

XL Fu Qing China	Product Specification Sheet	Format No. : QC/F/8.6/30
		Rev. No. : 01
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		Page No. : 01 of 01

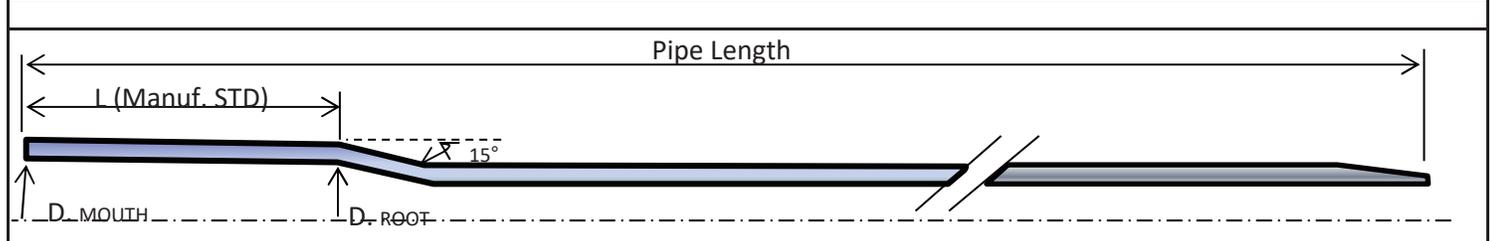
PRODUCT DESCRIPTION	DN 25 GREY uPVC SOLAR UV ELECTRICAL RIGID HD CONDUIT AS/NZS 61386.21, SCJ X 4.0M + SOE
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PRODUCT CODE	
EXTRUDER	PRODUCTION LINE 1- SJ45
FORMULATION CODE	C 202

PRODUCT DIMENSIONS			PROCESSING PARAMETERS	
	MIN (mm)	MAX (mm)		
PIPE WALL THICKNESS	1.6	1.8	Barrel Zone- 1 (°C)	190
OVALITY	--		Barrel Zone- 2 (°C)	188
PIPE OUTER DIAMETER	24.7	25.0	Barrel Zone- 3 (°C)	175
EFFECTIVE PIPE LENGTH	4.000 M		Barrel Zone- 4 (°C)	140
PIPE LENGTH INCLUDING SOCKET	4.025 M		Barrel Zone- 5 (°C)	..
SOCKET MOUTH DIAMETER	25.1	25.4	Adaptor (°C)	..
SOCKET ROOT DIAMETER	24.4	24.7	Die Zone- 1 (°C)	180
SOCKET LENGTH	25.0	30.0	Die Zone- 2 (°C)	190
SOCKET DEPTH	--		Die Zone- 3 (°C)	195
END SQUARENESS	--		Die Zone- 4 (°C)	..
RRJ SOCKET PROFILE			Die Zone- 5 (°C)	..
D2 = --	D5 = --	e = --	Master pot	1000
D3 = --		M = --	Main Drive Pot	900
D4 = --		u = --	Main Drive RPM	57.8
			Feeder Pot	580
			Feeder RPM	..
WALL THICKENING	-- mm min.		Haul-off pot	532
WITNESS MARK	--			
CHAMFER LENGTH	--	--		
MATERIAL	UPVC		BELLING SET-UP	
PIPE COLOUR	GREY		Pipe Size	25
TIMBER SIZE [TOP X SIDE]			Oven Temperature	300
QUANTITY PER PACKET			Belling Time	1 X 10 SEC
STD. PIPE WEIGHT (KG)	0.796		Heating Time	0.1 MIN
STD. PACK WEIGHT (KG)	0.796		Haul-off time	0.8 SEC
MINIMUM PRINT HEIGHT	2 MM		Belling Carriage	138
REPEAT PRINTING	1.0 M to 3.0 M		Stroke Control	
MINIMUM MEAN INTERNAL DIAMETER	--			

PRINT/ MARKING INFORMATION	
ER PVC SOLAR 25MM PVC-U ELECTRICAL HD T 5/60 CONDUIT AS/NZS 61386.21 CMI LIC No. PC10069 BEP L# DATE TIME	

ADDITIONAL INSTRUCTIONS: No defects shall be present. Pipe length shall be effective length -0mm, +10mm only. Pipe printing shall be clear. Date shall be in the format: Year.Month.Day [YYYY.MM.DD].



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