

LESSO

PP-R WATER PIPE AND FITTINGS



■ PP-R Water Pipe Fittings



■ Physical Properties

Properties		Typical Value
Specific Gravity, g/cm(20°C)		0.89~0.91
Tensile Strength, MPa		220
Modulus of Elasticity, N/mm2(20C)		800
Thermal Conductivity, w/(m · k) (20)		0.23~0.24
Coefficient of Linear Expansion, mm/(mk)		0.14~0.16
Longitudinal Reversion, %(135°C 2h)		≤2
Hydraulic Pressure Test	20°C, 1h, Hoop Stress is 16MPa	No Failure
	95°C, 1000h, Hoop Stress is 3.5MPa	No Failure
	110°C, 8760h, Hoop Stress is 1.90MPa	No Failure

Note: The plastic fittings should be adopted threaded metal fittings with corrosion resistance when they are intended to connect with metal pipe and water transportation device

■ Socket Fusion Joint for PP-R Pipelines



1 Cut the pipe rectangularly with pipe cutters. Take care that the pipe axis is free from burrs or cuttings debris and remove where necessary. Mark the welding depth at the end of the pipe according to the socket depth of fittings.



2 Clean the socket and the spigot with cleansing clothes



3 After the welding machine reaches the necessary operating temperature, push the end of the pipe and fittings, without turning, up to the welding depth into the welding tool. Heat up the pipe's spigot and fittings' socket according to the following heating time.



4 After the heating time, quickly remove the pipe and the fittings from the welding tools. Join them immediately without turning, until the marked welding depth is covered by the bead of PP-R from the fittings.



5 The joint elements have to be fixed during the specified assembly time. After the cooling period, the fused joint is ready for use.



6 Finish the welding.

Remark: The heating time should comply with the requirement of products and be adjusted according to the working temperature. When the working temperature is below 5°C the heating time should be extended by 50%.

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