PRODUCT DESCRIPTION	DN 40 ORANGE uPVC 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)	Barrel Zone- 1 (°C)	195
PIPE WALL THICKNESS	2.4	2.7	Barrel Zone- 2 (°C)	185
OVALITY	--		Barrel Zone- 3 (°C)	178
PIPE OUTER DIAMETER	49.7	50.0	Barrel Zone- 4 (°C)	150
EFFECTIVE PIPE LENGTH	4.000 M		Barrel Zone- 5 (°C)	..
PIPE LENGTH INCLUDING SOCKET		4.025 M	Adaptor (°C)	..
SOCKET MOUTH DIAMETER	40.1	40.4	Die Zone- 1 (°C)	185
SOCKET ROOT DIAMETER	39.4	39.7	Die Zone- 2 (°C)	185
SOCKET LENGTH	40.0	45.0	Die Zone- 3 (°C)	195
SOCKET DEPTH	--		Die Zone- 4 (°C)	..
END SQUARENESS	--		Die Zone- 5 (°C)	..
RRJ SOCKET PROFILE			Master pot	900
D2 = --	D5 = --	e = --	Main Drive Pot	850
D3 = --		M = --	Main Drive RPM	52
D4 = --		u = --	Feeder Pot	500
			Feeder RPM	..
WALL THICKENING	-- mm min.		Haul-off pot	550
WITNESS MARK	--			
CHAMFER LENGTH	--	--		
MATERIAL	UPVC		BELLING SET-UP	
PIPE COLOUR	ORANGE		Pipe Size	20
TIMBER SIZE [TOP X SIDE]			Oven Tempearture	300
QUANTITY PER PACKET			Belling Time	2.2 X 10 SEC
STD. PIPE WEIGHT (KG)	2.48		Heating Time	2.0 X 10 SEC
STD. PACK WEIGHT (KG)	2.48		Haul-off time	0.3 SEC
MINIMUM PRINT HEIGHT	3 MM		Belling Carriage Stroke Control	103
REPEAT PRINTING	1.0 M to 3.0 M			
MINIMUM MEAN INTERNAL DIAMETER	--			

PRINT/ MARKING INFORMATION
ER PVC 40MM PVC-U ORG. ELECTRICAL HD 5/60 COND. AS/NZS 61386.21 CMI LIC No. PC 10069 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].

Pipe Length

L (Manuf. STD)

15°

D. MOUTH   D. ROOT
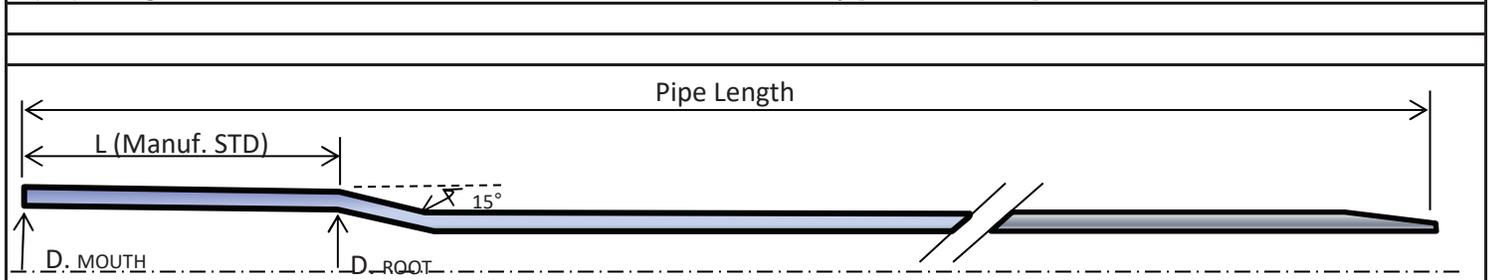
Issued By:	Checked By:	Date: