

管道系统（施工连接）

PP/PPH、PE、PVDF 管道系统加热工具热熔承插连接法

PP/PPH, PE, PVDF pipe system heating tool melt beat-in connection

热熔承插连接法 Melt beat-in connection:

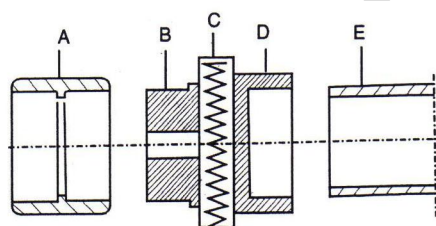
这种需要加热工具的熔接法，管道端口应插入接头套筒中不需要使用附加材料。用一个加热绝缘管和套筒分别加热管道端口和接头套筒至熔接温度，再一起推动。

The melt-connecting method ,which need heat the tool,the pipe end should insert in the tie-in sleeve,need not using additional material.With a insulation pipe and a sleeve to heat the pipe port and the tie-in sleeve to the melt-connecting temperature,then move together.

管道端口、接头套筒和加热工具相互协调达到必要的结合压力，使焊接均质。

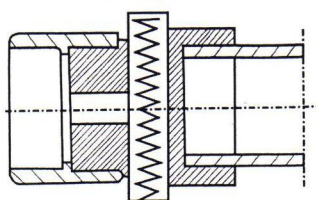
The pipe port,the tie-in sleeve assort with the heating tool to get the necessary combination pressure result to equality welding.

焊接过程 Melt-connecting course

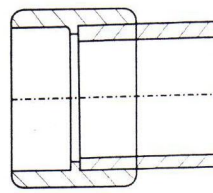


- A、接头 tie-in
- B、加热套筒 heating sleeve
- C、发热元件 heat element
- D、加热绝缘管 heating insulation
- E、管道 pipe

加热 Heat



已完成的接口 the finished connect



一般要求 Normal requirement

热熔承插时应注意最小管道壁厚。

When in melt beat-in,note that the min.pipe wall thickness.

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07.2021

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修正审

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热熔承插法除塑料管道焊接常用工具（切割机、带切割导向装置的锯子）外，还需要专门适用 PE、PVDF 及 PP 制成的热熔接头。将发热元件的温度设置到 260℃。熔接温度应该在 210~250℃。

The normal tool for hot melt bear-in method,except the plastic pipe structure tool(such as incision machine and the saw with incision guide equipment),need the anti-rust hot melt bear-in connect which special used in PE,PVDF and PP.Set the heat element to 260℃.The temperature of melt-connection is 210~260℃

熔接过程 Melt-connection course

加热 Heat

首先快速将接头推进加热套筒至正确深度，再沿轴向将管道推进加热绝缘管中不弯曲并抓牢。在熔接机中这将由固定定位器来调节。并按规定加热时间进行加热，加热时间是从上述过程结束后开始测量。对壁厚小于规定的厚度不可采用熔接。

Firstly,push the connect quickly into heat sleeve to the right depth,then along the axis push into the heating insulation pipe without distortion and cinch.This process would be made by the fixing localizer in the melt-connection machine.And heat according to the regulated time.The heating time begin to measure after the above course finished.

Those whose wall depth is less than the regulation should not be melt-connected.

接合（手动）Joint(Manual operation)

加热期结束后，快速将接头和管道从加热工具中拉出。注意对准标记，立即沿轴向它们推找，不可扭曲，将他们接在一起，保持与加热期相同的时间。

After heat,pull the connect and pipe out of the heating tool quickly.Note that point at the marks and along the axis closing them without distortion.Connect them together and keep the time similar to the heating period.

压力试验 Pressure test

进行压力试验前，所有熔接均要彻底冷却，如通常最后一次接合完成后必须等待约一个小时。（在施工过程中，如有不明之处，请于本厂联系）

Before pressure experiment test,all the melt-connection must be cooled drastically.Normal finished the last connection should wait for an hour(During the construct,if there is any not clearness,please contact us) ☎

Thank you for your business!

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