管道系统（施工连接）

PP/PPH、PE、PVDF 管道系统加热工具热熔对焊连接法

Hot melt welding connection of PP/PPH,PE,PVDF pipe system heating tool

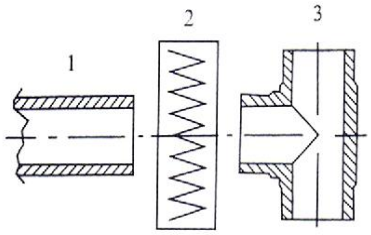
熔接方法 Melting connection method：

将管道和接头熔接区加热至熔接温度，在未使用其他附加材料的情况下用机械压力对其接合，接合结果均质。熔接借助熔接机才能进行，它允许调节接合压力。下图举例说明熔接原理。

Heat the melt-connecting area of pipe and the connecting joint to melting connecting temperature.On the condition of not using other additional material,connected with mechanical pressure that the connection is even and well.Only used melt-connecting machine can the connection regulate the pressure and the following is the example for the melt-connecting principle.

熔接原理 Melt-connection principle：

1、管道 Pipe
2、发热元件 Heating element
3、接头 Contact joint

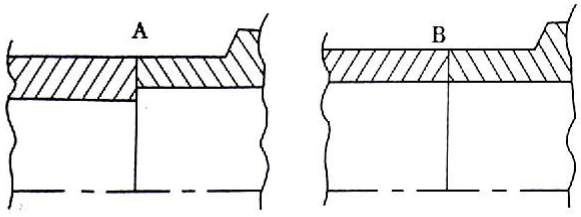


一般要求 Normal requirement

只能对相似材料进行熔接。接合原件的熔接区必须具有相同的壁厚。本厂PP、PVDF、熔接头符合此项要求。

The base standard is for the resemble material melt-connection. The melt-connecting area of the connecting element should have simoal wall thickness. The welded connectors in PP and PVDF produced by us are found in accordance with this requirement.

A、错误 error
B、正确 right



只有经过专业培训的人员才能利用加热工具热熔焊接。热熔焊接除塑料管道焊接常用工具（管切机、带切割导向装置的锯）外，还需要管道专业熔接机。PP、PPH 发热元件温度为 200~220℃、PVDF 发热元件温度为 232~248℃。

Only the professional who has been special trained can melt-connect the heating tool.Except the plastic pipe and the common-used tool(such as pipe-cut machine and the saw with cutting guide equipment),the tool for melt-connection also need special melt-connecting machine. The temperature of PP,PPH heating element is 200~220℃ and PVDF element 232~248℃.

焊接过程 Melt-connecting process:

达到熔接温度，即将发热元件安装到熔接机上。用均衡所需力将焊口压住顶着发热元件直到每个结合面的整个四周完全熔融，再将均衡压力降低至 0。

Once reached the melt-connecting temperature, equip the heating element into the melt-connecting machine soon. Press the parts in the heating element with equilibria power until the around of each combinating face tightly close and formed up a bead. Then reduce the equilibria to 0.

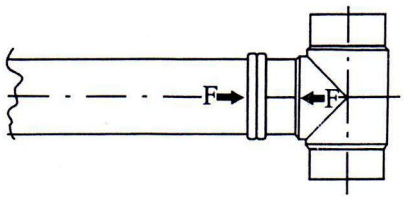
接合与冷却 Connecting and cooling:

将接口留在接合压力下的熔接机中直至融化期结束。

融化期结束后，移开发热元件且不接触到结合表面，再立即一起推动接口。转换时间必须在规定值内。

Leave the part in the melt-connecting machine with joint pressure untill colling.

After cooling,take the parts out of the heating element,then move the element to avoid of touch the joint surface,and drive the part together as soon.The conversion time is within the regulating value.For special notice that within joint course when touch the part surface,move the parts together quickly.



一起移动接口使其四周相互接触。在规定时间内迅速将压力增至现有的接合压力。整个冷却期必须保持该压力。尤其是在达到接合压力后瞬间有必要进行调整。

Move the parts together for the purpose the around of them touch each other.Then in the regulating time,increase the pressure to the existent joint pressure.And during the whole cooling time should keep this pressure.Especially at the time when reach to the joint pressure.

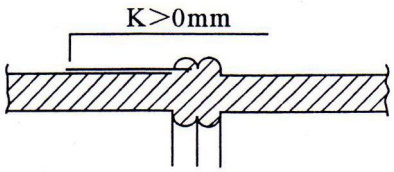
接口必须留在接合压力下的熔接机中直至到规定的冷却期结束。

The joint parts must leave in the melt-connecting machine with suitable joint pressure until to the regulated colling time.

熔接检查 Melt-connection check!

接口整个四周应形成一个珠子。图上“K”应始终完全。

The around of the pipe should shape a bead.And the “K” in the figure should keep full.



施压力试验 Carry out pressure experiment:

压力实验前，所有熔接必须冷却，如通常最后一次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,all the melt-connection must be cooled,at normal should wait for 1 hour(During construction period,if there is any not clearness,please contact us)

Thank you for your business!