

XL Fu Qing China	Product Specification Sheet	Format No. : QC/F/8.6/30
		Rev. No. : 01
		Rev Date : 05.04.2021
		Page No. : 01 of 01

PRODUCT DESCRIPTION	DN 20 GREY uPVC SOLAR UV ELECTRICAL RIGID HD CONDUIT AS/NZS 61386.21, SCJ X 4.0M + SOE
---------------------	--

PRODUCT CODE	ER PVC -
--------------	-----------------

EXTRUDER	PRODUCTION LINE 1- SJ45
----------	--------------------------------

FORMULATION CODE	
------------------	--

PRODUCT DIMENSIONS		PROCESSING PARAMETERS	
--------------------	--	-----------------------	--

	MIN (mm)	MAX (mm)		
PIPE WALL THICKNESS	1.6	1.8	Barrel Zone- 1 (°C)	195
OVALITY	--		Barrel Zone- 2 (°C)	185
PIPE OUTER DIAMETER	19.7	20.0	Barrel Zone- 3 (°C)	178
EFFECTIVE PIPE LENGTH	4.000 M		Barrel Zone- 4 (°C)	150
PIPE LENGTH INCLUDING SOCKET	4.025 M		Barrel Zone- 5 (°C)	..
SOCKET MOUTH DIAMETER	20.1	20.4	Adaptor (°C)	..
SOCKET ROOT DIAMETER	19.4	19.7	Die Zone- 1 (°C)	185
SOCKET LENGTH	25.0	30.0	Die Zone- 2 (°C)	185
SOCKET DEPTH	--		Die Zone- 3 (°C)	195
END SQUARENESS	--		Die Zone- 4 (°C)	..

RRJ SOCKET PROFILE			
---------------------------	--	--	--

D2 = --	D5 = --	e = --	Master pot	900
D3 = --		M = --	Main Drive Pot	850
D4 = --		u = --	Main Drive RPM	52
			Feeder Pot	500
			Feeder RPM	..

WALL THICKENING	-- mm min.		Haul-off pot	550
WITNESS MARK	--			
CHAMFER LENGTH	--	--		

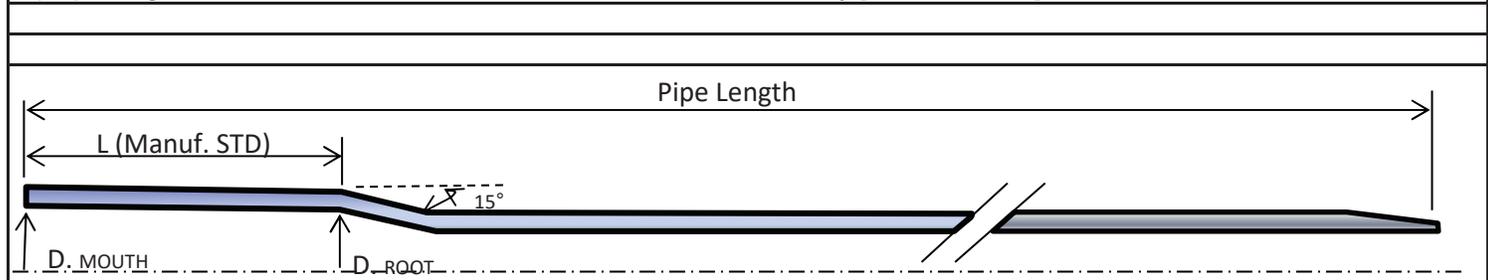
MATERIAL		BELLING SET-UP	
----------	--	----------------	--

PIPE COLOUR	UPVC	Pipe Size	20
TIMBER SIZE [TOP X SIDE]	GREY	Oven Temperature	300
QUANTITY PER PACKET		Belling Time	2.2 X 10 SEC
STD. PIPE WEIGHT (KG)	0.63	Heating Time	2.0 X 10 SEC
STD. PACK WEIGHT (KG)	0.63	Haul-off time	0.3 SEC
MINIMUM PRINT HEIGHT	2 MM	Belling Carriage	103
REPEAT PRINTING	1.0 M to 3.0 M	Stroke Control	
MINIMUM MEAN INTERNAL DIAMETER	--		

PRINT/ MARKING INFORMATION	
-----------------------------------	--

**ER PVC SOLAR 20MM 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].



Issued By:	Checked By:	Date:
------------	-------------	-------