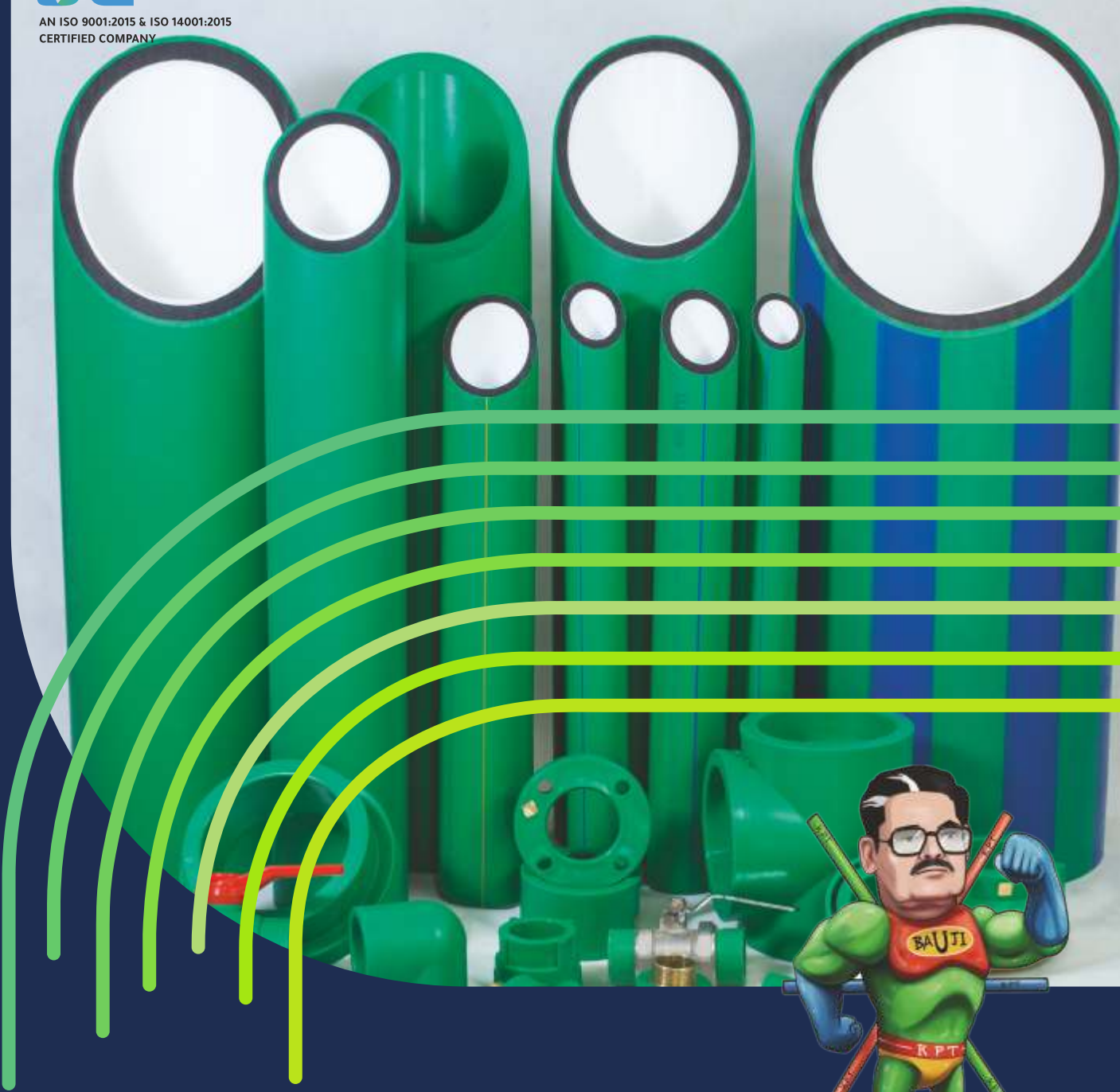




AN ISO 9001:2015 & ISO 14001:2015
CERTIFIED COMPANY



green therm™

PPR-C Pipes and Fittings

**An Eco-Friendly & 100% Food Grade
PPR-Piping System with the best in class
applications for Residential, Industrial &
Commercial segment for HOT & COLD
water applications**

Leaders in India to have PPR-C range from 16 mm to 400 mm



Technical Information Polypropylene Random Copolymer

Why choose this type of material?

The thermoplastic resins most often used to make pipes for water and heating systems are:

- PE-X cross linked polyethylene
- PP-C copolymer polypropylene
- PB polibutene

All the above - mentioned resins belong to the polyolephine family, a group of plastic materials obtained by polymerization of unsaturated hydrocarbons, which have one or more double links.

In a conventional polymer the molecular chains are irregularly placed; they have fairly good mobility, heat causes oscillation in these chains until they break, resulting in alteration of the material's characteristics. Two ways of preventing this problem have been tested.

Researchers have selected polymers with long molecular chains because, as molecular weight increases, the mechanical characteristics of manufactured items improve; these chains must be as linear as possible, i.e. they must show a low number of ramifications and a high degree of crystallization by extrusion these chains are submitted to stretch, allowing crystallization of a further percentage.

Isotactic polymers show much better mechanical characteristics as compared to their correspondent amorphous polymers; they maintain their properties up to temperatures close to melting point. This describes the nature of polypropylene techno-polymers in a simple way.

The other way tested by researchers is creation of chemical links among molecular chains in order to make them much steadier and avoid their sliding. This procedure has been adopted for the cross linking of polyethylene- PE- X.

There is a very big production of PP copolymers it is therefore important that fitness of raw material used be proven; it must be suitable to bear the thermo mechanical stresses required of it in operation for a long time (50 years).

Thus it is guaranteed that goods manufactured have high mechanical properties; it has been stabilized with appropriate anti-oxidants to postpone the combined effects of pressure and temperature for a very long time.

PROPERTY OF RAW MATERIAL

KPT- PPR Plumbing Pipe system is made from Basel & Hyosung materials which are considered as one of the best PPR-C material all over the world, a Random Copolymer Polypropylene (PPR-C) approved for the production of pipes and fittings according to DIN 8078 & DIN 16962 standards. Hyosung PPR Raw material is a thermoplastic resin which is transformed in to the finished product by a rise in temperature, which plasticises the material, allowing the pipe to be produced by means of EXTRUSION, and the fittings by MOULDING. The raw material is supplied in granules precolored. Special heat resistance is one of the features of this material, Its physical and chemical properties are well suited to the transfer of potable water and in the heating sector. Depending on pressure it is possible to use KPT - pipes for constant temperatures up to 70°C with service life of more than 50 years. Peak temperatures of 100°C arising from short disruptions are not creating any problems.

Advantages of KPT PPR-C Piping System

KPT pipes and fittings are made from polypropylene random copolymer specially developed for this use. Its characteristic make it suitable for both Industrial and Commercial applications with outstanding reliability over time.

One special feature of the KPT PPR-C pipe system is the assembly technique, in which the parts to be connected are welded by melting and fusion. After fusion welding, the pipe and fittings form a single continuous body with none of the problems, which may derive from potential leakage points. This makes the joints as PERMANENT. No sealants or adhesives are required for these permanent connections.

Special Features of KPT PPR-C Piping System

Anti Corrosive & Chemical Resistant - Chemically inert and highly resistant to wide range of acid bases. Suitable for highly corrosive areas and industrial cooling water, drinking water system.

Withstanding High Pressure - Pipes and fittings can withstand up to 20 kg/sqcm pressure. Suitable for high pressure application like Compressed Air Lines.

Low Pressure Drop - Because of the very smooth non porous inner surface of pipes and fittings the pressure loss is less than metallic pipes, which results saving of pumping energy considerably.

Withstanding Higher Temperature - Can withstand upto 95°C. Best pipe for heated water transport in solar applications.

Hygienic & Harmlessness - KPT PPR-C pipes are certified as food grade pipes as per DIN 1998 T2. Best piping system for drinking water, RO plants and DM Plants.

Low Thermal Conductivity - The material's high level of thermal insulation guarantees low heat loss on the part of fluid transport. (0.24 W/mK)

Low Noise - Having high sound insulation value, results in lower noise level at the time of high velocity flow.

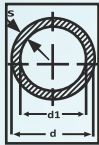
Non Toxic - Recyclable - Unlike PVC pipes, KPT PPR-C pipes are non toxic at the time of fire. PPR-C is recyclable material.

High Impact Rate - KPT PPR-C pipes are having high impact strength compare to any plastic pipe.

Low Flammability - KPT PPR-C pipes and fittings comply with fire classification B2 (normal inflammable). In case of fire no toxic emission to atmosphere like PVC pipes.

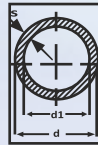
Resistant to stray electrical current - Thanks to high electrical insulating properties, KPT PPR-C pipe system is unaffected by stray currents

Like SS Pipe - The characters of KPT PPR-C piping system is almost like SS. KPT PPR-C pipes will have more advantage than SS for the specific application requirements.



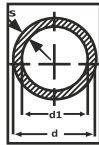
**KPT PPR-C Pipe
SDR 11/ S 5/ PN 10**

Pipe		Diameter	Wall Thickness	Internal Diameter	Water Content
Dimension	Packing Unit	d(mm)	S(mm)	di(mm)	litre/mtr
20mm	240m	20	1.9	16.2	0.206
25mm	180m	25	2.3	20.4	0.327
32mm	120m	32	2.9	26.2	0.539
40mm	75m	40	3.7	32.6	0.834
50mm	45m	50	4.6	40.8	1.307
63mm	30m	63	5.8	51.4	2.074
75mm	21m	75	6.8	61.4	2.959
90mm	15m	90	8.2	73.6	4.252
110mm	12m	110	10.0	90.0	6.359
125mm	9m	125	11.4	102.2	8.199
160mm	6m	160	14.6	130.8	13.430
200mm	3m	200	18.2	163.6	21.010
250mm	3m	250	22.7	204.6	32.861
315mm	3m	315	28.6	257.8	52.172
355mm	3m	355	32.2	290.6	66.292
400mm	3m	400	36.3	327.4	84.145



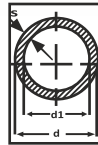
**KPT PPR-C Pipe
SDR 7.4/ S 3.2/ PN 16**

Pipe		Diameter	Wall Thickness	Internal Diameter	Water Content
Dimension	Packing Unit	d(mm)	S(mm)	di(mm)	litre/mtr
16mm	300m	16	2.2	11.6	0.106
20mm	240m	20	2.8	14.4	0.163
25mm	180m	25	3.5	18.0	0.254
32mm	120m	32	4.4	23.2	0.423
40mm	75m	40	5.5	29.0	0.660
50mm	45m	50	6.9	36.2	1.029
63mm	30m	63	8.6	45.8	1.647
75mm	21m	75	10.3	54.4	2.323
90mm	15m	90	12.3	65.4	3.358
110mm	9m	110	15.1	79.8	4.999
125mm	9m	125	17.1	90.8	6.472
160mm	6m	160	21.9	116.2	10.599
200mm	3m	200	27.4	145.2	16.550
250mm	3m	250	34.2	181.6	25.888
315mm	3m	315	43.4	228.2	40.879
355mm	3m	355	49.0	257	51.848



**KPT PPR-C Pipe
SDR 6/ S 2.5/ PN 20**

Pipe		Diameter	Wall Thickness	Internal Diameter	Water Content
Dimension	Packing Unit	d(mm)	S(mm)	di(mm)	litre/mtr
16mm	240m	16	2.7	10.6	0.088
20mm	210m	20	3.4	13.2	0.137
25mm	150m	25	4.2	16.6	0.216
32mm	105m	32	5.4	21.2	0.353
40mm	60m	40	6.7	26.6	0.555
50mm	36m	50	8.3	33.4	0.876
63mm	24m	63	10.5	42.0	1.385
75mm	21m	75	12.5	50.0	1.963
90mm	12m	90	15.0	60.0	2.826
110mm	9m	110	18.3	73.4	4.229
125mm	6m	125	20.8	83.4	5.460
160mm	3m	160	26.6	106.8	8.954



**KPT PPR-C Pipe
SDR 17.6/ S 8.3 /PN 6**

Pipe		Diameter	Wall Thickness	Internal Diameter	Water Content
Dimension	Packing Unit	d(mm)	S(mm)	di(mm)	litre/mtr
63mm	30m	63	3.6	55.8	2.444
75mm	21m	75	4.3	66.4	3.461
90mm	15m	90	5.1	79.8	4.999
110mm	12m	110	6.3	97.4	7.447
125mm	9m	125	7.1	110.8	9.637
160mm	6m	160	9.1	141.8	15.784
200mm	3m	200	11.4	177.2	24.649
250mm	3m	250	14.2	221.6	38.549
315mm	3m	315	17.9	279.2	61.193
355mm	3m	355	20.1	314.8	77.793
400mm	3m	400	22.7	354.6	98.707

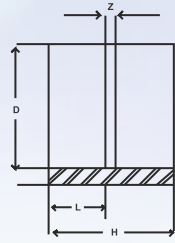
PERMISSIBLE WORKING PRESSURE

The below table list is the allowable working pressure for pipes with different pressure class under specific temperature and work life. Under normal work pressure and conditions, the life of KPT PPR Piping system is guaranteed to be 50 years at least.

Temperature in C	Years of Service	Allowable working pressure, in bar for				Temperature in C	Years of Service	Allowable working pressure, in bar for			
		PN-6 (SDR 17.6)	PN-10 (SDR 11)	PN-16 (SDR 7.4)	PN-20 (SDR 6)			PN-6 (SDR 17.6)	PN-10 (SDR 11)	PN-16 (SDR 7.4)	PN-20 (SDR 6)
10°C	1	10.6	17.6	27.8	35.0	50°C	1	5.5	9.1	14.4	18.2
	5	10.0	16.6	26.4	33.2		5	5.1	8.5	13.5	17.0
	10	9.7	16.1	25.5	32.1		10	5.0	8.2	13.1	16.5
	25	9.4	15.6	24.7	31.1		25	4.8	8.0	12.6	15.9
	50	9.1	15.2	24.0	30.3		50	4.6	7.7	12.2	15.4
	100	8.9	14.8	23.4	29.5		100	4.5	7.4	11.8	14.9
20°C	1	9.0	15.0	23.8	30.0	60°C	1	4.6	7.6	12.1	15.5
	5	8.5	14.1	22.3	28.1		5	4.3	7.2	11.4	14.3
	10	8.2	13.7	21.7	27.3		10	4.2	6.9	11.0	13.8
	25	8.0	13.3	21.1	26.5		25	4.0	6.7	10.5	13.3
	50	7.8	12.9	20.4	25.7		50	3.8	6.4	10.1	12.7
	100	7.5	12.5	19.8	24.9		70°C	1	3.9	6.5	10.3
30°C	1	7.7	12.8	20.2	25.5	5		3.6	6.0	9.5	11.9
	5	7.2	12.0	19.0	23.9	10		3.5	5.9	9.3	11.7
	10	7.0	11.6	18.3	23.1	25		3.0	5.1	8.0	10.1
	25	6.7	11.2	17.7	22.3	50		2.6	4.3	6.7	8.5
	50	6.6	10.9	17.3	21.8	80°C		1	3.3	5.5	8.6
	100	6.4	10.6	16.9	21.2		5	2.9	4.8	7.6	9.6
40°C	1	6.5	10.8	17.1	21.5		10	2.4	4.0	6.3	8.0
	5	6.1	10.1	16.0	20.2		25	1.9	3.2	5.1	6.4
	10	5.9	9.8	15.6	19.6		1	2.3	3.9	6.1	7.7
	25	5.7	9.4	15.0	18.8		5	1.5	2.5	4.0	5.0
	50	5.5	9.2	14.5	18.3	(10) ¹	(1.3) ¹	(2.1) ¹	(3.4) ¹	(4.2) ¹	
	100	5.4	8.9	14.1	17.8						

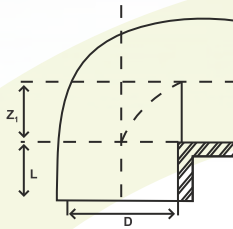
KPT PPR C Fittings

COUPLING



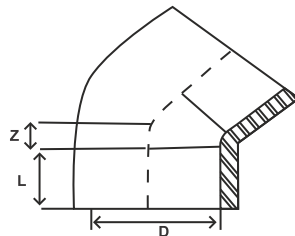
CODE	SIZE	D	L	Z	H
KPT C-0001	16MM	15.4	16	1.6	33.6
KPT C-0002	20 MM	19.2	14.5	3.9	32.9
KPT C-0003	25 MM	24.1	18.0	2.6	38.6
KPT C-0004	32 MM	31.0	18.4	3.0	39.8
KPT C-0005	40 MM	38.9	20.7	3.4	44.8
KPT C-0006	50 MM	48.0	24.4	3.1	51.9
KPT C-0007	63 MM	60.7	28.2	8.2	64.6
KPT C-0008	75 MM	71.9	31.5	4.0	67.0
KPT C-0009	90 MM	86.4	32.5	6.1	71.1
KPT C-0010	110 MM	106.8	38.8	3.0	80.6
KPT C-0011	125 MM	122.0	44.0	8.7	96.7
KPT C-0012	160 MM	153.0	42.5	5.4	90.4

ELBOW 90°



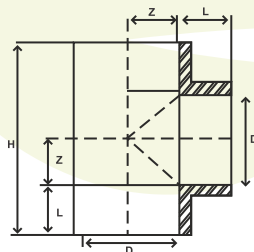
CODE	SIZE	D	L	Z	H
KPT E90-0013	16MM	15.5	14.4	8.5	34.3
KPT E90-0014	20 MM	19.1	15.5	10.9	40.0
KPT E90-0015	25 MM	24.2	16.9	14.1	47.4
KPT E90-0016	32 MM	31.1	18.0	16.4	54.2
KPT E90-0017	40 MM	39.5	20.0	20.0	66.2
KPT E90-0018	50 MM	48.4	23.8	26.2	80.3
KPT E90-0019	63 MM	60.5	27.4	32.2	98.2
KPT E90-0020	75 MM	72.6	31.5	38.0	115.4
KPT E90-0021	90 MM	86.8	33.0	44.7	130.6
KPT E90-0022	110 MM	106.5	39.0	54.8	160.6
KPT E90-0023	125MM	123.6	43.0	71.0	150.0
KPT E90-0024	160 MM	153.6	45.0	78.7	220.8
KPT E90-0025	200MM
KPT E90-0026	250MM
KPT E90-0027	315MM
KPT E90-0028	355MM
KPT E90-0029	400MM

ELBOW 45°



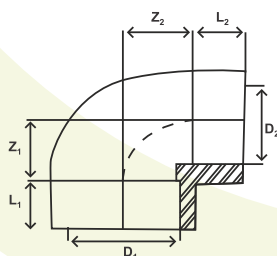
CODE	SIZE	D	L	Z
KPT E45-0030	20 MM	19.3	15.5	6.0
KPT E45-0031	25 MM	23.7	17.6	7.0
KPT E45-0032	32 MM	30.6	16.5	8.0
KPT E45-0033	40 MM	38.2	21.3	9.0
KPT E45-0034	50 MM	47.7	22.5	12.0
KPT E45-0035	63 MM	60.0	26.0	13.0
KPT E45-0036	75 MM	72.5	26.7	20.0
KPT E45-0037	90 MM	86.8	34.5	32.0
KPT E45-0038	110 MM	106.2	35.3	40.0
KPT E45-0039	125 MM
KPT E45-0040	160 MM	154.9	48.2	50.0
KPT E45-0041	200 MM
KPT E45-0042	250 MM
KPT E45-0043	315 MM
KPT E45-0044	355 MM
KPT E45-0045	400 MM

EQUAL TEE



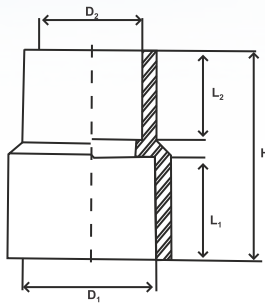
CODE	SIZE	D	L	Z	H
KPT ET-0046	16MM	15.3	14.6	8.9	46.9
KPT ET-0047	20 MM	19.3	15.8	10.5	52.6
KPT ET-0048	25 MM	24.2	18.0	12.7	61.4
KPT ET-0049	32 MM	31.4	20.2	16.1	72.5
KPT ET-0050	40 MM	39.0	20.3	20.9	82.4
KPT ET-0051	50 MM	48.6	24.4	24.5	97.8
KPT ET-0052	63 MM	61.7	27.4	32.6	120.0
KPT ET-0053	75 MM	72.2	31.3	36.7	136.0
KPT ET-0054	90 MM	86.9	32.9	47.1	160.0
KPT ET-0055	110 MM	106.7	38.8	55.3	188.2
KPT ET-0056	125 MM	122.2	42.2	101.3	287.0
KPT ET-0057	160 MM	153.7	45.0	85.0	260.0
KPT ET-0058	200MM
KPT ET-0059	250MM
KPT ET-0060	315MM
KPT ET-0061	355MM
KPT ET-0062	400MM

REDUCING ELBOW



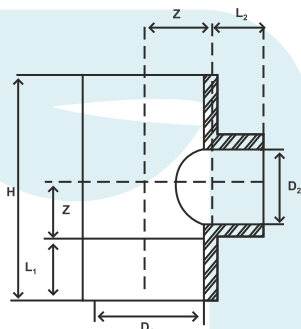
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KPT RE-0403	25/20	24.0	19.2	18.5	16.0	17.8	14.4
KPT RE-0404	32/20	31.3	19.2	21.1	16.0	18.3	18.0
KPT RE-0405	32/25	31.3	24.2	20.0	17.8	22.2	20.7
KPT RE-0406	40/20	38.7	19.2	21.6	16.3	19.6	24.2
KPT RE-0407	40/25	38.7	24.2	21.6	17.8	21.4	20.7
KPT RE-0408	40/32	38.6	31.2	21.9	19.8	24.2	25.3

REDUCER



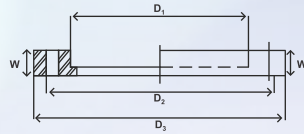
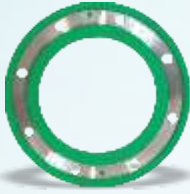
CODE	SIZE	D1	D2	L1	L2	H
KPT R-0063	25/20	24.0	19.2	18.5	15.7	38.1
KPT R-0064	32/20	31.3	19.2	20.0	15.7	39.3
KPT R-0065	32/25	31.4	24.4	21.0	18.4	41.7
KPT R-0066	40/20	38.7	19.3	22.9	16.9	48.0
KPT R-0067	40/25	39.0	24.2	24.2	18.0	48.5
KPT R-0068	40/32	38.6	31.0	21.1	18.8	44.9
KPT R-0069	50/20	48.0	18.8	24.6	16.6	44.5
KPT R-0070	50/25	48.0	23.8	24.5	16.2	45.6
KPT R-0071	50/32	48.0	31.1	24.4	18.0	48.1
KPT R-0072	50/40	48.2	38.8	24.3	20.9	48.2
KPT R-0073	63/20	60.9	19.2	28.2	15.9	48.3
KPT R-0074	63/25	60.7	24.1	28.2	18.0	49.5
KPT R-0075	63/32	60.6	30.7	28.0	18.0	48.0
KPT R-0076	63/40	60.8	38.3	25.3	25.5	56.8
KPT R-0077	63/50	60.9	48.2	29.2	25.8	64.8
KPT R-0078	75/20	72.5	19.0	42.7	21.1	63.8
KPT R-0079	75/25	72.5	24.3	42.7	21.1	63.8
KPT R-0080	75/32	72.5	31.0	42.7	21.1	63.8
KPT R-0081	75/40	72.2	38.7	31.6	22.5	63.6
KPT R-0082	75/50	72.1	48.4	31.7	27.0	63.2
KPT R-0083	75/63	71.8	60.9	31.4	30.0	67.0
KPT R-0084	90/20	87.3	19.0	43.5	27.0	70.5
KPT R-0085	90/25	87.3	24.1	43.5	27.0	70.5
KPT R-0086	90/32	87.3	31.0	42.5	27.0	70.5
KPT R-0087	90/40	87.3	38.9	42.5	27.0	70.5
KPT R-0088	90/50	86.5	48.1	33.0	26.3	70.0
KPT R-0089	90/63	86.6	60.9	32.8	29.9	68.8
KPT R-0090	90/75	86.7	72.7	37.2	31.5	71.7
KPT R-0091	110/20	106.8	19.0	58.1	19.5	76.0
KPT R-0092	110/25	106.8	24.0	53.3	19.2	76.0
KPT R-0093	110/32	106.8	31.0	57.6	19.5	76.0
KPT R-0094	110/40	106.8	39.0	56.6	19.3	76.0
KPT R-0095	110/50	106.8	48.4	38.9	26.0	76.0
KPT R-0096	110/63	106.8	61.2	38.9	30.1	76.0
KPT R-0097	110/75	106.8	72.6	38.9	31.8	76.0
KPT R-0098	110/90	106.8	86.6	38.9	33.0	76.0
KPT R-0099	125/110	122.2	104.3	43.0	40.0	96.0
KPT R-0100	160/20	155.3	18.9	61.8	29.5	91.2
KPT R-0101	160/25	155.3	23.9	61.8	29.5	91.2
KPT R-0102	160/32	155.3	30.6	61.8	29.5	91.2
KPT R-0103	160/40	155.3	38.7	61.8	29.5	91.2
KPT R-0104	160/50	155.3	48.5	61.8	29.5	91.2
KPT R-0105	160/63	155.3	61.8	61.8	29.5	91.2
KPT R-0106	160/75	155.3	73.5	61.8	29.5	91.2
KPT R-0107	160/90	155.3	88.5	61.8	29.5	91.2
KPT R-0108	160/110	155.3	106.3	61.8	29.5	91.2
KPT R-0109	160/125	157.3	122.1	43.0	40.0	92.1

REDUCING TEE



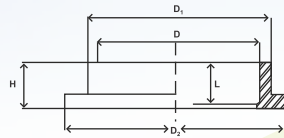
CODE	SIZE	D1	D2	L1	L2	Z	H
KPT RT-0110	25/20/25	24.2	19.1	17.6	16.2	10.8	56.8
KPT RT-0111	32/20/32	31.1	19.1	19.8	16.5	11.3	62.2
KPT RT-0112	32/25/32	31.4	24.2	20.0	17.8	13.4	66.8
KPT RT-0113	40/20/40	39.0	19.1	21.4	16.5	11.1	65.0
KPT RT-0114	40/25/40	38.8	24.2	21.4	17.6	13.5	69.8
KPT RT-0115	40/32/40	38.8	31.0	21.4	19.5	16.8	76.4
KPT RT-0116	50/25/50	48.4	19.1	24.4	18.1	24.5	97.7
KPT RT-0117	50/25/50	48.6	24.1	24.3	17.9	24.7	98.0
KPT RT-0118	50/32/50	48.6	30.5	24.3	18.8	24.6	97.8
KPT RT-0119	50/40/50	48.6	38.7	22.4	22.0	26.1	96.9
KPT RT-0120	63/20/63	61.2	19.0	27.5	16.2	32.2	119.4
KPT RT-0121	63/25/63	61.3	23.8	27.5	19.4	32.2	119.4
KPT RT-0122	63/32/63	61.3	30.8	27.5	19.3	32.2	119.4
KPT RT-0123	63/40/63	61.3	38.9	27.3	22.5	32.4	119.4
KPT RT-0124	63/50/63	61.2	48.0	27.4	25.8	32.3	119.4
KPT RT-0125	75/20/75	72.5	19.0	31.4	15.9	26.4	115.5
KPT RT-0126	75/25/75	72.5	24.0	31.4	17.6	26.4	115.5
KPT RT-0127	75/32/75	72.5	30.9	31.4	19.7	26.4	115.5
KPT RT-0128	75/40/75	72.3	38.4	31.4	20.3	26.4	115.5
KPT RT-0129	75/50/75	72.3	47.9	31.4	29.8	26.4	115.5
KPT RT-0130	75/63/75	72.2	60.2	31.4	29.8	26.4	115.5
KPT RT-0131	90/20/90	86.5	19.0	32.8	15.6	31.3	128.1
KPT RT-0132	90/25/90	86.5	24.0	32.8	17.6	31.3	128.1
KPT RT-0133	90/32/90	86.5	31.0	32.8	19.5	31.3	128.1
KPT RT-0134	90/40/90	86.5	38.6	32.8	21.2	31.3	128.1
KPT RT-0135	90/50/90	86.5	48.1	32.8	26.0	31.3	128.1
KPT RT-0136	90/63/90	86.5	61.2	32.8	30.1	31.3	128.1
KPT RT-0137	90/75/90	86.5	72.4	32.9	31.7	46.9	159.5
KPT RT-0138	110/20/110	106.5	19.0	38.7	15.8	38.5	154.3
KPT RT-0139	110/25/110	106.5	24.2	38.7	17.7	38.5	154.3
KPT RT-0140	110/32/110	106.5	31.0	38.7	19.7	38.5	154.3
KPT RT-0141	110/40/110	106.5	38.9	38.7	21.5	38.5	154.3
KPT RT-0142	110/50/110	106.5	48.6	38.9	26.2	38.3	154.3
KPT RT-0143	110/63/110	106.7	61.3	39.0	30.2	38.2	154.3
KPT RT-0144	110/75/110	106.4	72.5	39.0	32.0	38.2	154.3
KPT RT-0145	110/90/110	106.7	87.1	38.9	33.0	54.8	187.4
KPT RT-0146	125/110/125	122.5	107.5	44.0	44.0	64.0	216.0
KPT RT-0147	160/20/160	155.4	19.0	45.0	15.8	80.9	251.8
KPT RT-0148	160/25/160	155.4	23.8	45.0	18.5	80.9	251.8
KPT RT-0149	160/32/160	155.4	31.0	45.0	19.5	80.9	251.8
KPT RT-0150	160/40/160	155.4	38.9	45.0	21.5	80.9	251.8
KPT RT-0151	160/50/160	155.4	48.8	45.0	25.4	80.9	251.8
KPT RT-0152	160/63/160	157.5	61.9	45.0	27.6	80.9	251.8
KPT RT-0153	160/75/160	157.5	73.9	45.0	32.1	80.9	251.8
KPT RT-0154	160/90/160	157.5	88.5	45.0	33.0	80.9	251.8
KPT RT-0155	160/110/160	157.5	107.4	45.0	44.9	80.9	251.8
KPT RT-0156	200/90/200
KPT RT-0157	200/110/200
KPT RT-0158	200/125/200
KPT RT-0159	200/160/200
KPT RT-0160	250/90/250
KPT RT-0161	250/110/250
KPT RT-0162	250/125/250
KPT RT-0163	250/160/250
KPT RT-0164	250/200/250
KPT RT-0165	315/160/315
KPT RT-0166	315/200/315

SLIP ON (PPR C STEEL INLAY FLANGE)



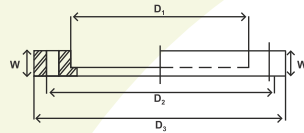
CODE	SIZE	PCD	MS Flange Wall thickness	(PPR +MS) Wall thickness	Flange OD.	Flange ID.	No. of Hole	Bolt Dia
KPT SIF-0216	20 MM	73.0	4.8	16.9	113.4	32.0	4	12.7
KPT SIF-0217	25 MM	82.6	4.8	17.0	126.2	37.1	4	12.7
KPT SIF-0218	32 MM	87.6	6.4	16.7	136.0	44.4	4	12.7
KPT SIF-0219	40 MM	98.4	6.4	17.8	149.7	51.2	4	12.7
KPT SIF-0220	50 MM	114.3	7.9	20.7	170.8	63.2	4	15.9
KPT SIF-0221	63 MM	127.0	7.9	20.7	183.5	82.6	4	15.9
KPT SIF-0222	75 MM	146.1	9.5	21.6	204.9	98.3	4	15.9
KPT SIF-0223	90 MM	165.1	9.5	23.6	222.7	114.8	4	15.9
KPT SIF-0224	110 MM	177.8	9.5	25.6	235.6	136.9	4	15.9
KPT SIF-0225	125 MM	209.6	12.7	28.5	273.7	160.1	8	15.9
KPT SIF-0226	160 MM	260.4	12.7	25.0	345.0	196.0	8	15.9
KPT SIF-0227	200 MM	292.1	12.7	26.0	366.0	218.0	8	15.9
KPT SIF-0228	250 MM	355.6	19.1	27.8	430.0	272.0	8	15.9
KPT SIF-0229	315 MM	406.4	19.1	30.0	492.0	320.0	12	19.1

FLANGE CORE(STUB END)



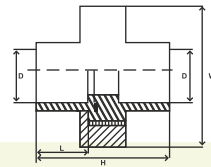
CODE	SIZE	D	D1	D2	L	H
KPT FC-0189	20 MM	19.2	29.9	44.6	20.7	24.2
KPT FC-0190	25 MM	24.1	33.9	49.7	20.0	24.0
KPT FC-0191	32 MM	31.1	42.9	50.5	19.9	23.3
KPT FC-0192	40 MM	31.1	49.6	60.2	20.3	25.8
KPT FC-0193	50 MM	48.1	62.6	72.3	22.2	27.2
KPT FC-0194	63 MM	61.0	80.7	95.0	20.9	35.4
KPT FC-0195	75 MM	72.6	95.0	111.3	31.9	39.0
KPT FC-0196	90 MM	87.1	111.8	129.4	24.2	42.1
KPT FC-0197	110 MM	106.8	133.3	151.0	25.4	43.3
KPT FC-0198	125 MM	123.8	157.6	179.8	43.4	68.0
KPT FC-0199	160 MM	155.0	194.4	214.0	31.0	52.8
KPT FC-0200	200MM	166.1	211.0	251.5	54.8	80.3
KPT FC-0201	250MM	213.8	261.4	312.0	80.5	84.4
KPT FC-0202	315MM	253.5	310.5	380.0	71.0	94.0
KPT FC-0203	355MM	300.0	355.0	427.0	63.8	119.0
KPT FC-0204	400MM	352.0	400.0	477.0	70.0	117.0

SLIP-ON (PPR FLANGES)



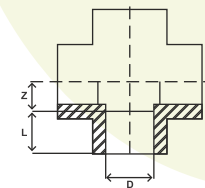
CODE	SIZE	D1	D2	D3	W
KPT F-0205	20 MM	31.5	67.6	112	17.7
KPT F-0206	25 MM	36.8	73.2	112	17.8
KPT F-0207	32 MM	43.6	97.0	115.7	20.6
KPT F-0208	40 MM	50.0	109.0	128.0	21.6
KPT F-0209	50 MM	62.5	122.0	140.7	22.5
KPT F-0210	63 MM	83.0	141.4	157.4	24.3
KPT F-0211	75 MM	97.0	175.3	172.3	26.2
KPT F-0212	90 MM	113.7	178.3	194.8	26.4
KPT F-0213	110 MM	135.7	197.9	216.0	30.6
KPT F-0214	125 MM	157.0	208.0	257.0	33.2
KPT F-0215	160 MM	195.8	266.0	292.0	35.5

PLAIN UNION



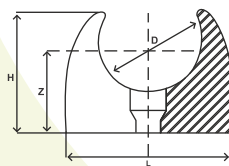
CODE	SIZE	D	L	W	H
KPT U-0230	20 MM	19.2	17.7	52.2	44.4
KPT U-0231	25 MM	24.2	18.6	51.4	55.2
KPT U-0232	32 MM	31.2	22.1	61.5	67.5
KPT U-0233	40 MM	39.2	29.2	79.0	79.9
KPT U-0234	50 MM	47.7	23.6	78.0	96.1
KPT U-0235	63 MM	60.7	27.7	89.0	107.6

4WAY/CROSS TEE



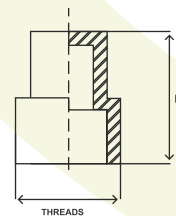
CODE	SIZE	D	L	Z
KPT CT-0236	20 MM	18.8	15.5	15.4
KPT CT-0237	25 MM	24.1	17.1	24.9
KPT CT-0238	32 MM	30.6	17.8	32.2
KPT CT-0239	40 MM	38.0	20.8	39.2
KPT CT-0240	50 MM	48.0	21.3	52.2
KPT CT-0241	63 MM	60.7	23.3	63.6

PIPE CLAMP



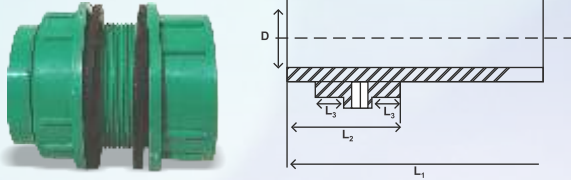
CODE	SIZE	D	L	Z	H
KPT PC-0242	16 MM	15.2	23.0	14.1	26.0
KPT PC-0243	20 MM	18.9	27.0	19.2	31.0
KPT PC-0244	25 MM	24.0	32.0	21.0	36.0
KPT PC-0245	32 MM	30.7	39.5	27.5	43.5
KPT PC-0246	40 MM	39.1	48.3	30.9	49.8
KPT PC-0247	50 MM	50.0	60.0	37.3	61.5
KPT PC-0248	63 MM	63.0	74.7	45.0	75.3

LONG PLUG



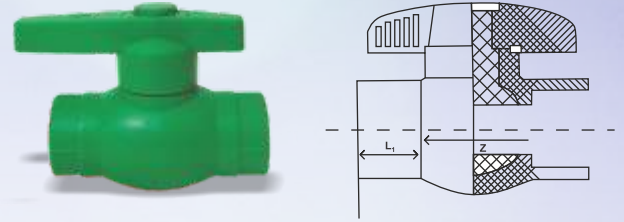
CODE	SIZE	THREADS	H
KPT LP-0249	1/2"	1/2"	69.7
KPT LP-0250	3/4"	3/4"	62.2
KPT LP-0251	1"	1"	73.6

TANK CONNECTOR



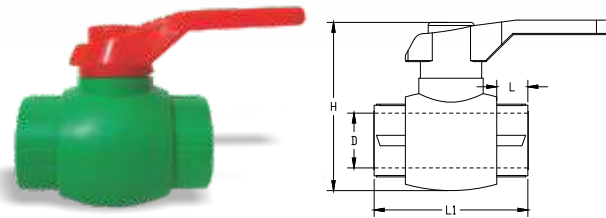
CODE	SIZE	D	L1	L2	L3
KPT TC-0252	20 MM	19.2	69.0	43.6	15.2
KPT TC-0253	25 MM	24.1	69.0	52.5	19.5
KPT TC-0254	32 MM	30.6	74.3	54.5	21.5
KPT TC-0255	40 MM	38.4	88.4	55.3	25.6
KPT TC-0256	50 MM	48.3	96.7	58.4	24.6
KPT TC-0257	63 MM	60.7	101.5	65.5	27.0

BALL VALVE PLASTIC (FOR COLD WATER)



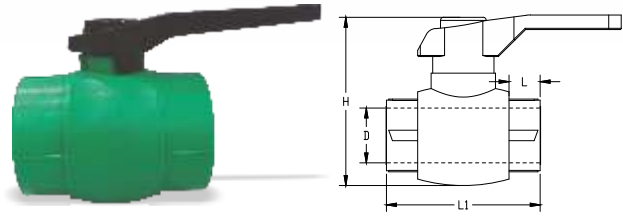
CODE	SIZE	D1	D2	L	Z	H
KPT PBV-0258	20 MM	19.10	19.35	16.15	41.35	64.25
KPT PBV-0259	25 MM	23.80	24.30	18.00	41.20	72.70
KPT PBV-0260	32 MM	30.85	31.20	19.90	46.90	82.65
KPT PBV-0261	40 MM	38.25	38.95	25.38	52.44	97.25

BALL VALVE PLASTIC (FOR COLD WATER)



CODE	SIZE	D	L1	L	H
KPT PBV-0262	50 MM	48.8	125.0	33.0	122.0
KPT PBV-0263	63 MM	62.1	147.0	38.0	138.0

BRASS BALL VALVE (FOR HOT WATER)



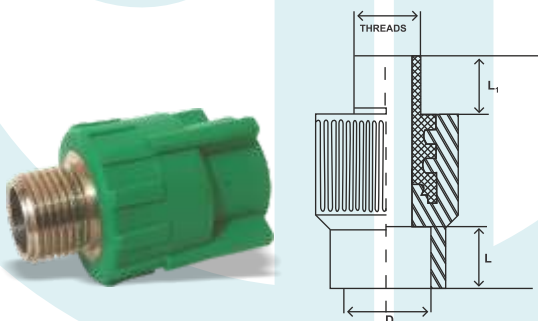
CODE	SIZE	D1	D2	L	Z	H
KPT BBV-0264	20 MM	18.90	19.35	20.90	26.50	70.55
KPT BBV-0265	25 MM	23.80	24.25	20.50	33.15	76.90
KPT BBV-0266	32 MM	30.80	31.10	24.00	37.65	86.70
KPT BBV-0267	40 MM	38.80	38.98	21.38	60.89	98.35
KPT BBV-0268	50 MM	48.90	49.10	22.80	68.20	122.25
KPT BBV-0269	63 MM	61.68	61.85	26.25	78.00	133.25

FLANGE END BALL VALVE



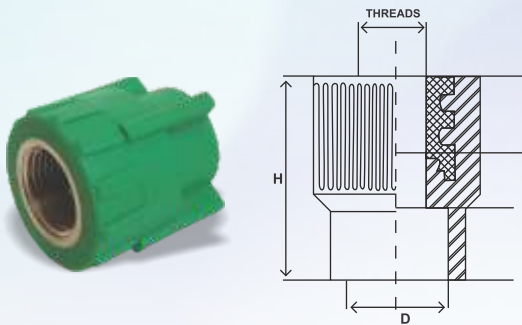
CODE	SIZE	Flange Ball Valve Bore ID. (mm)	Ball Valve Flange OD. (mm)	Flange Ball Valve No. of Hole	Ball Valve Flange Hole PCD. (mm)	Ball Valve Flange Hole Length/Width (mm)	Flange Ball Valve Height (mm)
KPT FEBV-0270	20 MM	18.5	100.0	4.0	71.0	16.5/15.0	142.8
KPT FEBV-0271	25 MM	24.1	122.0	4.0	84.8	18.8/13.8	158
KPT FEBV-0272	32 MM
KPT FEBV-0273	40 MM	37.55	138.00	4.00	101.56	22.10/15.90	101.55
KPT FEBV-0274	50 MM	49.67	167.40	4.00	116.05	24.60/17.80	116.10
KPT FEBV-0275	63 MM
KPT FEBV-0276	75MM	63.65	180.10	4.00	128.42	31.70/18.55	128.40
KPT FEBV-0277	90 MM	72.90	198.45	4.00	152.75	26.75/18.08	152.70
KPT FEBV-0278	110 MM	98.40	221.37	8.00	181.20	23.68/18.42	181.20

MALE THREADED COUPLING



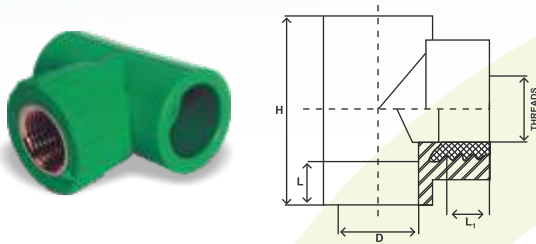
CODE	SIZE	THREADS	D	L	L1	H
KPT MTC-0279	16*1/2	1/2"	15.7	17.0	13.9	57.3
KPT MTC-0280	20*1/2	1/2"	19.2	16.2	14.2	57.0
KPT MTC-0281	25*1/2	1/2"	23.8	18.3	14.2	56.0
KPT MTC-0282	25*3/4	3/4"	24.1	18.2	14.1	59.1
KPT MTC-0283	32*1/2	1/2"	31.1	19.8	14.0	64.5
KPT MTC-0284	32*3/4	3/4"	31.1	20.3	14.2	67.8
KPT MTC-0285	32*1	1"	31.1	20.2	28.0	71.8
KPT MTC-0286	40*1	1"	38.7	21.6	28.0	76.0
KPT MTC-0287	40*1-1/4	1 1/4"	38.8	22.1	14.1	76.0
KPT MTC-0288	50*1-1/2	1 1/2"	48.9	25.5	21.3	80.0
KPT MTC-0289	63*2	2"	62.2	29.5	26.3	95.2
KPT MTC-0290	75*2-1/2	2 1/2"	72.0	32.4	24.9	100.5
KPT MTC-0291	90*3	3"	86.4	38.2	24.6	109.2
KPT MTC-0292	110*4	4"	104.9	38.1	25.5	119.0

FEMALE THREADED COUPLING



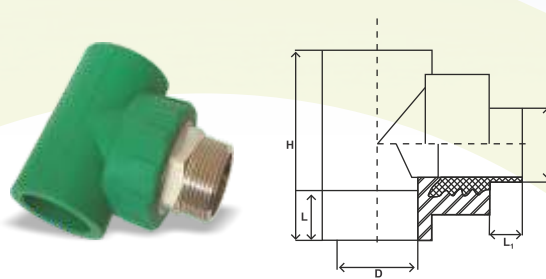
CODE	SIZE	THREADS	D	L	L1	H
KPT FTC-0293	16*1/2	1/2"	15.7	17.0	15.0	43.4
KPT FTC-0294	20*1/2	1/2"	19.2	16.0	15.0	43.2
KPT FTC-0295	20*3/4	3/4"	23.6	18.0	14.9	41.8
KPT FTC-0296	25*1/2	1/2"	23.6	18.0	14.9	41.8
KPT FTC-0297	25*3/4	3/4"	24.1	18.1	15.7	45.0
KPT FTC-0298	32*1/2	1/2"	31.1	20.0	15.0	50.5
KPT FTC-0299	32*3/4	3/4"	31.1	20.4	16.0	52.0
KPT FTC-0300	32*1	1"	31.1	20.2	17.8	54.7
KPT FTC-0301	40*1	1"	38.7	21.6	27.0	62
KPT FTC-0302	40*1-1/4	1 1/4"	38.8	22.1	18.0	62.0
KPT FTC-0303	50*1-1/2	1 1/2"	48.8	25.3	18.5	58.0
KPT FTC-0304	63*2	2"	61.5	28.6	25.6	68.1
KPT FTC-0305	75*2-1/2	2 1/2"	71.8	31.7	20.2	89.2
KPT FTC-0306	90*3	3"	86.5	38.0	21.9	101.5
KPT FTC-0307	110*4	4"	106.1	38.2	26.3	116.8

FEMALE THREADED TEE



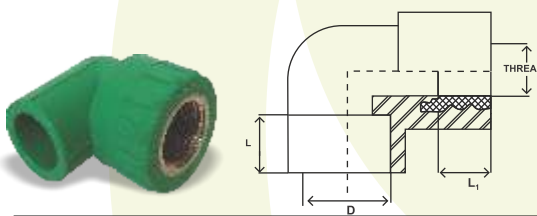
CODE	SIZE	THREADS	D	L	L1	H
KPT FTT-0308	20*1/2	1/2"	19.2	15.0	14.0	58.2
KPT FTT-0309	25*1/2	1/2"	24.2	14.9	14.0	62.2
KPT FTT-0310	25*3/4	3/4"	24.2	16.2	13.9	63.8
KPT FTT-0311	32*1/2	1/2"	31.3	15.0	14.2	78.0
KPT FTT-0312	32*3/4	3/4"	31.3	16.2	14.2	78.2
KPT FTT-0313	32*1	1"	31.2	17.7	15.8	77.8
KPT FTT-0314	40*1-1/4	1 1/4"	39.0	17.6	15.2	91.0

MALE THREADED TEE



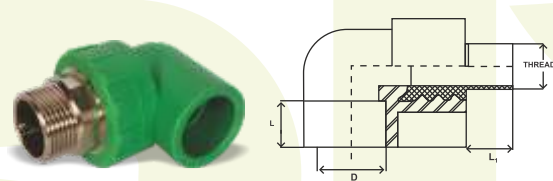
CODE	SIZE	THREADS	D	L	L1	H
KPT MTT-0315	20*1/2	1/2"	19.2	16.5	14.0	58.2
KPT MTT-0316	25*1/2	1/2"	24.2	18.2	14.0	62.2
KPT MTT-0317	25*3/4	3/4"	24.2	17.6	13.9	63.8
KPT MTT-0318	32*1/2	1/2"	31.3	20.0	14.2	78.0
KPT MTT-0319	32*3/4	3/4"	31.3	20.0	14.2	78.2
KPT MTT-0320	32*1	1"	31.2	20.0	15.8	77.8
KPT MTT-0321	40-1-1/4	1 1/4"	39.0	21.4	15.2	91.0

FEMALE THREADED ELBOW



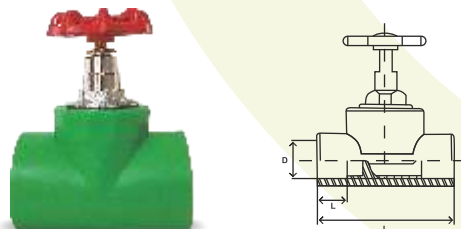
CODE	SIZE	THREADS	D	L	L1
KPT FTE-0322	20*1/2	1/2"	19.2	16.1	16.0
KPT FTE-0323	25*1/2	1/2"	24.1	17.9	15.0
KPT FTE-0324	25*3/4	3/4"	24.2	17.9	16.0
KPT FTE-0325	32*1/2	1/2"	31.2	20.2	15.0
KPT FTE-0326	32*3/4	3/4"	31.2	20.2	16.1
KPT FTE-0327	32*1	1"	31.2	20.3	18.3
KPT FTE-0328	40*1-1/4	1 1/4"	39.1	21.3	17.9

MALE THREADED ELBOW



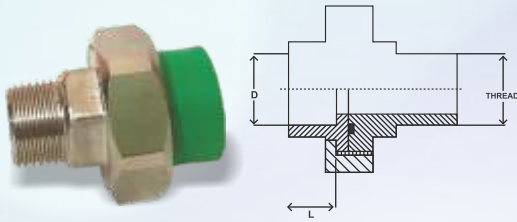
CODE	SIZE	THREADS	D	L	L1
KPT MTE-0329	20*1/2	1/2"	19.2	16.1	15.0
KPT MTE-0330	25*1/2	1/2"	24.1	17.9	15.0
KPT MTE-0331	25*3/4	3/4"	24.2	18.0	14.2
KPT MTE-0332	32*1/2	1/2"	31.3	21.0	14.3
KPT MTE-0333	32*3/4	3/4"	31.3	20.4	15.2
KPT MTE-0334	32*1	1"	31.3	20.1	27.0
KPT MTE-0335	40*1-1/4	1 1/4"	39.0	24.5	21.8

GATE VALVE



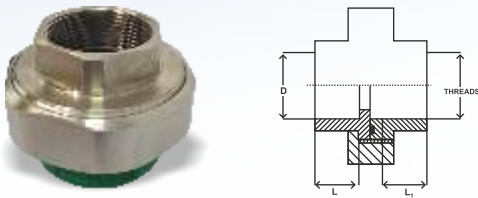
CODE	SIZE	D	L	L1
KPT GV-0336	20 MM	19.0	15.0	60.5
KPT GV-0337	25 MM	24.0	16.8	69.2
KPT GV-0338	32 MM	31.1	20.0	79.5
KPT GV-0339	40 MM	39.0	21.4	92.5
KPT GV-0340	50 MM	48.0	24.0	112.2
KPT GV-0341	63 MM	60.6	26.0	119.1
KPT GV-0342	75 MM	72.3	30.8	133.4
KPT GV-0343	90 MM	86.0	30.8	178.0
KPT GV-0344	110 MM	106.0	41.6	200.0

MALE THREADED UNION



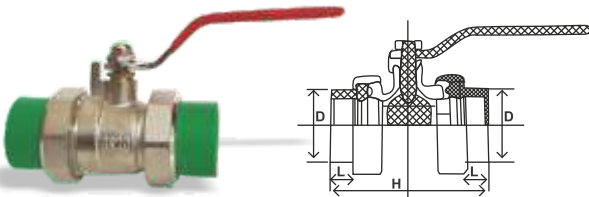
CODE	SIZE	THREADS	D	L
KPT MTU-0345	20*1/2	1/2"	19.2	17.8
KPT MTU-0346	25*3/4	3/4"	24.2	19.0
KPT MTU-0347	32*1	1"	31.3	23.5
KPT MTU-0348	40*1-1/4	1 1/4"	39.2	28.5
KPT MTU-0349	50*1-1/2	1 1/2"	47.6	24.6
KPT MTU-0350	63*2	2"	60.6	28.1

FEMALE THREADED UNION



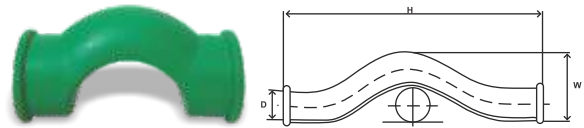
CODE	SIZE	THREADS	D	L	L1
KPT FTU-0351	20*1/2	1/2"	19.2	17.5	18.0
KPT FTU-0352	25*3/4	3/4"	24.2	19.0	18.5
KPT FTU-0353	32*1	1"	31.2	23.6	20.4
KPT FTU-0354	40*1-1/4	1 1/4"	39.2	28.4	23.0
KPT FTU-0355	50*1-1/2	1 1/2"	47.7	23.6	31.5
KPT FTU-0356	63*2	2"	60.6	28.4	28.7

DOUBLE UNION BALL VALVE



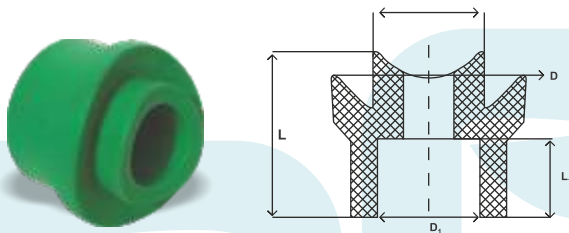
CODE	SIZE	D	L	H
KPT DUBV-0357	20 MM	18.7	16.3	84.1
KPT DUBV-0358	25 MM	23.8	17.4	95.7
KPT DUBV-0359	32 MM	30.8	21.8	107.3
KPT DUBV-0360	40 MM	38.9	25.2	125.3
KPT DUBV-0361	50 MM	48.7	27.3	147.0
KPT DUBV-0362	63 MM	61.4	29.0	168.5

BY PASS BEND



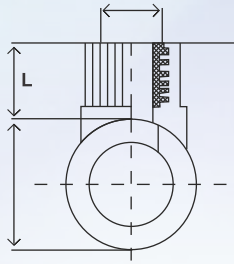
CODE	SIZE	D	W	H
KPT BPB-0363	20 MM	19.3	40	86
KPT BPB-0364	25 MM	23.9	47.0	94.9
KPT BPB-0365	32 MM	31.2	58.0	106.0
KPT BPB-0366	40 MM	37.9	80.0	133.0

WELD IN SADDLE REDUCER



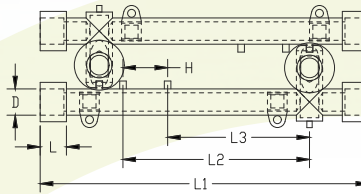
CODE	SIZE	D	D1	L	L1
KPT WIS R-0377	63/32	48.8	30.8	40.2	19.9
KPT WIS R-0378	75/32	48.8	30.8	40.2	19.9
KPT WIS R-0379	90/20	78.5	19.1	62.1	15.5
KPT WIS R-0380	90/25	78.5	24.2	62.1	17.5
KPT WIS R-0381	90/32	78.5	31.0	62.1	19.1
KPT WIS R-0382	90/40	79.2	38.9	62.1	21.4
KPT WIS R-0383	90/50	79.2	48.8	62.1	21.7
KPT WIS R-0384	90/63	79.2	62.7	62.1	27.5
KPT WIS R-0385	110/20	88.0	19.0	66.7	15.5
KPT WIS R-0386	110/25	88.0	24.0	66.7	17.3
KPT WIS R-0387	110/32	88.0	31.0	66.7	19.3
KPT WIS R-0388	110/40	88.0	39.1	66.7	21.5
KPT WIS R-0389	110/50	88.0	48.8	66.7	25.2
KPT WIS R-0390	110/63	88.0	62.4	66.7	27.4
KPT WIS R-0391	160/20	89.8	19.0	62.0	15.6
KPT WIS R-0392	160/25	89.8	23.9	62.0	17.3
KPT WIS R-0393	160/32	89.8	31.2	62.0	19.4
KPT WIS R-0394	160/40	89.8	38.8	62.0	21.3
KPT WIS R-0395	160/50	89.8	49.1	62.0	21.5
KPT WIS R-0396	160/63	89.8	62.5	62.0	27.3
KPT WIS R-0397	200/20	90.2	19.1	66.0	15.6
KPT WIS R-0398	200/25	90.2	24.1	66.0	17.7
KPT WIS R-0399	200/32	90.2	31.2	66.0	19.4
KPT WIS R-0400	200/40	90.2	39.0	66.0	21.4
KPT WIS R-0401	200/50	90.2	48.8	66.0	25.0
KPT WIS R-0402	200/63	90.2	62.5	66.0	27.3

**WELD IN SADDLE FEMALE
THREADED COUPLING**



CODE	SIZE	THREADS	L	L1	H
KPT WIS M-0367	160*1/2	1/2"	16.3	49.2	41.3
KPT WIS M-0368	110*1/2	1/2"	16.3	49.2	41.3
KPT WIS M-0369	90*1/2	1/2"	16.3	49.2	41.3
KPT WIS M-0370	75*1/2	1/2"	16.3	49.2	41.3
KPT WIS M-0371	63*1/2	1/2"	16.3	49.2	41.3
KPT WIS M-0372	160*3/4	3/4"	16.0	49.1	41.3
KPT WIS M-0373	110*3/4	3/4"	16.0	49.1	41.3
KPT WIS M-0374	90*3/4	3/4"	16.0	49.1	41.3
KPT WIS M-0375	75*3/4	3/4"	16.0	49.1	41.3
KPT WIS M-0376	63*3/4	3/4"	16.0	49.1	41.3

DOUBLE BATTERY TAP CONNECTOR

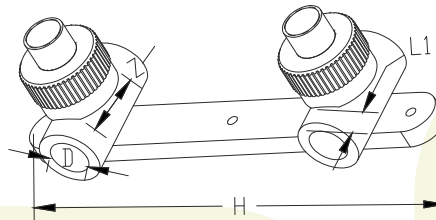


CODE	SIZE	THREADS	D	L	L1	L2	H
KPT DBTC F-0409	20*1/2	1/2"	19.1	17.3	248	101	30
KPT DBTC F-0410	25*1/2	1/2"	24.0	18.5	248	101	30

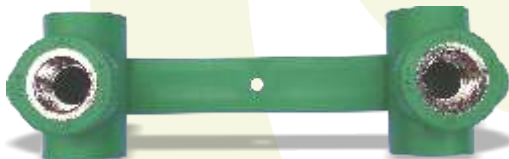
**DOUBLE MALE T HREADED TEE
WITH DISK**



CODE	SIZE	THREADS	D	L1	Z	H
KPT DMTWD -0411	20*1/2	1/2"	19.1	16.0	25.3	150
KPT DMTWD -0412	25*1/2	1/2"	24.0	18.0	25.2	150



**DOUBLE FEMALE T HREADED TEE
WITH DISK**



CODE	SIZE	THREADS	D	L1	Z	L
KPT DFTWD -0413	20*1/2	1/2"	19.1	16.0	25.3	150
KPT DFTWD -0414	25*1/2	1/2"	24.0	18.0	25.2	150



DOUBLE MALE ELBOW WITH DISK



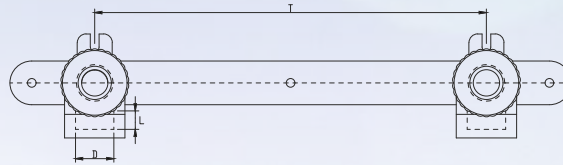
CODE	SIZE	THREADS	D	L	Z	T
KPT DMEWD -0415	20*1/2	1/2"	18.7	15.8	16.0	149.5
KPT DMEWD -0416	25*1/2	1/2"	24.0	17.6	16.2	149.5



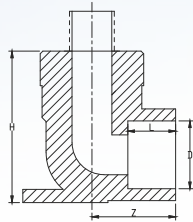
DOUBLE FEMALE ELBOW WITH DISK



CODE	SIZE	THREADS	D	L	Z	T
KPT DFEWD -0417	20*1/2	1/2"	18.7	15.8	16.0	149.5
KPT DFEWD -0418	25*1/2	1/2"	24.0	17.6	16.2	149.5

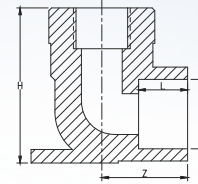


MALE THREADED ELBOW WITH DISK



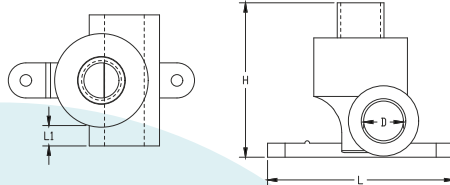
CODE	SIZE	THREADS	D	L	Z	H
KPT MTEWD -0419	20*1/2	1/2"	19.1	15.8	15.0	65
KPT MTEWD -0420	25*1/2	1/2"	24.0	17.6	16.2	70

FEMALE THREADED ELBOW WITH DISK



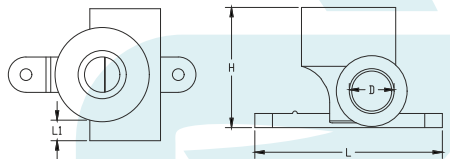
CODE	SIZE	THREADS	D	L	Z	H
KPT FTEWD -0421	20*1/2	1/2"	19.1	15.8	15.0	50
KPT FTEWD -0422	25*1/2	1/2"	24.0	17.6	16.2	55

MALE THREADED TEE WITH DISK



CODE	SIZE	THREADS	D	L1	Z	H
KPT MTTWD -0423	20*1/2	1/2"	19.1	16.0	56.0	64
KPT MTTWD -0424	25*1/2	1/2"	24.0	17.2	57.7	70

FEMALE THREADED TEE WITH DISK



CODE	SIZE	THREADS	D	L1	Z	H
KPT FTTWD -0425	20*1/2	1/2"	19.1	16.0	56.0	50
KPT FTTWD -0426	25*1/2	1/2"	24.0	17.2	57.8	56

CONCEALED VALVE



CODE	SIZE	D	L	L1
KPT CV-0427	20 MM	19.0	15.0	60.5
KPT CV-0428	25 MM	24.3	17.2	68.1
KPT CV-0429	32 MM	31.0	20.0	79.7

FUSION METHOD

The process of joining PPR-C pipes and fittings is very simple and results in inseparable watertight joints. It is carried out using a simple welding machine that fuses the internal surface of the fitting and the external surface of the pipe, so that the material of the pipe and the fitting will be bonded together.

THE FOLLOWING DESCRIBE THE STEPS OF THE WELDING PROCESS

Prepare the welding machine by fitting it with the welding dies of the diameters to be welded. Connect the plug to the 220V power supply socket and wait until the green light on the machine goes out indicating the welding machine has reached the working temperature.

- Cut the pipe at right angles to the pipe axis using suitable pipe cutter.
- Remove any burrs or cutting chips by deburring the cutting area.
- Mark the welding depth on the pipe using suitable marker.
- Insert the end of the pipe without turning into the heating sleeve up to the marked welding depth and at the same time slide the fitting without turning into the other side of the heating tool up to the stop. It is essential to observe the mentioned heating times (refer to the below table)
- Leave the pipe and fitting into the heating tool until the heating time is elapsed.
- At the end of the heating time, remove the pipe and fitting from the heating tool and push them immediately against each other up to the mark indicating the welding depth. At this stage the depth mark will be covered with the welding bead.
- During this process, do not rotate the pipe and fitting relative to each other.
- Allow the joint to cool fully before using.



Recommended Time For PPR Systems Fusion Joints

PIPE DIA. (MM)	WELDING DEPTH (MM)	HEATING TIME (SEC)	WELDING TIME (SEC)	COOLING TIME (MIN)
16	14.0	6	4	2
20	14.5	6	4	2
25	16.0	7	4	2
32	18.0	8	6	4
40	20.5	12	6	4
50	23.5	18	6	4
63	27.5	24	8	6
75	30.0	30	8	6
90	32.5	40	8	6
110	37.0	50	10	8
160	42.0	60	15	10

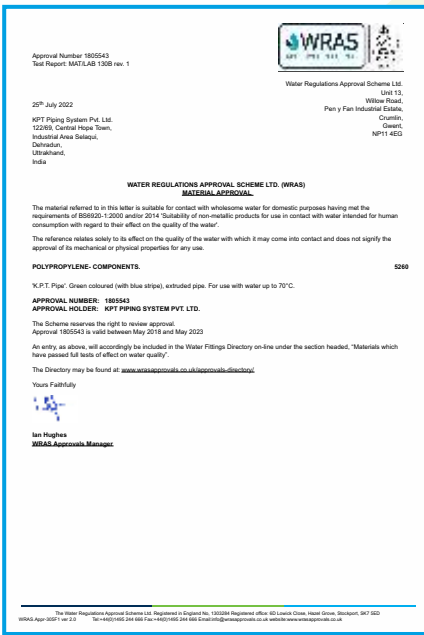
Recommended Time For PPR Systems Butt Joint

PIPE DIA. (MM)	WELDING MACHINE TEMPERATURE °C	HEATING TIME (MIN)	WELDING TIME (SEC)	COOLING TIME (MIN)
200	220-240	30	180	15-20
250	220-240	30	240	16-24
315	225-240	30	300	20-25
355	225-240	30	360	25-30
400	225-240	30	420	30-35

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