

Butt Welding Technology

PL DH - WELDING TABLES FOR DH FITTINGS

Uponor Infra markets a wide assortment of ready PU insulated fittings enabling any configuration of district heating networks. Uponor Infra delivers machinery and technology for your own manufacturing of preinsulated fittings, giving you a possibility to develop your business and keep your clients satisfied with custom made solutions. Your equipment kit might be comprise the following machinery; jacket pipe cutting saw, welding table

for manufacturing of PE-jackets, high pressure PU dispensing unit, fitting foaming table and special split flanges.

The PL-DH workshop machines are working by butt-fusion method for housing pipes. The pipe ends are heated by a (split-type) heating element and joined under pressure. The pressure is applied by a hydraulic system which has a dual-pressure control board. This allows the switching between right and left part of the tables and thereby a timesaving

processing of a complete fitting whilst only one spanning procedure. The split-type heating elements are pneumatically operated (from PL 800 DH and above). This feature combined with the SSS-System ("soft-start-stop") for electric hoist (directions: up, down, front, back) and beam (left, right), allows a rapid and smooth handling of the machines. The PL 315 DH is delivered with a lifting device with swivel beam and balancers for the heating elements.



Product
PL DH butt welding machines

Models

- PL 315 DH
- PL 800 DH
- PL 1200 DH
- PL 1600 DH

Welding Range Ø

- 90 - 315 mm
- 355 - 800 mm
- 900 - 1200 mm
- 900 - 1600

Applications
PL DH welding tables for manufacturing district heating pipe fittings

Butt Welding Technology

PL DH - WELDING TABLES FOR DH FITTINGS

PL 315 DH 400 V 3 Ph. 50 Hz (standard).

Fittings Welding range
Segmented bends OD 90 – 315

Basic machine consisting of Sizes (mm)
Central prismatic clamp
and two clamps on movable
trolleys for double welding.
Reducing inserts. 90, 110, 125, 140, 160,
180, 200, 225, 250, 280

Hydraulic unit with selector to
switch between left and right
welding piece.
Lifting system for heating elements.

Split type heating elements per customers specifications

OD of element (mm)	Opening of element (mm)	Diameter
240	75	90-110/ 32-38
240	95	125-140 / 57-76
310	140	160-200 / 89-108
420	190	225-250 /133-159
480	250	315/219

PL 800 DH 400 V 3 Ph. 50 Hz (standard), pneumatic connections

Fittings Welding range
Segmented bends OD 355 – 800

Basic machine consisting of Sizes (mm)
Central prismatic clamp
and two clamps on movable
trolleys for double welding.
Reducing inserts. 355, 400, 450,
500, 560, 630, 710

Two separate hydraulic circuits to be
controlled via one common panel.
Lifting system for heating elements and reductions.

Split type heating elements per customers specifications

OD of element (mm)	Opening of element (mm)	Diameter
480	250	355/219
540	365	400-500 / 273-325
670	510	560-630 / 426
780	590	710/530
950	700	800/630



PL 1200 DH 400 V 3 Ph. 50 Hz (standard)

Fittings Welding range
Segmented bends OD 900 – 1200

Basic machine consisting of Sizes (mm)
Central prismatic clamp
and two clamps on movable
trolleys for double welding.
Reducing inserts. 900, 1000, 1100

Two separate hydraulic circuits to be
controlled via one common panel.
Lifting system for heating elements and reductions.

Split type heating elements per customers specifications

OD of element (mm)	Opening of element (mm)	Diameter
1050	800	900/720
1200	930	1000-1100/820
1350	1050	1100-1200/920
1350	1130	1200/1020

PL 1600 DH 400 V 3 Ph. 50 Hz (standard)

Fittings Welding range
Segmented bends OD 900 – 1600

Basic machine consisting of Sizes (mm)
Central prismatic clamp
and two clamps on movable
trolleys for double welding.
Reducing inserts. 900, 1000, 1100,
1200, 1425

Two separate hydraulic circuits to be
controlled via one common panel.

Lifting system for heating elements and reductions.

Split type heating elements per customers specifications

OD of element (mm)	Opening of element (mm)	Diameter
1050	800	900/720
1200	930	1000-1100/820
1350	1050	1100-1200/920
1350	1130	1200/1020
1570	1340	1425/1220
1780	1560	1600/1420

Uponor Infra Oy
P.O. Box 21
FI-65101 Vaasa
Finland

Uponor Infra Tech GmbH
Industriestraße 15
D-36088 Hünfeld
Deutschland

T +358(0)20 129 211
F +358(0)20 129 2099
W www.uponor.fi/technology
E machinery.vaasa@uponor.com

T +49 (0) 6652-91189-40
F +49 (0) 6652-91189-44
W www.uponor.de

Uponor