	41	50	10	8
125	35		75	12	10
140	39		90	15	15
160	42		120	15	20