Edition: 5.2017



aquatherm green pipe

Pipe system made of polypropylene
for potable water supply

aquatherm blue pipe

Pipe system made of polypropylene
for chilled, hot fluid and various industrial applications

aquatherm lilac pipe

Pipe system made of polypropylene
for reclaimed water

aquatherm

state of the pipe

NEW SINCE THE LAST VERSION

D10101
aquatherm green pipe
aquatherm blue pipe
aquatherm lilac pipe

Page	Change
30	Environmental Product Declaration and LEED certification
32	Chemical and thermal disinfection
33	Integration of other systems or components with aquatherm piping for pressure pipe applications
47	Drilling through the pipe wall and removal of the oxygen barrier layer/UV layer
50	Drilling of aquatherm PP-pipes with the hot tapping tool Art. no. 50890 under pressure
60	Chamfering OT-pipes and UV-pipes
74	Determination size of expansion loop
105	Art. No. 70806–70824 & 70856 aquatherm green pipe SDR 7,4 MS removed from the programme
from 100	The article list was updated
168	Art. No. 50506 aquatherm peeling tool for welding sockets removed from the programme
173	Art. No. 50910, 50912 & 50914 aquatherm chamfering devices removed from the programme
177	aquatherm prefabrication

Our sales and delivery conditions (January 2014) and the contacts of our technical sales and distribution see on our homepage www.aquatherm.de.

Subject to technical alterations, errors and misprints excepted. With the edition of this catalogue, all former ones become void.



Dear readers,

We are always making decisions – in every minute of every hour of every day. At this moment, you have decided to open our "Company brochure" to consciously find out more about our company aquatherm.

Without knowing the reason behind your decision, we can promise you one thing, namely that the insight into our colourful, yet always slightly green tinged, aquatherm world is sure to impress you!

As a family business which is passionate about all it does we, together with our employees, confidently meet all challenges and, in doing so, are able to trustfully call upon values which have defined our company for already more than four successful decades.

We know where we want to go without forgetting where we came from. Hereby we like to live with the role of not being a "normal" business. The characteristics "being different" and "special" represent our motivation in all that we do to be the best.

We are "state of the pipe" because we act independently and decisively and are hereby always reliable which makes us the leading manufacturer of polypropylene pipes.

We were, are and will remain as this – promise!

But see for yourself and decide upon aquatherm not only in the next few moments but also in the long term.

Best wishes

Dirk Rosenberg
Managing Director

Maik Rosenberg
Managing Director

Christof Rosenberg
Managing Director

Gerhard Rosenberg
President of the Advisory Board

1973 aquatherm founded by Gerhard Rosenberg

1978 Move to the first building at the current site in Biggen

1977 First exports to Jordan and Belgium

1984 Opening up of further foreign markets including Italy and Greece

1990 Market launch of the fusiotherm stabi composite pipe

1991 Subsidiary plant opens in Radeberg

1995 The 200th employee joins the aquatherm family

1996 Takeover of turning shop aquatherm Metall GmbH & Co. KG, Attendorn

1996 First certification of our quality management system in accordance with ISO 9001

1999 Market launch of the fusiotherm fibre composite pipe

2001 aquatherm operates in more than 50 export markets

2004 Dirk and Maik Rosenberg join management

2006 Market launch of the aquatherm blue pipe

2006 aquatherm products permanently represented on all 5 continents

2007 Market launch of the aquatherm black system

2008 Market launch of the aquatherm red pipe

2009 More than 20 young people employed as trainees

2010 System expansion of the pipe size to max. ø 630 mm

2010 Dirk, Maik and Christof Rosenberg assume company management

2011 Market launch of aquatherm ti

2012 First time certification of our environment management system in accordance with ISO 14001

2012 Market launch of the material PP-RP

2013 First certification of our energy management system in accordance with ISO 50001

2013 Brand conversion "colours of innovation" and aquatherm 40th jubilee

2015 Start of building project ZuRo (future pipe manufacturing)

SERVICE

TECHNICAL HOTLINE
+49 (0)2722 950 200

info@aquatherm.de www.aquatherm.de

Parent plant Attendorn

aquatherm GmbH
Biggen 5
D-57439 Attendorn
Phone: +49 (0) 2722 950-0
Fax: +49 (0) 2722 950-100

Subsidiary Radeberg

aquatherm GmbH
Wilhelm-Rönsch-Str. 4
D-01454 Radeberg
Phone: +49 (0) 3528 4362-0
Fax: +49 (0) 3528 4362-30



Field staff

In addition to the regular training service at Attendorn and Radeberg aquatherm field staff are available to assist customers, on site, throughout Germany.



Training service

In addition to training service through the merchant network aquatherm offers its customers training, free of charge, at its training centres at Attendorn and Radeberg.

Fair

aquatherm is represented on all important fairs relevant for the sanitary and heating sector in Germany or abroad with its own exhibition booth. For more information regarding fairs near to you, please visit internet page: www.aquatherm.de.

CERTIFICATIONS IN ACCORDANCE WITH ISO 9001, 14001 & 50001

Since 1996 aquatherm has been meeting the requirements of the certifiable quality management system according to DIN ISO 9001. The 2012 TÜV certificate was extended by the environmental management system according to ISO 14001 and currently by the energy management system according to ISO 50001.

This success is a great contribution and represents a further step to strengthen our competitive position and to meet the high requirements and the responsiblity for our customers, partners and the environment.

TÜVRheinland ZERTIFIZIERT
Management System
ISO 9001:2008
ISO 14001:2004
ISO 50001:2011
www.tuv.com
ID 0091005348


Certificate
ISO 9001:2008
aquatherm
state of the pipe
TÜVRheinland


Certificate
ISO 14001:2004
aquatherm
state of the pipe
TÜVRheinland


Certificate
ISO 50001:2011
aquatherm
state of the pipe
TÜVRheinland

Laboratory

The aquatherm laboratory: from the testing of granulate through to the finished product the customer can be assured of only the highest quality products.

Software-Service

The aquatherm software service provides Datanorm-files, an independent graphical program (liNear), and the appropriate training.

Brochures etc.

No matter whether brochures, catalogues or product lists: Our in-house marketing department develops everything itself. You can download all documents as pdf from our website www.aquatherm.de
For printed copies, please send an e-mail to info@aquatherm.de.

SERVICE

TABLE OF CONTENTS

Systems **8–22**

- Rebranding 8–9
- Short cuts & Symbols 10
- aquatherm pipe systems 11
- Comparision of the water content per meter 12
- aquatherm green pipe/Application 13–15
- aquatherm blue pipe/Application 16–18
- Composite technology 19
- aquatherm blue pipe OT 20
- aquatherm TI 21
- aquatherm lilac pipe/Application 22

Features **23–33**

- Permissible working pressure – Potable Water 23
- Permissible working pressure – Non Potable Water 24
- Permissible working pressure for general pressure pipe applications in permanent operation 25
- **System overview** **26–27**
- Characteristic 26
- Installation 26
- Composite Technology 26
- Quality 26
- Guarantee 27
- Price 27
- Planning and software 27
- **Material** **28**
- fusiolen® 28
- Certificates/aquatherm & Ecology 29
- Sound Insulation/Hygienic suitability 29
- Environmental Product Declaration and LEED certification 30
- Fire protection/Fire load 31
- UV-resistance/Chemical and thermal disinfection 32
- Integration of other systems or components with aquatherm piping for pressure pipe applications 33

Quality assurance **34–38**

- Quality assurance 34
- Compliance with the system standard/ aquatherm quality management 35
- System control/Internal control 36–37
- External control 38

Welding technology **39–59**

- **Fusion** **40–66**
- Part A: assembly of welding tools 40
- Part A: Mounting of the tools 41
- Part A: Heating up phase/handling 42
- Part A: Guidelines 43
- Part B: Checking of devices and tools 43
- Part B: Heating of pipe and fitting 44
- Part B: Universal peeling tools 45–46
- Part C: Weld-in saddles 47–49
- Part D: Pulling jig (hitch) 51–53
- Part E: aquatherm welding machine 54
- Part E: Welding machine prisma-light 55
- Part E: Electrofusion device 56–58
- Part G: Possibilities of repair 59
- Part H: Butt-welding of pipe dimension 160–630 mm 60–61
- Welding defects and visual inspection of fusion seam 62–63
- Welding parameter 64–65
- Part E: Flange connections 66

TABLE OF CONTENTS

Installation principles **67–90**

— Fastening technique/Fixed points/Sliding points 67
— Installation advice/Linear expansion/Concealed installation 67
— Installation in ducts 68
— Open installation/Calculation of the linear expansion 69
— aquatherm green pipe & aquatherm blue pipe 70
— aquatherm green pipe MF (faser composite pipe) 71
— aquatherm blue pipe MF (faser composite pipe) 71
— Pipe clamps 72
— Bending side/Expansion loop 73
— Pre-stress/Bellow expansion joint 74
— Length of bending side 75
— Length of bending side with pre-stress 76
— Support intervals 77–78
— Thermal insulation of hot water pipes 79
— Insulation thickness acc. to Decree for Energy Saving 80
— Pressure test/Test control/Measuring of the test pressures/Test record 82
– Pressure test/Test control 83
— Test record 84
— Flushing of pipes/Earth wire/Transport and storage 85
— Water point connections 86
— Distribution block 87
— aquatherm distribution block 88
— Insulation for distribution block/aquatherm distribution block 89
— aquatherm distribution block: Example of applications – heating 90

Planning **91–99**

— DIN 1988 T3/Maximum flow rate/
Principles of calculation/Calculation guide/Software 92
— Minimum flow pressure 94–95
— Coefficient of loss aquatherm green pipe fittings 96–98
— Coefficient of loss aquatherm green pipe distribution block 99

Product list **100**

aquatherm green pipe pipes 101
aquatherm blue pipe pipes 108
aquatherm lilac pipe pipes 112
Fastening material 113
Fittings 114
Weld-in saddles 131
Flange adapter & flanges 135
Coupling Screws & back plate elbows 138
Transition pieces 142
Screwed connections and counter parts 143
Electrofusion sockets 140
Fitting connection & accessories 140
Transition pieces & counterparts 145
Distributors 155
Valves and accessories 157
Cutting tools, welding devices 165
Welding machines and welding jig 166
Butt welding machines & electrofusion device 167
Peeling tools 168
Saddle welding tools 171
Drills & saddle peeling tool 173
Hot tapping tool 175

Prefabrication **177**

— Form: special manifold 178
— Advantages aquatherm Prefabrication 179
— Product list 180

REBRANDING

The desire to avoid stagnation and continuously improve our products, as well as to find new fields of application and create solutions quickly, has resulted in some of the well-known aquatherm product groups. This often led to systems being named as they emerged and has resulted in naming conventions that no longer accurately convey the suitable applications for the pipe.

Another issue is that many of our pipes and systems have names that do not relate to each other, and in turn do not relate those products to their parent company, aquatherm. Furthermore, other companies from different industries around the globe use similar names, creating confusion between aquatherm products and their products. The desired uniqueness of our system identification is lost.

Thus, the next logical step for us is to introduce a naming system that matches and unifies our products.

no.:	new branding structure					Material/Glas fibre content GF[%]/ fire class. Acc. ISO 11925	article-no.
	brand name		appendix				
	company	system	Standard Dimension Ratio	structure of pipe	special feature of pipe		
1	aquatherm	green pipe	SDR 11	S		PP-R/GF0/E	10208 . . . 10248
2	aquatherm	green pipe	SDR 7.4	S		PP-R/GF0/E	10806 . . . 10908
3	aquatherm	green pipe	SDR 6	S		PP-R/GF0/E	10006 . . . 10110
4	aquatherm	green pipe	SDR 7.4	MF		PP-R/GF7/E	70708 . . . 70738
5	aquatherm	green pipe	SDR 7.4	MF	UV	inliner like 5 with black PE-coating	70758 . . . 70788
6	aquatherm	green pipe	SDR 9	MF	TI	inliner like 5 with PU-Insulation and black PE-casing	1370711 . . . 1370738
7	aquatherm	green pipe	SDR 9	MF	RP	PP-RP/GF7/E	370712 . . . 370744
8	aquatherm	green pipe	SDR 9	MF	RP UV	inliner like 8 with black PE-coating	370762 … 370794
9	aquatherm	blue pipe	SDR 11	S		PP-R/GF0/E	2010208 . . . 2010312
10	aquatherm	blue pipe	SDR 7.4 / SDR 11 / SDR 17.6	MF		PP-R/GF7/E	2070708 . . . 2570154
11	aquatherm	blue pipe	SDR 7.4 / SDR 11	MF	UV	inliner like 11 with black PE-coating	2070162 . . . 2070762
12	aquatherm	blue pipe	SDR 7.4 / SDR 11	MF	OT	inliner like 11 with EVOH O2-barrier	2170114 . . . 2170712
13	aquatherm	blue pipe	SDR 7.4 / SDR11	MF	TI	inliner like 11 with PU-Insulation and black PE-casing	2270111 . . . 2270142
14	aquatherm	blue pipe	SDR 7.4 / SDR11	MF	OT-TI	inliner like 13 with PU-insulation and black PE-casing	2470711 . . . 2470138
15	aquatherm	red pipe	SDR 7.4	MF	HI	PP-R/GF7/B-s1,d0	4170130 . . . 4170726
16	aquatherm	lilac pipe	SDR 7.4 / SDR11	S		PP-R/GF0/E	9010212 . . . 9010808
17	aquatherm	black system			OT		
18	aquatherm	orange system		S	OT		
19	aquatherm	grey pipe					

LEGEND			
S	single layer	**UV**	ultraviolet protected
M	multilayer	**TI**	isolated with PUR and external PE pipe
MF	multilayer faser	**RP**	raised pressure (resistance)
OT	oxygen tight	**HI**	hardly inflammable

fields of application									
potable water	HVACR	swimming pool	chemical fluids	recycled & reclaimed water	fire protection	compressed air	district heating	geothermal	shipbuilding sector
●	❍	●	●	❍		❍	●	●	●
●	❍	●	●	❍		❍	●	●	●
●	❍	●	●	❍		❍	●	●	●
●	❍	●	●	❍		❍	●	●	●
●	❍	●	●	❍		❍	●	●	●
●	❍	●	●	❍		❍	●	●	●
●	❍	●	●	❍		❍	●	●	●
●	❍	●	●	❍		❍	●	●	●
	●	●	●	❍		●	●	●	●
	●	●	●	❍		●	●	●	●
	●	●	●	❍		●	●	●	●
	●	●	●	❍		●	●	●	●
	●	●	●	❍		●	●	●	●
	●	●	●	❍		●	●	●	●
					●				
				●					
	●								
	●								
●	❍								

System recommended due to its technical advantages: ●
Application of the system is suitable: ❍

SHORT CUTS & SYMBOLS

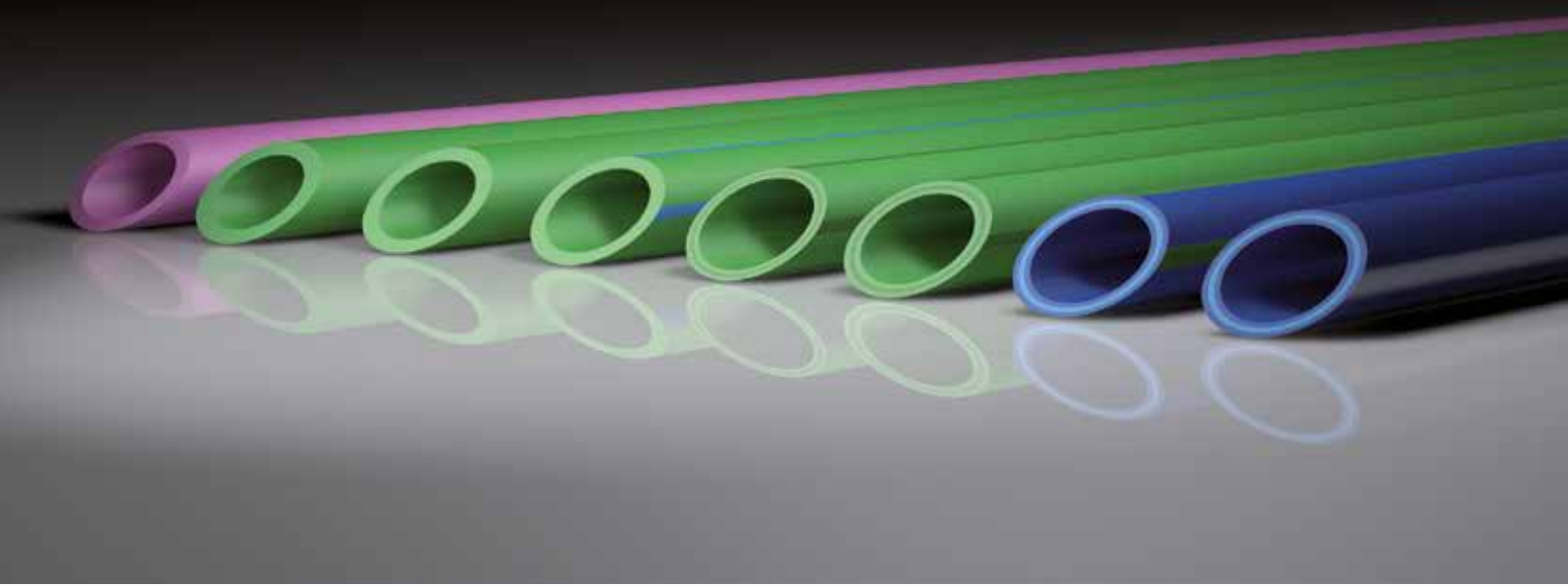
short cuts structure of pipe	
S	single
M	multilayer
MF	multilayer faser
OT	oxygen tight
UV	UV resistant
TI	thermal insulation
HI	hardly inflammable

short cuts material	
PP	polypropylene
PP-R	polypropylene random
PP-RP	polypropylene with raised pressure
PB	polybutene
PE-RT	polyethylene with raised temperature resistance
PEX	cross-linked polyethylene
AL	aluminium

FIELDS OF APPLICATION

- Potable water application
- Heating system construction
- Connection heating and cooling
- Underfloor heating
- Wall heating
- Ceiling heating and cooling
- Industrial floor cooling
- Industrial floor heating
- Chilled water technology
- Agriculture
- Sports floor heating and cooling
- Swimming-pool technology
- Chemical transport
- Rainwater application
- Irrigation
- Fire protection sprinkler-systems
- Application in the field of ship building
- District heating pipeline systems
- Geothermal

aquatherm pipe systems



AQUATHERM PP-R-PIPE SYSTEMS

aquatherm offers pipe systems with many applications due to their special characteristics and versatility.

The aquatherm pipe systems are applied in all fields of

NEW INSTALLATION

REPAIR and

RENOVATION.

SYSTEM COMPONENTS

The systems including all elements for the pipe system installation for chilled, hot fluid and various industrial applications.

- Pipes in straight lengths and / or coils
- Fittings
- Flanged joints
- Water point connections and accessories
- Welding devices and machines
- Weld-in saddles
- Manifolds
- Shut-off devices
- Cutting and peeling tools
- Installation guide and fastenings
- Transition joints from PP-R to metal or from metal to PP-R

FIELDS OF APPLICATION

System recommended due to its technical advantages: ●

Application of the system is suitable: ❍

	aquatherm green pipe	aquatherm blue pipe	aquatherm lilac pipe
Potable water application	●		
Heating system construction	❍	●	
Climate technology	❍	●	
Chilled water technology	❍	●	
Swimming-pool technology	●	●	
Chemical transport due to high chemical resistance	●	●	
Rainwater application	❍		●
Irrigation	❍	●	●
Compressed air systems	❍	●	
Under-floor-heating-systems	❍	●	
Application in the field of ship building	●	●	
District heating pipeline systems	●	●	
Geothermal		●	
Agriculture	●	●	●

COMPARISION OF THE WATER CONTENT PER METER

ø Dimension mm	aquatherm green pipe SDR 6 S	aquatherm green pipe SDR 7,4 MF aquatherm blue pipe SDR 7,4 MF SDR 7,4 MF OT aquatherm lilac pipe SDR 7,4 S	aquatherm green pipe SDR 9 MF RP	aquatherm green pipe SDR 11 S / MF aquatherm blue pipe SDR 11 MF SDR 11 MF OT SDR 11 S aquatherm lilac pipe SDR 11 S	aquatherm blue pipe SDR 17,6 MF
ø 16	0,088	0,106	-	-	-
ø 20	0,137	0,163	-	0,206	-
ø 25	0,216	0,254	-	0,327	-
ø 32	0,353	0,423	0,483	0,539	-
ø 40	0,555	0,660	0,754	0,834	-
ø 50	0,876	1,029	1,182	1,307	-
ø 63	1,385	1,647	1,869	2,074	-
ø 75	1,963	2,323	2,659	2,959	-
ø 90	2,826	3,358	3,825	4,252	-
ø 110	4,229	4,999	5,725	6,359	-
ø 125	-	-	7,386	8,199	9,637
ø 160	-	-	12,109	13,430	15,792
ø 200	-	-	18,908	21,010	24,661
ø 250	-	-	29,605	32,861	38,568
ø 315	-	-	46,966	52,172	61,223
ø 355	-	-	59,625	66,325	77,832
ø 400	-	-	-	84,290	98,756
ø 450	-	-	-	106,477	125,036
ø 500	-	-	-	-	154,272
ø 560	-	-	-	-	193,688
ø 630		-	-	-	245,070

SDR = Standard Dimension Ratio (diameter/wall thickness ratio)

S = single layer
MF = multilayer faser
MF RP = multilayer faser – raised pressure (resistance)
OT = oxygen tight

aquatherm green pipe



aquatherm green pipe

The innovative all-rounder, which revolutionized the plastic pipe sector, made a name for itself within a very short time that stands for highest quality and outstanding ecological properties. The system of aquatherm has proven its excellent technical suitability in more than 30 years of application worldwide, and among experts has long been one of the most extensive and at the same time best plastic pipe systems.

The system includes the different types of pipes SDR 6, SDR 7.4, SDR 9 and SDR 11. They are complemented by especially reinforced products: faser composite pipe SDR 7.4, aquatherm green pipe SDR 9 and stabi composite pipe SDR 7.4. More than 450 joining and connection elements as well as valves and ball valves complete the system.

The products are available from 16 mm to 450 mm external diameter.

aquatherm green pipe SDR9 RP

aquatherm sets the innovation standards in the production of PP-pipes and fittings worldwide. We continually bother to push developments for product improvement. The current level of evolution is called „fusiolen PP-RP".

With „fusiolen PP-RP" we can produce fibre-composite pipes with lower wall-thickness by keeping all the well-established advantages.
Further advantages on page 27.

The aquatherm green pipe system is applied in all fields of

- **NEW INSTALLATION**
- **REPAIR** and
- **RENOVATION.**

- **Potable water pipe networks**
  for cold and hot water installations e.g. in residential buildings, hospitals, hotels, office and school buildings, shipbuilding, sports facilities etc.
  house connection
  boiler connection
  water distribution
  rise
  high rise (conventional or specially connected)
  water point connection

- **Heating pipes for residential houses**
  heat generator connections
  heating manifolds
  risers
  high rise
  manifold connections
  radiator connections

- **Pipe networks in agriculture and horticulture**

- **Pipe networks for geothermal recovery**

- **Pipe networks for industry,**
  e.g. for the transport of aggressive fluids (acids, leys, etc.) considering the chemical resistance

Fields of application





aquatherm green pipe

POTABLE WATER AND HEATING INSTALLATIONS

From the house connection station, cold water distribution, boiler connection and hot water distributor to risers, installed with aquatherm green pipe composite pipe, with conventional high rise or high rise carried out with the aquatherm green pipe manifold system up to the last tap, installed conventionally or with the manifold, concealed or surface installation – the aquatherm green pipe system offers all possibilities of a complete installation with only one non-polluting material.

Types of installation

The aquatherm green pipe system is applicable for all common types of installation:

It is also possible to prefabricate pipe and fittings for risers and high rise.

aquatherm green pipe offers the perfect program for all types of installations.

With an extensive product range of pipe and fittings from Ø 16–450 mm external diameter and more than 450 fittings including fittings with brass threaded metal inserts, aquatherm green pipe offers ideal solutions for all fields of application.



House connection station



Surface installation



Concealed installation



Surface installation





Distribution network for domestic water and heating in residential buildings

All risers and distribution pipes are planned and assigned as usual.

1. Distribution piping with composite pipes

More dimensionally stable pipes are recommended for conventionally installed basement pipes, risers and multi storey pipe-systems.

Multi-storey installation can be done with the distribution blocks for plumbing and heating: quick processing is guaranteed.

Due to the low demand in fittings, the number of connections is reduced and thus time for installation.

High degree of pre-fabrication:

the special construction allows floor or wall installation (e. g. behind skirting boards) as one compact fitting with all branches provided.

2. Floor distribution with distribution blocks

The distribution blocks also offer further installation options: A simple opening of a side branch by drilling (18 mm borer) enables the connection of an additional pipe. e.g. the circulationpipe.

For further information concerning the distribution block plumbing and heating see page 87–90.

IMPORTANT:

The aquatherm grey pipe domestic water and radiator connection system is compatible with the aquatherm green pipe system.



Distribution piping

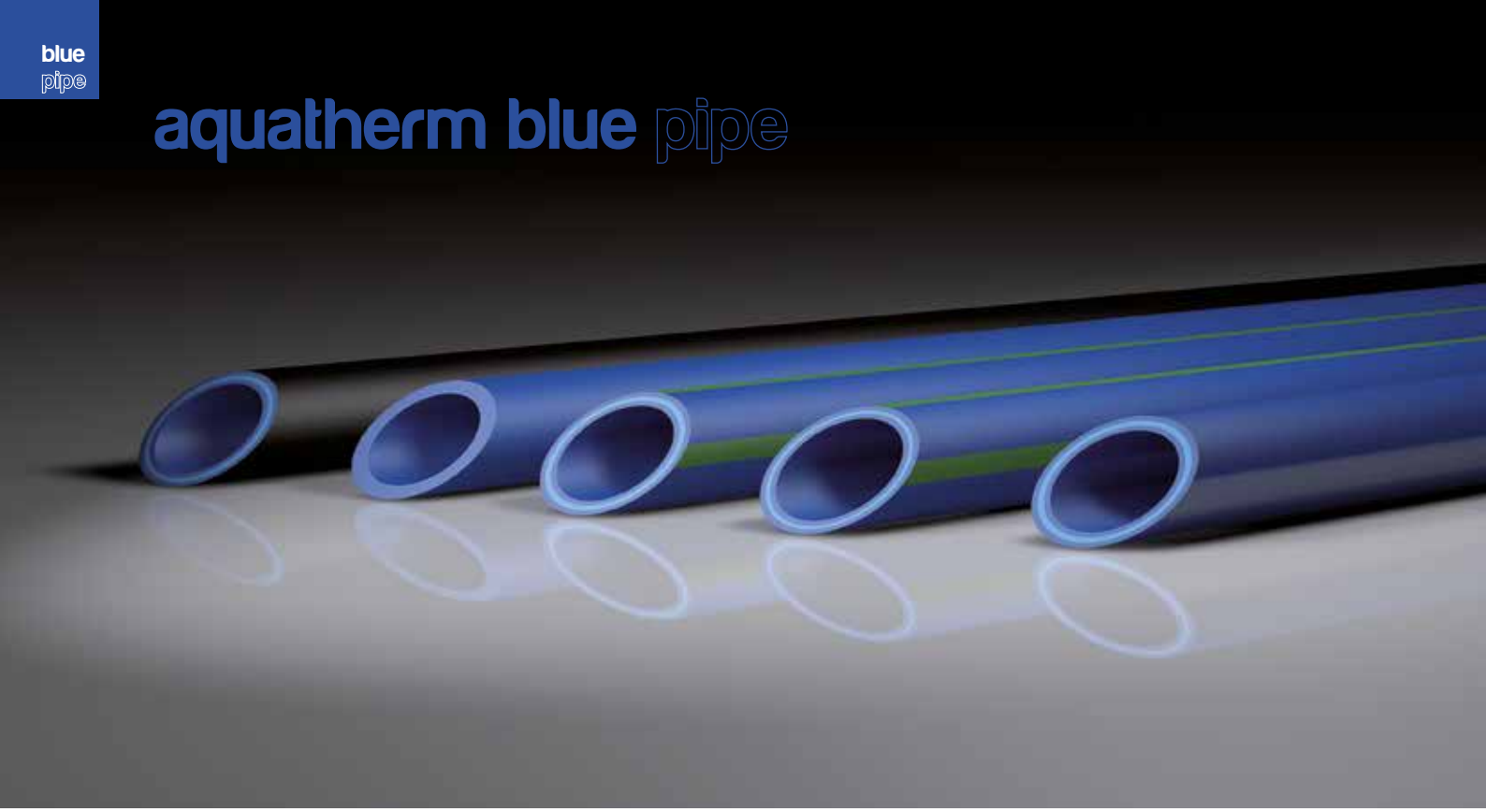


Floor distribution with distribution blocks



aquatherm grey pipe connection

aquatherm blue pipe



aquatherm blue pipe

aquatherm blue pipe, our specialty for distributing cooling and heating in closed systems as well as in several industrial applications. It was developed in order to prevent corrosion in heating system pipes and quickly expanded its range of application, with many positive features for other fields of piping installation. It has gone on to find success around the world in hotels, stadiums, schools, offices, and industrial applications. In addition to the general advantages of the PP-R pipesystem aquatherm blue pipe in comparison with the aquatherm green pipe system it offers higher volumetric current values due to smaller wall thickness.

System components

The system has to be installed in combination with the aquatherm green pipe fittings – and includes all elements for the pipe system installation for chilled, hot fluid and various industrial applications.

aquatherm blue pipe stopps corrosion damages!

Air conditioning systems (problems with dew-point) installed with steel pipes especially are affected by corrosion at the outer surface of the pipes. aquatherm blue pipe is manufactured from 100 % corrosion resistant materials which increase the life-time of air-conditioning pipe systems considerably.

Insulation against energy loss

Compared to metal pipes aquatherm blue pipes require a considerable thinner insulation.

The aquatherm blue pipe system is applied in all fields of

- **New installation**
- **Repair and**
- **Renovation.**

- **Heating pipes for residential houses**
  heat generator connections
  heating manifolds
  risers
  high rise
  manifold connections
  radiator connections

- **Pipe networks**
  for climate technology
  for chilled water technology
  for swimming-pool technology
  for chemical transport
  for rainwater application
  for compressed air systems
  for under-floor-heating-systems
  in ship building
  for district heating
  for geothermal





Fields of application

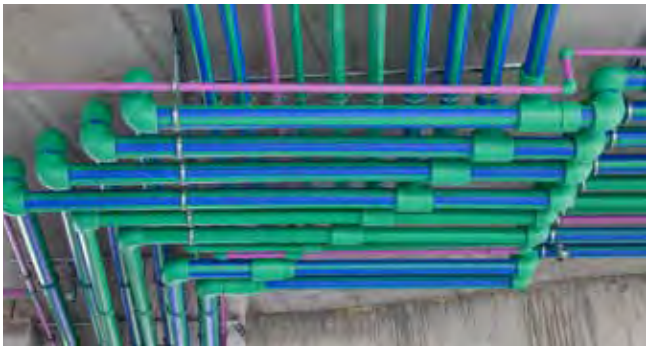




aquatherm blue pipe



Flange connections and transition joints enable the connection of all components to the central heating system and on the floor.



Risers and distribution piping for heating supply should be planned and installed with aquatherm blue pipe faser composite pipes.





The connection of floor heating systems or the installation of radiator pipes up to the manifold can also be carried out with aquatherm blue pipe.





Heating and air-conditioning

aquatherm blue pipe includes all pipe installation components for chilled water, hot and various industrial applications. Reduced wall thickness offers higher flow rates and the products are stabilised under heat.



Ice surface cooling

The ice surface cooling system is made of an ideal combination of aquatherm blue pipe and and aquatherm green pipe components. For the construction of mobile ice rink surfaces the pipework is completed with aquatherm blue pipe components.

The distribution pipes as well as the manifold connecting pipes are made from aquatherm blue pipes and connected by reverse return (Tichelmann-principle). The weld-in saddle technique, developed by aquatherm, is applied for the production of manifold branches.



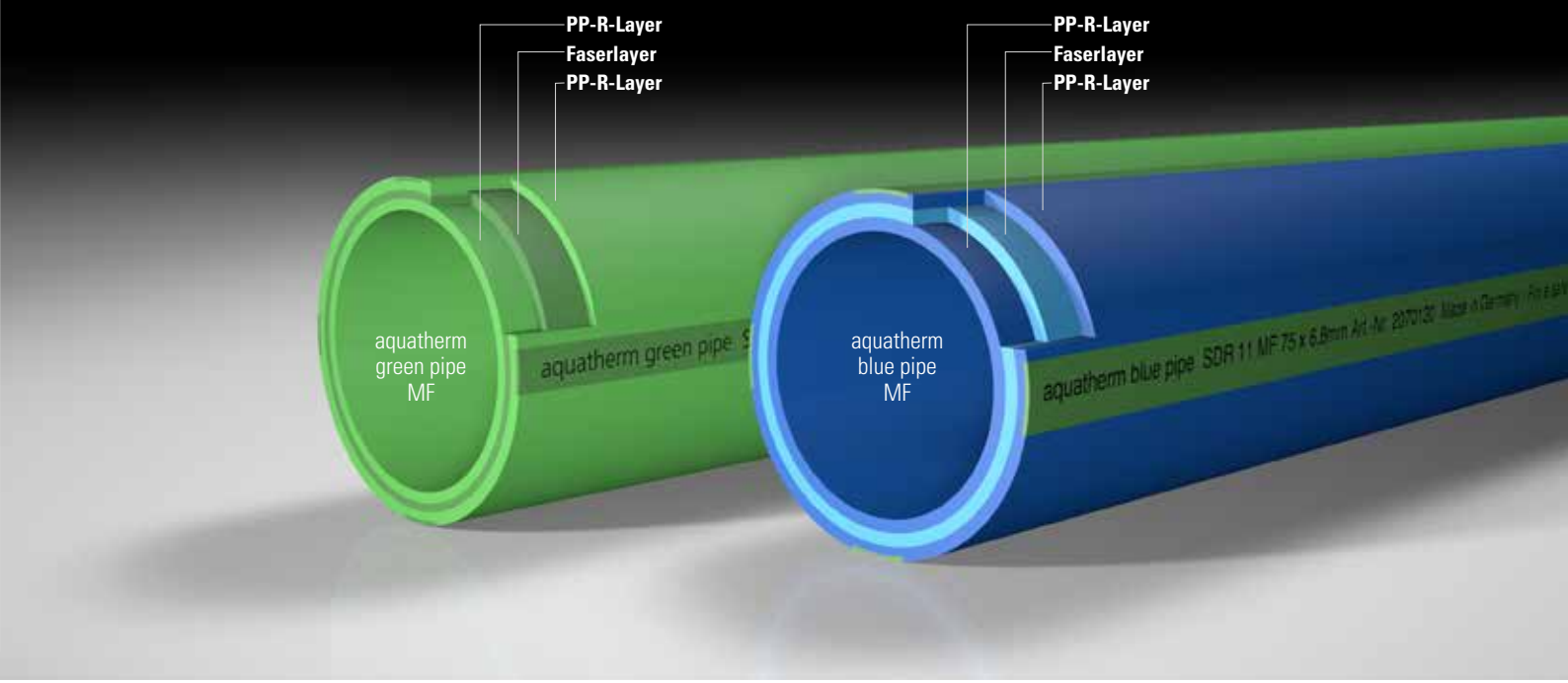
Under soil heating

To keep a pitch with natural or artificial turf free from ice and snow aquatherm offers a system to provide an under soil heating efficiently and in consideration of environmental aspects.

The ideal combination of aquatherm blue pipe and aquatherm green pipe compounds creates this condition.



COMPOSITE TECHNOLOGY



FASER COMPOSITE TECHNOLOGY

The composite pipes made in the multi-layer extrusion process produce a higher stability due to the fibre filling in the middle layer.
Compared to customary PP-pipes there are further advantages:

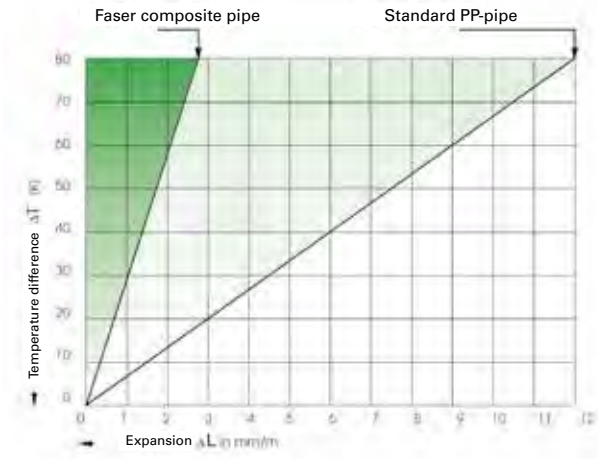
- Reduced expansion
- Higher flow rate due to increased inner diameter
- Greater support spacings
- Less weight

The following types of pipe are produced according to this technology:

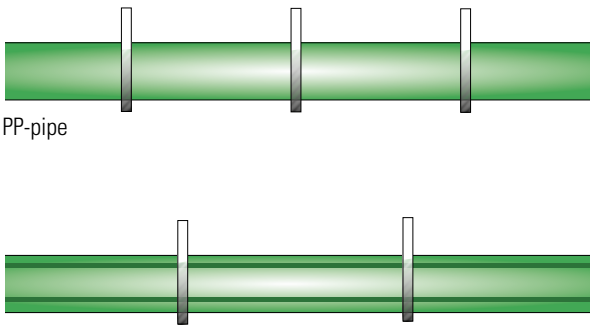
- aquatherm green pipe MF (Fasercomposite pipe)
- aquatherm blue pipe MF (Fasercomposite pipe)
- aquatherm red pipe MF (Fasercomposite pipe)

Expansion in comparison

Graph for determination of expansion

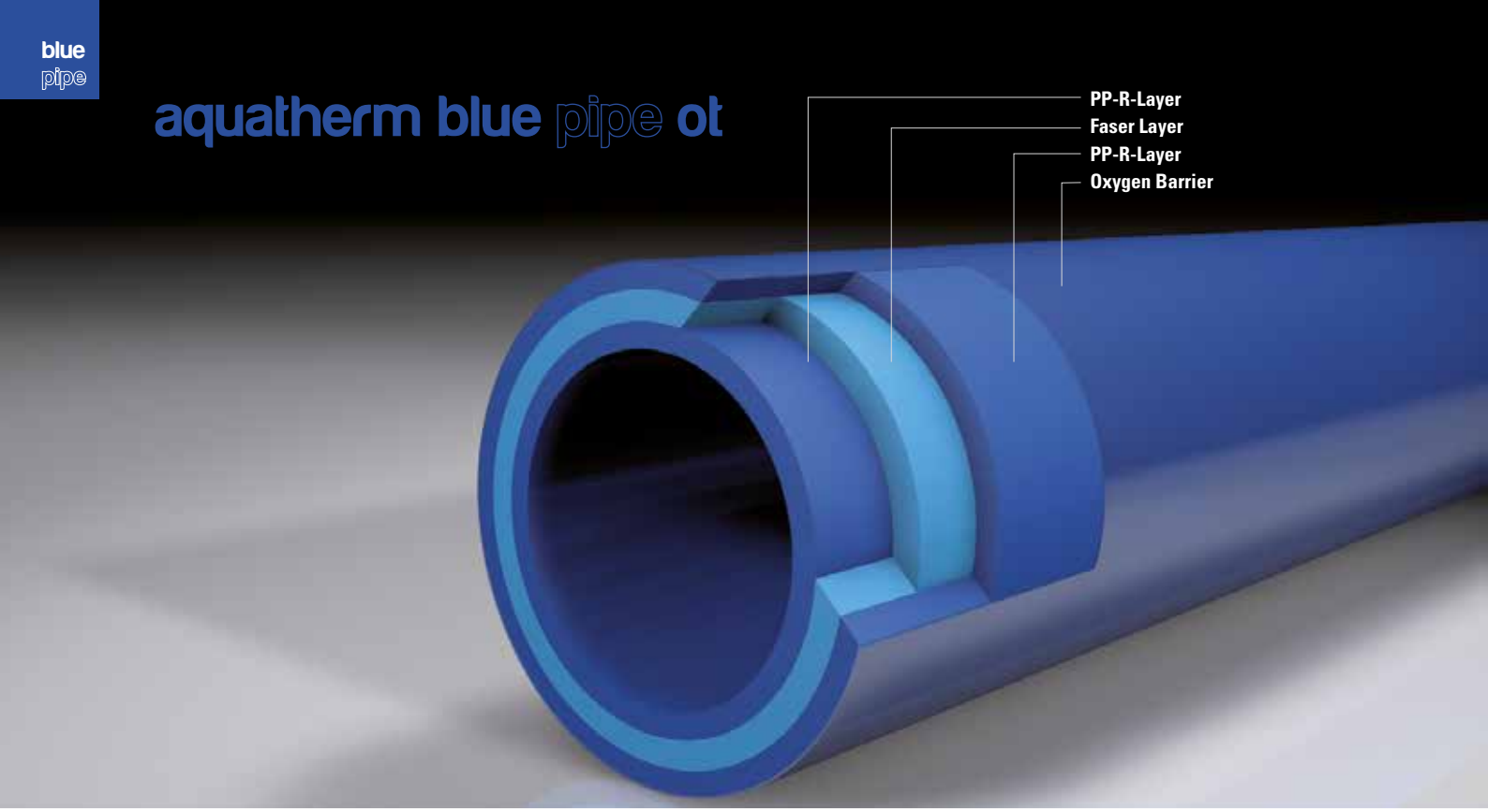


Support spacings PP-pipe and faser composite pipe



PP-pipe

Faser composite pipe approx. 30 % more fixing distance



aquatherm blue pipe ot

WITH OXYGEN BARRIER!

With the redeveloped aquatherm blue pipe faser composite pipe OT, aquatherm launches an oxygen tight pipe, which is equipped with an oxygen barrier and thus corresponds to the requirements of DIN 4726.

The aquatherm blue pipe faser composite pipe OT in combination with the aquatherm blue pipe system includes all elements for the pipe installation of chilled, hot fluid and various industrial applications.

The advantages of aquatherm blue pipe ot:

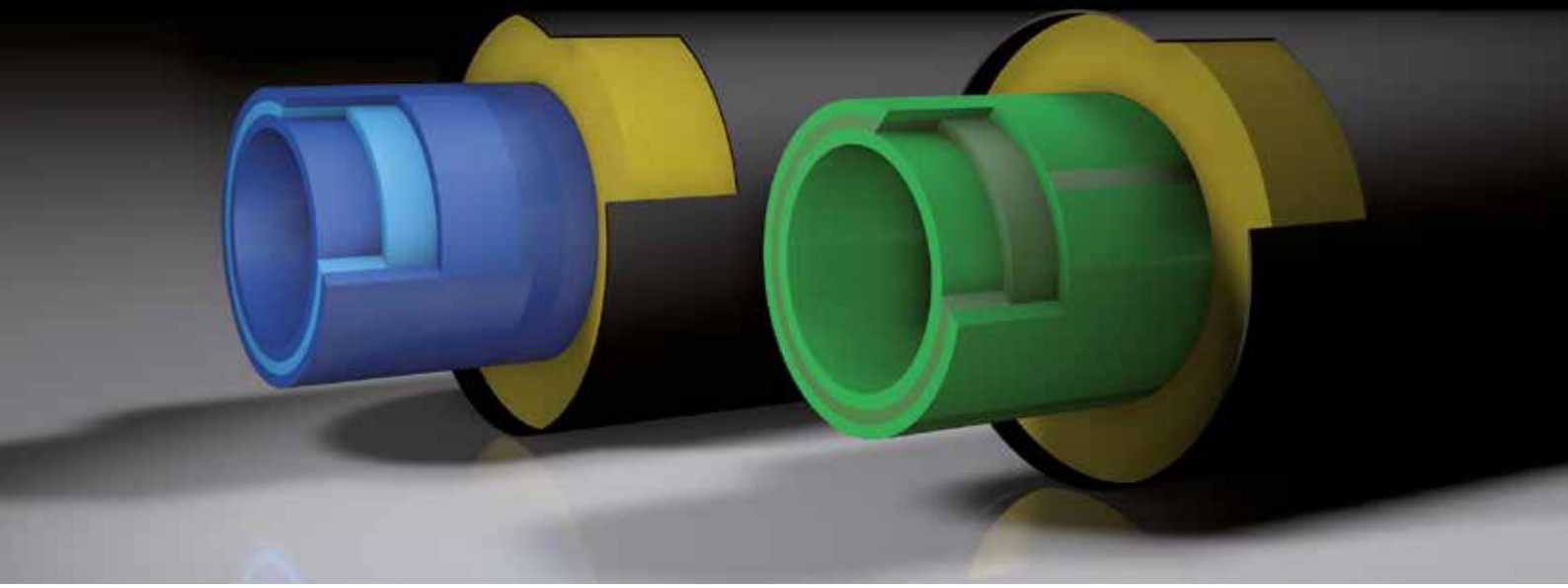
- Oxygen tight by diffusion barrier
- Certified according to DIN 4726
- Absolutely corrosion resistant
- Less pipe friction
- High stability
- High heat-stability
- High environmental compatibility
- High impact rate
- Resistant against chemicals
- Heat- and sound insulating characteristics
- Very good welding properties
- Considerably thinner insulation

Easy and quick installation technology

aquatherm blue pipe faser composite pipe OT also convinces by easy but effective installation- and connection technology. By heating of pipe end and fitting the plastic melts after joining of the elements into a permanent connection.

aquatherm blue pipe faser composite pipes OT have to be peeled with peeling tools Art. no. 50479–50488 before processing.

aquatherm green pipe ti
aquatherm blue pipe ti



aquatherm ti – PRE INSULATED PIPE SYSTEMS
for district heating

One of the most energy-efficient methods of transporting hot potable water as well as heating or cooling water covering long distances is the application of underground piping. To achieve the necessary insulating characteristics for this type of application, aquatherm offers the factory-made pre-insulated aquatherm ti pipe system with different medium pipes.

These systems are insulated with closed cell PUR rigid foam and coated with a casing pipe made of HDPE.

All medium pipes are plastic-fibre composite pipes.

Medium pipes

- **aquatherm green pipe ti**
  faser composite pipe system SDR 9 (7.4 on request available)
  pipe system for potable water
  in dimensions 32–315 mm
- **aquatherm blue pipe ti**
  faser composite pipe system
  SDR 11 in dimensions 32–315 mm and
  SDR 17.6 in dimensions 160–315 mm
  for heating, cooling and waste water
- **aquatherm blue pipe ot ti**
  faser composite pipe system SDR 11
  oxygen-tight pipe system for heating- and industrial
  in dimensions 32–250 mm

Fields of application	aquatherm green pipe ti	aquatherm blue pipe ti	aquatherm blue pipe ot ti
Potable water application	●		
Climate technology	❍	●	●
Chilled water technology	❍	●	●
Swimming pool technology	●	●	
Rainwater application	●	●	
Irrigation	●	●	
District heating pipeline systems	❍	●	●
Application in the field of Shipbuilding	●	●	●
Industrial liquids considering the material resistance	●	●	●

System recommended due to its technical advantages: ●
Application of the system is suitable: ❍

aquatherm ti MORE INFORMATION
For more information on the aquatherm ti system, please see our aquatherm ti catalogue with the order-no. **E30000**. You can request at our Info-Service on telephone-no. **+49 2722 950-0** or download in the download area of our **www.aquatherm.de**.

aquatherm lilac pipe



aquatherm lilac pipe

aquatherm lilac pipe was developed exclusively for the field of water recycling. In countries that are highly committed to the environment, like Australia and California, it is already standard to reduce daily water consumption by using recycled water when possible. Now lilac is also regarded in other countries as a standard colour for greywater pipes.

For technical, commercial, agricultural or domestic applications, cost-effective process water is often required. In the private sector, water recycling-systems are increasingly used. Thanks to the long-lasting and corrosion-resistant material Polypropylene, the aquatherm lilac pipe is ideally suited for process water (grey/rainwater).

System components

The system has to be installed in combination with the aquatherm green pipe fittings – and includes all elements for the pipe system installation for rainwater application and irrigation.

The aquatherm lilac pipe system is applied in all fields of

- **NEW INSTALLATION**
- **REPAIR** and
- **RENOVATION.**

Rainwater application
Irrigation
Agriculture

Fields of application

PERMISSIBLE WORKING PRESSURE – POTABLE WATER

Fluid transported: water acc. to DIN 2000

Temperature	Years of service	aquatherm green pipe SDR 11 S / aquatherm lilac pipe SDR 11 S		aquatherm green pipe SDR 7,4 S		aquatherm green pipe SDR 6 S		aquatherm green pipe SDR 7,4 MF		aquatherm green pipe SDR 9 MF RP	
		Permissible working pressure in bar and (psi)									
		bar	(psi)	bar	(psi)	bar	(psi)	bar	(psi)	bar	(psi)
20 °C 68 °F	1	15,0	(218)	23,8	(345)	30,0	(435)	28,6	(415)	25,0	(363)
	5	14,1	(205)	22,3	(323)	28,1	(408)	26,8	(389)	24,2	(351)
	10	13,7	(199)	21,7	(315)	27,3	(396)	26,1	(379)	23,9	(347)
	25	13,3	(193)	21,1	(306)	26,5	(384)	25,3	(367)	23,5	(341)
	50	12,9	(187)	20,4	(296)	25,7	(373)	24,5	(355)	23,1	(335)
30 °C 86 °F	1	12,8	(186)	20,2	(293)	25,5	(370)	24,3	(352)	21,7	(315)
	5	12,0	(174)	19,0	(276)	23,9	(347)	22,8	(331)	21,0	(305)
	10	11,6	(168)	18,3	(265)	23,1	(335)	22,0	(319)	20,6	(299)
	25	11,2	(162)	17,7	(257)	22,3	(323)	21,3	(309)	20,2	(293)
	50	10,9	(158)	17,3	(251)	21,8	(316)	20,7	(300)	20,0	(290)
40 °C 104 °F	1	17,1	(248)	21,5	(312)	20,5	(297)	18,7	(271)		
	5	16,0	(232)	20,2	(293)	19,2	(278)	18,0	(261)		
	10	15,6	(226)	19,6	(284)	18,7	(271)	17,7	(257)		
	25	15,0	(218)	18,8	(273)	18,0	(261)	17,4	(252)		
	50	14,5	(210)	18,3	(265)	17,5	(254)	17,0	(247)		
50 °C 122 °F	1	14,5	(210)	18,3	(265)	17,5	(254)	15,9	(231)		
	5	13,5	(196)	17,0	(247)	16,2	(235)	15,3	(222)		
	10	13,1	(190)	16,5	(239)	15,7	(228)	15,1	(219)		
	25	12,6	(183)	15,9	(231)	15,2	(220)	14,8	(215)		
	50	12,2	(177)	15,4	(223)	14,7	(213)	14,5	(210)		
60 °C 140 °F	1	12,2	(177)	15,4	(223)	14,7	(213)	13,5	(196)		
	5	11,4	(165)	14,3	(207)	13,7	(199)	13,0	(189)		
	10	11,0	(160)	13,8	(200)	13,2	(191)	12,8	(186)		
	25	10,5	(152)	13,3	(193)	12,6	(183)	12,5	(181)		
	50	10,1	(146)	12,7	(184)	12,1	(175)	12,3	(178)		
65 °C 149 °F	1	11,6	(168)	14,6	(212)	13,9	(202)	12,4	(180)		
	5	10,8	(157)	13,6	(197)	12,9	(187)	11,9	(173)		
	10	10,4	(151)	13,1	(190)	12,5	(181)	11,7	(170)		
	25	10,0	(145)	12,6	(183)	12,0	(174)	11,4	(165)		
	50	8,8	(128)	11,1	(161)	10,6	(154)	11,2	(162)		
70 °C 158 °F	1	10,3	(149)	13,0	(189)	12,4	(180)	11,4	(165)		
	5	9,5	(138)	11,9	(173)	11,4	(165)	10,9	(158)		
	10	9,3	(135)	11,7	(170)	11,1	(161)	10,7	(155)		
	25	8,0	(116)	10,1	(146)	9,6	(139)	10,5	(152)		
	30	7,0	(102)	8,8	(128)	9,3	(135)	10,3	(149)		
	50	6,7	(97)	8,5	(123)	8,1	(117)	10,2	(148)		
		Faser composite pipe: high working stress at lower wall thickness and higher flow rate									

Potable water (cold)

Potable water (warm)

SDR = Standard Dimension Ratio (diameter/wall thickness ratio)
S = single layer
MF = multilayer faser
MF RP = multilayer faser – raised pressure (resistance)

The determination of the allowable pressures resulted from the specific conditions to which pipe system components in the drinking water domestic installation are exposed to. Limiting factors such as increased flow rates, the use of disinfectants, increased content of oxygen, etc. were considered by the use of the appropriate safety factors.
For fittings of butt-welded pipe segments a reduction factor of 0.75 (reduction of the table values by 25 %) is effective.

PERMISSIBLE WORKING PRESSURE

For heating systems or closed systems considering the seasonal periods of operation – non potable water application

Heating period	Temperature	Years of service	aquatherm blue pipe SDR 11 MF, OT & S		aquatherm blue pipe SDR 17,6 MF		aquatherm green pipe SDR 7,4 MF		aquatherm green pipe SDR 9 MF RP	
			Permissible working pressure in bar and (psi)							
			bar	(psi)	bar	(psi)	bar	(psi)	bar	(psi)
constant operating temperature 70 °C / 158 °F incl. 30 days per year at	75 °C 167 °F	5	9,38	(136)	5,38	(78)	14,27	(207)	12,90	(187)
		10	9,08	(132)	5,21	(76)	13,79	(200)	12,60	(183)
		25	7,82	(113)	4,48	(65)	11,74	(170)	12,20	(177)
		45	6,77	(98)	3,89	(56)	10,18	(148)	12,00	(174)
	80 °C 176 °F	5	8,88	(129)	5,09	(74)	13,50	(196)	11,70	(170)
		10	8,46	(123)	4,86	(70)	12,80	(186)	11,40	(165)
		25	7,38	(107)	4,24	(61)	11,14	(162)	11,10	(161)
		42,5	6,49	(94)	3,72	(54)	9,79	(142)	10,90	(158)
	85 °C 185 °F	5	8,17	(118)	4,69	(68)	12,42	(180)	10,70	(155)
		10	7,82	(113)	4,49	(65)	11,87	(172)	10,40	(151)
		25	6,70	(97)	3,85	(56)	10,14	(147)	10,10	(146)
		37,5	6,07	(88)	3,49	(51)	9,18	(133)	10,00	(145)
	90 °C 194 °F	5	7,50	(109)	4,30	(62)	11,39	(165)	9,80	(142)
		10	7,19	(104)	4,13	(60)	10,94	(159)	9,50	(138)
		25	5,85	(85)	3,36	(49)	8,86	(129)	9,20	(133)
		35	5,39	(78)	3,09	(45)	8,16	(118)	9,10	(132)
constant operating temperature 70 °C / 158 °F incl. 60 days per year at	75 °C 167 °F	5	9,26	(134)	5,31	(77)	14,11	(205)	12,30	(178)
		10	8,90	(129)	5,11	(74)	13,57	(197)	12,10	(175)
		25	7,62	(111)	4,37	(63)	11,58	(168)	11,70	(170)
		45	6,60	(96)	3,79	(55)	10,05	(146)	11,50	(167)
	80 °C 176 °F	5	8,61	(125)	4,94	(72)	13,12	(190)	11,40	(165)
		10	8,24	(120)	4,73	(69)	12,54	(182)	11,20	(162)
		25	6,93	(101)	3,98	(58)	10,56	(153)	10,80	(157)
		40	6,18	(90)	3,55	(51)	9,41	(136)	10,70	(155)
	85 °C 185 °F	5	7,91	(115)	4,54	(66)	12,03	(174)	10,40	(151)
		10	7,56	(110)	4,34	(63)	11,52	(167)	10,20	(148)
		25	6,05	(88)	3,47	(50)	9,22	(134)	9,90	(144)
		35	5,57	(81)	3,20	(46)	8,48	(123)	9,80	(142)
	90 °C 194 °F	5	7,25	(105)	4,16	(60)	11,04	(160)	9,50	(138)
		10	6,40	(93)	3,67	(53)	9,76	(142)	9,30	(135)
		25	5,12	(74)	2,94	(43)	7,81	(113)	9,10	(132)
		30	4,90	(71)	2,81	(41)	7,46	(108)	9,00	(131)
constant operating temperature 70 °C / 158 °F incl. 90 days per year at	75 °C 167 °F	5	9,17	(133)	5,26	(76)	14,02	(203)	12,20	(177)
		10	8,79	(127)	5,04	(73)	13,38	(194)	12,00	(174)
		25	7,45	(108)	4,27	(62)	11,33	(164)	11,60	(168)
		45	6,45	(94)	3,70	(54)	9,82	(142)	11,40	(165)
	80 °C 176 °F	5	8,46	(123)	4,85	(70)	12,90	(187)	11,30	(164)
		10	8,11	(118)	4,65	(67)	12,35	(179)	11,00	(160)
		25	6,60	(96)	3,78	(55)	10,05	(146)	10,70	(155)
		37,5	5,98	(87)	3,43	(50)	9,09	(132)	10,60	(154)
	85 °C 185 °F	5	7,76	(113)	4,45	(65)	11,81	(171)	10,30	(149)
		10	7,03	(102)	4,04	(59)	10,72	(155)	10,10	(146)
		25	5,63	(82)	3,23	(47)	8,58	(124)	9,80	(142)
		32,5	5,28	(77)	3,03	(44)	8,03	(116)	9,70	(141)
	90 °C 194 °F	5	6,96	(101)	3,99	(58)	10,59	(154)	9,40	(136)
		10	5,88	(85)	3,37	(49)	8,96	(130)	9,20	(133)
		25	4,70	(68)	2,70	(39)	7,17	(104)	8,90	(129)

*** SDR = Standard Dimension Ratio** (diameter/wall thickness ratio)

SDR = 2 x S + 1 ≈ **d/s** (S = Pipe series index from ISO 4065)

PERMISSIBLE WORKING PRESSURE

for general pressure pipe applications in permanent operation
charted application ranges on page 23 and 24

Temperature	Years of service	aquatherm blue pipe SDR 17,6 MF		aquatherm blue pipe SDR 11 MF & MF OT aquatherm lilac pipe SDR 11 S		aquatherm green pipe SDR 7,4 MF		aquatherm green pipe SDR 9 MF RP	
		Permissible working pressure in bar and (psi)							
		bar	(psi)	bar	(psi)	bar	(psi)	bar	(psi)
10 °C 50 °F	1	12,8	(186)	27,8	(403)	30,2	(438)	28,8	(418)
	5	12,0	(174)	26,2	(380)	28,2	(409)	27,9	(405)
	10	11,7	(170)	25,6	(371)	27,7	(402)	27,5	(399)
	25	11,4	(165)	24,7	(358)	26,9	(390)	27,1	(393)
	50	11,1	(161)	24,1	(350)	26,1	(379)	26,7	(387)
	100	10,8	(157)	23,5	(341)	25,2	(366)	26,3	(381)
15 °C 59 °F	1	11,8	(171)	25,7	(373)	29,4	(426)	26,9	(390)
	5	11,1	(161)	24,2	(351)	27,4	(397)	26,0	(377)
	10	10,8	(157)	23,6	(342)	26,9	(390)	25,7	(373)
	25	10,5	(152)	22,8	(331)	26,1	(379)	25,2	(366)
	50	10,2	(148)	22,2	(322)	25,3	(367)	24,9	(361)
	100	9,9	(144)	21,6	(313)	24,5	(355)	24,5	(355)
20 °C 68 °F	1	10,9	(158)	23,8	(345)	28,6	(415)	25,0	(363)
	5	10,3	(149)	22,3	(323)	26,8	(389)	24,2	(351)
	10	10,0	(145)	21,7	(315)	26,1	(379)	23,9	(347)
	25	9,6	(139)	21,0	(305)	25,3	(367)	23,5	(341)
	50	9,4	(136)	20,4	(296)	24,5	(355)	23,1	(335)
	100	9,1	(132)	19,9	(289)	23,7	(344)	22,8	(331)
30 °C 86 °F	1	9,3	(135)	20,2	(293)	24,3	(352)	21,7	(315)
	5	8,7	(126)	18,9	(274)	22,8	(331)	20,9	(303)
	10	8,5	(123)	18,4	(267)	22,0	(319)	20,6	(299)
	25	8,2	(119)	17,8	(258)	21,3	(309)	20,2	(293)
	50	7,9	(115)	17,3	(251)	20,7	(300)	19,9	(289)
	100	7,7	(112)	16,8	(244)	20,0	(290)	19,7	(286)
40 °C 104 °F	1	7,9	(115)	17,1	(248)	20,5	(297)	18,6	(270)
	5	7,4	(107)	16,0	(232)	19,2	(278)	18,0	(261)
	10	7,2	(104)	15,6	(226)	18,7	(271)	17,7	(257)
	25	6,9	(100)	15,0	(218)	18,0	(261)	17,3	(251)
	50	6,7	(97)	14,6	(212)	17,5	(254)	17,1	(248)
	100	6,5	(94)	14,1	(205)	16,8	(244)	16,8	(244)
50 °C 122 °F	1	6,7	(97)	14,5	(210)	17,5	(254)	15,9	(231)
	5	6,2	(90)	13,5	(196)	16,2	(235)	15,3	(222)
	10	6,0	(87)	13,1	(190)	15,7	(228)	15,1	(219)
	25	5,8	(84)	12,6	(183)	15,2	(220)	14,7	(213)
	50	5,6	(81)	12,2	(177)	14,7	(213)	14,5	(210)
	100	5,5	(80)	11,9	(173)	14,1	(205)	14,3	(207)
60 °C 140 °F	1	5,6	(81)	12,2	(177)	14,7	(213)	13,5	(196)
	5	5,2	(75)	11,4	(165)	13,7	(199)	13,0	(189)
	10	5,1	(74)	11,0	(160)	13,2	(191)	12,7	(184)
	25	4,9	(71)	10,6	(154)	12,6	(183)	12,4	(180)
	50	4,7	(68)	10,3	(149)	12,1	(175)	12,2	(177)
70 °C 158 °F	1	4,7	(68)	10,3	(149)	12,4	(180)	11,3	(164)
	5	4,4	(64)	9,6	(139)	11,4	(165)	10,9	(158)
	10	4,2	(61)	9,2	(133)	11,1	(161)	10,7	(155)
	25	3,7	(54)	8,0	(116)	9,6	(139)	10,4	(151)
	50	3,1	(45)	6,8	(99)	8,1	(117)	10,2	(148)
75 °C 167 °F	1	4,3	(62)	9,4	(136)	11,7	(170)	10,4	(151)
	5	4,0	(58)	8,7	(126)	10,8	(157)	9,9	(144)
	10	3,7	(54)	8,0	(116)	10,0	(145)	9,7	(141)
	25	3,0	(44)	6,4	(93)	8,0	(116)	9,5	(138)
	50	2,5	(36)	5,4	(78)	6,7	(97)	9,3	(135)
80 °C 176 °F	1	4,0	(58)	8,6	(125)	10,4	(151)	9,5	(138)
	5	3,5	(51)	7,7	(112)	9,2	(133)	9,0	(131)
	10	3,0	(44)	6,5	(94)	7,8	(113)	8,9	(129)
	25	2,4	(35)	5,2	(75)	6,2	(90)	8,6	(125)
90 °C 194 °F	1	3,3	(48)	7,2	(104)	8,7	(126)	7,8	(113)
	5	2,3	(33)	5,1	(74)	6,0	(87)	7,4	(107)
	10	2,0	(29)	4,3	(62)	5,1	(74)	7,3	(106)

SDR = Standard Dimension Ratio (diameter/wall thickness ratio)
S = single layer
MF = multilayer faser
MF RP = multilayer faser – raised pressure (resistance)

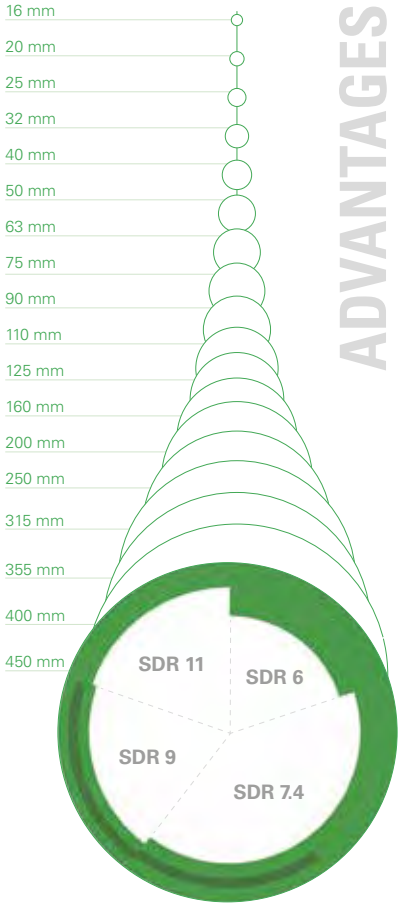
For fittings of butt-welded pipe segments a reduction factor of 0.75 (reduction of the table values by 25 %) is effective.

aquatherm green pipe

Pipe system made of polypropylene
for potable water supply

SDR:	6	**SDR:**	7.4	**SDR:**	11
ø:	16–110 mm	**ø:**	16–63 mm	**ø:**	20–450 mm
Type of pipe:		**Type of pipe:**		**Type of pipe:**	
Old:	Fusiotherm®	**Old:**	Fusiotherm®	**Old:**	Fusiotherm® SDR 11
New:	aquatherm green pipe S	**New:**	aquatherm green pipe S	**New:**	aquatherm green pipe S SDR 11





ADVANTAGES

Characteristic

aquatherm PP-R-pipe systems stopping corrosion damages. All materials are corrosion resistant and – compared to metallic pipes – have less noise flow rate. aquatherm PP-R-pipes are opaque – no danger of algae development.

Installation

aquatherm offers an unique and unrivalled connection process: material union by fusion. Shortest connection times are convincing:

e.g. outside diameter 20 mm = 8 sec.

aquatherm pipe connections can be hydraulic pressure tested or put into operation directly after their fusion. There are no extended waiting times.

Quality

This is reflected in national and international certificates, but above all in the satisfaction of aquatherm clients, installers and planners. For more details regarding quality and certificates see page 35.

Composite Technology

aquatherm developed a manufacturing method, realizing the integration of a special faser mixture within the material polypropylene.

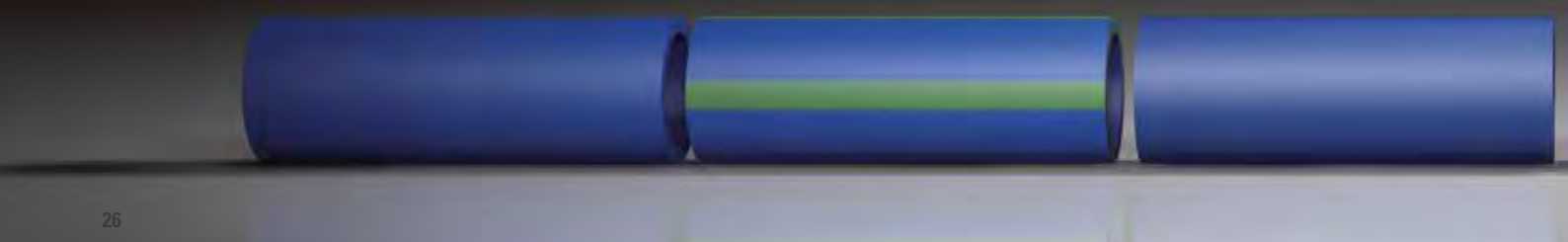
The result of this innovative technology is the singular compound of the different materials.

- The linear expansion is reduced by at least 75 % compared with standard PP-pipes
- The flow rate is increased by 20 % due to smaller wall thickness
- High stability
- The coefficient of linear expansion is nearly identical to that of metal pipes, so that compared with usual plastic pipes the support intervals can be enlarged and the number of clamps can be reduced
- Optimum cost-performance ratio
- Lower weight
- High impact rate
- Simply cut and weld

aquatherm blue pipe

Pipe system made of polypropylene
for chilled, hot fl uid and various industrial applications

SDR:	11	**SDR:**	7.4 / 11 / 17.6	**SDR:**	7.4 / 11
ø:	20–32mm	**ø:**	20–630 mm	**ø:**	20–250 mm
Type of pipe:		**Type of pipe:**		**Type of pipe:**	
Old:	climatherm pipe	**Old:**	climatherm faser composite pipe	**Old:**	climatherm faser composite pipe OT
New:	aquatherm blue pipe S	**New:**	aquatherm blue pipe MF	**New:**	aquatherm blue pipe MF OT



SDR: 7.4 / 9
ø: 20–355 mm
Type of pipe:
Old: Fusiotherm® faser composite pipe
New: aquatherm green pipe MF

SDR: 7.4 / 9
ø: 20–355 mm
Type of pipe:
Old: Fusiotherm® faser composite pipe UV
New: aquatherm green pipe MF UV

SDR: 9
ø: 32–315 mm
Type of pipe:
Old: Fusiotherm® ISO faser composite pipe
New: aquatherm green pipe MF TI



Advantages PP-RP

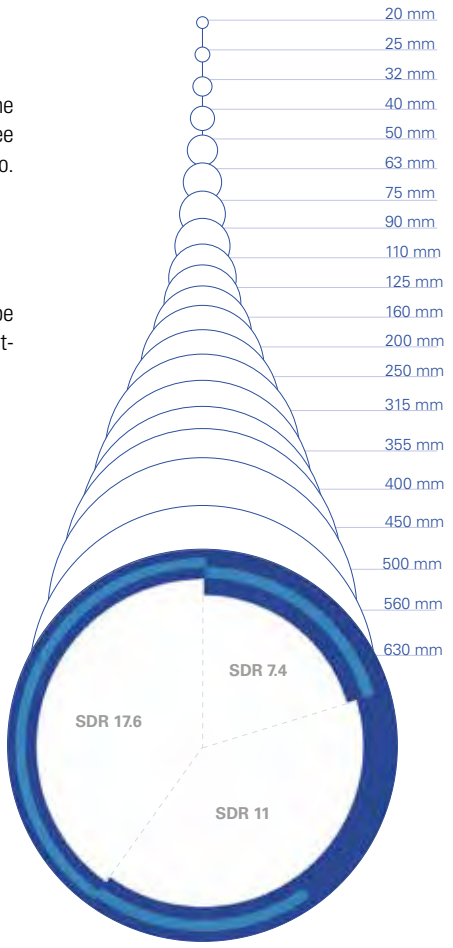
- Lower wall-thickness
- 14 % higher flow rate at same velocity compared to faser composite pipe SDR 7.4
- The permissible working pressures are on the same level like those of PP-R-faser composite pipes SDR 7.4 or are even exceeding them in the higher temperature range
- Identical expansion as faser pipe SDR 7.4
- 16 % lower weight than faser composite pipe PP-R SDR 7.4
- Lower weight than stainless steel, steel and copper pipes, thereby easier handling for transport and at site
- Quicker processing by shorter butt-welding times
- Trouble-free welding with all aquatherm PP-R-fittings

Guarantee

As a statement to aquatherm quality standards the aquatherm PP-R-pipe systems carries a 10 year guarantee for pipe and fittings with a product liability of 15 Mio. EUR per damage event.

Price

aquatherm PP-R-pipe systems are perfected pipe systems of high quality material with an optimum cost-performance ratio.



aquatherm lilac pipe

Pipe system made of polypropylene
for reclaimed water

SDR: 7.4 / 11 / 17.6
ø: 20–630 mm
Type of pipe:
Old: climatherm faser composite pipe UV
New: aquatherm blue pipe MF UV

SDR: 7.4 / 11 / 17.6
ø: 32–315 mm
Type of pipe:
Old: climatherm ISO faser composite pipe
New: aquatherm blue pipe MF TI

SDR: 7.4 / 11
ø: 20–125 mm
Type of pipe:
Old: aquatherm lilac
New: aquatherm lilac pipe S





The advantages

of aquatherm pipes and fusiolen® PP-R:

- **Absolutely corrosion resistant**
- **Resistant against chemicals**
- **High environmental compatibility**
- **High impact rate**
- **Less pipe roughness**
- **Heat and soundinsulating characteristics**
- **Very good welding properties**
- **High heat-stabilized**
- **Noticeable less insulation – recommended are 10 mm of insulation for all pipe dimensions**
- **High stability**
- **Lighter in weight**
- **Easy processing**
- **Well-priced**
- **Installation aids and fixings**

fusiolen®

OUR MATERIAL FUSIOLEN PP-R

Decades of experience in the production and the application of PP-R-pipe systems and the current ambition of continuous development led to numerous improvements of the aquatherm system technology.

Newly opened markets set a high standard of quality to make even larger demands against the pipe material. Various fields of application require the greatest possible independence of the material to be processed. Raw materials with new properties are required. aquatherm has developed and produced their own, innovative PP-R-materials which meet the requirement of a global market in the potable water and heating technology, in the airconditioning and chilling engineering, in the industrial and agriculture economy, in shipbuilding as well as in fire protection. Successful results of this research are fusiolen® PP-R, fusiolen® PP-R C or fusiolen® PP-R FS.

All aquatherm PP-R-pipes and fittings are made of fusiolen® PP-R.

Special heat and extraction stability are only two of the features of this material. Its physical and chemical properties are well-suited to the transfer of potable water and to the heating field. Above all, the good welding properties and fusion, resulting in a permanent connection, have made the aquatherm systems and the raw material fusiolen® PP-R well known worldwide.

Environment

The environmentally friendly material polypropylene fusiolen® PP-R is recyclable and can be ground, melted and reutilised for various applications e.g. motor-protections, wheel linings, laundry baskets and other kinds of transport boxes. There are no polluting substances with PP-R either in its processing or in its disposal.

fusiolen® PP-R – for the benefit of our environment!

Use of metal deactivators

By adding suitable food-approved additives the risk of amaterial damage caused by metal under extreme conditions of application is substantially reduced.

Higher long-term heat stabilization

The long-term heat stabilization has been increased to resist to the potential effects of peak temperatures within higher safety parameters.

MATERIAL PROPERTIES

Potable water is one of the most controlled commodity goods.

The domestic supply system should influence the water on its way up to the taps as less as possible. The choice of the right potable water pipe system and its material is of decisive importance.

aquatherm green pipe systems are suitable for all different qualities of potable water. The environmentally friendly and hygienically enhanced potable water pipe system made from fusiolen® is physiologically and microbiologically harmless. The technical suitability of the aquatherm pipe systems has been evident worldwide for more than 30 years.

The extrapolated service life of aquatherm PP-R-pipes is more than 50 years. Peak temperatures of 100 °C arising from short disruptions are unproblematic. Permanent temperatures from 70°C up to 90 °C reduce the service life of the pipe (see table “Permissible Working Pressure”, page 23–25).

Using aquatherm PP-R-pipes for heating or air conditioning applications the pressure- and temperature conditions according to table “Permissible Working Pressure” are valid. The following table shows the operating conditions related to pressure and temperature as a basis for pipe and pipe connections. These figures refer to potable water installations based on a theoretical service life of 50 years.

	Working pressure bar (psi)	**Temperature** °C	**Annual working hours** h/a
Cold water	0 up to 10 (145) transient	to 25 (77) *	8760
Hot water	0 up to 10 (145) transient	to 60 (140) to 85 (185)	8710 50

* Reference temperature for the creep rupture strength: 20 °C (68 °F)

HYGIENIC SUITABILITY

According to DIN 1988 T2 all installation parts comingdirectly in contact with potable water are commodity goods acc. to the Law for Food and Commodity Goods. Plastic pipes have to comply with the KTW-recommendations of the Federal Public Health Department.

Certificates

Numerous international certificates testify to the high quality standard of the green pipes.

DVGW, SKZ, HIG (Germany)
AENOR (Spain)
ÖVGW (Austria)
WRAS (UK)
KIWA (Netherlands)
SAI-Global (Australia)
CSTB, CARSO (France)
SII (Israel)
TIN (Poland)
SITAC, KIWA, SWEDCERT (Sweden)
NSF, ICC (USA)
IIP (Italy)
BNQ (Canada)
BRANZ (New Zealand)
CERTIF (Portugal)
EMI (Hungary)
a.m.m.



Material:

The hygienc suitability of the material used for the aquatherm green pipe system is independently verified through test certificates from the Hygiene Institute Gelsenkirchen. The suitability for potable water pipes in the field of cold and hot water is confirmed by current tests.

Processing:

The joining method requires no additives such as fluxes or solder. The connection is made by socket fusion. Potable water – our most precious commodity good: The increasing use of PP in the field of foodpacking confirms the hygienic qualities of the material. This makes aquaterm green pipe the optimal packing for our most precious commodity goods – potable water.

SOUND INSULATION

The sound insulation qualities of the PP-R-pipe system, related to water flow and hydraulic shock within a building, provide a sound proofing effect on noise transmission. Therefore the sound transmission is much lower compared to metallic pipes.

AQUATHERM & ECOLOGY

Environmental protection is taken very seriously by aquatherm! Products such as the aquatherm PP-R-pipe systems feature not only a long service life, but also excellent environmental and social compatibility.

From the origin of the company aquatherm placed emphasis on the fact that its products and manufacturing processes should not pollute our sensitive eco-systems, and ensured development of fully recyclable materials which can thus be added, problem-free, to new production.

Long before environmental protection was recognised as a global issue aquatherm fulfilled ecological standards which are demanded today. For now 40 years aquatherm has underlined its philosophy that ecological and economic interests should not be contradictory, neither during production and sales, nor in the product application. The environmentally friendly raw material fusiolen® its used for the manufacture of the aquatherm pipe systems. To ensure its environmental compatibility the basic material polypropylene, as well as all contained additives (colour pigments and stabilizers) were extensively tested, not only by aquatherm's own laboratory, but also by independent laboratories. Their results show that the material fusiolen® and the pipe systems from which it is manufactured, comply with the highest ecological standards and are thus future-oriented.

TECHNICHAL DATA SHEET

Technical properties	fusiolen PP-R (80)	fusiolen PP-R (80) faserpipe
Melt-flow index 190°C/5 kg	0.5 g/10 min.	0.5 g/10 min.
Melt-flow index 230°C/2.16 kg	0.3 g/10 min.	0.3 g/10 min.
Modulus of elasticity	800 N/mm^2	1200 N/mm^2
Yield stress	25 N/mm^2	30 N/mm^2
Density	0.9 g/cm^3	1.0 g/cm^3
Tensile strength	25 MPa	35 MPa
Inflammation temperature	430 °C – 450 °C	490 °C – 500 °C
Thermal expansion coefficient	1.5 *10^{-4} K^{-1}	0.35 *10^{-4} K^{-1}
Coefficient of thermal conduction	0,15 W/mK (measured at pipe)	0,15 W/mK (measured at pipe)
Coefficient of friction in pipes	0.007	0.007
Bending radius	6 x d	
Water absorption	< 0.02 %	< 0.02 %
Electrical properties	**fusiolen PP-R (80)**	**fusiolen PP-R (80) Faser**
Relative permittivity	2,3 (in case of 1 MHz)	2,3 (in case of 1 MHz)
Puncture voltage	500 kV/cm	500 kV/cm
Specific resistance	> 10^{17} Ω cm	> 10^{17} Ω cm
Surface resistance	10^{14} Ω	10^{14} Ω
Dissipation coefficient	0.0002 (in case of 50 Hertz)	0.0002 (in case of 50 Hertz)

ENVIRONMENTAL PRODUCT DECLARATION AND LEED CERTIFICATION

As the world´s first pipe system manufacturer, aquatherm has developed an Environmental Product Declaration (EPD). for its products. Thus the aquatherm products contribute to the attainment of points in the LEED system Learn more about the importance of life cycle assesments, environmental product declarations and LEED for planners, engineers and builders.

Life-Cycle Assessments (LCAs)
LCAs provide a comprehensive evaluation of the upstream and downstream energy and environmental impacts associated with a product. They are comprised of five parts: Goal, Scope, Life-Cycle Inventory Analysis, Results, and Interpretation. aquatherm has chosen the gradle-to-gate approach for its LCA „Life Cylce of Polypropylene Pressure Piping Systems" encompassing the product life cycle from the extraction of raw materials through manufacturing and product distribution.

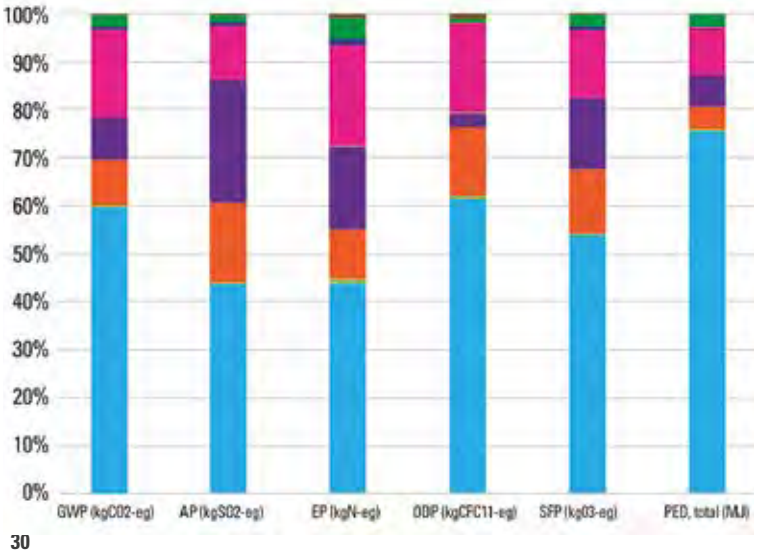
Environmental Product Declarations (EPDs)
The EPD is the document used to convey the LCA's results to the products' users and specifiers. It focuses on information about a product's environmental impact such as global warming, ozone depletion, water pollution, ozone creation, and greenhouse gas emissions.

EPDs typically are verified following the processes described in ISO 14025, EN 15804, and ISO 21930 for construction products. These steps include: 1) Finding or developing a Product Category Rule (PCR); 2) Generating the input data and performing an LCA according to a specific PCR; 3) Compiling information in the EPD; 4) Verification of the EPD and LCA; and 5) Registration and publication.

aquatherm utilized ThinkStep as independent third party to conduct an ISO-conformant LCA for its following product lines: green pipe, blue pipe, lilac pipe, red pipe and the black system for radiant heating and cooling, and red pipe. In the study, one meter (3.2 ft) length of pipe was selected as functional unit per the requirements of the respective PCR "Piping Systems for Use for Sewage and Storm Water (Under Gravity)". The declared product was defined as a representative average of the five aquatherm product offerings.

Two different test methodologies were chosen to analyze the products in the LCA: Tool for Reduction and Assessment of Chemical and Other Environmental Impacts (TRACI) 2.1 and CML 2001, a method developed by the Institute of Environmental Sciences at the University of Leiden in the Netherlands. The TRACI 2.1 method utilized impact categories, including Global Warming Potential (GWP), Acidification Potential (AP), Eutrophication Potential (EP), Ozone Depletion Potential (ODP), and Smog Formation Potential (SFP). The results of the findings are summarized in the following table.

Environmental impacts and Primary Energy Demand of aquatherm PP-R piping systems according to TRACI 2.1



Upon completion of the aquatherm product-specific LCA, aquatherm submitted its products, the LCA, and supporting documentation for independent verification by NSF International. The verification process included a review by an independent panel of experts, an audit of the manufacturing facilities and records, and a confirmation of material formulations. aquatherm's Product-Specific Type III third-party verified EPD was published Dec. 18, 2015: http://info.nsf.org/Certified/Sustain/ProdCert/EPD10069.pdf
Within the EPD, you will find information on aquatherm, its product descriptions, data quality requirements, raw-materials origins, a manufacturing diagram, a declaration of parameters per the PCR, and the lifecycle-impact conclusion for aquatherm pipe.

Advantages of PP-R piping systems and radiant panels compared to metall systems
The analysis has shown that polypropylene comprises nearly 50% or more of the impact contribution depending on the impact category. Also Primary Energy Demand (PED) is mainly driven by polypropylene. However, this is because of the embodied energy content of the resin rather than fuel consumption upstream. In other words, aquatherm polypropylene has available energy within the material that can be recovered later in the product's life cycle during recycling. This differs greatly compared with metals. With metal systems, all of the energy is used in the original processing of the raw material. Metals do not provide energy to the recycling process.

Thus aquatherm PP-R piping systems and radiant panels can provide a more sustainable, lower environmental impact option to designers, engineers, and building owners when compared with other piping and radiant panel systems.

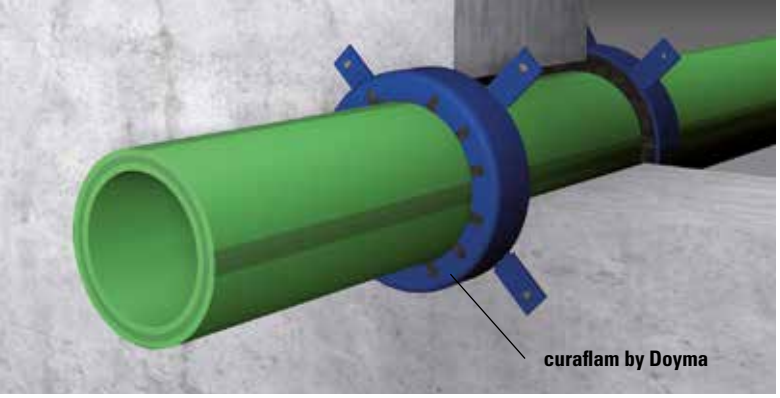
How is aquatherm's EPD relevant to LEED v4 points?
LEED stands for „Leadership in Energy and Environmental Design" and is one of the most popular green building certification programs used worldwide. It was developed by the U.S. Green Building Council (USGBC) in 1998 and has defined various standards for environmentally friendly, resource-saving and sustainable construction.

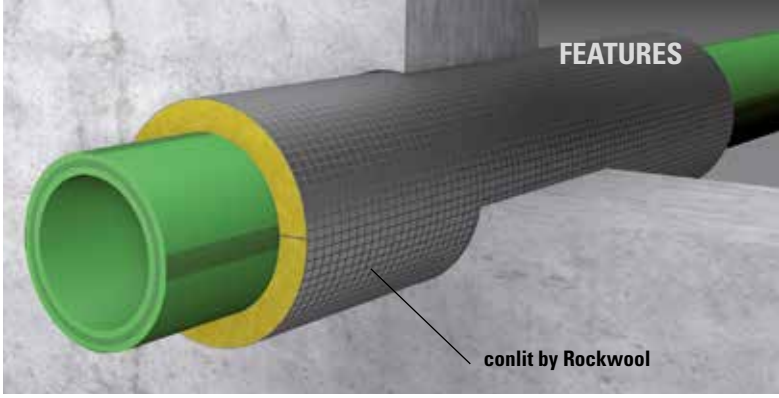
LEED v4 incorporates point structures to encourage the use of products/ materials that environmentally, economically, and socially support preferable life-cycle impacts. Point structures were developed to reward the selection of products from manufacturers who have verified improved environmental life-cycle impacts.

aquatherm's green pipe, blue pipe, lilac pipe, red pipe and black system products have attained Type III EPD status through independent verification by NSF International. They now can be utilized as a portion of the 20 permanent products engineers must have throughout their LEED-certified buildings. aquatherm's EPD also carries double the weight of the Industry-Wide (Generic) EPD in terms of LEED product value and four times the weight of a self-certified Product-Specific Declaration by a manufacturer.

aquatherm has continued its industry leadership position by becoming the first piping manufacturer to have an independently verified, Product-Specific Type III EPD and by supporting building owner to achieve LEED certification.

For further information please see our White Paper:
http://www.aquatherm-pipesystems.com/fileadmin/template/img/4.%20Service/PDF/aquatherm_LEEDv4_english.pdf





FIRE PROTECTION

The aquatherm PP-R-pipe systems comply with the requirements of the fire classification B2 DIN 4102 (normal inflammable). Compared to natural products like wood, cork or wool, aquatherm PP-R-pipes do not produce any gas toxicity. In case of fire, there is no risk of dioxin emissions. To avoid fire and smoke transmission aquatherm advises the use of fire retardant seals. The fire resistance period is the minimum period in minutes.

The extent of the preventive measures depends on the type of installation. The determining of fire areas and fire classification has to be made in acc. with the law of the country. Information is given by the Planning Department and Building Control Office or the Fire Protection Representative.

Basically fire walls and ceilings with pipe passages have to be installed to the same fire resistance classification. All fire protection systems with a corresponding classification are suitable for aquatherm PP-R-pipes.

aquatherm recommends the Rockwool®-Conlit fire retardant seals as ideal solution for both systems. Detailled information about the draft-guidelines 2000 will be given by our technical hotline +49 (0) 2722 950-200 or directly by Rockwool GmbH.

Recommended suppliers

- Deutsche Rockwool Mineralwoll | www.rockwool.de
- Doyma GmbH u. Co | www.doyma.de

FIRE LOAD

The values required for determining the fire load within a fire section are calculated from the total of all flammable materials located within this area. The calculation for establishing the combustion heat V [kWh / m] for a fire section in the event of an outbreak is dependent on dimensions and materials.

The basis used for the calculation of pipes made of PP-R is the lower calorific value

H_u = 12.2 kWh/kg (as per DIN V 18230 T1) in conjunction with the mass of material m_{pipe} [kg / m].

The integrated layers of faser in aquatherm faser-composite pipes also are considered.

Depending on the calculation procedure, the fire load is worked out with reference to the burn-up factor. This value is designated as mfactor and is taken as 0.8 for polypropylene.

Fire protection for aquatherm PP-R-pipes

The latest pipe supply regulation draft determines the professional wall and ceiling duct and also the pipe insulation of escape and rescue routes. The required pipe-insulation stipulated in this draft can be easily achieved by the aquatherm PP-R-pipes.

Combustion values V [kWh/m] for aquatherm green pipe, aquatherm blue pipe and aquatherm lilac pipe

Dimension mm	aquatherm green pipe & aquatherm lilac pipe SDR 11 S	aquatherm green pipe SDR 7.4 S	aquatherm green pipe SDR 6 S	aquatherm green pipe SDR 9 MF RP	aquatherm green pipe SDR 7.4 MF & aquatherm blue pipe SDR 7.4 MF SDR 7.4 MF OT	aquatherm green pipe SDR 11 MF & aquatherm blue pipe SDR 11 MF SDR 11 MF OT	aquatherm blue pipe SDR 17.6 MF
16	-	1,17	1,5	-	-	-	-
20	1,32	1,82	2,12	-	1,76	-	-
25	2,01	2,83	3,27	-	2,74	-	-
32	3,18	4,54	5,33	3,12	4,39	3,14	-
40	5,05	7,05	8,24	5,69	-	4,83	-
50	7,82	10,99	12,77	8,80	-	7,48	-
63	12,35	17,28	20,26	14,03	-	11,82	-
75	17,21	24,58	28,68	19,71	-	16,48	-
90	24,92	35,21	41,22	28,41	-	23,86	-
110	36,89	52,68	61,45	42,17	-	35,33	-
125	47,91	-	-	54,38	-	45,83	32,91
160	78,28	-	-	88,90	-	74,88	48,53
200	121,89	-	-	139,00	-	116,64	75,68
250	189,59	-	-	216,18	-	181,42	117,64
315	313,54	-	-	343,66	-	285,82	186,32
355	381,86	-	-	436,33	-	362,93	236,07
400	505,08	-	-	-	-	460,78	299,73
450	639,28	-	-	-	-	583,21	378,64
500	-	-	-	-	-	-	468,24
560	-	-	-	-	-	-	584,88
630	-	-	-	-	-	-	740,59



UV-RESISTANCE

Pipes made from fusiolen® PP-R and fusiolen® PP-R C are normally not installed where subject to UV-radiation. All aquatherm PP-R-pipes and -fittings have UV-stabilizer to bridge transport and installation times. Maximum storage time in the open air is 6 months.

For the application in open air aquatherm offers composite pipes with UV-protective layer made from polyethylene, which excludes damages caused by sunlight.

aquatherm PP-R-pipes with UV-protection are always available in stock.

Available types of pipe:
aquatherm green pipe MF
aquatherm blue pipe MF

UV ADHESIVE TAPE

As an alternative to our pipes, factory-equipped with UV protective layer, the wrapping with UV tape is possible, e.g. when fittings or short pieces of pipe must be protected. Therefore an elastic tape with good resistance to abrasion, moisture, oils, mild acids and alkalis and outdoor weather influences should be selected. The tape should always be applied to a dry, clean and grease-free surface. The winding should be performed with slight pulling and at least 50 % overlap.

Further information on page 112.

CHEMICAL AND THERMAL DISINFECTION

of aquatherm drinking water systems made of polypropylene

a) Chemical disinfection of the system

Contrary to the disinfection of drinking water, the disinfection of a system is a discontinuous measure, comprising a drinking water system from the area of contamination to the tapping point of the consumer. In general, a disinfection is to be applied temporarily only in case of a proven contamination.

In case of **discontinuous** disinfections, it is allowed to load aquatherm pipes and the corresponding fittings twice a year with a content of free chlorine of 50 mg/l for not more than 12 hours.

Alternatively, 150 mg/l hydrogen peroxide (H2O2) can be used for 24 hours. A temperature of 30 °C must not be exceeded during the disinfection process. The use of a disinfection process, especially with chlorinated waters can have a direct influence on the lifetime of the drinking water system. Under no circumstances should chlorine dioxide be used.

b) Chemical disinfection of drinking water

In case of **continuous** disinfection with chlorinated drinking water, it can be used with a content of free chlorine of up to 0.3 mg/l (limit according to 2001 drinking water ordinance). The maximum temperature of 70 °C should not be exceeded.

Unless required by local regulations, residual disinfection is not necessary where there is no evidence of bacterial water contamination.

Under no circumstances should chlorine dioxide be used.

Recommendation of the World Health Organization – Guidelines for Drinking-water Quality, Fourth Edition
For effective disinfection, there should be a residual concentration of free chlorine of ≥ 0.5 mg/l after at least 30 min contact time at pH < 8.0. A chlorine residual should be maintained throughout the distribution system. At the point of delivery, the minimum residual concentration of free chlorine should be 0.2 mg/l.

c) Thermal disinfection of the system

In general, a thermal disinfection according to DVGW W551 is possible. In case of the thermal disinfection for the prevention of legionella bacteria according to DVGW worksheet W 551, the water temperature will be adjusted in such a way that it amounts to 70 °C for at least 3 minutes at all points of the drinking water system. The maximum admissible limits of use regarding the service temperature and pressure are to be observed.

INTEGRATION OF OTHER SYSTEMS OR COMPONENTS WITH AQUATHERM PIPING FOR PRESSURE PIPE APPLICATIONS

When integrating aquatherm piping systems with other systems or components not made of PP-R (e.g. components not made of PP-R like valves, pumps, other piping, check valves, strainers, etc), care must be taken to ensure the operating parameters for PP-R won't damage the other materials or vice versa.

Be aware that even if the aquatherm pipe is compatible with the fluid being transported, other materials in the system may not be. All parts of the system must be verified as compatible with the medium being carried before installing them. And, while aquatherm pipe does not require treatment to protect it from corrosion, metals (ferrous and non-ferrous) in the system may be susceptible to corrosion.

Do not mix aquatherm pipe with other piping systems in conditions that will cause the other system or components to fail.

DOMESTIC HOT WATER RECIRCULATION (DHWR)

When there is copper piping used in conjunction with PP-R in a DHWR system, care should be taken to ensure the operating conditions will not cause degradation or erosion/corrosion of the copper. aquatherm recommends following the Copper Development Association guidelines (CDA Publication A4015-14/16: The Copper Tube Handbook – www.copper.org) for sizing, temperature and flow velocity in copper tubing. This will also help ensure that the copper levels in the water do not approach the regulatory action levels recommended by independent institutions (e.g. U.S. Environmental Protection Agency (EPA), World Health Organization (WHO), Federal Ministry of Justice and Consumer Protection of Germany). Sustained high levels of copper in DHWR piping can damage components within the system, even PP-R. **Damage caused by copper in the water resulting from erosion/corrosion or other degradation of copper components in the DHWR system will void the aquatherm warranty.**

Accordingly, and as mandated by various regulations and codes in DHWR systems, it is considered good design and operational practice to ensure that the maximum HW-temperature within any part of the system / loop does not exceed 60 °C (140 °F). Some regulations and codes further restrict the temperature at any fixture to a maximum of 50 °C (120 °F). There are some exceptions to this such as the process of thermal disinfection in health care facilities where temperatures of 70 °C (160 °F) or higher can be applied for short periods of time throughout the pipe system.

Importantly, the maximum temperature used must not exceed the rating of the pipe for the operating pressure. (See aquatherm green pipe catalogue – table: permissible working pressure potable/drinking water – Fluid transported: water acc. to DIN 2000)

According to some regulations and codes, flow rates in a DHWR system should not exceed 0.5 m/s (1.5 ft/sec) anywhere in the system, except in some special cases where velocities up to 1 m/s (3 ft/sec) are needed to achieve proper flow temperature. The CDA Publication A4015-14/16 – The Copper Tube Handbook – limits the velocity in DHWR system to similar rates.

When re-piping an existing DHWR-system originally installed in copper tubing, ensure all possible copper is replaced. If some copper remains as part of the system, strictly follow the rules and guidelines of the Copper Development Association (CDA Publication A4015-14/16: The Copper Tube Handbook) regarding flow rates and water conditions. Small amounts of copper or brass in valves and other equipment will generally not cause an issue. If the copper fails, it may degrade o-rings, gaskets, PP-R and other components as well, shortening their service life.

When adding PP-R to an existing copper system in a DHWR-application, the level of copper in the water should be tested. These levels should not exceed 0.1 mg/L (ppm). Higher levels of total copper indicate that the copper pipe is corroding/eroding due to system and/or water conditions.

To hydraulically balance a DHWR-system and ensure the required flow rate for each area of the building, it is necessary to install hydraulic-balancing-valves in every circulating loop throughout the complete system. This also maintains the flow velocity in the smaller return piping at or below the manufacturer's or CDA's recommendations.

In addition to sizing the piping and pumps to the correct flow velocity, care must also be taken to avoid water hammer and excessive surge pressures. Pump systems operating with on/off cycling, or pumps over-sized for the piping, can create high pressure and fatigue the piping material. The pump total dynamic head (TDH) must also be matched to the flow requirements, piping layout, and operating conditions to avoid cavitation for all components throughout the system. Cavitation can lead to excessive system noise and more importantly, can result in the erosion and degradation of the pipe surface and other components. Properly sized variable-speed (VFD) constant pressure pumping systems and pressure-sustaining valves can alleviate these issues. The pumps should be sized to operate at maximum efficiency with the lowest energy usage for the required flow rate.

The issues described here are only of concern in DHWR-systems. For domestic cold water (DCW) and mechanical (heating-cooling)-systems no additional requirements or actions are necessary. In some situations, the DHWR system is also used to provide hot water to the mechanical heating system. Additional consideration and care must be given for this type of combined system, as the mechanical components may not be compatible with the more aggressive water conditions and flow velocity limitations of DHWR systems, and these components may be not suitable for potable water contact.

QUALITY ASSURANCE

The following laws, decrees, guidelines and standards have to be considered on planning and designing aquatherm PP-R-pipes for potable water and heating installations:*

Planning:

TrinkwV-2000 Regulation for Potable Water

DIN 2000 Central drinking water supply-Guidelines regarding requirements for drinking water, planning, construction,operation and maintenance of plants

EnEV Decree for Energy Saving

DIN 1988 Standard for Potable Water Installations

ISO 10508Plastic pipe systems for hot and cold water installation – Guideline for classification and dimensioning

All provided pipe-systems correspond to the technical conditions of the application classes acc. to ISO 10508 for the field of potabel water and heating.

aquatherm green pipe for the classes 1, 2 (potable water), aquatherm blue pipe for the classes 4 and 5 (heating). For the application of the classification system (acc. to ISO 10508) the national regulations and the manufacturer´s instructions must be considered.

DIN 4109 Standard for the Elimination of Noise in the Field of Structural Engineering

DIN 18381 Installation of Gas, Water and VOB Part C Sewage Pipes inside Buildings

DIN 16928 Pipe Connections, Fittings, Installation

DVS 2207 Welding of Thermoplastics

DVS 2208 Welding Machines and Devices for Thermoplastics

aquatherm Technical Information

Systemspecific standards:
General quality requirements, dimensions

DIN 8077 Polypropylene (PP) Pipes, Dimensions

DIN 8078 Polypropylene (PP) Pipes, General Quality Requirements

DIN 16962ff Pipe Joint Assemblies and Fittings for Polypropylene Pressure Pipes

DIN EN ISO 15874ff Plastic pipe systems for hot and cold water installation; polypropylene

DVGW-Working sheets

SKZ-Guidelines

DIN EN ISO 9000 ff.

Systemspecific standards: Hygiene

BfR Federal Institute for risk assignment

Health assessment of plastics and non-metallic materials within the framework of the law for foods and commodity goods for potable water applications

DVGW-working sheet W 270

Increase of Microorganism on Materials. Used for Potable Water Applications – Test and Evaluation

BS 6920

"Suitability of non-metallic products for use in contact with water intended for human consumption with regard to their effect on the quality of water."

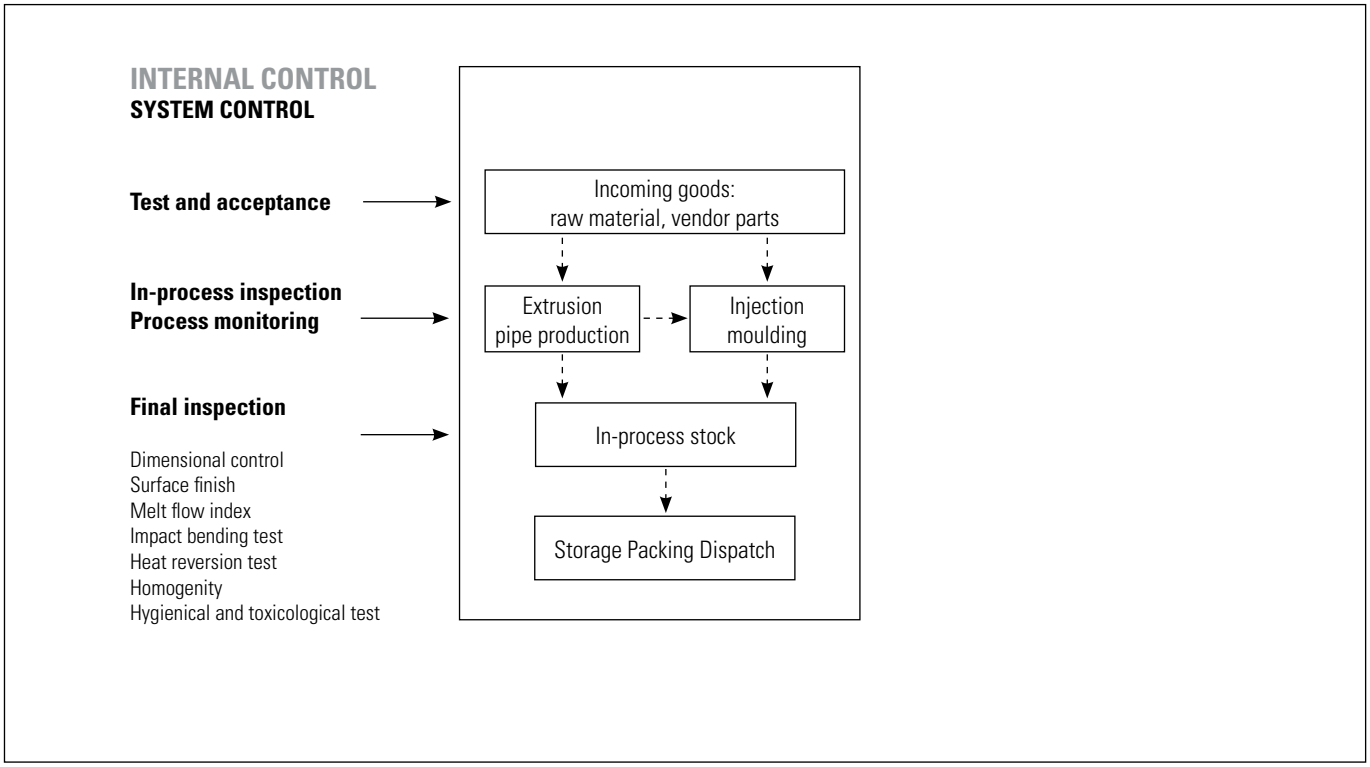
Local regulations and codes of practice must be observed. The same goes for regulations regarding the use of chemicals.

*(Additional regional decrees and recommendations are disregarded.)

COMPLIANCE WITH THE SYSTEM STANDARD

Various national and international independent authorities and institutions confirm aquatherm's quality standard

AQUATHERM QUALITY MANAGEMENT SYSTEM



In addition to the permanent internal quality control, an external control is made by i.e. SKZ, SAI, TGM, Hygieneinstitut.



SYSTEM CONTROL

The production of a quality controlled pipe system demands the supervision, regulation and control of all work operations. All results and processes have to be documented.

This requires

- Test and acceptance of incoming goods
- Process control
- In-process inspection and test
- Final inspection and test

Relevant regulations for the quality control of potable water pipe systems are:

- DIN-guidelines
- DVGW-working sheets
- Supervisory Regulations of the SKZ (Süddeutsches Kunststoff-Zentrum)

These standards and guidelines detail the minimum requirements for internal control.

Conformance to the standards is verified by independent institutes in form of internal audits and laboratory tests.

aquatherm has many years of experience in extrusion and injection moulding and is the market leader and pioneer in the manufacture of polypropylene pipe systems.

This experience is reflected in internal quality standards and laid down procedures, which are taken strongest note of and are documented by the constant quality of our products.

Internal control

Trained and qualified employees and a modern equipped laboratory ensure that all tests are carried out and regulations are complied with in accordance with the quality control policy, which includes

- Control of inspection, measuring and test equipment process and Production control
- Receiving inspection test
- In-process inspection
- Final inspection

All internal quality controls are documented and recorded in acc. with the quality control policy.



QUALITY ASSURANCE

Test and acceptance of incoming goods

All incoming goods are subject to a test. This ensures that incoming products conform to specified requirements. Goods, which have not been tested are not released for production.

In-process inspection and test

The quality plan requires that tests and inspections are carried out before and during production. At the start of production all quality relevant data are checked by the quality assurance department. Preproduction samples are tested by the laboratory technicians for

- Surface finish
- Dimensional accuracy of the test samples
- Data from extrusion and injection moulding machines

The goods will be released for production only if optimal test results are achieved. These tests are carried out at the beginning of each production series to ensure perfect system quality.

Process control

Ultrasonic measurement and process data recording in the field of extrusion are only one example of the extensive quality control process.

This equipment enables constant observation and control of production.

Ultrasonics automatically measure and report any deviations in tolerance to the cutting device on the extrusion machine so that the sizing plant automatically isolates a substandard product. This ensures that only perfect quality products are packed and stored.

All data received during production is analyzed in detail.

Final inspection and test

The quality plan requires that inspections and tests are carried out on all finished products. The results are documented in test reports. Finished products are only released to stock when all tests and inspections conform to the prescribed procedures and specifications.

The final inspection and test includes time lapse test procedures. This enables statements regarding the usability of the products in their later field of application.

These tests are the method for quality assurance during production and for design tests. This is to discover and remove production weaknesses. The results document the system quality and optimize the manufacturing processes. The final inspection and test covers the following test procedures:

- Dimensional control
- Surface finish
- Measurement of the melt flow index
- Impact bending test
- Heat reversion test
- Homogeneity of the material
- Internal pressure test

In addition to the tests mentioned above, daily hygiene tests in accordance with KTW / DVGW Guidelines arecarried out regularly in the company's own sensoryanalysis laboratory.



EXTERNAL CONTROL

External supervision consists of tests of a defined scope and in defined intervals. The respective supervising institutions appoint authorized test organizations to carry out these tests.

The external supervision includes external tests of the products and

a) internal audit of aquatherm's quality assurance system and test procedures,

b) calibration of the test equipment and

c) hygienic and toxicity tests.

The results of the supervisory visits as well as external tests made on pipe and fitting samples are confirmed to aquatherm in test certificates.

In Germany, the external supervision of the aquatherm green pipe system is carried out by the

- SKZ (Süddeutsches Kunststoffzentrum Würzburg)
- Institute for Hygiene, Gelsenkirchen (Hygieneinstitut Gelsenkirchen)

who are authorized by the DVGW (German Institute for Gas and Water) as controlling organization. The external supervision for certificates from abroad is carried out in a similar way.

Storage / packing / dispatch

Upon successful release the products are stored in suitable warehouses.

Internal instructions control the method of packing, storage and dispatch of the products. The warehouse staff is responsible for control of the stored product.

FUSION

PART A: ASSEMBLY OF WELDING TOOLS

The professional processing of aquatherm PP-R-medium pipes is made by the following tools for the connection of insulated pipes and fittings by socket welding or by butt-welding.

IMPORTANT!

Only use the original aquatherm welding devices and aquatherm welding tools, except devices and tools which are especially approved by aquatherm.

1. **aquatherm** manual welding device (800 W) without welding tools (Art. no. 50337) for medium pipes of dimension 16–63 mm

2. **aquatherm** manual welding device (1400W) without welding tools (Art. no. 50341) for medium pipes of dimension 50–125 mm

3. **aquatherm** welding tools for manual welding devices

Art. no. 50206	16 mm
Art. no. 50208	20 mm
Art. no. 50210	25 mm
Art. no. 50212	32 mm
Art. no. 50214	40 mm
Art. no. 50216	50 mm
Art. no. 50218	63 mm
Art. no. 50220	75 mm
Art. no. 50222	90 mm
Art. no. 50224	110 mm
Art. no. 50226	125 mm

4. **aquatherm** welding machine (1400W) incl. welding tools 50–125 mm (Art. no. 50148) for medium pipes of dimension 50–125 mm

5. **aquatherm** butt-welding-machines for medium pipes of dimension 160–630 mm

6. **aquatherm** electrical welding jig Art. no. 50159 for medium pipes of dimension 63–125 mm



Manual welding device 800W with welding tools 16–63 mm



Manual welding device 1400W with welding tools 50–125 mm



Welding machine



Butt-welding machine two-ring-machine and accessories



Electrical welding jig

MOUNTING OF THE TOOLS

1. aquatherm green, blue and lilac pipe system are processed identically.

Assemble and tighten the cold welding tools manually.

3. Before fusing the distribution block, in which two connections are fused simultaneously, the welding tools have to be placed into the respective holes as described in the adjoing table A and drawing B.

4. All welding tools must be free from impurities. Check if they are clean before assembling. If necessary clean the welding tools with a non fibrous, coarse tissue and with methylated spirit.

Place the welding tools on the welding device so that there is full surface contact between the welding tool and the heating plate. Welding tools over Ø 40 mm must always be fitted to the rear position of the heating plate.

Electric supply:

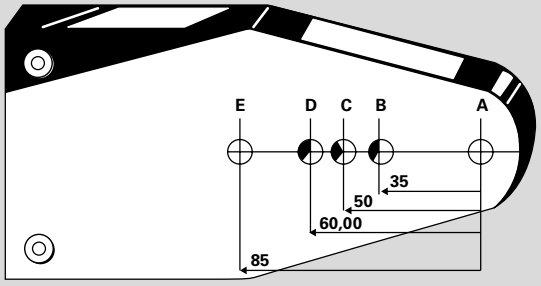
The power supply must coincide with the data on the type plate of the welding device and must be protected according to the local regulations. To avoid high power loss, the conductor cross-section of the used extension cables must be selected according to the power input of the welding devices.

6. Plug in the welding device. Depending on the ambient temperature it takes 10–30 minutes to heat up the heating plate.

A

Art. no.	Passage	Hole	Branch	Hole
30115	Ø 25 mm	A + E	Ø 20 mm	A + C
85123	Ø 20 mm	A + B	Ø 16 mm	A + C

B







PART A: HEATING UP PHASE / HANDLING



Part A: Heating up phase

7. During the heating up phase tighten the welding tools carefully with the Allan key.

   Take care that the tools completely contact the heating plate. Never use pliers or any other unsuitable tools, as this will damage the coating of the welding tools.

8. The temperature of 260 °C is required for the welding of aquatherm PP-R-pipes.

   Acc. to DVS-Welding Guidelines the temperature of the welding device has to be checked at its tool before starting the welding process.

   This can be done with a fast indicating surface thermometer.

ATTENTION:

First welding – soonest 5 minutes after reaching of the welding temperature. DVS 2207, Part 11.

Part A: Handling

9. A tool change on a heated device requires another check of the welding temperature at the new tool (after its heating up).

10. If the device has been unplugged, e.g. during longer breaks, the heating up process, has to be restarted (see item 6).

11. After use unplug the welding device and let it cool down. Water must never be used to cool the welding device, as this would destroy the heating resistances.

12. Protect aquatherm welding devices and tools against impurities. Burnt particles may lead to an incorrect fusion. The tools may be cleaned with aquatherm cleaning cloths, Art. no.50193.

Always keep the welding tools dry.

13. After welding, do not lay the device on the Teflon coated tool, but put it down in the provided supporting stand.

14. For a perfect fusion, damaged or dirty welding tools must be replaced, as only impeccable tools guarantee a perfect connection.

15. Never attempt to open or repair a defective device. Return the defective device for repair.

16. Check the operating temperature of aquatherm welding devices regularly by means of suitable measuring instruments.

PART A: GUIDELINES
PART B: CHECKING OF DEVICES AND TOOLS

Part A: Guidelines

17. For the correct handling of welding machines the following must be observed:

General Regulations for Protection of Labour and Prevention of Accidents and particularly the Regulations of the Employers' Liability Insurance Association of the Chemical Industry regarding Machines for the Processing of Plastics, chapter: „Welding Machines and Welding Equipment".

18. For the handling of aquatherm welding machines, devices and tools please observe General Regulations DVS 2208 Part 1 of the German Association for Welding Engineering, Registered Society (Deutscher Verband für Schweißtechnik e.V.).

Part B: Checking of devices and tools

1. Check, if the aquatherm welding devices and tools comply with to the guidelines "Fusion Part A".

2. All used devices and tools must have reached the necessary operating temperature of 260 °C. This requires acc. to "Fusion Part A, item 8" a separate test, which is indispensable (DVS-Welding Guidelines):

Suitable measuring instruments have to measure a temperature of up to 350 °C with a high accuracy.

NOTE:
aquatherm recommends the original aquatherm temperature measuring device Art. no. 50188



Measurement of temperature at the aquatherm manual welding device (800W)



Measurement of temperature at the aquatherm welding machine



Measurement of temperature at the aquatherm butt-welding machine

PART B: PREPARATION FOR THE FUSION

3. Cut the pipe at right angles to the pipe axis. Only use aquatherm pipe cutters or other suitable cutting pliers. Take care that the pipe axis is free from burrs or cutting debris and remove where necessary.

4. Mark the welding depth at the end of the pipe with the enclosed pencil and template.

5. Mark the desired position of the fitting on the pipe and/or fitting. The markings on the fitting and the uninterrupted line on the pipe may be used as a guide.



Cutting of the pipe



Marking of the welding depth

PART B: HEATING OF PIPE AND FITTING

Heating of pipe and fitting

6. Push the end of the pipe, without turning, up to the marked welding depth into the welding tool.

   It is essential to observe the aforementioned heating times.

   Pipes and fittings of the dimensions Ø 75 to 125 mm can only be welded with welding device Art. no. 50341 (or with machine Art. no. 50148). On using the aquatherm welding machine Art. no. 50148 a separate operating instruction has to be observed.

ATTENTION:

The heating time starts, when pipe and fitting have been pushed to the correct welding depth on the welding tool. Not before!

PART B: SETTING AND ALIGNMENT

7. After the required heating time quickly remove pipe and fitting from the welding tools. Joint them immediately, and without turning, until the marked welding depth is covered by the PP-bead from the fitting.

ATTENTION:

Do not push the pipe too far into the fitting, as this would reduce the bore and in an extreme case will close the pipe.

8. The joint elements have to be fixed during the specified assembly time. Use this time to correct the connection. Correction is restricted to the alignment of pipe and fitting. Never turn the elements or align the connection after the processing time.

9. After the required cooling time the fused joint is ready for use.

   The result of the fusion of pipe and fitting is a permanent material joining of the system elements. Connection technique with security for a life-time.

The fusion is subject to the following data

Pipe external- Ø	Welding depth	Heating time		Welding time	Cooling time
mm	mm	sec. DVS	sec. AQT*	sec.	min.
20	14,5	5	8	4	2
25	16,0	7	11	4	2
32	18,0	8	12	6	4
40	20,5	12	18	6	4
50	23,5	18	27	6	4
63	27,5	24	36	8	6
75	30,0	30	45	8	8
90	33,0	40	60	8	8
110	37,0	50	75	10	8
125	40,0	60	90	10	8

ATTENTION: **sec. AQT*** heating times recommended by aquatherm at ambient temperatures below + 5 °C



Heating-up of pipe and fitting



Joining, fixing and…



…aligning



The result: a permanent connection!

Dimension 160–630 mm:

The dimension 160–630 mm are joined by butt-welding.

Detailed information page 60–65.

The General Guidelines for Heated Tool Socket Welding acc. to DVS 2207 Part 11 are applied hereupon.

PART B: UNIVERSAL PEELING TOOLS

By using the aquatherm universal peeling tools the end pieces of the aquatherm OT (oxygen tight) and UV (UV-resistant) can be peeled. By the uniform removal of the outer layer of the pipe any extension of the pipe system by electrofusion socket or fitting is possible. The universal peeling tools are available in the sizes Ø 20–125 mm (Art. no. 50479–50488). The peeling process is done either mechanically or manually. For the mechanical processing two attachment plates for pipe sizes Ø 20–63 mm (Art. no. 50499) and Ø 75–125 (Art. no. 50500) mm are available. For the mechanically processing of the electrofusion sockets the peeler is extended by an attachment (Art. no. 50489–50498). The power drill should have a high torque.

1. INSTRUCTIONS FOR THE MECHANICAL PEELING PROCESS

1.1. The attachment plate is clamped with the hexagon bolt in the power drill.

1.2. The peeler is fixed with its screws in the slot matching the diameter of the attachment plate and rotated clockwise so that the peeler adheres to the attachment plate.

1.3. The peeling tool clamped on the chuck is set by the lead to the end of the pipe.

1.4. The peeling process starts with rotation of the peeling tool upon slight force in axial direction. The peeling operation is completed when the attachment plate strikes against the pipe end.

1.5. The pipe now can be welded by socket welding method.

2. INSTRUCTIONS FOR THE MECHANICAL PEELING PROCESS FOR ELECTROFUSION SOCKETS

2.1. The extension is centered with the peeler through the superimposed chamfer fit and fastened with three Allen screws.

2.2. The attachment plate is clamped with the hexagon bolt in the power drill and connected with the peeling tool (see photo **1.2.**).

2.3. The peeling process starts with rotation of the peeling tool upon slight force in axial direction. The peeling operation is completed when the carrier plate strikes against the pipe end.

2.4. The peeling tool is withdrawn from the pipe and the E-socket welding process can start.

3. PEELING INSTRUCTIONS FOR MANUAL PEELING

3.1. For the manual peeling two handles are mounted at the peeling tool.

3.2. The peeling tool is pushed onto the untreated pipe up to the stop.

3.3. The peeling tool is turned clockwise as long as the marked peeling depth (see table on the next page) is reached.

3.4. If the specified/marked peeling depth (see table) is reached, the peeling tool is removed and the socket welding process can start. If the electric socket can be used as a sliding sleeve, the peeling depth for the electric socket welding (see table) must be doubled.

1.1



1.2



1.3



1.4



1.5



















TABLE OF PEELING DEPTH:
SOCKET AND ELECTRIC SOCKET WELDING

Diameter	Peeling depth Socket welding	Peeling depth Electric socket welding
ø 20	16 mm	39 mm
ø 25	20 mm	43 mm
ø 32	22 mm	45 mm
ø 40	25 mm	50 mm
ø 50	28 mm	56 mm

Diameter	Peeling depth Socket welding	Peeling depth Electric socket welding
ø 63	32 mm	65 mm
ø 75	34 mm	69 mm
ø 90	37 mm	77 mm
ø 110	42 mm	85 mm
ø 125	44 mm	90 mm

46

PART C: WELD-IN SADDLES

aquatherm weld-in saddles are available for pipe outer diameter of 40–630 mm.

Weld in saddles are used for

- Branch connections in existing installations
- The substitution of a reduction-tee
- Branch connections in risers
- Sensor wells, etc.

The maximum sensor well diameter is specified in the table on page 49.

1. Before starting the welding process, check whether the aquatherm welding devices and tools comply with the requirements of "Fusion Part A".

2. The first step is to drill through the pipe wall at the intended outlet point by using the aquatherm drill (Art. no. 50940–50958).

3. IMPORTANT!

Only the oxygen barrier layer of the aquatherm blue pipe OT Art. no. 2170708–2170138 must be removed with the mentioned aquatherm special peeling drills mentioned in the table beside.

For this the special peeling drill is inserted into the bore hole and swaied 2–3 times with light pressure and low rotating speed between the pipe walls until the oxygen barrier layer is completely peeled off.

The UV-layer is removed in the same way.

Remove burrs, debris and other dirts with a chamfering tool or the aquatherm cleaning wipes. Do not touch the peeled surface any more and protect it from new pollution.

4. The welding device / saddle welding tool must have reached the required operating temperature of 260 °C (check with reference to "Fusion Part B, item 2").

5. The welding surfaces have to be clean and dry.

6. Insert the heating tool on the concave side of the weld in saddle tool into the hole drilled in the pipe wall until the tool is completely in contact with the outer wall of the pipe. Next the weld-in saddle tool is inserted into the heating sleeve until the saddle surface is up against the convex side of the welding tool. The heating time of the elements is generally 30 seconds.

7. After the welding tool has been removed, the weld-in saddle tool is immediately inserted into the heated, drilled hole. Then the weld-in saddle should be pressed on the pipe for about 15 seconds. After being allowed to cool for 10 minutes the connection can be exposed to its full loading. The appropriate branch pipe is fitted into the sleeve on the aquatherm weld-in saddle using conventional fusion technology.

By fusing the weld-in saddle with the pipe outer surface and the pipe inner wall the connection reaches highest stability.





Drilling through the pipe wall





Removal of the oxygen barrier layer in case of the aquatherm blue pipe OT and of the UV layer in case of the aquatherm UV-pipe

aquatherm saddle peeling tools
for **aquatherm blue pipe** OT-pipes
aquatherm blue pipe UV-pipes
aquatherm green pipe UV-pipes
ø 50–125 mm

Art. no.	Dimension
50921	for weld-in saddles ø 20 & 25 mm
50922	for weld-in saddles ø 32 mm
50924	for weld-in saddles ø 40 mm
50926	for weld-in saddles ø 50 mm
50928	for weld-in saddles ø 63 mm

aquatherm saddle peeling tools
for **aquatherm blue pipe** OT-pipes
aquatherm blue pipe UV-pipes
aquatherm green pipe UV-pipes
ø 160–250 mm

Art. no.	Dimension
50421	for weld-in saddles ø 20 & 25 mm
50422	for weld-in saddles ø 32 mm
50424	for weld-in saddles ø 40 mm
50426	for weld-in saddles ø 50 mm
50428	for weld-in saddles ø 63 mm



The welding tool is inserted into the pipe wall …



…heating-up of the elements



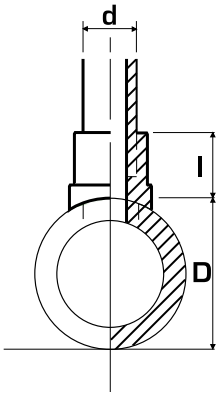
Joining



Ready!

PART C: WELD-IN SADDLES

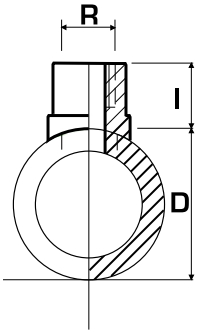
Art. no.	Dimension	D	d	l	Drill	Special peeling drill[1]	Tool
		mm	mm	mm	Art. no.	Art. no.	Art. no.
15156	40/20 mm	40	25	27.0	50940	50921	50614
15158	40/25 mm	40	25	28.0	50940	50921	50614
15160	50/20 mm	50	20	27.0	50940	50921	50616
15162	50/25 mm	50	25	28.0	50940	50921	50616
15164	63/20 mm	63	20	27.0	50940/50941	50921	50619
15166	63/25 mm	63	25	28.0	50940/50941	50921	50619
15168	63/32 mm	63	32	30.0	50942	50922	50620
15170	75/20 mm	75	20	27.0	50940/50941	50921	50623
15172	75/25 mm	75	25	28.0	50940/50941	50921	50623
15174	75/32 mm	75	32	30.0	50942	50922	50624
15175	75/40 mm	75	40	34.0	50944	50924	50625
15176	90/20 mm	90	20	27.0	50940/50941	50921	50627
15178	90/25 mm	90	25	28.0	50940/50941	50921	50627
15180	90/32 mm	90	32	30.0	50942	50922	50628
15181	90/40 mm	90	40	34.0	50944	50924	50629
15182	110/20 mm	110	20	27.0	50940/50941	50921	50631
15184	110/25 mm	110	25	28.0	50940/50941	50921	50631
15186	110/32 mm	110	32	30.0	50942	50922	50632
15188	110/40 mm	110	40	34.0	50944	50924	50634
15189	110/50 mm	110	50	34.0	50946	50926	50635
15190	125/20 mm	125	20	27.0	50940/50941	50921	50636
15192	125/25 mm	125	25	28.0	50940/50941	50921	50636
15194	125/32 mm	125	32	30.0	50942	50922	50638
15196	125/40 mm	125	40	34.0	50944	50924	50640
15197	125/50 mm	125	50	34.0	50946	50926	50642
15198	125/63 mm	125	63	38.0	50948	50928	50644
15206	160/20 mm	160	20	27.5	50940/50941	50421	50648
15208	160/25 mm	160	25	28.5	50940/50941	50421	50648
15210	160/32 mm	160	32	30.0	50942	50422	50650
15212	160/40 mm	160	40	34.0	50944	50424	50652
15214	160/50 mm	160	50	34.0	50946	50426	50654
15216	160/63 mm	160	63	38.0	50948	50428	50656
15218	160/75 mm	160	75	42.0	59050	-	50657
15220	160/90 mm	160	90	45.0	50952	-	50658
15228	200–250/20 mm	200–250	20	27.5	50941	50421	50660 / 50672
15229	200–250/25 mm	200–250	25	28.5	50941	50421	50660 / 50672
15230	200–250/32 mm	200–250	32	30	50942	50422	50662 / 50674
15231	200/40 mm	200	40	34	50944	50424	50664
15232	200/50 mm	200	50	34	50946	50426	50666
15233	200/63 mm	200	63	37.5	50948	50428	50668
15234	200/75 mm	200	75	42.0	50950	-	50667
15235	200/90 mm	200	90	42.0	50952	-	50669
15236	200/110 mm	200	110	49.0	50954**	-	50670
15237	200/125 mm	200	125	55.0	50956**	-	50671
15251	250/40 mm	250	40	34	50944	50424	50676
15252	250/50 mm	250	50	34	50946	50426	50678
15253	250/63 mm	250	63	37.5	50948	50428	50680
15254	250/75 mm	250	75	42.0	50950	-	50682
15255	250/90 mm	250	90	45.0	50952	-	50684
15256	250/110 mm	250	110	49.0	50954**	-	50686
15257	250/125 mm	250	125	55.0	50956**	-	50688
15260	315/63 mm	315	63	37,5	50948	-	50690
15261	315/75 mm	315	75	42,0	50950	-	50692
15262	315/90 mm	315	90	45,0	50952	-	50694
15263	315/110 mm	315	110	49,0	50954**	-	50696
15264	315/125 mm	315	125	55,0	50956**	-	50698
15268	355/90 mm	355	90	45,0	50952	-	50716
15269	355/110 mm	355	110	49,0	50954**	-	50718
15270	355/125 mm	355	125	55,0	50956**	-	50720
15271	355/160 mm	355	160	-	50958	-	50722
15275	400–500/75 mm	400–500	75	-	50950	-	50728
15277	400–450/110 mm	400–500	110	-	50954	-	50736
15278	400/125 mm	400	125	-	50956	-	50742
15288	400–500/90 m	400–500	90	-	50952	-	50732
15290	450–500/125 m	400–500	125	-	50956	-	50744
15300	400–630/63 mm	400	63	-	50948	-	50726
15303	500–560/110 mm	500–560	110	-	50954	-	50738
15315	560–630/75 mm	560–630	75	-	50950	-	50730
15316	560–630/90 mm	560–630	90	-	50952	-	50734
15318	560–630/125 mm	560–630	125	-	50956	-	50746
15331	630/110 mm	630	110	-	50954	-	50740



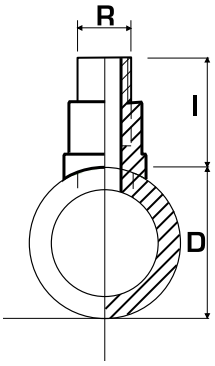
[1] only for aquatherm blue pipe OT faser composite pipes, Art. no. 2170708–2170138
** tool holder MK4

PART C: WELD-IN SADDLES

Art. no.	Dimension	D	d	l	Sensor-wells	Drill	Special peeling drill[1]	Tool
		mm	mm	mm	Art. no.	Art. no.	Art. no.	Art. no.
28214	40/25 x 1/2" f	40	1/2"	39,0	14	50940	50921	50614
28216	50/25 x 1/2" f	50	1/2"	39,0	14	50940	50921	50616
28218	63/25 x 1/2" f	63	1/2"	39,0	14	50940/50941	50921	50619
28220	75/25 x 1/2" f	75	1/2"	39,0	14	50940/50941	50921	50623
28222	90/25 x 1/2" f	90	1/2"	39,0	14	50940/50941	50921	50627
28224	110/25 x 1/2" f	110	1/2"	39,0	14	50940/50941	50921	50631
28226	125/25 x 1/2" f	125	1/2"	39,0	14	50940/50941	50921	50636
28230	160/25 x 1/2" f	160	1/2"	39,0	14	50940/50941	50921	50648
28232	200–250/25 mm x 1/2" f	200–250	1/2"	39,0	14	50941	50921	50660/50672
28234	40/25 x 3/4" f	40	3/4"	39,0	16	50940	50920	50614
28236	50/25 x 3/4" f	50	3/4"	39,0	16	50940	50921	50616
28238	63/25 x 3/4" f	63	3/4"	39,0	16	50940/50941	50921	50619
28240	75/25 x 3/4" f	75	3/4"	39,0	16	50940/50941	50921	50623
28242	90/25 x 3/4" f	90	3/4"	39,0	16	50940/50941	50921	50627
28244	110/25 x 3/4" f	110	3/4"	39,0	16	50940/50941	50921	50631
28246	125/25 x 3/4" f	125	3/4"	39,0	16	50940/50941	50921	50636
28250	160/25 x 3/4" f	160	3/4"	39,0	16	50940/50941	50921	50648
28254	200–250/25 mm x 3/4" f	200–250	3/4"	39,0	16	50941	50921	50660/50672
28260	75/32 x 1" f	75	1"	43,0	20	50942	50922	50624
28262	90/32 x 1" f	90	1"	43,0	20	50942	50922	50628
28264	110/32 x 1" f	110	1"	43,0	20	50942	50922	50632
28266	125/32 x 1" f	125	1"	43,0	20	50942	50922	50638
28270	160/32 x 1" f	160	1"	43,0	20	50942	50922	50650
28274	200–250/32 mm x 1" f	200–250	1"	43,0	20	50942	50922	50662/50674



Art. no.	Dimension	D	d	l	Drill	Special peeling drill[1]	Tool
		mm	mm	mm	Art. no.	Art. no.	Art. no.
28314	40/25 x 1/2" m	40	1/2"	55,0	50940	50921	50614
28316	50/25 x 1/2" m	50	1/2"	55,0	50940	50921	50616
28318	63/25 x 1/2" m	63	1/2"	55,0	50940/50941	50921	50619
28320	75/25 x 1/2" m	75	1/2"	55,0	50940/50941	50921	50623
28322	90/25 x 1/2" m	90	1/2"	55,0	50940/50941	50921	50627
28324	110/25 x 1/2" m	110	1/2"	55,0	50940/50941	50921	50631
28326	125/25 x 1/2" m	125	1/2"	55,0	50940/50941	50921	50636
28330	160/25 x 1/2" m	160	1/2"	55,0	50940/50941	50921	50648
28334	40/25 x 3/4" m	40	3/4"	56,0	50940	50921	50614
28336	50/25 x 3/4" m	50	3/4"	56,0	50940	50921	50616
28338	63/25 x 3/4" m	63	3/4"	56,0	50940/50941	50921	50619
28340	75/25 x 3/4" m	75	3/4"	56,0	50940/50941	50921	50623
28342	90/25 x 3/4" m	90	3/4"	56,0	50940/50941	50921	50627
28344	110/25 x 3/4" m	110	3/4"	56,0	50940/50941	50921	50631
28346	125/25 x 3/4" m	125	3/4"	56,0	50940/50941	50921	50636
28350	160/25 x 3/4" m	160	3/4"	56,0	50940/50941	50921	50648



[1] only for aquatherm blue pipe OT faser composite pipes, Art. no. 2170708–2170138

PART C: WELD-ON SADDLE

Drilling of aquatherm PP-pipes with the hot tapping tool Art. no. 50890 under pressure.

The aquatherm weld-on saddle set (consisting of ball valve, pipe and saddle in the dimensions 40 mm and 63 mm) is used for the additional installation of branch connections.
The PP-R pipes aquatherm green pipe, blue pipe and lilac pipe with the pipe structure S, MF and MF UV in the dimensions 75–630 mm can be drilled under pressure.

SAFETY INSTRUCION::
The medium pressure (e.g. water) in the main pipe of 6 bar and the medium temperature of max. 60 °C must not be exceeded.

1. Preparation and fusion

After removal of the oxide layer on the main pipe and the cleaning of the welding surfaces, the welding device is placed with the weld-on saddle tool on the surfaces to be welded. Under gentle pressure and a warm-up time of 90 sec. an even bead must be there on the welding surfaces. After a warm-up time, the component is placed quickly on the main pipe. The component is fixed and aligned on the main pipe for max. 15 seconds. The connection is fully able to work under pressure after a cooling time of 15 minutes.

2. Assembly of the hot tapping tool

The hot tapping tool is screwed onto the component with the retracted drill rod, which is secured by the clamping claw. The screw connection on the ball valve is tightened by hand. After the ball valve has been opened, the welded component in conjunction with the hot tapping tool is tested for leaks with water or air.

3. Drilling process

When the clamping claw is loosened, the drill rod is pushed until the drilling tool contacts the pipe. Depending on the branch size, the appropriate feed rate must be set. The drilling is carried out by actuating the ratchet handle and simultaneously by giving a manually sensitive feed on the feed handles. After completion of the drilling and the release of the clamping claw, the drill rod is lead back to the stop by hand. Caution: The drill rod can rebound by the pressure in the pipe. The ball valve is then closed and the hot tapping device is relieved of pressure.

4. Disassembly

Detach the hot tapping device by holding the screw on the ball valve and remove it from the component. Pull the drill rod out of the hot tapping device and screw the drilling tool from the drill rod using a suitable wrench or armature tongs.



Hot tapping device Art.no. 50890



1. Welding-on of weld-on saddle set onto the main pipe



2. Assembly of the hot tapping tool onto the component



3. Start of the drilling process



4. Removal of the drilling residues out of the drilling tool

PART D: PULLING JIG (HITCH)

Notice

The following description of the electric pulling jig applies to the type of the year 2013.

Operation and fusion

With the help of the electric pulling jig, all aquatherm PP-R-pipes and fittings in dimensions from 63 to 125 mm are in a very simple manner without any effort welded together.

Also the pulling jig simplifies the welding of pipes and fittings under ceilings, in narrow shafts and other hard-to-reach places.

1. Preparation for the fusion

Mark the welding depth with the included green marking template on the pipe end (Fig. 1). In addition, the clamping depth is measured 2 cm from the welding depth marking and marked again (Fig. 2 + 3).









PART D: PULLING JIG (HITCH)

1. Preparation for the fusion

The pulling jig is now placed on the fitting or pipe to be welded with the clamping jaws (Fig. 4).

The two arrows of the jaws and the machine must be flush with each other. The jaws are to be fixed with the help of the clamping device (Fig. 5).

Align the pipe so that the rear marking is flush with the inner edge of the clamping jaw. The front marking identifies the welding depth (Fig. 6).

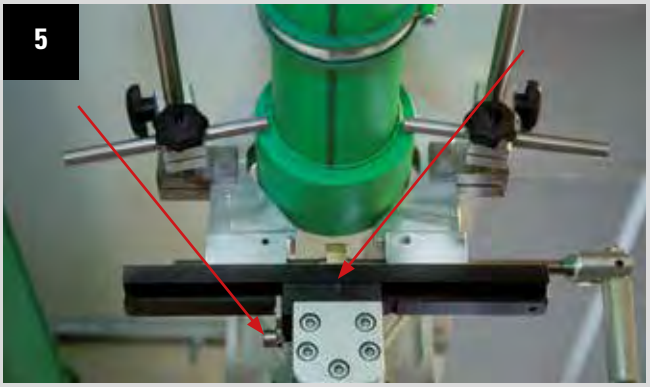
Lock pipe and fitting by using the front adjusting screws (Fig. 7).

Never clamp so tight that deformations appear. Additionally, with the fitting support, all fittings are supported. The support is mounted on the clamping jaw for fittings (Fig. 8).

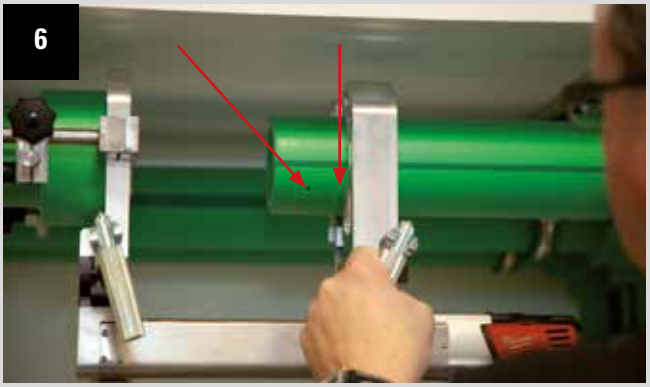
4



5



6



7



8



PART D: PULLING JIG (HITCH)

2. Fusion

Hold the welding device between pipe and fitting and ride machine carriage in batches together (pay attention to the welding depth).

Basically the jaws must be released after the insertion of pipe and fitting in the welding tool by a short return of the machine (3–7 mm)! The jaws must always be parallel to each other (Fig. 9 +10).

After finishing of the warm-up drive the machine carriage apart and remove the welding device (Fig. 11).

Ride the jaws together again and release the clamping jaws again by a short return of the machine (3–7 mm) (Fig. 12).

CAUTION:

Jaws may be released only after the expiry of the cooling time!

Pipe and fitting are now joined by fusion to a material unit (Fig. 13).

The fusion is subject to the following data

Pipe external-Ø	Welding depth	Heating time		Welding time	Cooling time
mm	mm	sec. DVS	sec. AQT*	sec.	min.
63	27,5	24	36	8	6
75	30,0	30	45	8	8
90	33,0	40	60	8	8
110	37,0	50	75	10	8
125	40,0	60	90	10	8

ATTENTION: **sec. AQT*** heating times recommended by aquatherm at ambient temperatures below + 5 °C

The General Guidelines for Heated Socket Welding acc. to DVS 2207, Part 11 are applied hereupon.

9



10



11



12



13



PART E: AQUATHERM WELDING MACHINE

for stationary processing 50–125 mm

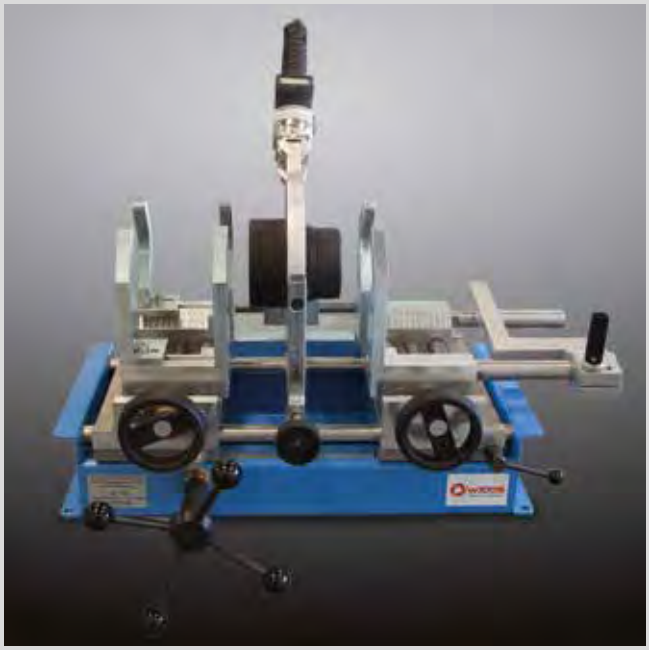
precise pre-assembly and facilitation by hand creek

clamping jaws 50–125 mm, tools 50–125 mm

Scope of supply:
wooden transport box, slide with sub construction, clamping jaws 50–125 mm, welding tools 50–125 mm, stay with rolls

For welding of aquatherm green pipe/aquatherm blue pipe/aquatherm lilac pipe a welding temperature of 260 °C at the welding tools is necessary (see page 43).

Instructions for use can be taken from the attached operation manual.



The fusion is subject to the following data

Pipe external-Ø	Welding depth	Heating time		Welding time	Cooling time
mm	mm	sec. DVS	sec. AQT*	sec.	min.
50	23,5	18	27	6	4
63	27,5	24	36	8	6
75	30,0	30	45	8	8
90	33,0	40	60	8	8
110	37,0	50	75	10	8
125	40,0	60	90	10	8

ATTENTION: **sec. AQT*** heating times recommended by aquatherm at ambient temperatures below + 5 °C

The General Guidelines for Heated Socket Welding acc. to DVS 2207, Part 11 are applied hereupon.

Dimension 160–630 mm:

The dimension 160–630 mm are joined by butt-welding.

Detailed information on page 60–65.

PART E: WELDING MACHINE PRISMA-LIGHT



Welding machine prisma-light with heating plate without tools

Clamping fixture for fixing the prisma-light e. g. at the work bench

1. Check machine: temperature lamp blinks after reaching the welding temperature (260 °C), adjust clamping jaws 63–125 mm coarsely. Mark welding depth with the template at the pipe.

2. Fix the fitting against the clamping jaws.

3. Place the pipe loose in the opposite clamping jaws.

4. Position the welding device centrically to the pipe-fitting axis and remove it.

5. Lock the front calibration knob and drive up the slide as far as it will go.

6. In this position push the pipe against the fitting and fix it with the clamping jaws.

7. Regulate the welding time according to the table on page 53, place the welding device and push the fitting and pipe slowly as far as it will go up to the marking.

8. The heating time starts when pipe and fitting are completely pushed on the tool. When heating time is complete slide return the slide, remove the heating device quickly and join the pipe and fitting.

9. Consider cooling times from the table on page 53.

More detailed information can be taken from the enclosed operating manuals.

PART F: ELECTROFUSION DEVICE

Fusion

The aquatherm electrofusion device was specially developed for electrofusion sockets from Ø 20–250 mm.

The fusion of 160–250 mm aquatherm blue pipe MF OT with the electrofusion socket is not possible.

Technical information:

supply voltage: 230 V (nominal voltage)
nominal capacity: 2.800 VA, 80 % ED
rated frequency: 50–60 Hz
protection class: IP 54

1. General and inspection

Cleanliness is – besides correct workmanship – the most important precondition for a correct fusion. For keeping the sockets clean do not unwrap them before processing.

The pipe surface must also be clean and undamaged. Deformed pipe ends must be cut off.

All parts of the system to be fused as well the temperature sensors shall have the same temperature (e.g. sun radiation or unadapted storing may cause differences in temperature!) within the acceptable range of temperature (e.g. +5 °C to 40 °C according to DVS 2207).

2. Preparation

Follow carefully the order of working steps!

Preparation is one of the most important steps of the electrofusion process!

a. Cut the ends of the pipes rectangularly and deburr them thoroughly

b. Clean and dry the ends of the pipes at the necessary length

c. Mark the depth of aquatherm electro-fusion-socket on the end of the pipe



aquatherm electrofusion device Ø 20–250 mm



aquatherm electrofusion socket



aquatherm peeling tool (Art. no. 50558–50572, up to 90 mm)
(from 110–250 mm: Art. no. 50574–50592 (without picture))

Welding depth up to 250 mm													
ø	20	25	32	40	50	63	75	90	110	125	160	200	250
ET	35,0	39,0	40,0	46,0	51,0	59,0	65,0	72,5	80,0	86,0	93,0	105,0	125,0

TEIL F: ELECTROFUSION DEVICE

Fusion

d. Peel the surface of both pipes up to the marks thoroughly with a peeling tool (use the aquatherm peeling tool with the respective pipe diameter)

IMPORTANT!

Before the fusion peel off the oxygen barrier layer of the aquatherm blue pipe OT and the UV-layer of the faser composite pipe UV completely to the stop by using the universal peeling tools considering the pipe diameter.

By turning the adjusting screw clockwise to the stop, the peeling tools can be adjusted into small depths (sockets), by turning them counter clockwise up to the stop they can be adjusted into big peeling depth (electrofusion sockets).

e. Clean again thoroughly

Without complete peeling of the fusion surface a homogeneous and tight welding connection is not assured. Damages of the surface like axial grooves and scratches are not accepted in the fusion zone. Never touch peeled surfaces and protect them against dirt and grease. Start the fusion process within 30 mins after peeling.

3. Assembling the electrofusion sockets

Avoid soiling and fix all parts securely!

1. Open the protective wrapping of the aquatherm electrofusion sockets (cut with knife along the edge of the bore), leaving the rest of the foil intact. Clean the inside of the fitting carefully with aquatherm cleaning wipes. Assemble the fitting within 30 mins after opening of the protective foil.

2. Push the aquatherm electrofusion sockets on the clean and dry end of the pipe (up to the marked depth). Use pressing clamps if necessary.



Cut the pipes to be welded, peel, clean and dry thoroughly with a lint-free cloth or paper



Clean the electrofusion socket´s inner surface with a lint-free cloth or paper.
Remove moisture that may occur **immediately before the welding process** again.



Push the electrofusion socket onto the pipe end



PART F: ELECTROFUSION DEVICE

Remove the protective foil completely and push the other prepared pipe end into the aquatherm electro-fusion sockets tighten in the fixation.

Leave the pipes, free from bending stress or own weight, within the aquatherm electrofusion socket. The socket is movable at both pipe ends after assembling. The air gap has to be even around the circumference. Pipes and fittings must be welded stress-free.

4. Fusion process

1. Position the fitting with even air gap around the circumference.

2. Regulate fusion equipment for the right fusion parameter.

3. Compare the indications of the fusion equipment with the parameters of the label.

4. Start and watch the fusion process.

Do not move or stress pipe and fitting during the whole fusion process and cooling time.

5. Cooling time and pressure test

A fused pipe-joint shall not be moved (no release of the fixation) or stressed before complete cooling.

The minimum required cooling time is marked on each aquatherm electrofusion socket. Ambient temperatures of more than 25 °C or strong sun-radiation need longer cooling times.

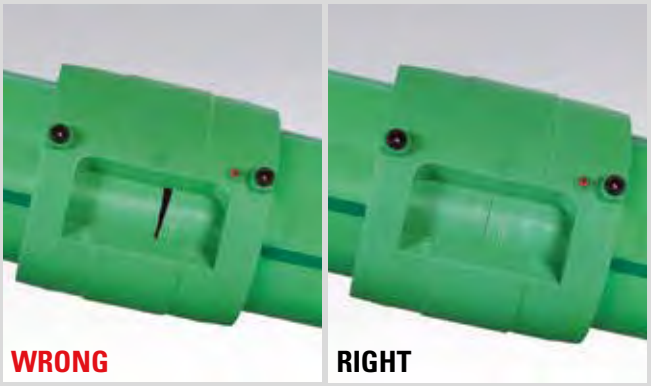
Working pressure

The operation pressure can be taken from the imprint on the electric welding socket. The relation between working temperature, pressure load and service life is given in the tables "Permissible working pressure."

For further information concerning electrofusion socket and details about the aquatherm electrofusion device read the enclosed operating instructions.



Push the second pipe – also peeled and cleaned – into the socket



For a stable welding result it is important that both pipe ends inside the electrofusion socket are with parallel faces! Follow the minimum welding depth – absolutely!



Adjust the socket diameter on the welding device. Start and control welding process. Keep the cooling time. Finished!

Kind of stress	Compressive stress	Minimum waiting period
Tension, bend, torsion of unpressurized pipes		20 minutes
Test- or working pressure of pipes pressurized	up to 0.1 bar (1.5 psi) 0.1 up to 1 bar (1.5–14.5 psi) over 1 bar (14.5 psi)	20 minutes 60 minutes 120 minutes
Repeating of the welding process		60 minutes

POSSIBILITIES OF REPAIR

Pipe repairs with the aquatherm green pipe electrofusion socket

Cut squarely 3 to 4 lengths of a fitting out of the defect pipe, symmetrically to the defect. Fit the new pipe into this gap. Prepare the pipe ends of the existing pipe as in the case ofa new welding.

Peel the new piece of pipe on both sides with the peeling tool on a length of more than the length of one fitting.

Unwrap two fittings and carefully move the fittings over both ends of the new pipe.

Then place the repair-pipe into the gap and move the fittings until they are aligned with the markings on the existing pipes.

Take care, that the fittings are exactly aligned and completely free of stress before welding.

Additional possibilities of repair

Damaged pipes may be repaired – as already mentioned – by means of

fusion (see Part B)
electrofusion socket (see Part F).

In addition to this the aquatherm PP-R-systems offers the possibility of the

pipe repair stick.

The necessary welding tool (Art. no. 50307/11) and repair stick (Art. no. 60600) are described on page 168.

The installation information is enclosed with the welding tool, but may also be ordered separately (Order-No. D 11450) from aquatherm.



Heat-up



Repair stick



Cutting

PART H: BUTT-WELDING OF PIPE DIMENSION 160–630 mm

The following aquatherm pipes series are available:

aquatherm green pipe SDR 11 S for cold water

aquatherm green pipe SDR 7.4 / 9 / 11 MF faser-composite pipe

aquatherm blue pipe SDR 11 / 17.6 MF faser-composite pipe

aquatherm blue pipe SDR 11 MF OT faser-composite pipe

Pipes and fittings are fused, as explained below, by butt welding:

1. Protect your place of work from weather influences
2. Check, if welding machine works properly and heat it up
3. Cut pipes into required length
4. Plastic pipes are aligned and fixed by means of the clamping elements
5. Use the milling machine for planing the pipe end to be plane-parallel
6. Remove the debris and clean the pipe ends with methylated spirit
7. Check if pipes match (tolerance: max. 0.1 x wall thickness)
8. Check width of gap between the two pipes to be welded (tolerance: max. 0.5 mm)
9. Check the temperature of the heating element (210 °C +/- 10 °C)
10. Clean the heating element

IMPORTANT:

Before welding, the side to be welded of the aquatherm blue pipe ot must be chamfered with the aquatherm chamfering tool (page 170).

To ensure an optimal weld joint, the heating plates' surfaces have to be cleaned before each welding process and be free of visible and invisible residues.



Before welding, pipes are cut into the required lengths



Check performance of the welding machine and heat it up



The parts to be welded are fixed and aligned respectively, the milling machine is used







Chamfering of the front side in case of the OT and UV pipe

PART H: BUTT-WELDING OF PIPE DIMENSION 160–630 MM

11. After the heating element has been positioned, the pipes are pushed onto the heating plate with a defined adjusting pressure.

12. After reaching the specified bead height (see tablet) the pressure is reduced. This process marks the beginning of the heating time. This time is for heating up the pipe ends up to the right welding temperature.

Specified bead height in mm:

	SDR 7,4	SDR 11	SDR 9	SDR 17,6
160 mm	1,5	1,0	1,0	1,0
200 mm	2,0	1,0	1,5	1,0
250 mm	2,0	1,5	2,0	1,0
315 mm	-	2,0	2,0	1,0
355 mm	-	2,0	2,5	1,5
400 mm	-	2,0	-	1,5
450 mm	-	2,5	-	1,5
500 mm	-		-	2,0
560 mm	-		-	2,0
630 mm	-		-	2,0

13. When heating time has expired, divide the machine slide, remove heating element quickly and join the pipes (by putting both parts of the slide together).

14. The pipes are fused with the required welding pressure and cooled down under pressure.

15. The welded connection can be unclamped – the welding process is finished.

    Additionally please follow the instructions given in the operating manual of the welding machine and observe guideline DVS 2207, part 11.

Important Note

1. The welding machines have to be suitable for the welding of pipes with a diameter/wall thickness ratio of up to SDR 7.4

aquatherm recommends the following manufacturers of welding machines for butt welding:

Company Ritmo
Company Widos

2. For hydraulically operated welding machines, the real manometer pressure has to be calculated in consideration of the hydraulic piston area.

This value can be taken from the respective operating manuals.



Positioning of heating element



Divide the machine slide, remove heating element

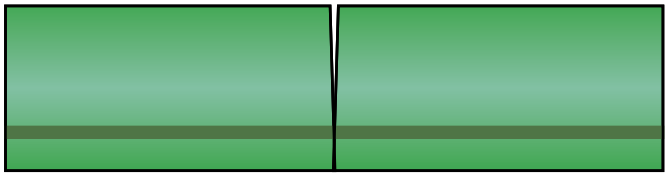


Join the pipes, cool down under pressure

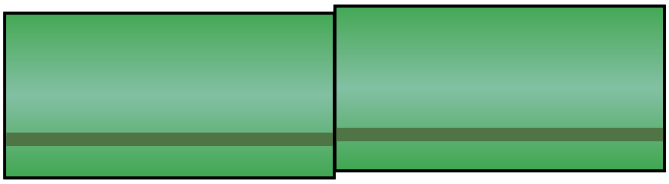


Unclamp and work on...

Visual inspection of fusion seam – Misalignment and gap width for butt welding



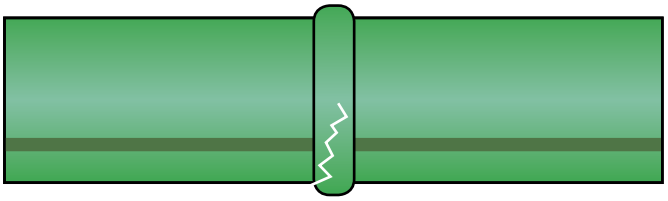
Gap width up to 355 mm outer diameter = 0.5 mm
Gap width from 400 mm to 630 mm outer diameter = 1 mm



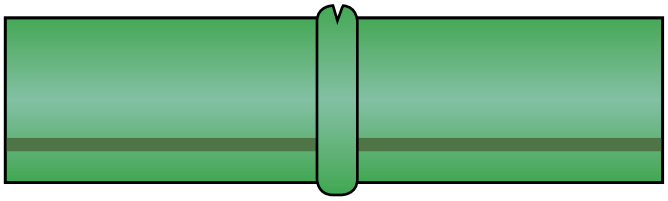
The misalignment cannot be more than 10 % of the wall thickness or max. 2 mm

Welding defects during butt-welding

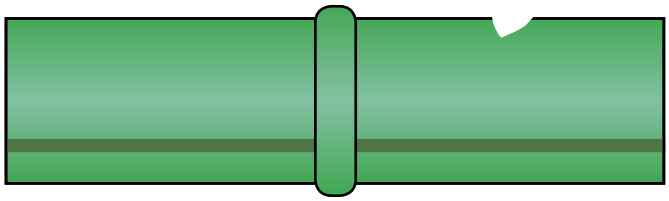
Normally a bead around the entire circumference is formed at the edge of the socket during the welding process. This bead indicates the proper welding.
It is important to assure that the following welding defects are avoided:



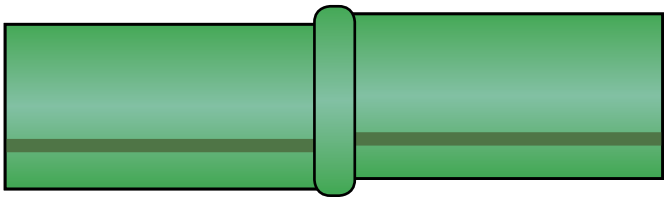
Cracks



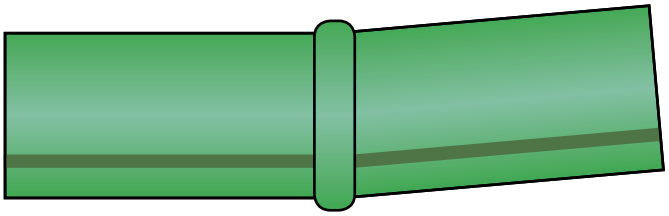
Grooves in the bead



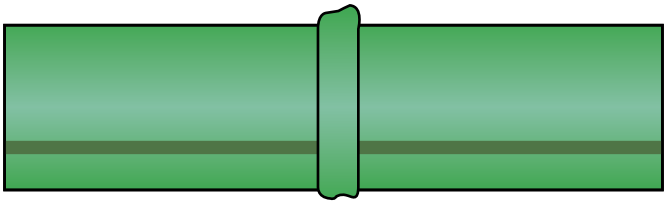
Grooves and scratches



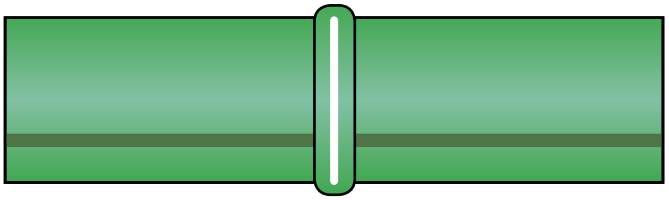
Misalignment of the joining area



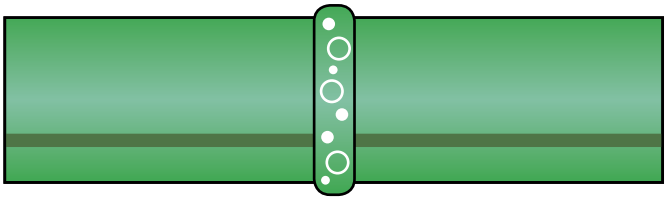
Tilting of the joining area



Uneven welding bead



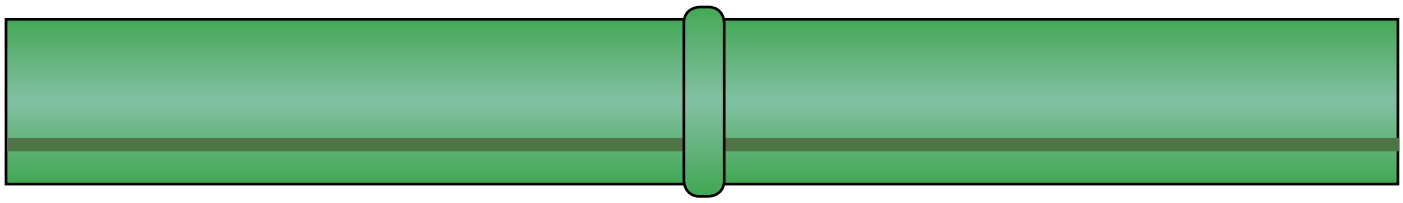
Lack of fusion at the joining area



Pores, voids and inclusion of impurities

Correct butt welded seam





The visual inspection may be only a first indication of the welding seam quality.
But it is not a replacement for the leak test, which has to be carried out after the completion of the installation.

Requirements for welding



The immediate welding area is to be protected against bad climatic conditions (e.g. wind, moisture and low temperatures).



If the pipes are heated unevenly as a result of sun exposure, temperature compensation by timely covering of the welding area is to be created. Cooling down by draft during the welding process should be avoided.



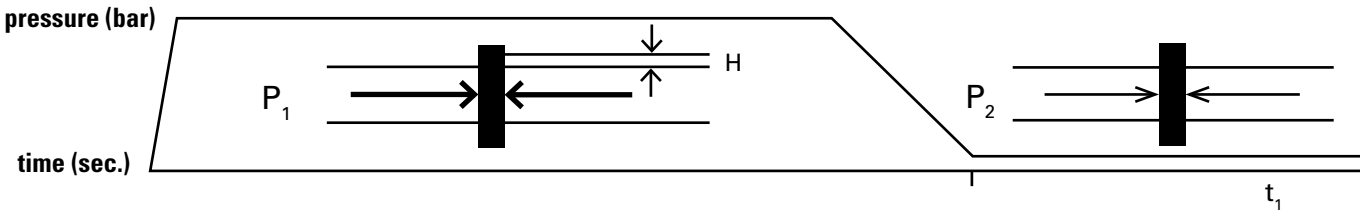
For perfect welding joints, both the welding areas and tools must be clean and free of grease.

AQUATHERM WELDING PARAMETERS
WELDING TEMPERATURE: 210 °C +/- 10 °C

The calculated drag pressure is added to the adjustment and welding pressure (see description)

ATTENTION: When using other welding machines, the pressures P1, P2 and P3 must be adjusted.

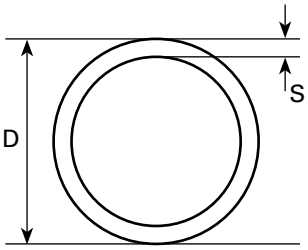
Excerpt from the DVS 2207 part 11



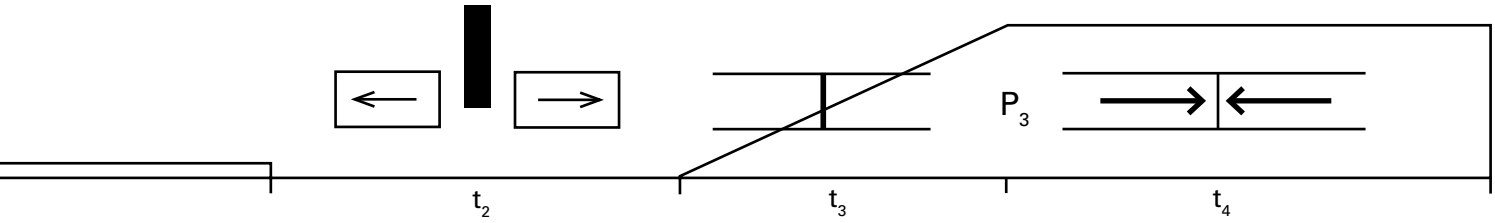
		P1 Adjustment pressure (bar)						P2 Heating pressure (bar)		
Dimension (mm)	Pipe series SDR	Rothenberger Art. no. 50163, 50167 + 50178	Ritmo Art. no. 50165	Ritmo Art. no. 50166	Ritmo Art. no. 50177	Ritmo Art. no. 50169	Height of bead (mm)	Rothenberger Art. no. 50163, 50167 + 50178	Ritmo Art. no. 50165	Ritmo Art. no. 50166
							H			
160x 9,1	17,6	7	7	6	3		1	1	1	1
160x14,6	11	11	11	10	5		1	1	1	1
160x17,9	9	13	13	12	6		1	1	1	1
160x21,9	7,4	15	16	14	7		1,5	2	2	2
200x11,4	17,6	11	11	10	5		1	1	1	1
200x18,2	11	17	18	16	7		1	2	2	2
200x22,4	9	20	21	19	9		1,5	2	2	2
200x27,4	7,4	24	25	22	11		2	2	3	2
250x14,2	17,6	17	18	16	7		1	2	2	2
250x22,7	11	26	28	24	11		1,5	3	3	2
250x27,9	9	31	33	29	14		2	3	3	3
250x34,2	7,4	37	39	35	16		2	4	4	3
315x17,9	17,6	27		25	12	8	1	3		3
315x28,6	11	41		38	18	13	2	4		4
315x35,2	9	49		46	22	15	2	5		5
315x42,6	7,4	59		56	26	18	2,5	6		6
355x20,1	17,6	34			15	10	1,5	3		
355x32,2	11	52			23	16	2	5		
355x39,5	9	63			28	19	2,5	6		
355x49,0	7,4	77			33	23	2,5	7		
400x22,7	17,6					13	1,5			
400x36,3	11					20	2			
400x44,5	9					24	2,5			
450x25,5	17,6					17	1,5			
450x40,9	11					26	2,5			
500x28,4	17,6					21	2			
500x45,5	11					32	2,5			
560x31,7	17,6					26	2			
630x35,7	17,6					33	2			

Note: A reduction of the cooling time up to 50 %, i.e. release of the jointing pressure and removal of the welded part from the welding machine is allowed under the following conditions:

- The join connection is manufactured under factory conditions and
- The removal from the welding machine and the temporary storage cause only a slight load to the join connection and
- The joining parts have a wall thickness ≥ 15 mm



Further processing with full mechanical load on the joining connection may be effected only after complete cooling down according to the table.



					P3 Adjustment pressure (bar)					
Ritmo Art. no. 50177	Ritmo Art. no. 50169	Heating time DVS 2207 (sec.)	Max. changeover time (sec.)	Max. pressurization time (sec.)	Rothenberger Art. no. 50163, 50167 + 50178	Ritmo Art. no. 50165	Ritmo Art. no. 50166	Ritmo Art. no. 50177	Ritmo Art. no. 50169	Cooling time (min.)
		t1	t2	t3						t4
0		204	6	9	7	7	6	3		15
0		277	8	13	11	11	10	5		24
1		315	9	16	13	13	12	6		28
1		359	10	19	15	16	14	7		34
0		237	7	11	11	11	10	5		19
1		320	9	16	17	18	16	7		29
1		364	10	19	20	21	19	9		35
1		411	11	23	24	25	22	11		42
1		272	8	13	17	18	16	7		23
1		367	10	20	26	28	24	11		35
1		415	12	24	31	33	29	14		43
2		463	13	29	37	39	35	16		51
1	1	317	9	16	27		25	12	8	28
2	1	412	12	24	41		38	18	13	44
2	2	471	14	30	49		46	22	15	53
3	2	520	15	37	59		56	26	18	62
1	1	341	9	18	34			15	10	32
2	2	448	13	28	52			23	16	48
3	2	501	15	34	63			28	19	58
3	2	551	17	42	77			33	23	68
	1	367	10	20					13	35
	2	480	14	31					20	54
	2	528	16	39					24	63
	2	395	11	22					17	39
	3	508	15	35					26	59
	2	419	12	24					21	43
	3	534	16	39					32	65
	3	444	12	27					26	48
	3	475	14	31					33	53

FLANGE CONNECTIONS

THE FOLLOWING MUST BE OBSERVED IN THE USE OF FLANGE CONNECTIONS:

Flange adapter respectively the sealing surfaces must always be aligned parallel to each other. A subsequent tightening of the flange connection after the welding process must be avoided. It is important to ensure that the flange faces are clean and undamaged.

The screw length should be selected so that the screw thread is as flush as possible, maximum two threads from the nut. To distribute the force of the screw head and the nut over a larger area, washers are used. Screws, nuts and washers must be clean and undamaged.

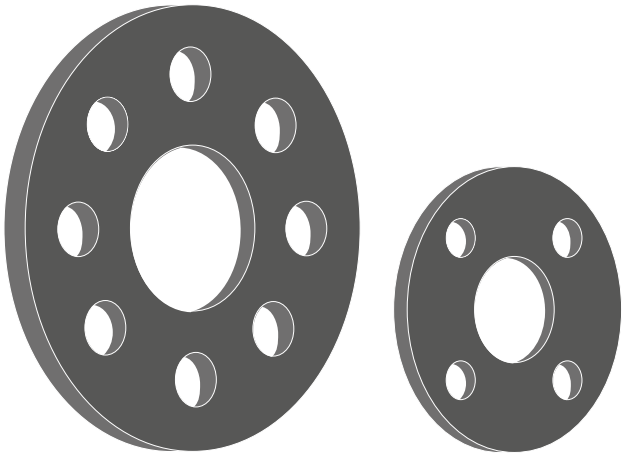
In order to achieve proper force distribution (surface pressure) acting on the seal, note the following:

– Screw joints must be tightened diagonally and evenly
– Torque information on the individual flanges must be observed (see table)

For flange connections, exposed to a mutual load, take care that they are checked as part of the maintenance and retightened, if necessary.

TORQUE FLANGE according to manufacturere´s instructions

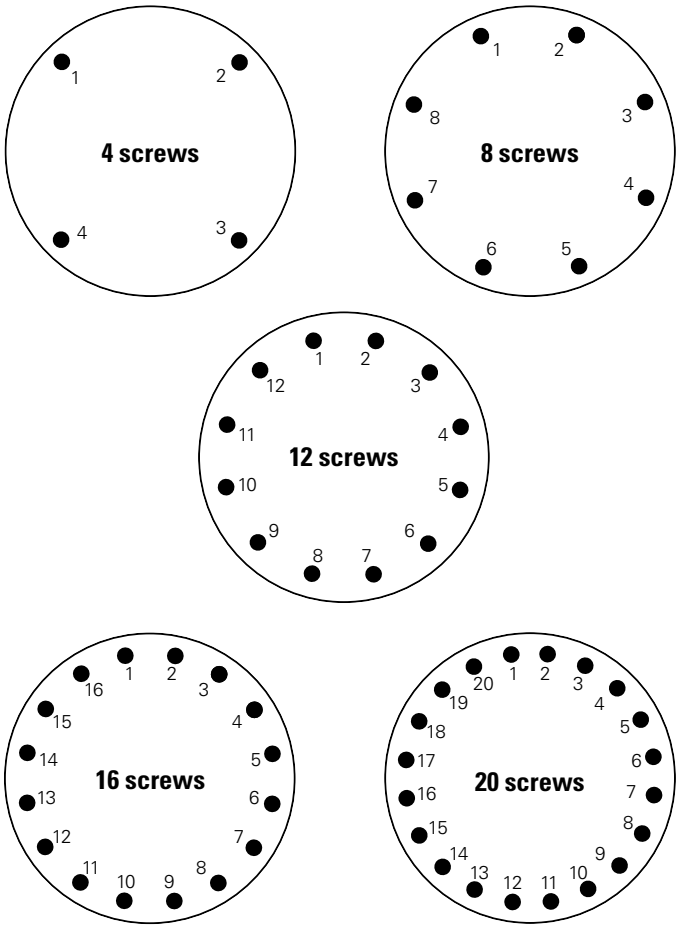
Art. no.	Dimension	DN specification	Nm
15712	32 mm	25	15
15714	40 mm	32	20
15716	50 mm	40	30
15718	63 mm	50	35
15720	75 mm	65	40
15722	90 mm	80	40
15724	110 mm	ohne	50
15726	125 mm	100	50
15730	160 mm	125	60
15734	200 mm	150	75
15738	250 mm	200	95
15742	315 mm	250	100
15744	355 mm	300	100
15746	400 mm	350	244–366
15748	450 mm	400	271–407
15750	500 mm	450	271–407
15752	560 mm	500	353–529
15754	630 mm	500	393–590



TIGHTENING SEQUENCE

Number of screws	Criss-Cross Pattern Tightening Sequence
4	1 - 3 - 2 - 4
8	1 - 5 - 3 - 7 - 2 - 6 - 4 - 8
12	1 - 7 - 4 - 10 - 2 - 8 - 5 - 11 - 3 - 9 - 6 - 12
16	1 - 9 - 5 - 13 - 3 - 11 - 7 - 15 - 2 - 10 - 6 - 14 - 4 - 12 - 8 - 16
20	1 - 11 - 6 - 16 - 3 - 13 - 8 - 18 - 5 - 15 - 10 - 20 - 4 - 14 - 9 - 19 - 7 - 17 - 2 - 12

Following the table, tighten the given screw number to the desired torque value for the given round of tightening.



FASTENING TECHNIQUE / FIXED POINTS / SLIDING POINTS

Fastening technique

Pipe clamps for aqautherm PP-R-pipes must be dimensioned for the external diameter of the plastic pipe.

Take care, that the fastening material does not mechanically damage the surface of the pipe (aquatherm pipe clamps Art. no.: 60516–60660).

All pipes should be fastened with only aquatherm's green rubber compound fasteners, with expansion spacers, or other as deemed equal or approved by aquatherm and /or the project's Hydraulic Consultant.

Basically it must be distinguished on pipe assembly, whether the fastening material is used as

a fixed point or
a sliding point.

Fixed points

On locating fixed points the pipelines are divided into individual sections. This avoids uncontrolled movements of the pipe.

In principle fixed points have to be measured and installed in a way, that the forces of expansion of aquatherm PP-R-pipes as well as probable additional loads are accommodated.

On using threaded rods or threaded screws the drop from the ceiling should be as short as possible. Swinging clamps should not be used as fixed points.

Basically vertical distributions can be installed. Risers do not require expansion loops, provided that fixed points are located immediately before or after a branch.

To compensate the forces arising from the linear expansion of the pipe there must be sufficient and stable clamps and mountings.

aquatherm pipe clamps meet all mentioned requirements and – when considering the following installation instructions – are perfect for fixed point installations.

Sliding points

Sliding clamps have to allow axial pipe movements without damaging the pipe.

On locating a sliding clamp it has to be ensured that movements of the pipelines are not hindered by fittings or armatures installed next to the clamps.

aquatherm pipe clamps have an extra even and sliding surface of the sound insulation insert.

INSTALLATION ADVICE / LINEAR EXPANSION / CONCEALED INSTALLATION

Installation advices

aquatherm pipe clamps are perfectly suited for fixed point and sliding point installations.

The application of distance rings depends on the type of pipe.

Fastening	MF Pipes (faser composite pipe) & S Pipes (single layer)
Sliding Point	1 distance ring
Fixed point	no distance ring

Linear expansion

The linear expansion of pipes depends on the difference of operating temperature to installation temperatur:

$\Delta T = T_{\text{operating temperature}} - T_{\text{installation temperature}}$

Therefore cold water pipes have practically no linear expansion.

Because of the heat dependent expansion of the material, the linear expansion must especially be considered in case of hot and heating installations. This requires a distinction of the types of installation, e.g.

- **Concealed installation**
- **Installation in ducts**
- **Open installation.**

Concealed installation

Concealed installations generally do not require a consideration of the expansion of aquatherm PP-R-pipes.

The insulation acc. to DIN 1988 or the EnEV (Energieeinsparverordnung) provides enough expansion space for the pipe. In the case where the expansion is greater than the room to move in the insulation, the material absorbs any stress arising from a residual expansion.

The same applies to pipes, which do not have to be insulated acc. to current regulations.

A temperature induced linear expansion is prevented by the embedding in the floor, concrete or plaster. The compressive strain and tensile stress arising from this are not critical as they are absorbed by the material itself.

INSTALLATION IN DUCTS

Installation in ducts

Due to the different linear expansion of the aquatherm PP-R-pipes with or without stabilization, the installation of pipe branches in risers has to be made according to the selected type of pipe.

aquatherm green pipe MF
aquatherm blue pipe MF

The linear expansion of aquatherm faser composite pipes in vertical risers can be ignored.

The positioning of a fixed point directly before each branch-off point is sufficient. All clamps in the riser must be installed as fixed points (see 1).

In general it is possible to install risers rigidly, that means without expansion joints. This directs the expansion on the distance between the fixed points, where it is ineffective.

For a maximum distance between two fixed points please refer pages 73/74.

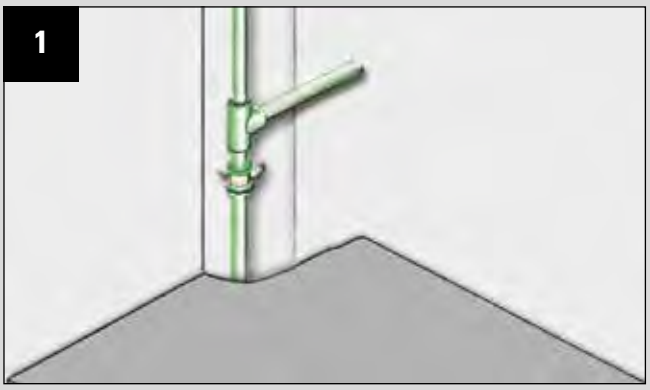
aquatherm green pipe
aquatherm blue pipe
aquatherm lilac pipe

The installation of risers of aquatherm pipes without stabilizing components requires a branch pipe, which is elastic enough to take the linear expansion of the riser.

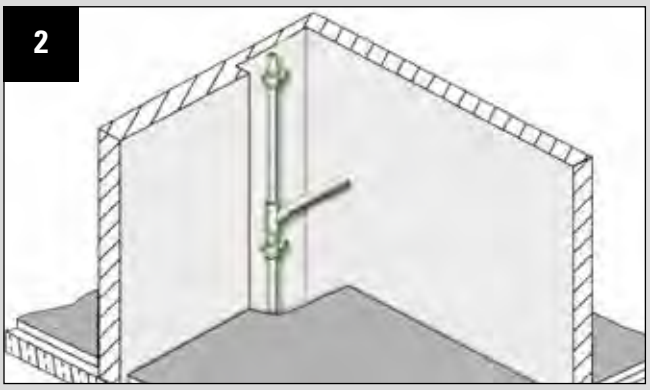
This can be ensured by a favourable fixing of the riser in the duct (see 2).

An adequate large pipe liner also gives sufficient elasticity to the branch-off pipe (see 3).

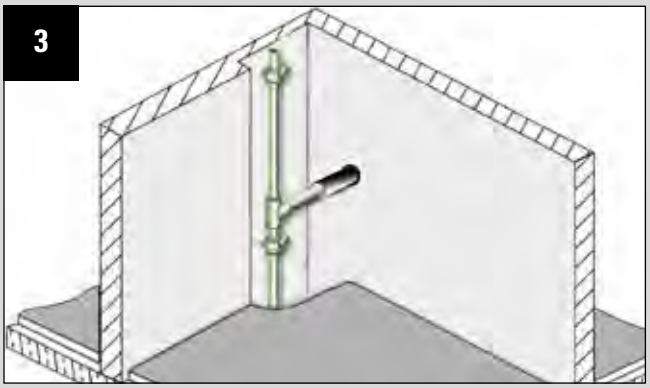
Furthermore the installation of a spring leg gives the appropriate elasticity (see 4).



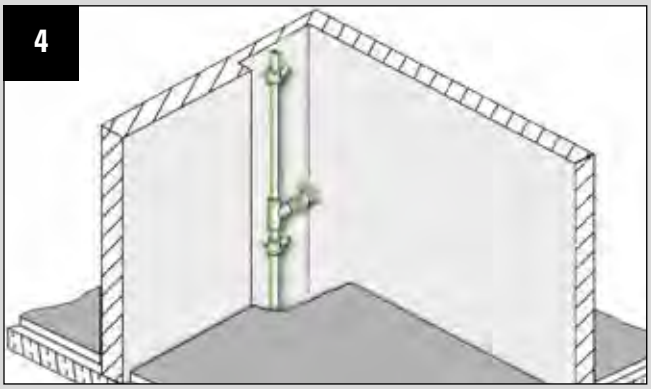
Positioning of the fixed point clamp



Favourable fixing



Large diameter pipe liner



Installation of a spring leg

OPEN INSTALLATION / CALCULATION OF THE LINEAR EXPANSION

Open installation

In case of open installed pipes (e.g. in the basement), excellent optical characteristics and form stability are important. aquatherm pipes for cold water and aquatherm faser composite pipes for hot water and heating plants make this possible. The coefficient (α) of linear expansion of aquatherm composite pipes is only

$\alpha_{\text{green pipe MS}}$ = 0,030 mm/mK
$\alpha_{\text{green pipe MF}}$ = 0,035 mm/mK

and therefore nearly identical with the linear expansion of metal pipes.

The coefficient of linear expansion of aquatherm pipes without stabilizing components is

$\alpha_{\text{green pipe}}$ = 0,150 mm/mK

aquatherm faser composite pipes must have enough space to expand (see below). An expansion control is required for long and straight faser composite pipes (over 40 m).

aquatherm pipes without the stabilizing compound should have the expansion control after 10 m straight pipelines. Risers of composite pipes may be installed rigidly without expansion compensation. The following formula, calculation examples, data-tables and diagrams help to determine the linear expansion. The difference between working temperature and maximum or minimum installation temperature is essential for the calculation of linear expansion.

Calculation of the linear expansion

Given and required values

Symbol	Meaning	Value	Measuring unit
ΔL	Linear expansion	?	[mm]
α_2	Coefficient of linear expansion aquatherm faser composite pipe	0,035	mm/mK
α_3	Linear expansion coefficient	0,15	mm/mK
L	Pipe length	25,0	[m]
T_B	Working temperature	60	°C
T_M	Installation temperature	20	°C
ΔT	Temperature difference between working and installation temperature ($\Delta T = T_W - T_M$)	40	K

The linear expansion ΔL is calculated according to the following formula:

$\Delta L = \alpha \times L \times \Delta T$

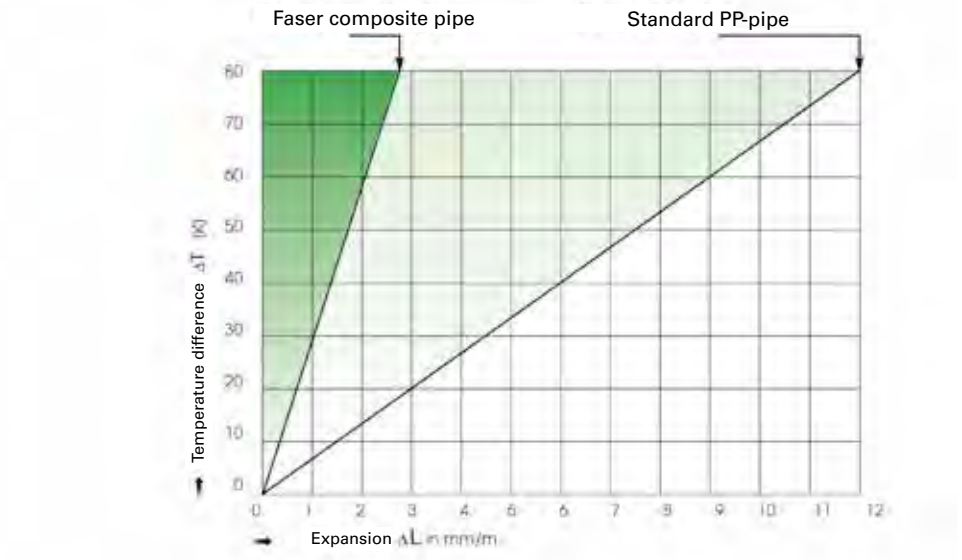
Example:
aquatherm green pipe MF faser composite pipe (a = 0.035 mm/mK)

ΔL = 0,035 mm/mK x 25,0 m x 40 K

ΔL = 35,0 mm

Linear expansion comparison:

faser composite- to standard PP-pipe



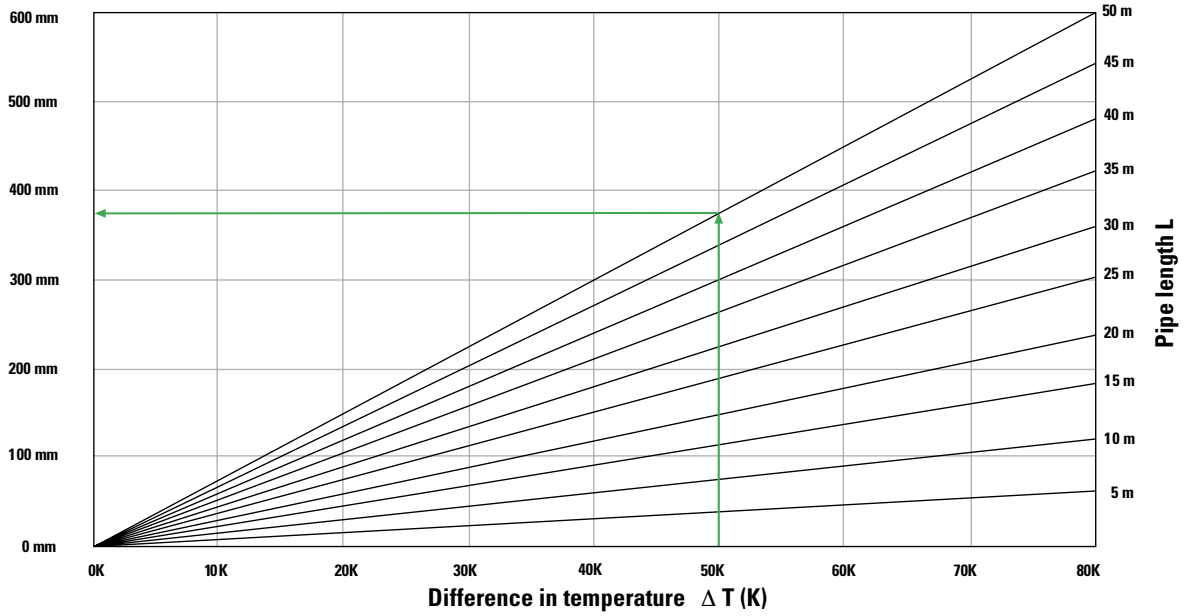
aquatherm green pipe & aquatherm blue pipe

(without faser)

The linear expansion, described on the preceding pages, can be taken from the following tables and graphs.

Linear expansion ΔL in [mm]: green and blue pipe - α = 0,150 mm/mK

Pipe length	Difference in temperature $\Delta T = T_{operating\ temperature} - T_{installation\ temperature}$							
	10 K	**20 K**	**30 K**	**40 K**	**50 K**	**60 K**	**70 K**	**80 K**
	Linear expansion ΔL (mm)							
5 m	8	15	23	30	38	45	53	60
10 m	15	30	45	60	75	90	105	120
15 m	23	45	68	90	113	135	158	180
20 m	30	60	90	120	150	180	210	240
25 m	38	75	113	150	188	225	263	300
30 m	45	90	135	180	225	270	315	360
35 m	53	105	158	210	263	315	368	420
40 m	60	120	180	240	300	360	420	480
45 m	68	135	203	270	338	405	473	540
50 m	75	150	225	300	375	450	525	600



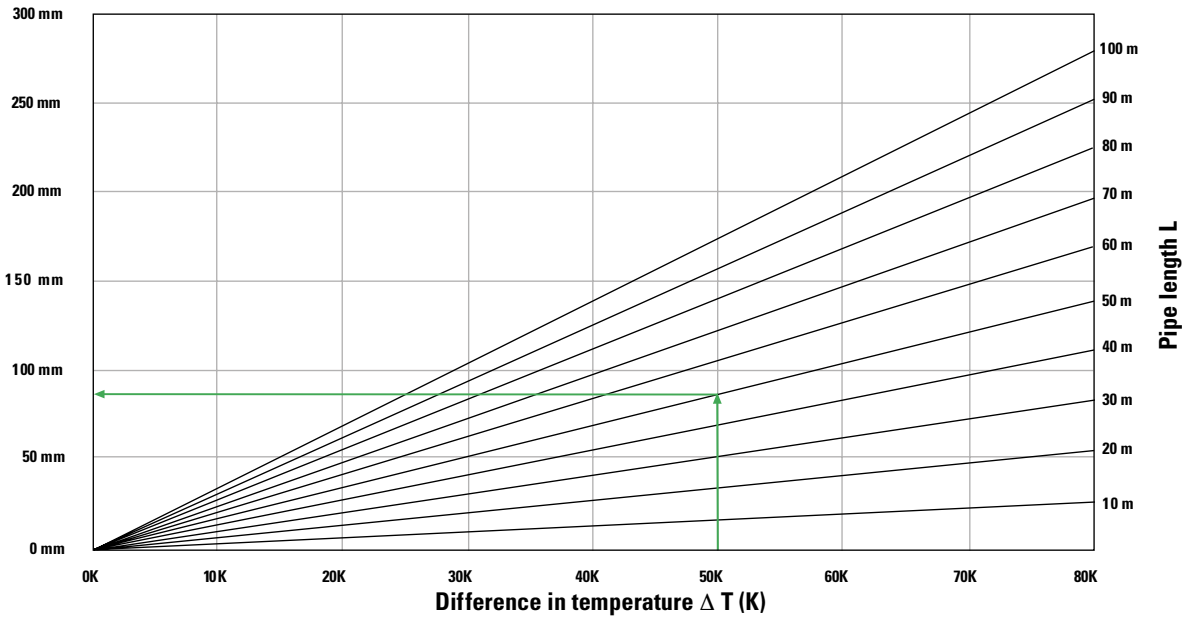
aquatherm green pipe MF (faser composite pipe)

aquatherm blue pipe MF (faser composite pipe)

Due to the integration and positive bond of the different materials, the aquatherm faser composite pipes offers much higher stability.
The linear expansion reduces its value to $^1/_5$ of the mere PP-pipes.

Linear expansion ΔL in [mm]: aquatherm faser composite pipes - α = 0.035 mm / mK

Pipe length	Difference in temperature $\Delta T = T_{operating\ temperature} - T_{installation\ temperature}$							
	10 K	20 K	30 K	40 K	50 K	60 K	70 K	80 K
	Linear expansion ΔL (mm)							
10 m	4	7	11	14	18	21	25	28
20 m	7	14	21	28	35	42	49	56
30 m	11	21	32	42	53	63	74	84
40 m	14	28	42	56	70	84	98	112
50 m	18	35	53	70	88	105	123	140
60 m	21	42	63	84	105	126	147	168
70 m	25	49	74	98	123	147	172	196
80 m	28	56	84	112	140	168	196	224
90 m	32	63	95	126	158	189	221	252
100 m	35	70	105	140	175	210	245	280



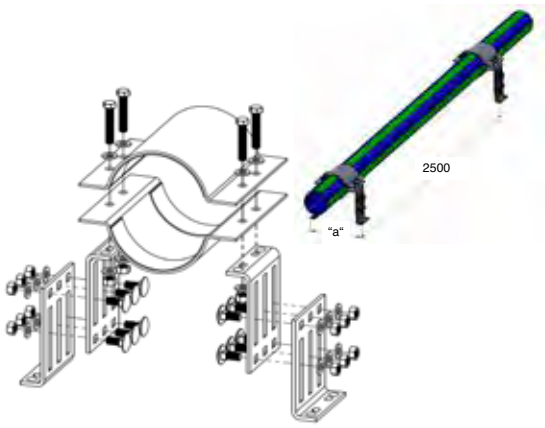
PIPE CLAMPS suitable as fixing point

From now on aquatherm offers fixed-point fastenings for pipes from 160 mm–630 mm (Art. no. 60768–60790). Packing unit is each with 1 piece.

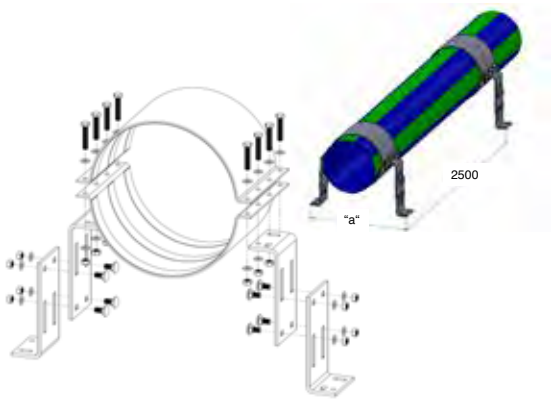
Advantages:

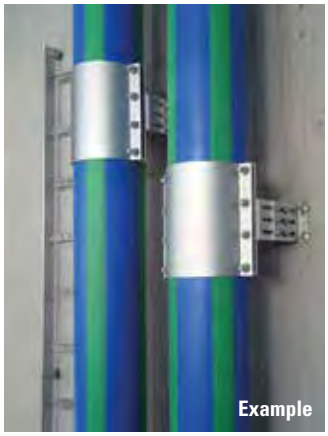
- Reliable and permanent protection against perforation corrosion and breakdown of the static load capacity
- 1000 hours salt spray test without ferric oxide (rust)
- Suitable for installation in corrosive inner and outside areas
- Considerably higher corrosion protection than with electrogalvanized and hot-dip galvanized products (after spread test acc. to DIN EN ISO 9227)

Art. no.	diameter	min. torque clamp locking	min. torque height adjustment	height adjustment	fixig on building	measure „a“	weight per set
[-]	[mm]	[Nm]	[Nm]	[mm]	[-]	[mm]	[kg]
0060768	160	25	75	192,5–283,5	M 12	354,1	8,55
0060770	200	25	75	192,5–283,5	M 12	394,5	9,45
0060774	250	50	75	192,5–283,5	M 12	444,8	19,37
0060778	315	50	75	192,5–283,5	M 12	510	22,75
0060780	355	50	75	192,5–283,5	M 12	550,1	24,84



art.-no.	diameter	min. torque clamp locking	min. torque height adjustment	height adjustment	fixig on building	measure „a“	weight per set
[-]	[mm]	[Nm]	[Nm]	[mm]	[-]	[mm]	[kg]
0060782	400	50	120	404,5–497,5	M16	823,2	43,64
0060784	450	50	120	404,5–497,5	M16	873,3	46,25
0060786	500	50	120	404,5–497,5	M16	923,4	48,87
0060788	560	50	120	404,5–497,5	M16	983,4	52,00
0060790	630	50	120	404,5–497,5	M16	1053,5	55,66




Example

BENDING SIDE

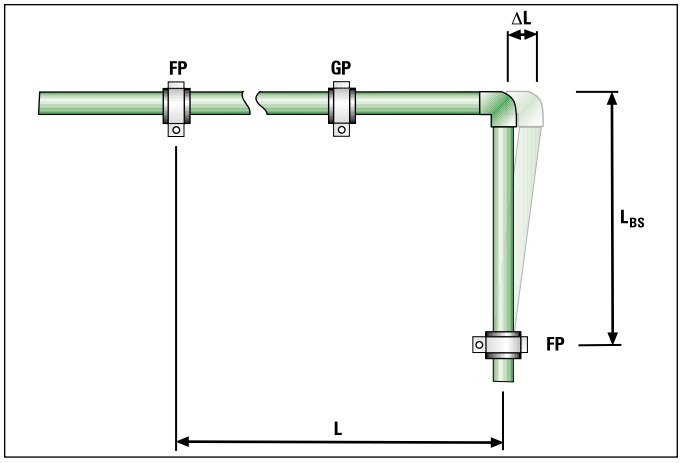
Linear expansion due to temperature difference between operating temperature and installation temperature can be compensated by different installation techniques.

Bending side

In most cases direction changes can be used to compensate for linear expansion in pipes.

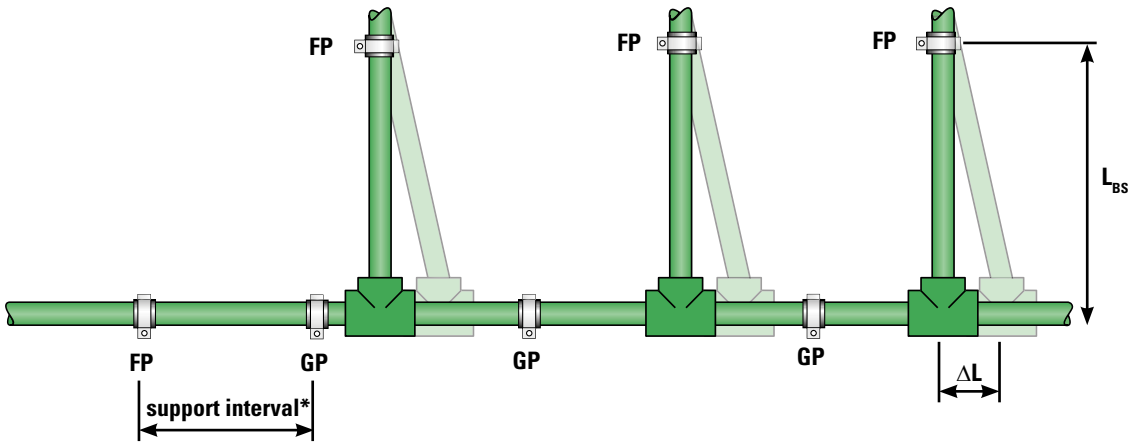
The values of the bending side can be taken directly from the tables and graphs on the following pages.

Symbol	Meaning	
L_{BS}	Length of the bending side	[mm]
K	Material specific constant	15,0
d	Outside diameter	[mm]
ΔL	Linear expansion	[mm]
L	Pipe Length	[m]
FP	Fixed point	
GP	Sliding point	



Calculational determination of the bending side length

$$L_{BS} = K \times \sqrt{d \times \Delta L}$$



* support intervals on page 77

PRE-STRESS / BELLOW EXPANSION JOINT

Expansion loop

If the linear expansion cannot be compensated by a change in direction, it will be necessary to install an expansion loop with long and straight pipelines.

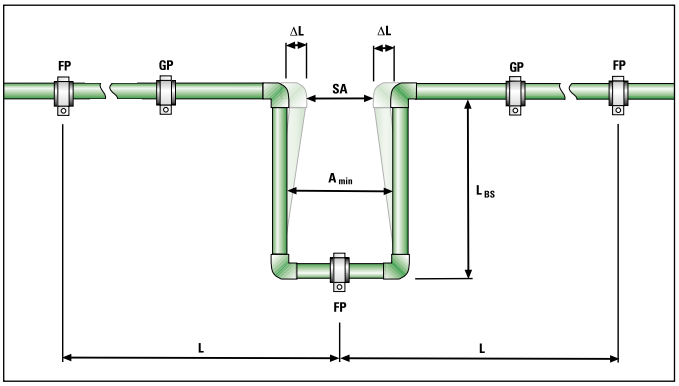
In addition to the length of the bending side L_{BS} the width of the pipe bend $A_{min.}$ must be considered.

Symbol	Meaning	
$A_{min.}$	Width of the expansion loop	[mm]
SA	Safety distance	150 mm

The pipe bend $A_{min.}$ is calculated acc. to the following formula:

$$A_{min} = 2 \times \frac{\Delta L}{2} + SA$$

The width of the expansion loop $A_{min.}$ should be at least 210 mm.



Determination size of expansion loop

Example
Specification: Pipeline, length 80 m (MF pipe)

Determined expansion: 112 mm = $(\Delta L = \frac{0{,}035 \text{ mm}}{\text{mK}} \times 80 \text{ m} \times 40 \text{ K})$

The expansion loop should be installed exactly in the center of the pipe.

Calculation:
Given: $\Delta L = 112$ mm
$SA = 150$ mm
Formula:

$$A_{min.} = 2 \times \frac{\Delta L}{2} + SA$$

$$A_{min.} = 2 \times \frac{112 \text{ mm}}{2} + 150 \text{ mm}$$

$$A_{min.} = 262 \text{ mm}$$

The width of the expansion loop should be 262 mm in this example.

Pre-stress

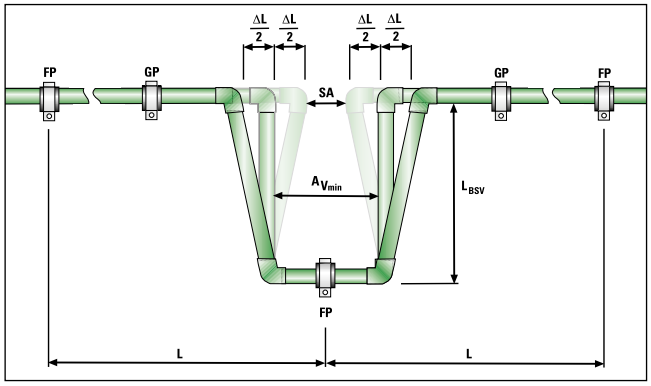
Where space is limited, it is possible to shorten the total width $A_{min.}$ as well as the length of the bending side L_{BSV} by pre-stressing.

Pre-stress installations, if planned and carried out carefully, offer an optically perfect installation, as the linear expansion is hardly visible.

Symbol	Meaning	
L_{BSV}	Length of pre-stress	[mm]

The side length of expansion loops wih pre-stress is calculated acc. to the following example:

$$L_{BSV} = K \times \sqrt{d \times \frac{\Delta L}{2}}$$



Below expansion joint

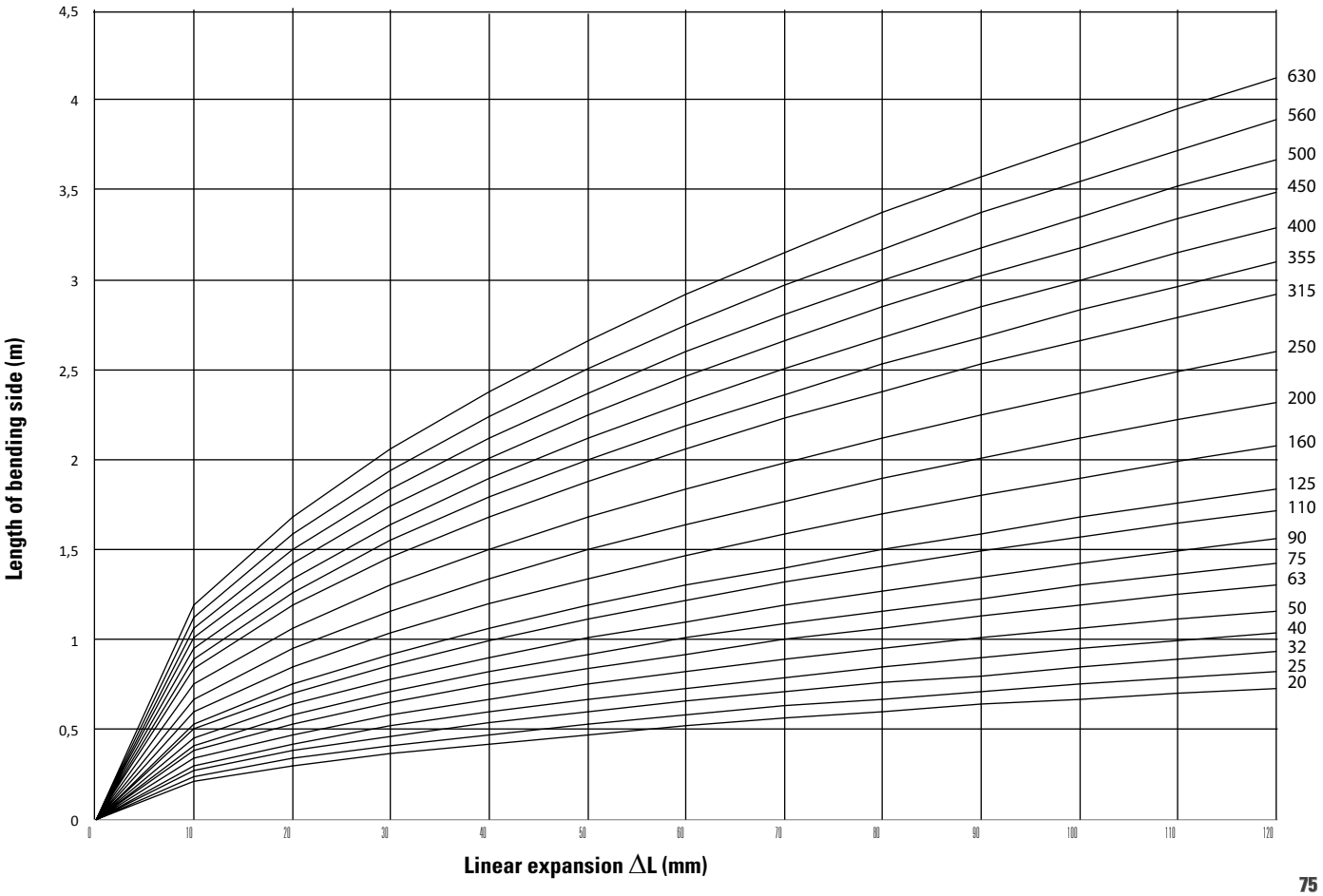
All bellow expansion joints for corrugated pipes designed for metal materials are unsuitable for aquatherm PP-R-pipes.

When using axial expansion joints observe the manufacturers instructions.

LENGTH OF BENDING SIDE

for aquatherm PP-R-pipes – the length of the bending side with pre-stress L_{BSV} can be taken from the tables and graphs in consideration of the applied pipe dimensions and determined linear expansion.

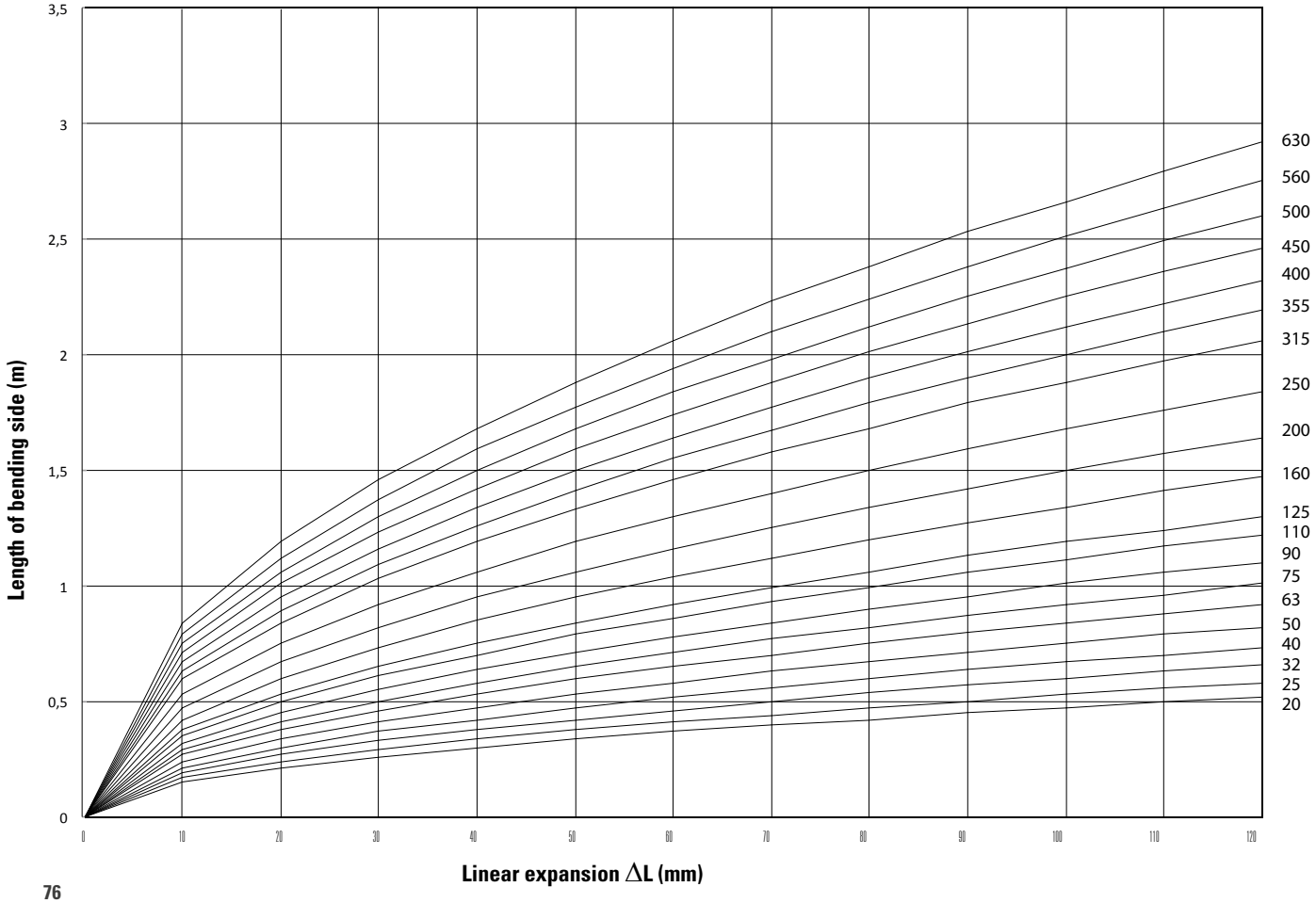
Pipe Dimension	Linear expansion (mm)											
	10	20	30	40	50	60	70	80	90	100	110	120
	Length of bending side (m)											
20 mm	0,21	0,30	0,37	0,42	0,47	0,52	0,56	0,60	0,64	0,67	0,70	0,73
25 mm	0,24	0,34	0,41	0,47	0,53	0,58	0,63	0,67	0,71	0,75	0,79	0,82
32 mm	0,27	0,38	0,46	0,54	0,60	0,66	0,71	0,76	0,80	0,85	0,89	0,93
40 mm	0,30	0,42	0,52	0,60	0,67	0,73	0,79	0,85	0,90	0,95	0,99	1,04
50 mm	0,34	0,47	0,58	0,67	0,75	0,82	0,89	0,95	1,01	1,06	1,11	1,16
63 mm	0,38	0,53	0,65	0,75	0,84	0,92	1,00	1,06	1,13	1,19	1,25	1,30
75 mm	0,41	0,58	0,71	0,82	0,92	1,01	1,09	1,16	1,23	1,30	1,36	1,42
90 mm	0,45	0,64	0,78	0,90	1,01	1,10	1,19	1,27	1,35	1,42	1,49	1,56
110 mm	0,50	0,70	0,86	0,99	1,11	1,22	1,32	1,41	1,49	1,57	1,65	1,72
125 mm	0,53	0,75	0,92	1,06	1,19	1,30	1,40	1,50	1,59	1,68	1,76	1,84
160 mm	0,60	0,85	1,04	1,20	1,34	1,47	1,59	1,70	1,80	1,90	1,99	2,08
200 mm	0,67	0,95	1,16	1,34	1,50	1,64	1,77	1,90	2,01	2,12	2,22	2,32
250 mm	0,75	1,06	1,30	1,50	1,68	1,84	1,98	2,12	2,25	2,37	2,49	2,60
315 mm	0,84	1,19	1,46	1,68	1,88	2,06	2,23	2,38	2,53	2,66	2,79	2,92
355 mm	0,89	1,26	1,55	1,79	2,00	2,19	2,36	2,53	2,68	2,83	2,96	3,10
400 mm	0,95	1,34	1,64	1,90	2,12	2,32	2,51	2,68	2,85	3,00	3,15	3,29
450 mm	1,01	1,42	1,74	2,01	2,25	2,46	2,66	2,85	3,02	3,18	3,34	3,49
500 mm	1,06	1,50	1,84	2,12	2,37	2,60	2,81	3,00	3,18	3,35	3,52	3,67
560 mm	1,12	1,59	1,94	2,24	2,51	2,75	2,97	3,17	3,37	3,55	3,72	3,89
630 mm	1,19	1,68	2,06	2,38	2,66	2,92	3,15	3,37	3,57	3,76	3,95	4,12



LENGTH OF BENDING SIDE WITH PRE-STRESS

For aquatherm PP-R-pipes – the length of the bending side with pre-stress L_{BSV} can be taken from the tables and graphs in consideration of the applied pipe dimensions and determined linear expansion.

Pipe Dimension	Linear expansion (mm)											
	10	20	30	40	50	60	70	80	90	100	110	120
	Length of bending side (m)											
20 mm	0,15	0,21	0,26	0,30	0,34	0,37	0,40	0,42	0,45	0,47	0,50	0,52
25 mm	0,17	0,24	0,29	0,34	0,38	0,41	0,44	0,47	0,50	0,53	0,56	0,58
32 mm	0,19	0,27	0,33	0,38	0,42	0,46	0,50	0,54	0,57	0,60	0,63	0,66
40 mm	0,21	0,30	0,37	0,42	0,47	0,52	0,56	0,60	0,64	0,67	0,70	0,73
50 mm	0,24	0,34	0,41	0,47	0,53	0,58	0,63	0,67	0,71	0,75	0,79	0,82
63 mm	0,27	038	0,46	0,53	0,60	0,65	0,70	0,75	0,80	0,84	0,88	0,92
75 mm	0,29	0,41	0,50	0,58	0,65	0,71	0,77	0,82	0,87	0,92	0,96	1,01
90 mm	0,32	0,45	0,55	0,64	0,71	0,78	0,84	0,90	0,95	1,01	1,06	1,10
110 mm	0,35	0,50	0,61	0,70	0,79	0,86	0,93	0,99	1,06	1,11	1,17	1,22
125 mm	0,38	0,53	0,65	0,75	0,84	0,92	0,99	1,06	1,13	1,19	1,24	1,30
160 mm	0,42	0,60	0,73	0,85	0,95	1,04	1,12	1,20	1,27	1,34	1,41	1,47
200 mm	0,47	0,67	0,82	0,95	1,06	1,16	1,25	1,34	1,42	1,50	1,57	1,64
250 mm	0,53	0,75	0,92	1,06	1,19	1,30	1,40	1,50	1,59	1,68	1,76	1,84
315 mm	0,60	0,84	1,03	1,19	1,33	1,46	1,58	1,68	1,79	1,88	1,97	2,06
355 mm	0,63	0,89	1,09	1,26	1,41	1,55	1,67	1,79	1,90	2,00	2,10	2,19
400 mm	0,67	0,95	1,16	1,34	1,50	1,64	1,77	1,90	2,01	2,12	2,22	2,32
450 mm	0,71	1,01	1,23	1,42	1,59	1,74	1,88	2,01	2,13	2,25	2,36	2,46
500 mm	0,75	1,06	1,30	1,50	1,68	1,84	1,98	2,12	2,25	2,37	2,49	2,60
560 mm	0,79	1,12	1,37	1,59	1,77	1,94	2,10	2,24	2,38	2,51	2,63	2,75
630 mm	0,84	1,19	1,46	1,68	1,88	2,06	2,23	2,38	2,53	2,66	2,79	2,92



SUPPORT INTERVALS

aquatherm green pipe SDR 6 S & aquatherm lilac pipe SDR 7.4 S

Table to determine support intervals in conjunction with temperature and outside diameter.

Difference in temperature ΔT [K]	Pipe diameter d (mm)									
	16	20	25	32	40	50	63	75	90	110
	Support intervals in cm									
0	70	85	105	125	140	165	190	205	220	250
20	50	60	75	90	100	120	140	150	160	180
30	50	60	75	90	100	120	140	150	160	180
40	50	60	70	80	90	110	130	140	150	170
50	50	60	70	80	90	110	130	140	150	170
60	50	55	65	75	85	100	115	125	140	160
70	50	50	60	75	80	95	105	115	125	140

aquatherm green pipe, aquatherm blue pipe & aquatherm lilac pipe SDR 11 S

Table to determine support intervals in conjunction with temperature and outside diameter.

Pipe diameter d (mm)														
20	25	32	40	50	63	75	90	110	125	160	200	250	315	355
Support intervals in cm														
60	75	90	100	120	140	150	160	180	200	260	265	275	280	285

aquatherm blue pipe SDR 17.6 MF

Table to determine support intervals in conjunction with temperature and outside diameter.

Difference in temperature ΔT [K]	Pipe diameter d (mm)										
	125	160	200	250	315	355	400	450	500	560	630
	Support intervals in cm										
0	255	260	265	275	280	285	295	305	315	325	330
20	185	190	200	205	210	215	230	240	255	270	280
30	175	180	190	195	200	205	220	230	245	260	275
40	170	175	180	190	190	195	210	225	235	250	265
50	160	165	175	180	185	190	200	215	230	240	255
60	150	155	165	170	175	180	185	200	215	230	240
70	140	145	155	160	170	175	180	190	205	220	230

SUPPORT INTERVALS

aquatherm green pipe SDR 7.4 MF & aquatherm blue pipe SDR 7.4 MF (faser composite pipes)

Table to determine support intervals in conjunction with temperature and outside diameter.

Difference in temperature ΔT [K]	Pipe diameter d (mm)		
	20	25	32
	Support intervals in cm		
0	120	140	160
20	90	105	120
30	90	105	120
40	85	95	110
50	85	95	110
60	80	90	105
70	70	80	95

Pipe clamp distances of vertically installed pipes can be increased by 20 % of the tabular values, e.g. to multiply the tabular value by 1.2.

aquatherm green pipe SDR 9 MF RP (faser composite pipe)

Table to determine support intervals in conjunction with temperature and outside diameter.

Difference in temperature ΔT [K]	Pipe diameter d (mm)												
	32	40	50	63	75	90	110	125	160	200	250	315	355
	Support intervals in cm												
0	155	175	200	225	240	255	285	300	310	315	325	335	340
20	115	130	150	170	180	190	210	225	225	240	245	250	255
30	115	130	150	170	180	190	200	210	215	225	230	240	245
40	105	120	140	160	170	180	190	200	205	215	225	225	230
50	105	120	140	160	170	180	180	185	195	205	215	220	220
60	100	115	130	150	160	170	170	175	185	195	200	205	210
70	90	105	125	140	155	155	160	165	175	185	190	200	205

Pipe clamp distances of vertically installed pipes can be increased by 20 % of the tabular values, e.g. to multiply the tabular value by 1.2.

aquatherm blue pipe SDR 11 MF & aquatherm green pipe SDR 11 MF (faser composite pipes)

Table to determine support intervals in conjunction with temperature and outside diameter.

Difference in temperature ΔT [K]	Pipe diameter d (mm)														
	32	40	50	63	75	90	110	125	160	200	250	315	355	400	450
	Support intervals in cm														
0	150	170	195	220	235	250	275	280	285	290	300	310	315	325	325
20	110	125	145	165	175	185	200	205	210	220	225	230	235	250	265
30	110	125	145	165	175	185	190	195	200	210	215	220	225	240	255
40	100	115	135	155	165	175	180	185	190	200	210	210	215	230	245
50	100	115	135	155	160	170	170	175	180	190	200	205	205	220	235
60	95	110	125	145	150	160	160	165	170	180	185	190	195	205	220
70	85	100	120	135	140	145	150	155	160	170	175	185	190	195	210

Pipe clamp distances of vertically installed pipes can be increased by 20 % of the tabular values, e.g. to multiply the tabular value by 1.2.

THERMAL INSULATION OF HOT WATER PIPES

minimum insulation thickness in [mm] against condensation

Medium temperature 5°C – thermal conductivity value of insulation 0,040 W/mK												
Dimension	humidity	ambient temperature										
		20°C	22°C	24°C	26°C	28°C	30°C	32°C	34°C	36°C	38°C	40°C
75 mm	50 %		1	1	2	2	3	3	4	4	5	5
	60 %	2	3	3	4	5	5	6	7	7	8	8
	70 %	5	6	7	8	8	9	10	11	12	13	13
	80 %	9	11	12	14	15	17	18	19	20	21	22
110 mm	50 %				1	2	2	3	3	4	4	4
	60 %	1	2	3	3	4	5	5	6	7	7	8
	70 %	4	5	6	7	8	9	10	10	11	12	13
	80 %	9	11	12	14	15	17	18	19	20	21	22
160 mm	50 %						1	1	2	2	3	3
	60 %		1	1	2	3	4	4	5	5	6	7
	70 %	3	4	5	6	7	8	9	9	11	11	12
	80 %	8	10	11	13	14	16	17	19	20	21	22

The decree for energy saving thermal protection and energy saving technique for buildings Decree for Energy Saving (EnEV) regulates the thermal insulation of hot water supplies and fittings in Germany.

Central heating pipes, line 1–4 installed in heated rooms or building parts between heated rooms of the one user, where heat output can be controlled by open stop valves do not require a minimum thickness of the insulation.

This even applies to hot water pipes up to an inner diameter of 22 mm in flats, which are neither in the circulation nor have an additional electric heating.

Applying material with thermal conductivities different to 0.035 W/(mK) the minimum thickness of the insulation has to be converted correspondingly.

For the conversion and the thermal conductivity of the insulation the ways and values of calculation described in the technical regulations must be applied.

The minimum insulation acc. to the table for heating distributions and heating pipes can be reduced as far as the same limit of heat output even for further insulation requirements in consideration of the insulating effect of the pipe walls are guaranteed.

EnEV 2009, § 14, addendum 5, chart 1

Line	Type of pipe/fitting	minimum thickness of insulation referred to thermal conductivity of 0.035 W/(mK)
1	inner diameter up to 22 mm	20 mm
2	inner diameter more than 22 mm up to 35 mm	30 mm
3	inner diameter more than 35 mm up to 100 mm	same as inner diameter
4	inner diameter more than 100 mm	100 mm
5	pipes and fittings after line 1–4 in wall- and ceiling openings, in crossing area of pipes, at pipe connections, at distributors	½ of the requirements of line 1 to 4
6	pipes of central heating after line 1–4, which have been installed after introduction of this decree between heated rooms of various users	½ of the requirements of line 1 to 4
7	pipes after line 6 in floor construction	6 mm
8	Cooling distribution and cold water pipes and fittings of air handling and air conditioning systems	6 mm

INSULATION THICKNESS ACC. TO DECREE FOR ENERGY SAVING

Acc. to this decree aquatherm PP-R-pipes and fittings have to be insulated against loss of heat. The insulation thickness depends on the respective installation.

The heat conductivity figure of fusiolen® PP-R is 0.15 W/(mK) aquatherm PP-R-pipes and fittings offer a significantly higher degree of insulation compared to metal pipes.

Due to the high insulation values of the pipe-material PP-R the insulation thickness – compared to metallic pipe systems – can be reduced.

Undermentioned are the recommendation based on EnEV 2009. Regional standards might vary and are to be considered.

Thermal insulation from heat distribution and hot water pipes, cooling distribution and cold water pipes acc. EnEV 2009
Minimum thickness of insulation referred to thermal conductivity of 0.035 W/(mK)

pipe diameter	50 %	100 %
16 mm	10 mm	20 mm
20 mm	10 mm	20 mm
25 mm	10 mm	20 mm
32 mm	15 mm	30 mm
40 mm	15 mm	30 mm
50 mm	18 mm	35 mm
63 mm	23 mm	45 mm
75 mm	28 mm	55 mm
90 mm	33 mm	65 mm
110 mm	40 mm	80 mm
125 mm	45 mm	90 mm
160 mm	50 mm	100 mm
200 mm	50 mm	100 mm
250 mm	50 mm	100 mm
315 mm	50 mm	100 mm
355 mm	50 mm	100 mm
400 mm	50 mm	100 mm
450 mm	50 mm	100 mm
500 mm	50 mm	100 mm
560 mm	50 mm	100 mm
630 mm	50 mm	100 mm

* The insulation thickness has to be calculated due to the thermal conductivity of polyproplene pipes acc. to test report no.: G.2 - 136/97 of FIW-Munich

LEAKAGE TEST

All aquatherm pipe systems shall be subjected to a hydraulical pressure test with a test-pressure of 10 bar.

The material properties of the aquatherm PP-R-pipe systems result in an expansion of the pipes during the pressure test. This affects the test result. Due to the thermal expansion coefficients of the aquatherm PP-R-pipe systems the results are influenced additionally. The temperature differences between the pipe and the test medium lead to changes in pressure. Hereby a temperature change of 10 K corresponds to a pressure difference of 0,5 up to 1 bar.

Therefore pressure testing of the aquatherm PP-R-pipe systems should be made with a constant temperature of the test medium. The hydraulic pressure test requires a preliminary, principal and final test.

In the preliminary test a pressure of 18 bar is applied 3 x 5 minutes for the expansion/release of the pipes. Between the cycles the pipe system must be depressurized.

Immediately after the preliminary test the principal test should be performed. The test duration is 15 min. Here, the test pressure (10 bar) may not fall more than 0,5 bar.

After completion of the preliminary and principle test finally the final test must be performed.

The test duration is 60 minutes. Here, the test pressure – read after the principle test – may not fall more than 0,5 bar.

Measuring of the test pressures

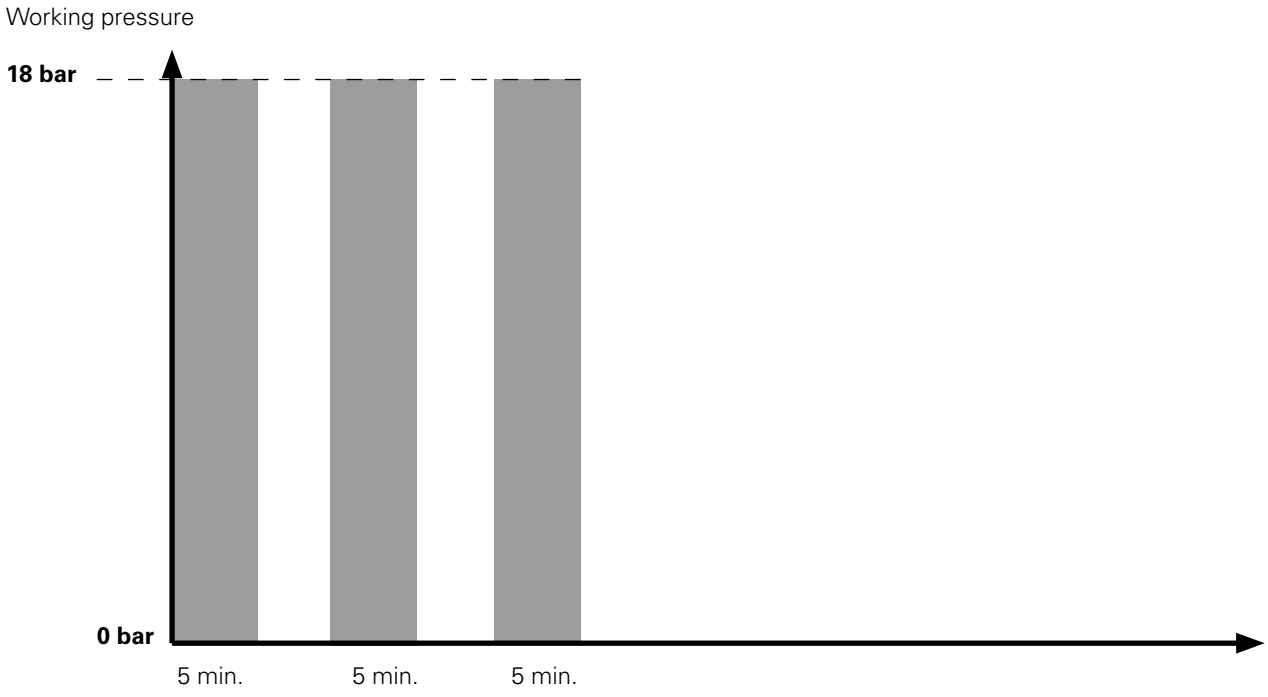
Measuring has to be done with a manometer allowing a perfect reading of a pressure change of 0.1 bar. The manometer has to be placed at the deepest point of the installation.

Test record

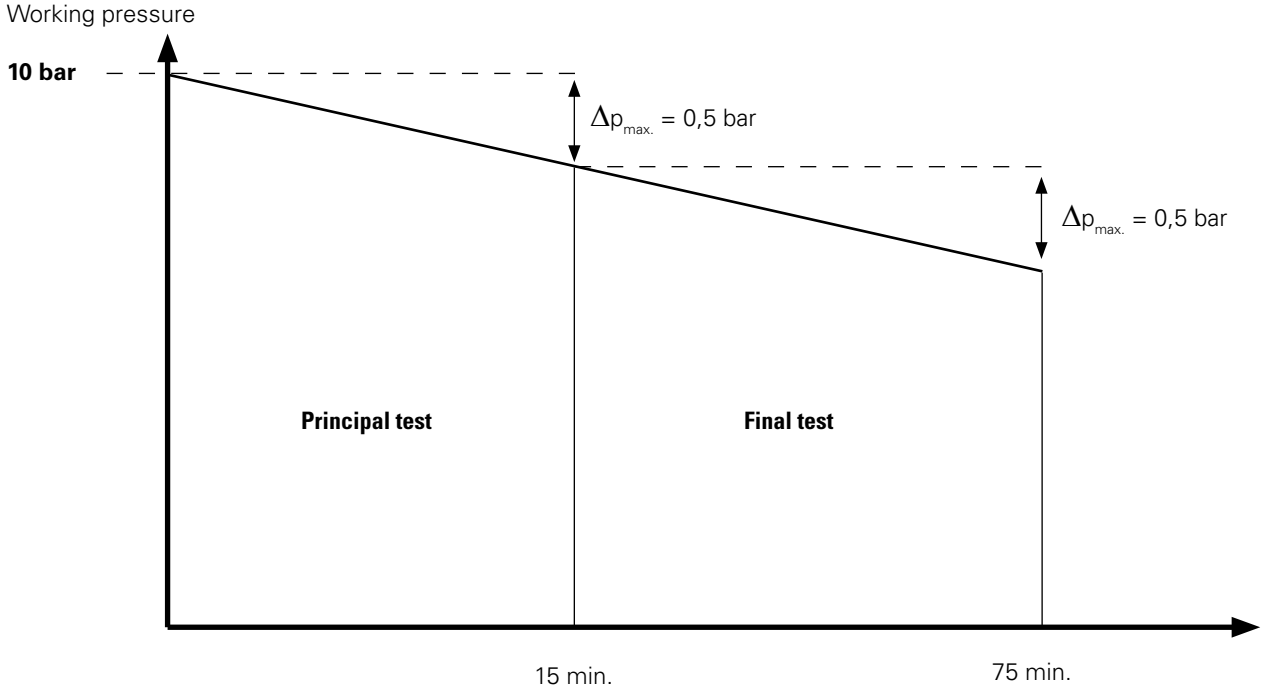
A record of the hydraulic pressure test has to be prepared and signed by the client and contractor stating place and date (see page 83).

LEAKAGE TEST/PRESSURE DIAGRAM

PRELIMINARY TEST



PRINCIPAL- AND FINAL TEST



TEST RECORD AQUATHERM PIPE SYSTEM INSTALLATION

Place: _____

Object: _____

Note before the test:
3 x 5 minutes system pressure of 18 bar for expansion/release of the pipes are required.

Preliminary test
The pipe system must be unpressurized between each cycle.

18 bar	5 min.	realized:	yes	no
18 bar	5 min.	realized:	yes	no
18 bar	5 min.	realized:	yes	no

Principal test

Test pressure: _____ 10 bar

Pressure decline after 15 min.: _____ bar **max. 0.5 bar**

Final test
(directly after the principal test, without changing the pressure)

Result principal test: _____ bar

Pressure decline after 60 min.: _____ bar **max. 0.5 bar**

Notes: _____

Place: _____

Date: _____

Stamp/Signature

Description of installation

Place: _____

Object: _____

Pipe length:

Ø 20 mm	_____	m	Ø 160 mm	_____	m
Ø 25 mm	_____	m	Ø 200 mm	_____	m
Ø 32 mm	_____	m	Ø 250 mm	_____	m
Ø 40 mm	_____	m	Ø 315 mm	_____	m
Ø 50 mm	_____	m	Ø 355 mm	_____	m
Ø 63 mm	_____	m	Ø 400 mm	_____	m
Ø 75 mm	_____	m	Ø 450 mm	_____	m
Ø 90 mm	_____	m	Ø 500 mm	_____	m
Ø 125 mm	_____	m	Ø 560 mm	_____	m
			Ø 630 mm	_____	m

Start of test: _____

End of test: _____

Testperiod: _____

Test medium: ☐ water ☐ water/glycol

Client: _____

_____

_____

Contractor: _____

_____

_____

Place: _____

Date: _____

_____

Stamp/Signature

FLUSHING OF PIPES / EARTH WIRE / TRANSPORT AND STORAGE

Flushing of pipes

The technical rule for potable water installations (TRWI)

DIN 1988, Part 2

includes a paragraph about the flushing of pipes, which has to be carried out with an air-water-mixture under pressure.

Basically all potable water plants, independent of their material, have to be flushed thoroughly after their installation. The following requirements have to be complied with before the installation can be put into service:

- Protection of the potable water quality
- Avoidance of corrosion damage
- Avoidance of malfunctions of armatures and apparatus.
- Cleanliness of the inner surface of the pipe

These requirements are met by

- Flushing with water
- Flushing with air-water-mixture

On choosing the type of flushing required, the experiences of the installer, the requirements of the client and the instructions of the system manufacturer have to be observed.

For potable water installations acc. to DIN 1988, the aquatherm green pipe system complies with, "1 – flushing with water" is sufficient.

The aquatherm green pipe system complies with DIN 1988 for potable water installations. Thus, flushing with water is sufficient, acc. to procedure 1 stipulated therein.

For this reason it is sufficient to flush the installation with water only.

Earth wire

DIN VDE 0100, Part 701 contains safety measures for rooms containing baths or showers. Among other aspects, this standard regulates the potential balance for such rooms.

The standard stipulates that all conductive components such as metal baths and shower trays, metal outlet valves, metal stench traps and metal pipe systems (e. g. drinking water and heating pipe systems) must be connected to each other.

The connection to an earth conductor must be provided, at a central point, e.g. in the building`s mini-distributors installation (power circuit distributors).

Information on renovating potable drinking water pipe systems using aquatherm green pipes:

Where metal pipes are replaced by aquatherm green pipes, the potential balance can not be created by the water pipes.

It should be ensured that the potential balance is checked out by a qualified electrician.

Transport and storage

aquatherm PP-R-pipes may be stored outside at any temperature. A solid base for the pipe is very important to avoid a deformation of the pipes while in transport and storage.

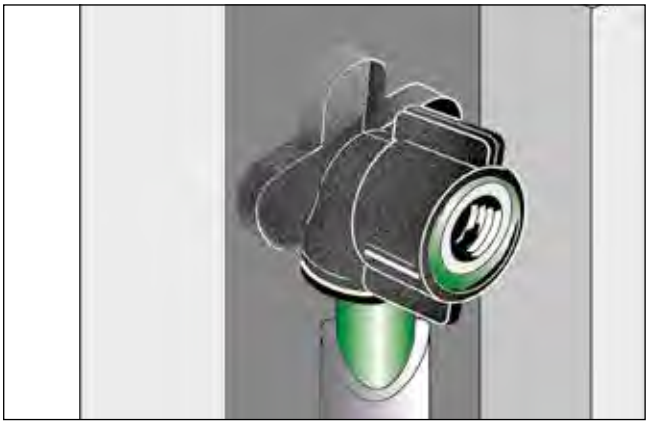
At temperatures below 0 °C it is possible to damage the pipes through strong impacts. The material has to be treated with caution at low temperatures.

In spite of its high resistance aquatherm pipes should be treated with care.

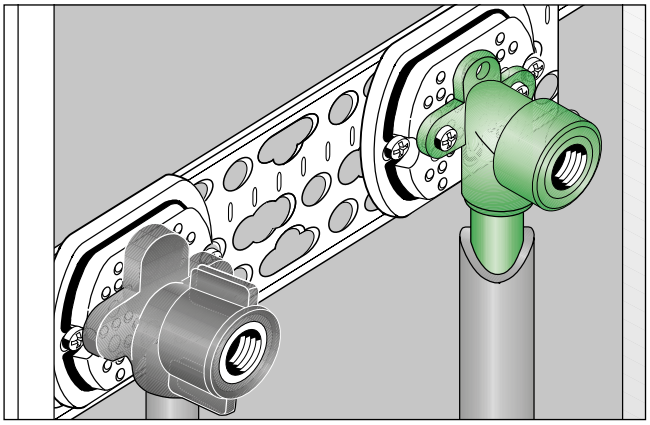
UV-radiation has effects on all high polymer plastics. Do not store permanently outdoor. Maximum storage time (outdoor) is 6 months.



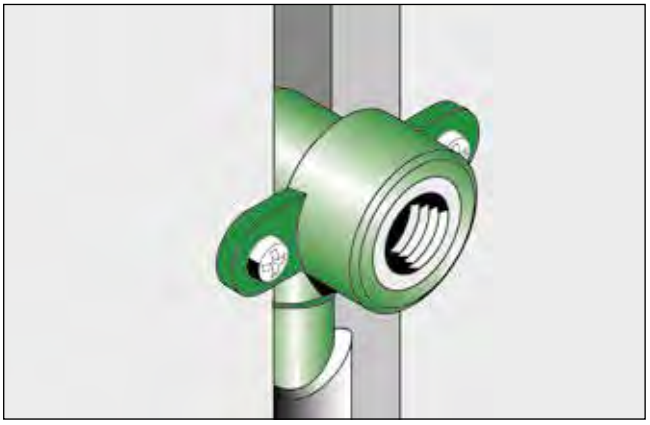
WATER POINT CONNECTIONS



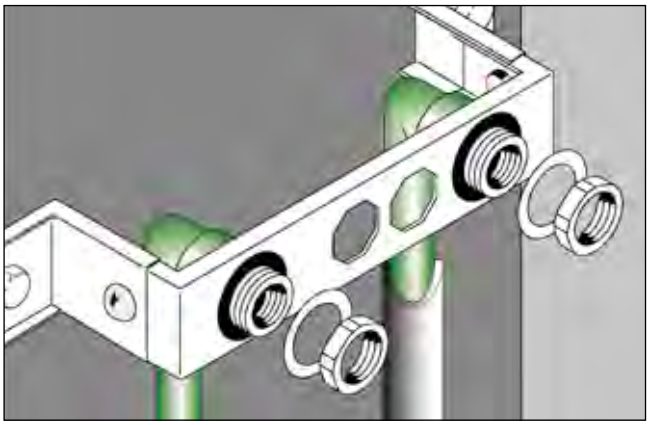
aquatherm green pipe back plate elbow in sound insulation cover (Art. no. 20120), e.g. in a pipe chase or for concealed installation



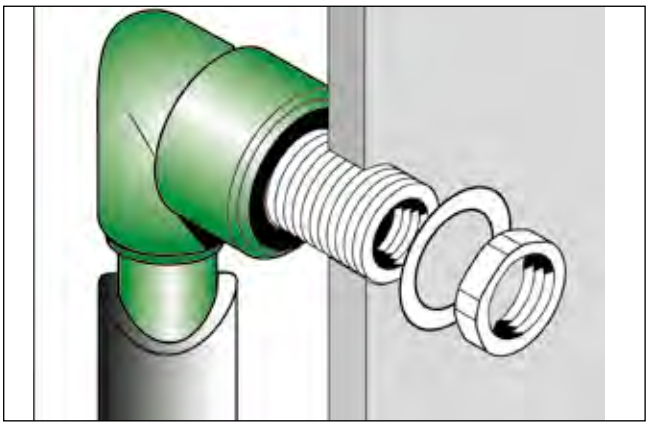
aquatherm green pipe back plate elbow for twin water point connections with galvanized mounting plate and sound insulation plate (Art. no. 79080) from the fixing program (gauge for bore holes 220-153-80 mm)



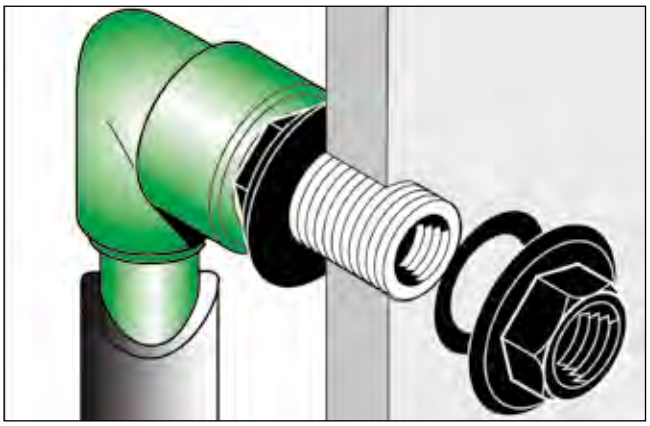
aquatherm green pipe back plate elbow for dry construction installed in a pipe chase



Mounting unit twin (gauge for bore holes 80-100-150 mm) incl. 2 aquatherm green pipe transition elbows female/male with counternut, gasket and spring washer



aquatherm green pipe transition elbow female / male for dry construction with 30 mm thread



aquatherm green pipe dry construction wall fitting with transition elbow

The aquatherm green pipe transition elbow with female / male thread is suitable for flushing box connections.
This transition elbow is also available with a single mounting unit.

DISTRIBUTION BLOCK:
EXAMPLE OF APPLICATIONS

Example of applications

The stamped numbers 1 and 2 indicate the proper connection of the aquatherm green pipe distribution block. They provide assistance with the installation.

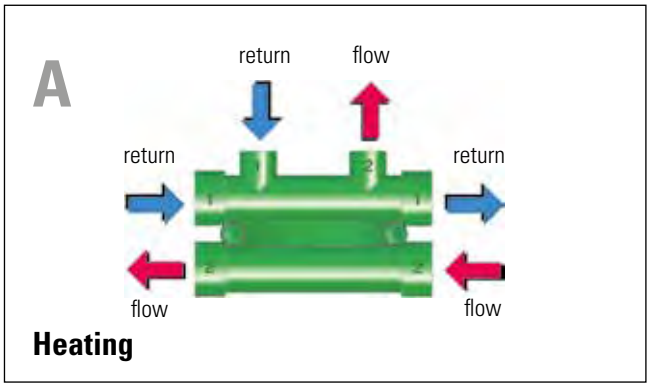
In case of the "heating" connection variant (top A), the return is connected to the supply channel marked 1 and the flow to supply channel marked 2. The connections can also be used reverse.

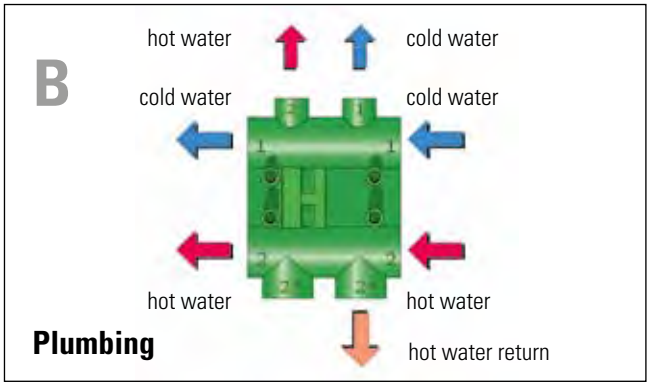
In potable water connection variant (top B), supply channel 1 is intended for the cold water pipe and supply channel 2 for the hot water pipe connection. In as-delivered condition, the lower outlets are closed. The connection with supply channel 2 is made by drilling out (18 mm drill bit). Thus an additional pipe can be connected.

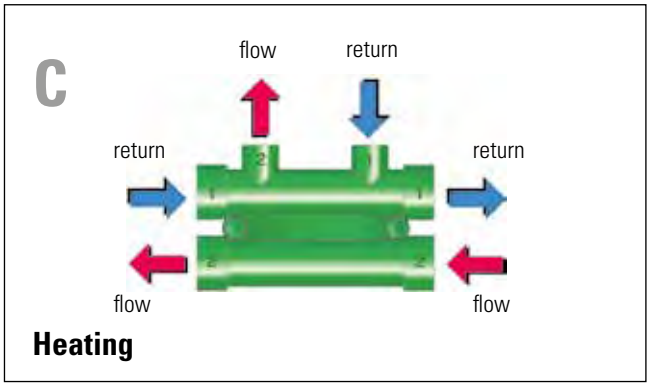
By turning the aquatherm green pipe distribution block a mirror-image connection can be made. These variants are presented in the illustrations C and D.

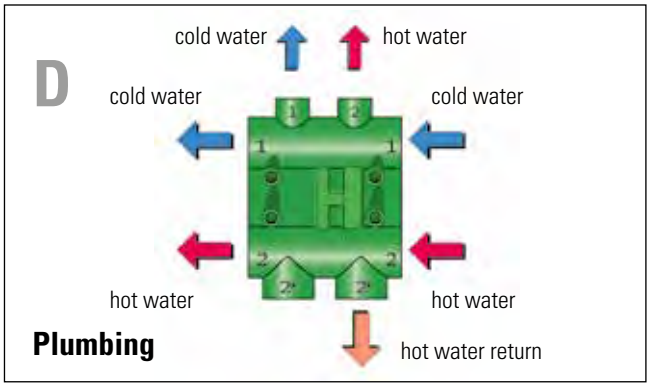
The flow and return connections of the aquatherm green pipe distribution block heating are installed with Ø 20 mm pipes. For radiator connections Ø 16 mm pipes have to be welded into the outflow sockets of the distribution block.

The aquatherm green pipe distribution block plumbing has to be connected with Ø 25 mm pipes. For pipe connections to the taps, Ø 20 mm pipes have to be welded into the outflow sockets of the distribution block.









DISTRIBUTION BLOCK:
EXAMPLE OF APPLICATIONS – POTABLE WATER



The connection pipes in the individual floors or risers are connected for hot and cold water with aquatherm PP-R-pipes with an external diameter of 25 mm. The same applies for also for the hot water return which can be led back from any aquatherm green pipe distribution block.



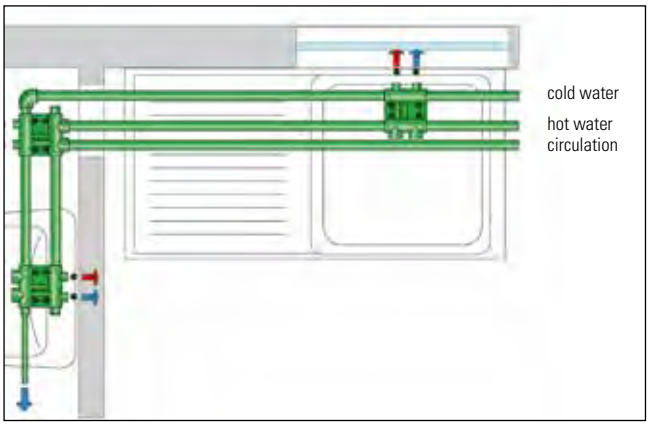
Reducers for further pipe systems can be welded directly onto the distribution block.



The supplied 25 mm end plug seals off a through-flow unit or, alternatively, the 16 mm end cap.
By cutting the end of the plug, it can be used as 25 mm to 16 mm reducer or as 16 mm socket.

By turning the aquatherm green pipe distribution block and drilling out the factory-sealed outlets, it is possible to create compact connection arrangements even in areas of restricted space.

This avoids the time-consuming operation of guiding under or over pipes and the associated sealing work.



INSULATION FOR DISTRIBUTION BLOCK / AQUATHERM DISTRIBUTION BLOCK

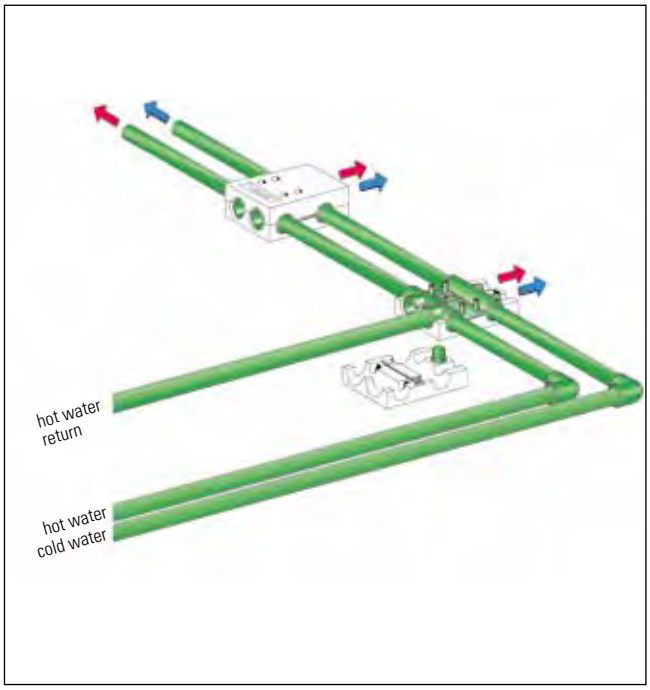
Insulation for distribution block

It is also possible to install the compact distribution block by using a specially adapted insulation. In this case the green junction does not only avoid the crossing of pipes, but also the extra work involved in the expensive insulation of the double tee-branch.

The insulation for the aquatherm green pipe distribution block is made from high-quality PPO/PS rigid expanded polyurethane. Thus, a fast, unproblematic and safe insulation acc. to the current Decree for the Installation of Heating Systems is provided.

Thermal conductivity: WLG 040
Length: 184 mm
Width: 119 mm
Height: 70 mm

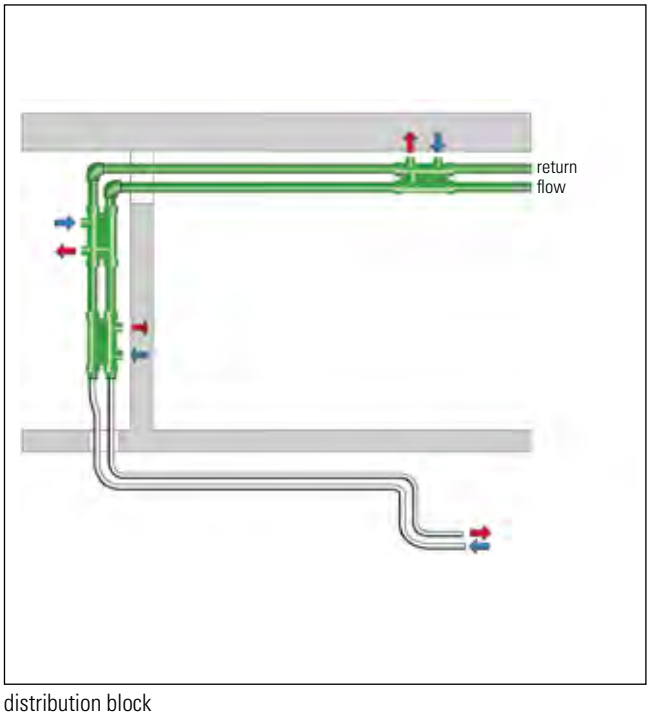
The accessories (1 plug, 2 fastening plugs) are integrated in the insulation of supply unit aquatherm green pipe distribution block (Art. no. 30115, see picture).



Insulation block for distribution block

aquatherm green pipe distribution block

If the radiator connection is not in the immediate vicinity of the pipe connection of the distribution block, this supply can be arranged with a 16 mm pipe by welding-in of two reducers 20 / 16 mm (Art. no. 11109).



distribution block

AQUATHERM DISTRIBUTION BLOCK:
EXAMPLE OF APPLICATIONS – HEATING



The flow and return connections of heating pipes to the aquatherm distribution block are with aquatherm PP-R-pipes of an external diameter of 20 mm. Used in conjunction with the aquatherm connecting bend (Art. no. 85120) and the aquatherm radiator valves (Art. no. 79606 or 79608), the outgoing 16 mm pipe connections are ideal for radiator connections.



It is of no importance, where the heating flow or return is connected to the aquatherm distribution block. A simply turning of the distribution block adapts it to the appropriate specification.

PLANNING

DIN 1988 T3 / MAXIMUM FLOW RATE / PRINCIPLES OF CALCULATION / CALCULATION GUIDE / SOFTWARE

DIN EN 806 PART 3 AND DIN 1988 PART 300

DIN EN 806 part 3 and DIN 1988 part 300 (Technical Rules for Potable Water Installations) specifies the calculation principles for the determining of the pipe diameter.

The determining of the pipe diameter is based on the calculation of the pressure loss in pipes.

Beside the diameter the pressure loss depends on the length of the pipe, the pipe material and on the flow rate, dependent on the quantity and size of the water points to which the pipe is connected.

The basis for determining the maximum flow rate should be calculated on the desired flow rate of each water point. The simultaneous use resp. the peak pressure of flow of an installation part has to be determined by taking the calculation values from DIN 1988 T 3 as a basis.

Maximum flow rate

A further criterion for the selection of the pipe diameter is the maximum permissible flow rate. Because of sonic reasons and for the limitation of water hammer, the calculated flow rate may not exceed the values of the table below.

DIN EN 806-part 3
Collective supply pipes, riser pipes, storey pipes max. 2,0 m/s;
Individual supply pipes max. 4,0 m/s
NOTE: National regulations may require lower flow rates to avoid water hammers and noises.

DIN1988 part 300 table 5 – Maximum calculated flow rate in case of the related peak flow

Section of the installation	max. calculated flow rate at run (m/s)	
	< 15 min.	≥ 15 min.
Connecting pipes (Building connection)	2	2
Supply pipelines: Sections with resistance coeffcients $\zeta < 2{,}5$ for individual resistances [a]	5	2
Sections with resistance coefficients $\zeta \geq 2{,}5$ for indidvidual resistances [b]	2.5	2

[a] i. e. piston valves acc. to DIN 3500. ball cock. inclined valves acc. to DIN 3502 (from DN 20)
[b] i. e. screw-down stop globe valves acc. to DIN 3512

Principles of calculation

To determine the pipe diameter in potable water networks of buildings numerous principles of calculation are necessary. The revised version of DIN 1988 provides a simplified and differentiated method of calculation.

The simplified method is suitable for clearly arranged pipes i. e. in residential buildings. The differentiated method includes all pipes and local resistances and offers the highest accuracy as well as the most accurate approximation of real operating conditions. The determining of the pipe diameter requires the following data:

- Minimum gauge pressure of supply or pressure in flow direction behind pressure reducing or boosting valve
- Head variations
- Pressure loss due to apparatus i. e. watermeter, filter, softening installations etc.
- Minimum flow pressure of the water point applied
- Pipe friction factor of the used pipe material
- Coefficients of loss for fittings and pipe connections

Calculation guide / Software

The potable water network calculation acc. to DIN EN 806 and/or DIN 1988 is normally made with the assistance of software.

aquatherm offers the independent and easy to use calculation programm "liNear", which can be ordered directly with – or without – training at aquatherm.

For any questions, please contact our aquatherm information service:
+ 49 (0) 2722 950-200

We like to help you!

aquatherm
Software-Service

liNear

MINIMUM FLOW PRESSURE

Calculated flows of common water points

Minimum flow pressure $p_{min. Fl}$	Type of water point		Calculated flow on taking:		
			mixed water[1]		only cold or heated potable water
			V_R cold	V_R warm	V_R
bar	Designation		l/s	l/s	l/s
	Taps				
0.5	without air inlet (airator) [2]	DN 15	-	-	0.30
0.5	without air inlet (airator) [2]	DN 20	-	-	0.50
0.5	without air inlet (airator) [2]	DN 25	-	-	1.00
1.0	with air inlet (airator)	DN 10	-	-	0.15
1.0	with air inlet (airator)	DN 15	-	-	0.15
1.0	Shower heads for purification showers	DN 15	0.10	0.10	0.20
1.2	Flush valves acc. to DIN 3265 Part 1	DN 15	-	-	0.70
1.2		DN 20	-	-	1.00
0.4		DN 25	-	-	1.00
1.0	Flush valves urinals	DN 15	-	-	0.30
1.0	Domestic dish washers	DN 15	-	-	0.15
1.0	Domestic washing machine	DN 15	-	-	0.25
	Mixing battery for:				
1.0	Shower-bathes	DN 15	0.15	0.15	-
1.0	Bath-tubs	DN 15	0.15	0.15	-
1.0	Kitchen sinks	DN 15	0.07	0.07	-
1.0	Washstands	DN 15	0.07	0.07	-
1.0	Bidets	DN 15	0.07	0.07	-
1.0	Mixing battery	DN 20	0.30	0.30	-
0.5	Flushing- box DIN 19542	DN 15	-	-	0.13
1.0	Electro boiler	DN 15	-	-	0.10 [3]

COMMENT:

All other water points and apparatus of the above type with larger armature passages or minimum pressures of flow have to be considered with determining the pipe diameter acc. to the manifacturer`s instructions.

1) The calculated flows of mixed water points are based on 15 °C for cold potable water and 60 °C for hot potable water.
2) In case of taps without air inlet (airator) and with hose screw. the loss of pressure in the hose pipe (up to 10 m length) and in the connected apparatus (i.e. lawn sprinkler) is considered over the minimum pressure of flow. The minimum pressure of flow is increased by 1.0 bar to 1.5 bar.
3) In case of fully opened flow control valve.

MINIMUM FLOW PRESSURE

Determination of the peak flow rate Vs from the total flow ∑VR for buildings

acc. to DIN 1988 Teil 3 VS = 0.682 · (∑VR)0.45 – 0.14 [l/s]

ΣV_R	V_S	ΣV_R	V_S	ΣV_R	V_S	ΣV_R	V_S	ΣV_R	V_S	ΣV_R	V_S	ΣV_R	V_S	ΣV_R	V_S
0,03	0,00	1,02	0,55	2,02	0,80	3,02	0,98	4,02	1,14	5,10	1,28	10,10	1,79	15,10	2,17
0,04	0,02	1,04	0,55	2,04	0,80	3,04	0,98	4,04	1,14	5,20	1,29	10,20	1,80	15,20	2,18
0,06	0,05	1,06	0,56	2,06	0,80	3,06	0,99	4,06	1,14	5,30	1,30	10,30	1,81	15,30	2,19
0,07	0,07	1,08	0,57	2,08	0,81	3,08	0,99	4,08	1,14	5,40	1,32	10,40	1,82	15,40	2,19
0,08	0,08	1,10	0,57	2,10	0,81	3,10	0,99	4,10	1,15	5,50	1,33	10,50	1,82	15,50	2,20
0,09	0,09	1,12	0,58	2,12	0,82	3,12	1,00	4,12	1,15	5,60	1,34	10,60	1,83	15,60	2,21
0,10	0,10	1,14	0,58	2,14	0,82	3,14	1,00	4,14	1,15	5,70	1,35	10,70	1,84	15,70	2,21
0,13	0,13	1,16	0,59	2,16	0,82	3,16	1,00	4,16	1,16	5,80	1,36	10,80	1,85	15,80	2,22
0,15	0,15	1,18	0,59	2,18	0,83	3,18	1,01	4,18	1,16	5,90	1,38	10,90	1,86	15,90	2,23
0,20	0,19	1,20	0,60	2,20	0,83	3,20	1,01	4,20	1,16	6,00	1,39	11,00	1,87	16,00	2,23
0,22	0,21	1,22	0,61	2,22	0,84	3,22	1,01	4,22	1,16	6,10	1,40	11,10	1,87	16,10	2,24
0,24	0,22	1,24	0,61	2,24	0,84	3,24	1,02	4,24	1,17	6,20	1,41	11,20	1,88	16,20	2,25
0,26	0,23	1,26	0,62	2,26	0,84	3,26	1,02	4,26	1,17	6,30	1,42	11,30	1,89	16,30	2,25
0,28	0,24	1,28	0,62	2,28	0,85	3,28	1,02	4,28	1,17	6,40	1,43	11,40	1,90	16,40	2,26
0,30	0,26	1,30	0,63	2,30	0,85	3,30	1,03	4,30	1,17	6,50	1,44	11,50	1,91	16,50	2,27
0,32	0,27	1,32	0,63	2,32	0,86	3,32	1,03	4,32	1,18	6,60	1,45	11,60	1,91	16,60	2,27
0,34	0,28	1,34	0,64	2,34	0,86	3,34	1,03	4,34	1,18	6,70	1,47	11,70	1,92	16,70	2,28
0,36	0,29	1,36	0,64	2,36	0,86	3,36	1,04	4,36	1,18	6,80	1,48	11,80	1,93	16,80	2,29
0,38	0,30	1,38	0,65	2,38	0,87	3,38	1,04	4,38	1,19	6,90	1,49	11,90	1,94	16,90	2,29
0,40	0,31	1,40	0,65	2,40	0,87	3,40	1,04	4,40	1,19	7,00	1,50	12,00	1,95	17,00	2,30
0,42	0,32	1,42	0,66	2,42	0,88	3,42	1,05	4,42	1,19	7,10	1,51	12,10	1,95	17,10	2,31
0,44	0,33	1,44	0,66	2,44	0,88	3,44	1,05	4,44	1,19	7,20	1,52	12,20	1,96	17,20	2,31
0,46	0,34	1,46	0,67	2,46	0,88	3,46	1,05	4,46	1,20	7,30	1,53	12,30	1,97	17,30	2,32
0,48	0,35	1,48	0,67	2,48	0,89	3,48	1,06	4,48	1,20	7,40	1,54	12,40	1,98	17,40	2,33
0,50	0,36	1,50	0,68	2,50	0,89	3,50	1,06	4,50	1,20	7,50	1,55	12,50	1,99	17,50	2,33
0,52	0,37	1,52	0,68	2,52	0,89	3,52	1,06	4,52	1,20	7,60	1,56	12,60	1,99	17,60	2,34
0,54	0,38	1,54	0,69	2,54	0,90	3,54	1,06	4,54	1,21	7,70	1,57	12,70	2,00	17,70	2,35
0,56	0,39	1,56	0,69	2,56	0,90	3,56	1,07	4,56	1,21	7,80	1,58	12,80	2,01	17,80	2,35
0,58	0,39	1,58	0,70	2,58	0,90	3,58	1,07	4,58	1,21	7,90	1,59	12,90	2,02	17,90	2,36
0,60	0,40	1,60	0,70	2,60	0,91	3,60	1,07	4,60	1,22	8,00	1,60	13,00	2,02	18,00	2,36
0,62	0,41	1,62	0,71	2,62	0,91	3,62	1,08	4,62	1,22	8,10	1,61	13,10	2,03	18,10	2,37
0,64	0,42	1,64	0,71	2,64	0,92	3,64	1,08	4,64	1,22	8,20	1,62	13,20	2,04	18,20	2,38
0,66	0,43	1,66	0,72	2,66	0,92	3,66	1,08	4,66	1,22	8,30	1,63	13,30	2,05	18,30	2,38
0,68	0,43	1,68	0,72	2,68	0,92	3,68	1,09	4,68	1,23	8,40	1,64	13,40	2,05	18,40	2,39
0,70	0,44	1,70	0,73	2,70	0,93	3,70	1,09	4,70	1,23	8,50	1,65	13,50	2,06	18,50	2,40
0,72	0,45	1,72	0,73	2,72	0,93	3,72	1,09	4,72	1,23	8,60	1,66	13,60	2,07	18,60	2,40
0,74	0,46	1,74	0,74	2,74	0,93	3,74	1,09	4,74	1,23	8,70	1,67	13,70	2,07	18,70	2,41
0,76	0,46	1,76	0,74	2,76	0,94	3,76	1,10	4,76	1,24	8,80	1,67	13,80	2,08	18,80	2,41
0,78	0,47	1,78	0,74	2,78	0,94	3,78	1,10	4,78	1,24	8,90	1,68	13,90	2,09	18,90	2,42
0,80	0,48	1,80	0,75	2,80	0,94	3,80	1,10	4,80	1,24	9,00	1,69	14,00	2,10	19,00	2,43
0,82	0,48	1,82	0,75	2,82	0,95	3,82	1,11	4,82	1,24	9,10	1,70	14,10	2,10	19,10	2,43
0,84	0,49	1,84	0,76	2,84	0,95	3,84	1,11	4,84	1,25	9,20	1,71	14,20	2,11	19,20	2,44
0,86	0,50	1,86	0,76	2,86	0,95	3,86	1,11	4,86	1,25	9,30	1,72	14,30	2,21	19,30	2,44
0,88	0,50	1,88	0,77	2,88	0,96	3,88	1,12	4,88	1,25	9,40	1,73	14,40	2,12	19,40	2,45
0,90	0,51	1,90	0,77	2,90	0,96	3,90	1,12	4,90	1,25	9,50	1,74	14,50	2,13	19,50	2,46
0,92	0,52	1,92	0,77	2,92	0,96	3,92	1,12	4,92	1,26	9,60	1,75	14,60	2,14	19,60	2,46
0,94	0,52	1,94	0,78	2,94	0,97	3,94	1,12	4,94	1,26	9,70	1,76	14,70	2,15	19,70	2,47
0,96	0,53	1,96	0,78	2,96	0,97	3,96	1,13	4,96	1,26	9,80	1,76	14,80	2,15	19,80	2,47
0,98	0,54	1,98	0,79	2,98	0,97	3,98	1,13	4,98	1,26	9,90	1,77	14,90	2,16	19,90	2,48
1,00	0,54	2,00	0,79	3,00	0,98	4,00	1,13	5,00	1,27	10,00	1,78	15,00	2,17	20,00	2,49

This table is valid, if the calculated flow V_R of the respective water points is less than 0.5 l/s.

MINIMUM FLOW PRESSURE

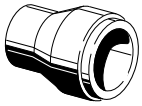
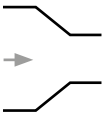
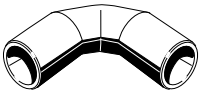
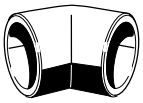
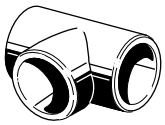
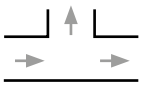
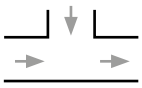
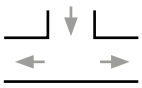
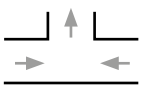
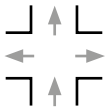
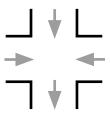
Determination of the peak flow rate Vs from the total flow ∑VR for buildings

acc. to DIN 1988 Teil 3 VS = 1.7 · (∑VR)0.21 – 0.7 [l/s]

ΣV_R	V_S	ΣV_R	V_S	ΣV_R	V_S	ΣV_R	V_S	ΣV_R	V_S	ΣV_R	V_S	ΣV_R	V_S	ΣV_R	V_S
1,00	1,00	5,10	1,69	10,10	2,06	15,10	2,31	22,40	2,57	142,20	4,12	262,40	4,78	382,40	5,23
1,05	1,02	5,20	1,70	10,20	2,07	15,20	2,31	24,80	2,64	144,80	4,13	264,80	4,79	384,80	5,23
1,10	1,03	5,30	1,71	10,30	2,07	15,30	2,31	27,20	2,70	147,20	4,15	267,20	4,81	387,20	5,24
1,15	1,05	5,40	1,72	10,40	2,08	15,40	2,32	29,60	2,76	149,60	4,17	269,60	4,81	389,60	5,25
1,20	1,07	5,50	1,73	10,50	2,09	15,50	2,32	32,00	2,82	152,00	4,18	272,00	4,82	392,00	5,26
1,25	1,08	5,60	1,74	10,60	2,09	15,60	2,33	34,40	2,87	154,40	4,20	274,40	4,83	394,40	5,26
1,30	1,10	5,70	1,75	10,70	2,10	15,70	2,33	36,80	2,92	156,80	4,21	276,80	4,84	396,80	5,27
1,35	1,11	5,80	1,76	10,80	2,10	15,80	2,34	39,20	2,97	159,20	4,23	279,20	4,85	399,20	5,28
1,40	1,12	5,90	1,77	10,90	2,11	15,90	2,34	41,60	3,02	161,60	4,25	281,60	4,86	401,60	5,29
1,45	1,14	6,00	1,78	11,0	2,11	16,00	2,34	44,00	3,06	164,00	4,26	284,00	4,87	404,00	5,29
1,50	1,15	6,10	1,79	11,10	2,12	16,10	2,35	46,40	3,11	166,40	4,28	286,40	4,88	406,40	5,30
1,55	1,16	6,20	1,79	11,20	2,12	16,20	2,35	48,80	3,15	168,80	4,29	288,80	4,89	408,80	5,31
1,60	1,18	6,30	1,80	11,30	2,13	16,30	2,35	51,20	3,19	171,20	4,31	291,20	4,90	411,20	5,32
1,65	1,19	6,40	1,81	11,40	2,13	16,40	2,36	53,60	3,22	173,60	4,32	293,60	4,91	413,60	5,32
1,70	1,20	6,50	1,82	11,50	2,14	16,50	2,36	56,00	3,26	176,00	4,34	296,00	4,92	416,00	5,33
1,75	1,21	6,60	1,83	11,60	2,14	16,60	2,37	58,40	3,29	178,40	4,35	298,40	4,93	418,40	5,34
1,80	1,22	6,70	1,83	11,70	2,15	16,70	2,37	60,80	3,33	180,80	4,36	300,80	4,93	420,80	5,35
1,85	1,23	6,80	1,84	11,80	2,15	16,80	2,37	63,20	3,36	183,20	4,38	303,20	4,94	423,20	5,35
1,90	1,25	6,90	1,85	11,90	2,16	16,90	2,38	65,60	3,39	185,60	4,36	305,60	4,95	425,60	5,36
2,00	1,27	7,00	1,86	12,00	2,16	17,00	2,38	68,00	3,42	188,00	4,41	308,00	4,96	428,00	537
2,10	1,29	7,10	1,87	12,10	2,17	17,10	2,39	70,40	3,45	190,40	4,42	310,40	4,97	430,40	5,38
2,20	1,31	7,20	1,87	12,20	2,17	17,20	2,39	72,80	3,48	192,80	4,43	312,80	4,98	432,80	5,38
2,30	1,32	7,30	1,88	12,30	2,18	17,30	2,39	75,20	3,51	195,20	4,45	315,20	4,99	435,20	5,39
2,40	1,34	7,40	1,89	12,40	2,18	17,40	2,40	77,60	3,54	197,60	4,46	317,60	5,00	437,60	5,40
2,50	1,36	7,50	1,90	12,50	2,19	17,50	2,40	80,00	3,57	200,00	4,47	320,00	5,01	440,00	5,40
2,60	1,38	7,60	1,90	12,60	2,19	17,60	2,40	82,40	3,59	202,40	4,49	322,40	5,02	442,40	5,41
2,70	1,39	7,70	1,91	12,70	2,20	17,70	2,41	84,80	3,62	204,80	4,50	324,80	5,03	444,80	5,42
2,80	1,41	7,80	1,92	12,80	2,20	17,80	2,41	87,20	3,64	207,20	4,51	327,20	5,04	447,20	5,42
2,90	1,43	7,90	1,92	12,90	2,21	17,90	2,42	89,60	3,67	209,60	4,52	329,60	5,04	452,00	5,43
3,00	1,44	8,00	1,93	13,00	2,21	18,00	2,42	92,00	3,69	212,00	4,54	332,00	5,05	454,40	5,44
3,10	1,46	8,10	1,94	13,10	2,22	18,10	2,42	94,40	3,72	214,40	4,55	334,40	5,06	456,80	5,44
3,20	1,47	8,20	1,94	13,20	2,22	18,20	2,43	96,80	3,74	216,80	4,56	336,80	5,07	459,20	5,45
3,30	1,48	8,30	1,95	13,30	2,23	18,30	2,43	99,20	3,76	219,20	4,57	339,20	5,08	461,60	5,46
3,40	1,50	8,40	1,96	13,40	2,23	18,40	2,43	101,60	3,79	221,60	4,58	341,60	5,09	464,00	5,47
3,50	1,51	8,50	1,96	13,50	2,24	18,50	2,44	104,00	3,81	224,00	4,60	344,00	5,10	466,40	5,47
3,60	1,52	8,60	1,97	13,60	2,24	18,60	2,44	106,40	3,83	226,40	4,61	346,40	5,10	468,80	5,48
3,70	1,54	8,70	1,98	13,70	2,25	18,70	2,44	108,80	3,85	228,80	4,62	348,80	5,11	471,20	5,49
3,80	1,55	8,80	1,98	13,80	2,25	18,80	2,45	111,20	3,87	231,20	4,63	351,20	5,12	473,60	5,49
3,90	1,56	8,90	1,99	13,90	2,25	18,90	2,45	113,60	3,89	233,60	4,64	353,60	5,13	476,00	5,50
4,00	1,57	9,00	2,00	14,00	2,26	19,00	2,45	11,6,00	3,91	236,00	4,66	356,00	5,14	478,40	5,51
4,10	1,59	9,10	2,00	14,10	2,26	19,10	2,46	118,40	3,93	238,40	4,67	358,40	5,15	480,80	5,51
4,20	1,60	9,20	2,01	14,20	2,27	19,20	2,46	120,80	3,95	240,80	4,68	360,80	5,15	483,20	5,52
4,30	1,61	9,30	2,02	14,30	2,27	19,30	2,47	123,20	3,97	243,20	4,69	363,20	5,16	485,60	5,52
4,40	1,62	9,40	2,02	14,40	2,28	19,40	2,47	125,60	3,99	245,60	4,70	365,00	5,17	488,00	5,53
4,50	1,63	9,50	2,03	14,50	2,28	19,50	2,47	128,00	4,01	248,00	4,71	368,00	5,18	490,40	5,54
4,60	1,64	9,60	2,03	14,60	2,29	19,60	2,48	130,40	4,03	250,40	4,72	370,40	5,19	492,40	5,54
4,70	1,65	9,70	2,04	14,70	2,29	19,70	2,48	132,80	4,05	252,80	4,763	372,80	5,19	492,80	5,55
4,80	1,66	9,80	2,05	14,80	2,29	19,80	2,48	135,20	4,06	255,20	4,74	375,20	5,20	495,20	5,56
4,90	1,67	9,90	2,05	14,90	2,30	19,90	2,49	137,60	4,08	257,60	4,75	377,60	5,21	497,60	5,56
5,00	1,68	10,00	2,06	15,00	2,30	20,00	2,49	140,00	4,10	260,00	4,77	380,00	5,22	500,00	5,57

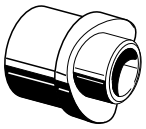
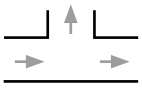
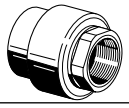
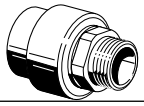
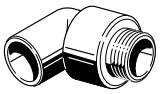
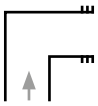
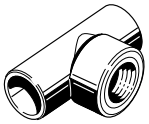
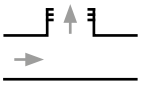
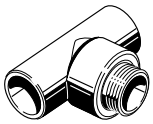
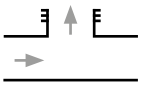
This table is valid, if the calculated flow V_R of the respective water points is less than 0.5 l/s.

Coefficient of loss ζ aquatherm green pipe fittings

Fitting	Picture	Symbol	Comment	ζ-Value
Socket				0.25
Reducer			Reduction…	
			…by 1 dimension	0.40
			…by 2 dimension	0.50
			…by 3 dimension	0.60
			…by 4 dimension	0.70
			…by 5 dimension	0.80
			…by 6 dimension	0.90
Elbow 90°				1.20
Segment elbow 90° (200–630 mm)				0,80
Elbow 90° male/female				1.20
Elbow 45°				0.50
Elbow 45° male/female				0.50
			Separation of flow	1.20
			Conjunction of flow	0.80
			Counter current in case of separation of flow	1.80
			Counter current in case of conjunction of flow	3.00
Reducing tee	The z-value results from the addition of tee and reducer			
Cross			Separation of flow	2.10
			Conjunction of flow	3.70

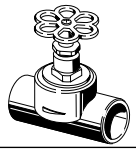
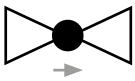
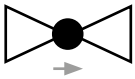
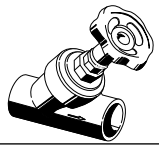
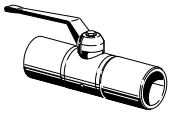
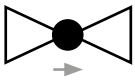
(→ = flow direction)

Coefficient of loss ζ aquatherm green pipe fittings

Fitting	Picture	Symbol	Comment	ζ-Value
			Separation of flow	0.5
Reducing tee	The z-value results from the addition of the weld in saddle and tee			
Transition piece with female thread				0.50
Transition piece with male thread				0.70
Elbow with female thread				1.40
Elbow with male thread				1.60
Transition tee with female thread			Separation of flow	
			- 16 x ½" x 16 - 20 x ¾" x 20	1.40
			- 20 x ½" x 20 - 25 x ¾" x 25 - 32 x 1" x 32	1.60
			- 25 x ½" x 25 - 32 x ¾" x 32	1.80
Threaded branch tee with male thread			Separation of flow - 20 x ½" x 20	1.80

(→ = flow direction)

Coefficient of loss ζ aquatherm green pipe fittings

Fitting	Picture	Symbol	Comment	ζ-Value
Screw-down stop globe valve			- 20 mm	10
			- 25 mm	8.5
			- 32 mm	7
			- 40 mm	6
Inclined valve			- 20 mm	3.5
			- 25 mm	2.5
			- 32 mm	2
			- 40 mm	2
Non-return valve			- 20 mm	7.7
			- 25 mm	6
			- 32 mm	5
			- 40 mm	5
Ball valve			- 20 mm	1
			- 25 mm	0.5
			- 32 mm	0.5
			- 40 mm	0.3
			- 50 mm	0.3
			- 63 mm	0.3
Draining branch				

(→ = flow direction)

Source: DIN 1988 Part 3

$$Z = \frac{\zeta \; v^2 \; \delta}{2}$$

Z = Pressure lost in [Pa]

ζ = Coefficient of loss of fitting

v = Flow rate [m/s]

δ = Density of medium [kg/m^3]

(K_V= Cold Water Volume Rate circulatory [m^3/h] of water [5 °C–30 °C] at a pressure difference of 1 bar)

Note:

For the determination of pressure loss in (mbar) the result has to be divided by the factor 100 (100Pa = 1 mbar).

1bar = 10^5 Pa = 14,5 psi = 10 N/cm^2)

Coefficient of loss ζ aquatherm green pipe distribution block

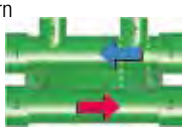
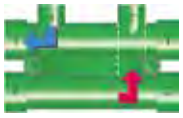
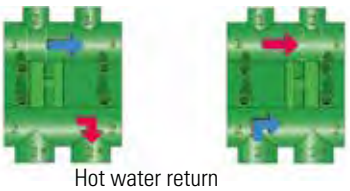
<table>
<tr><th>Picture</th><th>Comment</th><th>Picture</th><th>Comment</th><th>ζ -Value</th></tr>
<tr><td rowspan="2">Potable water installation
Cold water
Hot water
</td><td>Reduced 25 mm passage in case of separation of flow</td><td rowspan="2">Heating installation
Return

Flow</td><td>Reduced 20 mm passage in case of separation of flow</td><td>1.00</td></tr>
<tr><td>25 mm passage in case of separation of flow</td><td>20 mm passage in case of separation of flow</td><td>0.25</td></tr>
<tr><td rowspan="3">Potable water installation
Cold water
Hot water
</td><td>20 mm passage in case of separation of flow</td><td rowspan="3">Heating installation
Return

Flow</td><td>16 mm branch in case of separation of flow</td><td>0.80</td></tr>
<tr><td>20 mm branch in case of conjunction of flow</td><td>16 mm branch in case of conjunction of flow</td><td>1.60</td></tr>
<tr><td>Reduced 20 mm passage in case of separation of flow</td><td>16 mm branch in case of separationof flow</td><td>2.20</td></tr>
<tr><td colspan="3" rowspan="2">Potable water installation
Cold water
Hot water

Hot water
Cold water
Hot water return</td><td>25 mm branch in case of separation of flow</td><td>1.20</td></tr>
<tr><td>16 mm branch in case of conjunction of flow</td><td>0.80</td></tr>
</table>

TABLE OF CONTENTS

– aquatherm green pipe pipes

– aquatherm blue pipe pipes

– aquatherm lilac pipe pipes

– Fastening material

– Fittings

– Weld-in saddle

– Weld-on saddle

– Flange adapter

– Threaded connections and accessories

– Transition pieces

– Screwed connections and counter parts

– Distributors

– Valves and accessories

– Cutting tools, welding devices

– Welding machines and welding jig

– Butt welding machines & electrofusion device

– Peeling tools

– Saddle welding tools

– Drills & saddle peeling tool

– Hot tapping tool and accessoires

aquatherm green pipe

The innovative all-rounder, which revolutionized the plastic pipe sector, made a name for itself within a very short time that stands for highest quality and outstanding ecological properties. The system of aquatherm has proven its excellent technical suitability in more than 30 years of application worldwide, and among experts has long been one of the most extensive and at the same time best plastic pipe systems.

The system includes the different types of pipes SDR 6, SDR 7.4, SDR 9 and SDR 11. These are supplemented by the especially reinforced fiber composite pipe. More than 450 joining and connection elements as well as valves and ball valves complete the system. The products are available from 16 mm to 450 mm external diameter.

Pipe system made of polypropylene
for potable water supply

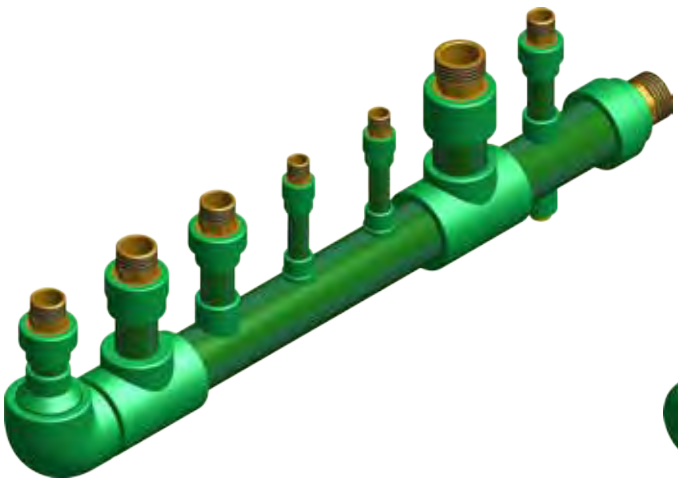
article-no.	old brand name	new brand name		Standard Dimension Ratio	structure of pipe	special feature of pipe	material
		company	system				
10208 . . . 10248	fusiotherm SDR11	aquatherm	green pipe	SDR 11	S		PP-R
10806 . . . 10818	fusiotherm SDR7.4	aquatherm	green pipe	SDR 7.4	S		PP-R
10006 . . . 10024	fusiotherm SDR6	aquatherm	green pipe	SDR 6	S		PP-R
70708 . . . 70738	fusiotherm faser composite pipe	aquatherm	green pipe	SDR 7.4	MF		PP-R
70758 . . . 70788	fusiotherm faser composite pipe UV	aquatherm	green pipe	SDR 7.4	MF	UV	PP-R
1370711 . . . 1370738	fusiotherm faser composite pipe ISO	aquatherm	green pipe	SDR 9	MF	TI	PP-R
370712 . . . 370744	aquatherm green pipe	aquatherm	green pipe	SDR 9	MF	RP	PP-RP
370762 . . . 370794	aquatherm green pipe	aquatherm	green pipe	SDR 9	MF	RP UV	PP-RP

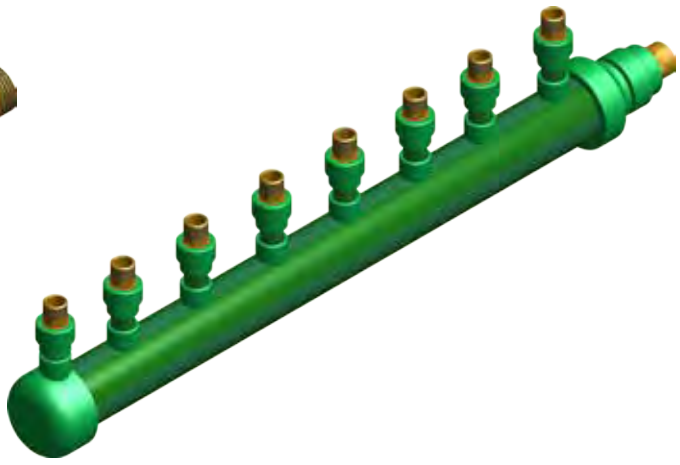
MANIFOLD CONSTRUCTION – CUSTOM MADE

We design and construct your complete manifolds in our company according to your specifications and dispatch them pre-finished to any place of the world.

You only have to send us the respective drawings and / or sketches with specifications. We return the offer including material list and drawing. A qualified team of experienced technicians likes to assist you.

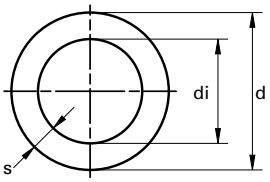
For detailed information referring “manifold construction” please contact our technical hotline: +49 (0) 2722 950-200!

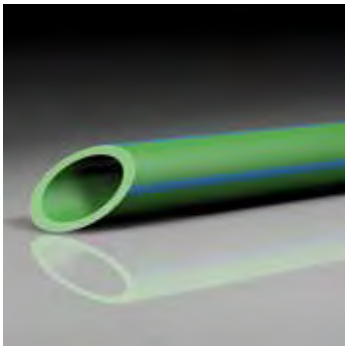




Cold Water System

aquatherm green pipe **SDR 11 S / MF**





Structure of pipe: 20 – 355 mm = s (single)
400&450 mm = MF (multilayer faser)

Material: fusiolen PP-R

Pipe series: SDR 11/S5

Standards: DIN 8077/78, DIN EN ISO 15874, ASTM F 2389, CSA B 137.11

Colour: green with 4 blue stripes

Form supplied: ø 20 – 125 mm 4 m straight lengths, also* in coils
ø 160 – 450 mm straight lengths 5,8 m

Packing Unit: PU in meter

Application:

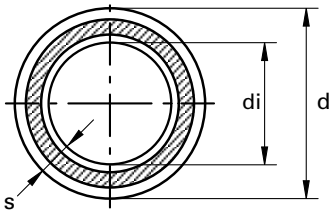
SDR	Art. no.	Dimension d [mm]	Wall thickness s [mm]	Internal diameter di [mm]	Water content [l/m]	Weight [kg]	DN	PU [m]	Price € m/pc
					Socket welding				
11	**10208**	**20**	1,9	16,2	0,206	0,108	15	100	
	10210	**25**	2,3	20,4	0,327	0,165	20	100	
	10212	**32**	2,9	26,2	0,539	0,261	25	40	
	10214	**40**	3,7	32,6	0,834	0,414	32	40	
	10216	**50**	4,6	40,8	1,307	0,641	40	20	
	10218	**63**	5,8	51,4	2,074	1,012	50	20	
	10220	**75**	6,8	61,4	2,959	1,411	65	20	
	10222	**90**	8,2	73,6	4,252	2,043	80	12	
	10224	**110**	10,0	90,0	6,359	3,026	-	8	
	10226	**125**	11,4	102,2	8,199	3,924	100	4	
	10308*	**20**	1,9	16,2	0,206	0,108	15	100	
	10310*	**25**	2,3	20,4	0,327	0,165	20	100	
	10312*	**32**	2,9	26,2	0,539	0,261	25	50	
					Butt welding				
	10230	**160**	14,6	130,8	13,430	6,415	125	5.8	
	10234	**200**	18,2	163,6	21,010	9,992	150	5.8	
	10238	**250**	22,7	204,6	32,861	15,548	200	5.8	
	10242	**315**	28,6	257,8	52,172	24,664	250	5.8	
	10244	**355**	32,2	290,6	66,325	31,300	300	5.8	
	10246[1)]	**400**	36,3	327,6	84,290	39,734	300	5.8	
	10248[1)]	**450**	40,9	368,2	106,477	50,292	400	5.8	

[1)] *mechanically stabilized through a fibre mix integrated in the middle layer of the fusiolen® PP-R*

Hot Water System

aquatherm green pipe **SDR 7.4 MF**

Structure of pipe: MF = multilayer, with fibre reinforced
Material: fusiolen PP-R
Pipe series: SDR 7.4 / S 3.2
Standards: SKZ HR 3.28, ASTM F 2389, CSA B 137.11, ISO 21003
SKZ A314/616
Colour: green with 4 dark green stripes
Packing Unit: straight legths 4 m
Packing Unit: PU in meter
Application:





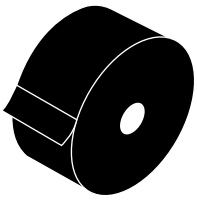
Mechanically stabilized through a fibre mix integrated in the middle layer of the fusiolen® PP-R.

SDR	Art. no.	Dimension d [mm]	Wall thickness s [mm]	Internal diameter di [mm]	Water content [l/m]	Weight [kg]	DN	PU [m]	Price € m/pc
7.4					*Socket welding*				
	70708	**20**	2,8	14,4	0,163	0,157	15	100	
	70710	**25**	3,5	18,0	0,254	0,244	20	100	
	70712	**32**	4,4	23,2	0,423	0,391	25	40	
	70714	**40**	5,5	29,0	0,660	0,608	32	40	
	70716	**50**	6,9	36,2	1,029	0,948	40	20	
	70718	**63**	8,6	45,8	1,647	1,490	50	20	
	70720	**75**	10,3	54,4	2,323	2,120	-	20	
	70722	**90**	12,3	65,4	3,358	3,037	65	12	
	70724	**110**	15,1	79,8	4,999	4,546	80	8	
	70726	**125**	17,1	90,8	6,472	5,850	-	4	
					Butt welding				
	70730	**160**	21,9	116,2	10,599	9,559	125	5.8	
	70734	**200**	27.4	145,2	16,558	14,944	150	5.8	
	70738	**250**	34,2	181,6	25,901	23,312	175	5.8	
		315 – 355		*Dimensions 315 and 355 mm see aquatherm green pipe SDR 9 MF RP on page 102*					

ADHESIVE TAPE TO PROTECT AGAINST UV-RADIATION

for aquatherm MF UV pipes

Art. no.	Dimension	PU	Price € m/pc
10871	50mm x 10m	1m/Pckg	



AQUATHERM PP-PRIMER

for aquatherm-PP pipes

Art. no.	Dimension	PU	Box unit	Price € m/pc
50230		1l		
50231		10l		



AQUATHERM SPECIAL TOP COAT

for aquatherm PP-pipes

Art. no.	Dimension	PU	Box unit	Price € m/pc
50232	black	2,5l		
50233	white	2,5l		

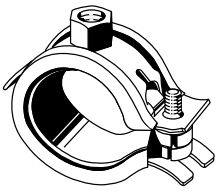


PIPE CLAMPS

suitable for sliding and fixed point installation

Thread connection: M8 & M10 for 16 – 125 mm | M10 for 160 mm | M16 for 200 – 355 mm

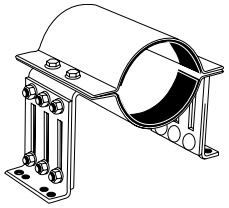
Art. no.	for pipe dimension [mm]	PU	Box unit	Price € m/pc
60516	**16**	50		
60520	**20**	50		
60525	**25**	50		
60532	**32**	50		
60540	**40**	50		
60550	**50**	50		
60563	**63**	25		
60575	**75**	25		
60590	**90**	25		
60594	**110**	25		
60595	**125**	25		
60597	**160**	25		
60650	**200**	1		
60654	**250**	1		
60658	**315**	1		
60660	**355**	1		



PIPE CLAMPS

suitable for fixed point installation

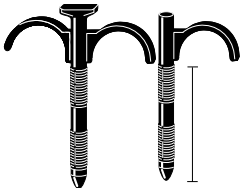
Art. no.	for pipe dimension [mm]	PU	Box unit	Price € m/pc
60768	**160**	1		
60770	**200**	1		
60774	**250**	1		
60778	**315**	1		
60780	**355**	1		
60782	**400**	1		
60784	**450**	1		
60786	**500**	1		
60788	**560**	1		
60790	**630**	1		



PIPE FASTENING BOW

suitable for ø 16-32 mm pipes

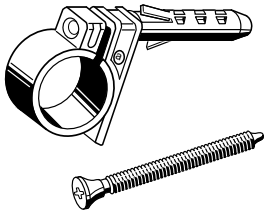
Art. no.	for pipe dimension	PU	Box unit	Price € m/pc
60604	**1-fold - length = 45mm**	50		
60606	**1-fold - length = 75mm**	50		
60608	**2-fold - length = 45mm**	50		
60610	**2-fold - length = 75 mm**	50		



PLASTIC PIPE CLAMPS

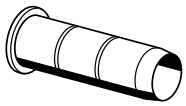
suitable for ø 16 – 40 mm pipes

Art. no.	for pipe dimension [mm]	PU	Box unit	Price € m/pc
60616	**16**	50		
60620	**20**	50		
60625	**25**	30		
60632	**32**	30		
60640	**40**	30		



PIPE SUPPORT

Art. no.	for pipe dimension	PU	Box unit	Price € m/pc
85110	ø 16x2,2mm - ø 11,4mm	10		
10186	ø 16x2,7mm - ø 10,4mm	10		



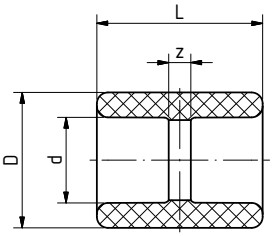
SOCKET

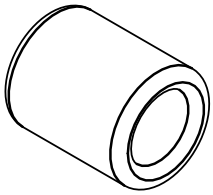
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

Material: Fusiolen® PP-R

Standard: DIN 16962, DIN EN ISO 15874

Colour: green





SDR	Art. no.	Dimension d [mm]	l	z	D	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7.4 9 11 17.6	**11006**	**16**	30,00	4,00	24,50	0,008	•	10		
	11008	**20**	32,00	3,00	29,50	0,011	• • •	10	1500	
	11010	**25**	35,00	3,00	34,00	0,013	• • •	10	1000	
	11012	**32**	40,50	4,50	43,00	0,026	• • •	5	600	
	11014	**40**	47,50	6,50	52,00	0,044	• • •	5	400	
	11016	**50**	53,00	6,00	68,00	0,084	• • •	5	200	
	11018	**63**	60,50	5,50	84,00	0,139	• • •	1	100	
	11020	**75**	66,50	6,50	100,00	0,226	• • •	1	70	
	11022	**90**	72,50	6,50	120,00	0,343	• • •	1	50	
	11024	**110**	82,00	8,00	147,00	0,581	• • •	1	30	
	11026	**125**	92,00	12,00	167,00	0,845	• • •	1	25	

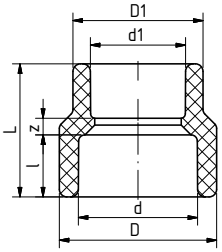
REDUCING SOCKET FEMALE/FEMALE

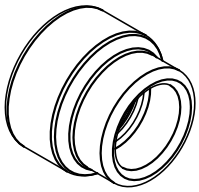
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

Material: Fusiolen® PP-R

Standard: DIN 16962, DIN EN ISO 15874

Colour: green

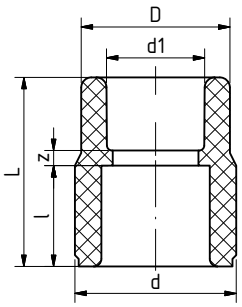


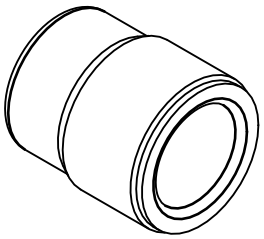


SDR	Art. no.	Dimension d [mm]	Dimension d1 [mm]	L	l	z	D	D1	Weight [kg]	System	PU	Box unit	Price € m/pc
	double-sided socket welding												
6 7.4 9 11 17.6	**11222**	**40**	**32**	44,00	20,50	5,50	52,00	43,00	0,035	• • •	1		
	11228	**50**	**32**	53,00	23,50	11,50	68,00	43,00	0,066	• • •	1		
	11230	**50**	**40**	50,50	23,50	6,25	68,00	52,00	0,069	• • •	1		
	11236	**63**	**40**	61,00	27,50	13,00	84,00	52,00	0,115	• • •	1		
	11238	**63**	**50**	56,00	27,50	5,00	84,00	68,00	0,120	• • •	1		
	11240	**75**	**50**	60,00	30,00	6,50	100,00	68,00	0,178	• • •	1		
	11242	**75**	**63**	62,50	30,00	5,00	100,00	84,00	0,185	• • •	1		
	11252	**90**	**63**	74,00	33,00	13,50	120,00	84,00	0,276	• • •	1		
	11253	**90**	**75**	69,00	33,00	6,00	120,00	100,00	0,297	• • •	1		
	11257	**110**	**75**	85,00	37,00	18,00	147,00	100,00	0,516	• • •	1		
	11259	**110**	**90**	77,25	37,00	7,25	147,00	120,00	0,520	• • •	1		
	11263	**125**	**90**	91,00	40,00	18,00	167,00	120,00	0,749	• • •	1		
	11265	**125**	**110**	87,00	40,00	10,00	167,00	147,00	0,726	• • •	1		

REDUCING SOCKET, SOCKET WELDING

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R
Standard: DIN 16962, DIN EN ISO 15874
Colour: green

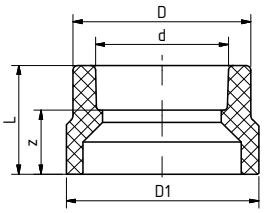


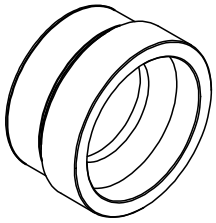


SDR	Art. no.	Dimension d [mm]	Dimension d1 [mm]	l	L	z	D	Weight [kg]	System	PU	Box unit	Price € m/pc
						double-sided socket welding						
	11109	**20**	**16**	14,50	39,00	11,50	24,50	0,009	•	10	2000	
	11110	**25**	**16**	16,00	38,00	9,00	26,00	0,012	•	10	2000	
	11112	**25**	**20**	16,00	38,50	8,00	29,50	0,012	• • •	10	1500	
	11114	**32**	**20**	18,00	37,50	5,00	29,50	0,015	• • •	5	1000	
	11116	**32**	**25**	18,00	38,00	4,00	34,00	0,016	• • •	5	1000	
	11118	**40**	**20**	20,50	45,00	10,00	29,50	0,025	• • •	5	750	
	11120	**40**	**25**	20,50	50,00	13,50	34,00	0,028	• • •	5	600	
	11122	**40**	**32**	20,50	50,00	11,50	43,00	0,032	• • •	5	500	
	11124	**50**	**20**	23,50	55,00	17,00	29,50	0,045	• • •	5	500	
	11126	**50**	**25**	23,50	55,00	15,50	34,00	0,044	• • •	5	500	
	11128	**50**	**32**	23,50	54,00	12,50	43,00	0,048	• • •	5	350	
	11130	**50**	**40**	23,50	53,00	9,00	52,00	0,053	• • •	5	300	
	11131	**63**	**20**	27,50	65,00	23,00	29,50	0,073	• • •	1	200	
	11132	**63**	**25**	27,50	65,00	21,50	34,00	0,071	• • •	1	200	
6	**11134**	**63**	**32**	27,50	62,00	16,50	43,00	0,080	• • •	1	200	
7,4	**11136**	**63**	**40**	27,50	64,50	16,50	52,00	0,089	• • •	1	200	
9	**11138**	**63**	**50**	27,50	63,50	12,50	68,00	0,107	• • •	1	150	
11	**11139**	**75**	**40**	30,00	69,50	19,00	52,00	0,131	• • •	1		
17,6	**11140**	**75**	**50**	30,00	63,00	9,50	68,00	0,141	• • •	1		
	11142	**75**	**63**	30,00	71,00	13,50	84,00	0,170	• • •	1		
	11143	**75**	**20**	30,00	65,50	21,00	34,50	0,113	• • •	1		
	11144	**75**	**25**	30,00	65,50	19,50	34,50	0,111	• • •	1		
	11145	**75**	**32**	30,00	69,50	21,50	52,00	0,140	• • •	1		
	11151	**90**	**50**	33,00	75,00	18,50	68,00	0,193	• • •	1		
	11152	**90**	**63**	33,00	78,00	17,50	84,00	0,224	• • •	1		
	11153	**90**	**75**	33,00	81,50	18,50	100,00	0,273	• • •	1		
	11155	**110**	**63**	37,00	86,00	21,50	84,00	0,356	• • •	1		
	11157	**110**	**75**	37,00	89,00	22,00	100,00	0,383	• • •	1		
	11159	**110**	**90**	37,00	99,00	29,00	120,00	0,500	• • •	1		
	11161	**125**	**75**	40,00	101,00	31,00	100,00	0,518	• • •	1		
	11163	**125**	**90**	40,00	99,00	26,00	120,00	0,588	• • •	1		
	11165	**125**	**110**	40,00	112,00	35,00	147,00	0,832	• • •	1		

REDUCING SOCKET, SOCKET & BUTT WELDING

Systems: aquatherm green pipe, aquatherm blue pipe
Material: Fusiolen® PP-R & PP-RP
Standard: DIN 16962, DIN EN ISO 15874
Colour: green

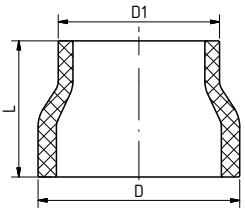


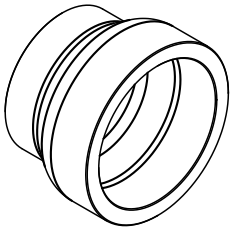


SDR	Art. no.	D1	Dimension d [mm]	L	z	D	Weight [kg]	System		PU	Box unit	Price € m/pc
					onesided socket welding, other side butt welding							
	11174	**160**	**110**	90,00	53,00	147,00	0,730	•		1		
7,4	**11176**	**160**	**125**	90,00	50,00	167,00	0,837	•		1		
	11182	**200**	**125**	135,00	95,00	167,00	1,644	•		1		
	311174	**160**	**110**	90,00	53,00	147,00	0,730	•		1		
9	**311176**	**160**	**125**	90,00	50,00	167,00	0,868	•		1		
	311182	**200**	**125**	135,00	95,00	167,00	1,599	•		1		
	11175	**160**	**110**	90,00	53,00	147,00	0,655	•	•	1		
11	**11177**	**160**	**125**	90,00	50,00	167,00	0,636	•	•	1		
	11183	**200**	**125**	135,00	95,00	167,00	1,341	•	•	1		
	2511174	**160**	**110**	90,00	53,00	147,00	0,618		•	1		
17,6	**2511176**	**160**	**125**	90,00	50,00	167,00	0,628		•	1		
	2511182	**200**	**125**	135,00	95,00	167,00	1,055		•	1		

REDUCING SOCKET, BUTT WELDING

Systems: aquatherm green pipe, aquatherm blue pipe
Material: Fusiolen® PP-R & PP-RP
Standard: DIN 16962, DIN EN ISO 15874
Colour: green

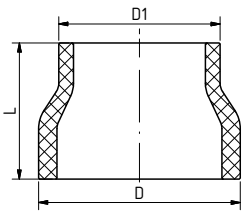


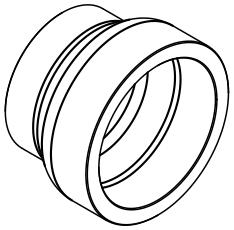


SDR	Art. no.	D	D1	L	Weight [kg]	System		PU	Box unit	Price € m/pc
				double-sided butt welding						
	11184	**200**	**160**	135,00	1,638	•		1		
7,4	**11188**	**250**	**160**	172,50	2,881	•		1		
	11190	**250**	**145,20**	172,50	3,250	•		1		
	311184	**200**	**160**	135,00	1,588	•		1		
	311188	**250**	**160**	172,50	2,900	•		1		
	311190	**250**	**200**	172,50	3,206	•		1		
9	**311192**	**315**	**200**	225,00	6,350	•		1		
	311194	**315**	**250**	225,00	7,050	•		1		
	311196	**355**	**250**	170,00	5,640	•		1		
	311198	**355**	**315**	160,00	4,940	•		1		
	11185	**200**	**160**	135,00	1,206	•	•	1		
	11189	**250**	**160**	172,50	2,313	•	•	1		
	11191	**250**	**200**	172,50	2,389	•	•	1		
	11193	**315**	**200**	225,00	4,389	•	•	1		
	11195	**315**	**250**	225,00	4,786	•	•	1		
	11197	**355**	**250**	170,00	4,431	•	•	1		
11	**11199**	**355**	**315**	160,00	4,532	•	•	1		
	11201	**400**	**250**	152,00	7,475	•	•	1		
	11203	**400**	**315**	122,00	6,095	•	•	1		
	11204	**400**	**355**	110,00	5,520	•	•	1		
	11206	**450**	**315**	142,00	9,200	•	•	1		
	11207	**450**	**355**	132,00	7,590	•	•	1		
	11208	**450**	**400**	122,00	7,590	•	•	1		

REDUCING SOCKET, BUTT WELDING

Systems: aquatherm blue pipe
Material: Fusiolen® PP-R
Standard: DIN 16962, DIN EN ISO 15874
Colour: green

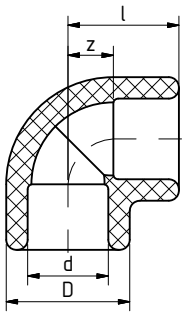


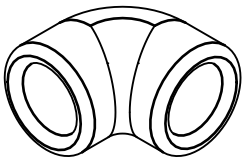


SDR	Art.- No.	D	D1	L	Weight [kg]	System	PU	Box unit	Price € m/pc
				double-sided butt welding					
17,6	**2511184**	**200**	**160**	135,00	1,012	•	1		
	2511188	**250**	**160**	172,50	1,500	•	1		
	2511190	**250**	**200**	172,50	1,338	•	1		
	2511193	**315**	**200**	225,00	4,141	•	1		
	2511195	**315**	**250**	225,00	3,420	•	1		
	2511197	**355**	**250**	245,00	3,099	•	1		
	2511199	**355**	**315**	160,00	3,108	•	1		
	2511201	**400**	**250**	152,00	4,482	•	1		
	2511203	**400**	**315**	122,00	3,366	•	1		
	2511204	**400**	**355**	112,00	3,049	•	1		
	2511206	**450**	**315**	142,00	4,891	•	1		
	2511207	**450**	**355**	132,00	4,688	•	1		
	2511208	**450**	**400**	122,00	4,287	•	1		
	2511209	**500**	**315**	172,00	8,100	•	1		
	2511210	**500**	**355**	152,00	6,500	•	1		
	2511211	**500**	**400**	142,00	6,700	•	1		
	2511212	**500**	**450**	122,00	5,500	•	1		
	2511213	**560**	**400**	162,00	9,000	•	1		
	2511214	**560**	**450**	142,00	8,600	•	1		
	2511215	**560**	**500**	132,00	7,600	•	1		
	2511216	**630**	**400**	192,00	15,100	•	1		
	2511217	**630**	**450**	172,00	13,700	•	1		
	2511218	**630**	**500**	152,00	11,000	•	1		
	2511219	**630**	**560**	132,00	9,000	•	1		

ELBOW 90°

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R
Standard: DIN 16962, DIN EN ISO 15874
Colour: green





SDR	Art.- No.	Dimension d [mm]	z	l	D	Weight [kg]	System	PU	Box unit	Price € m/pc
					socket welding					
6 7,4 9 11 17,6	**12106**	**16**	9,00	22,00	24,50	0,010	•	10	2000	
	12108	**20**	11,00	25,50	27,00	0,013	• • •	10	1200	
	12110	**25**	13,50	29,50	34,00	0,023	• • •	10	800	
	12112	**32**	17,00	35,00	43,00	0,043	• • •	5	400	
	12114	**40**	21,00	41,50	52,00	0,077	• • •	5	250	
	12116	**50**	26,00	49,50	68,00	0,162	• • •	5	125	
	12118	**63**	32,50	60,00	84,00	0,293	• • •	1	75	
	12120	**75**	38,50	68,50	100,00	0,445	• • •	1	40	
	12122	**90**	46,00	79,00	120,00	0,729	• • •	1	25	
	12124	**110**	56,00	93,00	147,00	1,292	• • •	1		
	12126	**125**	76,50	116,50	167,00	2,004	• • •	1		

ELBOW 90° BUTT WELDING

Systems: aquatherm green pipe, aquatherm blue pipe

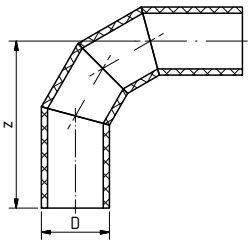
Material: Fusiolen® PP-R & PP-RP

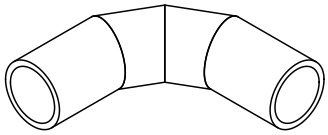
Standard: DIN 16962, DIN EN ISO 15874

Notice There is a gradual conversion of the XXL-fittings made of pipe segments to an injection molded design. The table shows which articles are already available in new design at the time of printing this catalogue. In the aquatherm technews we will inform you of further changes, but first the current stock of the elbows made of pipe segments has to be sold.

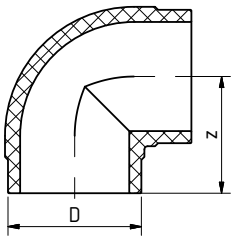
All fittings, which are converted to the injection molding production, are still available on inquiry as special fittings made of pipe segments. No article-numbers are defined for special fittings of any type.

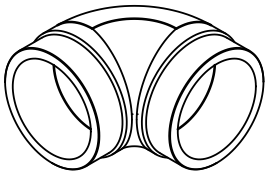
Please note! Electrofusion sockets can not be processed directly with injection molded fittings. When using electrofusion sockets either segment welded special fittings must be used or pipe pieces must be welded to the injection molded fittings.





Fitting made of pipe segments





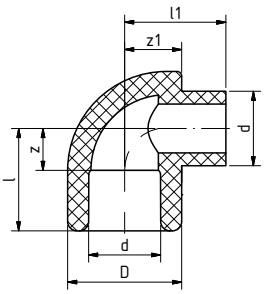
Injection molded fitting
Colour: green

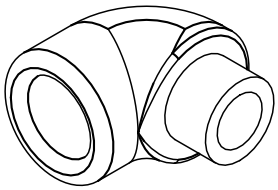
SDR	Art. no.	D	z	Weight [kg]	System		pipe segments	NEW injection molded* (green)	PU	Box unit	Price € m/pc
					butt welding						
	12130	**160**	145,00	2,561	•			•	1		
7,4	**12134**	**200**	450,00	11,685	•		•		1		
	12138	**250**	625,00	26,000	•		•		1		
	312130	**160**	145,00	2,371	•			•	1		
	312134	**200**	175,00	4,311	•			•	1		
9	**312138**	**250**	220,00	8,400	•			•	1		
	312142	**315**	773,00	42,300	•		•		1		
	312144	**355**	833,00	57,628	•		•		1		
	12131	**160**	145,00	2,145	•	•		•	1		
	12135	**200**	175,00	4,056	•	•		•	1		
	12139	**250**	220,00	7,325	•	•		•	1		
11	**12143**	**315**	773,00	37,850	•		•		1		
	12145	**355**	833,00	49,000	•		•		1		
	12147	**400**	900,00	62,800	•		•		1		
	12149	**450**	975,00	89,500	•		•		1		
[1] mechanically stabilized through a fibre mix integrated in the middle layer of the fusiolen® PP-R											
	2012143	**315**	773,00	37,300		•	•		1		
	2012145	**355**	833,00	57,074		•	•		1		
11	**2012147**	**400**	900,00	74,500		•	•		1		
	2012149	**450**	975,00	89,080		•	•		1		
	2512130	**160**	145,00	1,642		•		•	1		
	2512134	**200**	175,00	3,244		•		•	1		
	2512138	**250**	220,00	5,500		•		•	1		
	2512142	**315**	773,00	24,000		•	•		1		
	2512144	**355**	833,00	32,000		•	•		1		
17,6	**2512146**	**400**	900,00	42,549		•	•		1		
	2512148	**450**	975,00	62,200		•	•		1		
	2512150	**500**	1100,00	91,000		•	•		1		
	2512152	**560**	1190,00	108,779		•	•		1		
	2512154	**630**	1295,00	164,600		•	•		1		

* status quo at the time of printing, further injection molded parts follow

ELBOW 90° FEMALE/MALE

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R
Standard: DIN 16962, DIN EN ISO 15874
Colour: green

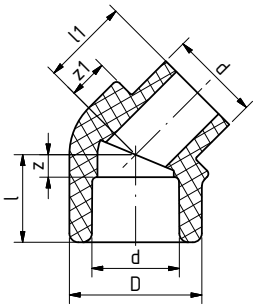


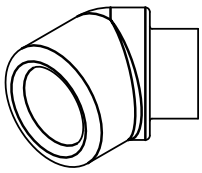


SDR	Art. no.	Dimension d [mm]	z	l	D	l1	z1	Weight [kg]	System	PU	Box unit	Price € m/pc
						socket welding						
6 7.4 9 11	**12306**	**16**	9,00	22,00	24,50	21,75	12,25	0,010	•	10	2000	
	12308	**20**	11,00	25,50	29,50	25,50	14,75	0,017	• • •	10	1200	
	12310	**25**	13,50	29,50	34,00	29,50	17,00	0,023	• • •	10	800	
	12312	**32**	17,00	35,00	43,00	39,00	21,50	0,048	• • •	5	400	
	12314	**40**	21,00	41,50	52,00	45,50	26,00	0,080	• • •	5	300	

ELBOW 45° FEMALE/MALE

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R
Standard: DIN 16962, DIN EN ISO 15874
Colour: green

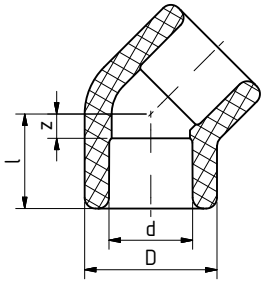


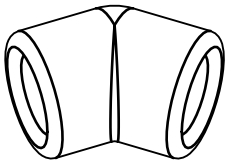


SDR	Art. no.	Dimension d [mm]	z	l	D	l1	z1	Weight [kg]	System	PU	Box unit	Price € m/pc
						socket welding						
6 7.4 9 11	**12708**	**20**	5,00	19,50	29,50	19,50	9,00	0,013	• • •	10	1500	
	12710	**25**	6,00	22,00	34,00	22,00	8,50	0,017	• • •	10	1000	
	12712	**32**	7,50	25,50	43,00	28,50	11,50	0,036	• • •	5	500	
	12714	**40**	9,50	30,00	52,00	30,50	13,50	0,057	• • •	5	300	

ELBOW 45° SOCKET WELDING

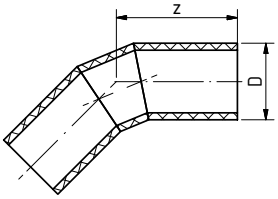
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R
Standard: DIN 16962, DIN EN ISO 15874
Colour: green

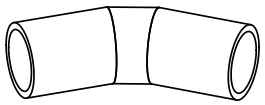




SDR	Art. no.	Dimension d [mm]	z	l	D	Weight [kg]	System	PU	Box unit	Price € m/pc
					socket welding					
6 7.4 9 11 17.6	**12506**	**16**	4,50	17,50	24,50	0,009	•	10	2000	
	12508	**20**	5,00	19,50	29,50	0,014	• • •	10	1500	
	12510	**25**	6,00	22,00	34,00	0,018	• • •	10	1000	
	12512	**32**	7,50	25,50	43,00	0,035	• • •	5	500	
	12514	**40**	9,50	30,00	52,00	0,053	• • •	5	300	
	12516	**50**	11,50	35,00	68,00	0,112	• • •	5	150	
	12518	**63**	14,00	41,50	84,00	0,227	• • •	1	75	
	12520	**75**	16,50	46,50	100,00	0,350	• • •	1	60	
	12522	**90**	19,50	52,50	120,00	0,568	• • •	1	30	
	12524	**110**	23,50	60,50	147,00	1,025	• • •	1	20	
	12526	**125**	27,00	67,00	167,00	1,329	• • •	1		

ELBOW 45° BUTT WELDING



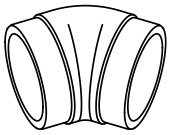


Fitting made of pipe segments

Systems: aquatherm green pipe, aquatherm blue pipe
Material: Fusiolen® PP-R & PP-RP
Standard: DIN 16962, DIN EN ISO 15874

Notice

There is a gradual conversion of the XXL-fittings made of pipe segments to an injection molded design. The table shows which articles are already available in new design at the time of printing this catalogue. In the aquatherm technews we will inform you of further changes, but first the current stock of the elbows made of pipe segments has to be sold. All fittings, which are converted to the injection molding production, are still available on inquiry as special fittings made of pipe segments. No article-numbers are defined for special fittings of any type.
Please note! Electrofusion sockets can not be processed directly with injection molded fittings. When using electrofusion sockets either segment welded special fittings must be used or pipe pieces must be welded to the injection molded fittings.

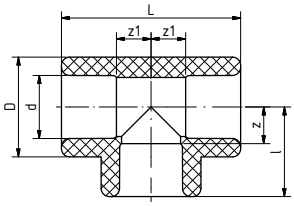


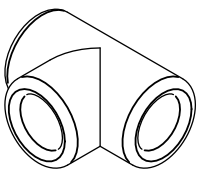
Injection molded fitting
Colour: green

SDR	Art.- No.	D	z	Weight [kg]	System		pipe segments	injection molded*	PU	Box unit	Price € m/pc
				butt welding							
7,4	**12530**	**160**	95,00	1,903	•			•	1		
	12534	**200**	274,00	8,175	•		•		1		
	12538	**250**	412,00	20,500	•		•		1		
9	**312530**	**160**	95,00	4,230	•			•	1		
	312534	**200**	274,00	6,745	•		•		1		
	312538	**250**	412,00	15,928	•		•		1		
	312542	**315**	498,00	30,567	•		•		1		
	312544	**355**	520,00	40,771	•		•		1		
11	**12531**	**160**	95,00	1,393	•	•		•	1		
	12535	**200**	274,00	5,735	•		•		1		
	12539	**250**	412,00	13,000	•		•		1		
	12543	**315**	498,00	27,300	•		•		1		
	12545	**355**	520,00	26,650	•		•		1		
	12547[1)]	**400**	548,00	44,900	•		•		1		
	12549[1)]	**450**	580,00	60,500	•		•		1		
[1)] mechanically stabilized through a fibre mix integrated in the middle layer of the fusiolen® PP-R											
11	**2012535**	**200**	274,00	6,285		•	•		1		
	2012539	**250**	412,00	14,181		•	•		1		
	2012543	**315**	498,00	27,100		•	•		1		
	2012545	**355**	520,00	38,158		•	•		1		
	2012547	**400**	548,00	44,712		•	•		1		
	2012549	**450**	580,00	60,260		•	•		1		
17,6	**2512530**	**160**	95,00	1,080		•		•	1		
	2512534	**200**	274,00	3,672		•	•		1		
	2512538	**250**	412,00	9,400		•	•		1		
	2512542	**315**	498,00	18,000		•	•		1		
	2512544	**355**	520,00	22,058		•	•		1		
	2512546	**400**	548,00	30,800		•	•		1		
	2512548	**450**	580,00	39,123		•	•		1		
	2512550	**500**	665,00	55,112		•	•		1		
	2512552	**560**	698,00	72,519		•	•		1		
	2512554	**630**	741,00	97,148		•	•		1		

* status quo at the time of printing, further injection molded parts follow

T-PIECE SOCKET WELDING





Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R
Standard: DIN 16962, DIN EN ISO 15874
Colour: green
Form: injection moulded fittings

SDR	Art.- No.	Dimension d [mm]	z	z1	l	L	D	Weight [kg]	System			PU	Box unit	Price € m/pc
						socket welding								
	13106	**16**	9,00	9,00	22,00	44,00	24,50	0,015	•			10	1500	
	13108	**20**	11,00	11,00	25,50	51,00	27,00	0,022	•	•	•	10	800	
	13110	**25**	14,50	15,00	30,50	62,00	34,00	0,033	•	•	•	10	500	
6	**13112**	**32**	15,50	17,00	33,50	70,00	43,00	0,054	•	•	•	5	300	
7,4	**13114**	**40**	20,00	20,00	40,50	81,00	52,00	0,099	•	•	•	5	200	
9	**13116**	**50**	26,00	26,00	49,50	99,00	68,00	0,177	•	•	•	5	100	
11	**13118**	**63**	32,50	32,50	60,00	120,00	84,00	0,368	•	•	•	1	50	
17,6	**13120**	**75**	38,50	38,50	68,50	137,00	100,00	0,541	•	•	•	1	30	
	13122	**90**	47,00	46,00	80,00	158,00	120,00	0,920	•	•	•	1	25	
	13124	**110**	56,00	56,00	93,00	186,00	147,00	1,598	•	•	•	1	14	
	13126	**125**	76,50	76,50	116,50	233,00	167,00	2,673	•	•	•	1		

T-PIECE BUTT WELDING

Systems: aquatherm green pipe, aquatherm blue pipe

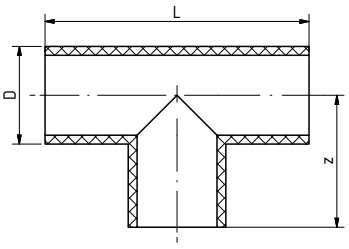
Material: Fusiolen® PP-R & PP-RP

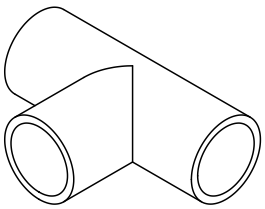
Standard: DIN 16962, DIN EN ISO 15874

Notice There is a gradual conversion of the XXL-fittings made of pipe segments to an injection molded design. The table shows which articles are already available in new design at the time of printing this catalogue. In the aquatherm technews we will inform you of further changes, but first the current stock of the t-pieces made of pipe segments has to be sold.

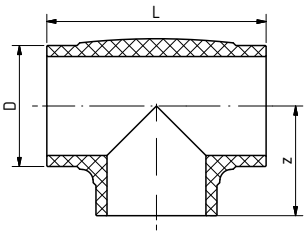
All fittings, which are converted to the injection molding production, are still available on inquiry as special fittings made of pipe segments. No article-numbers are defined for special fittings of any type.

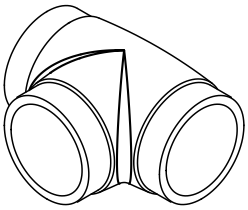
Please note! Electrofusion sockets can not be processed directly with injection molded fittings. When using electrofusion sockets either segment welded special fittings must be used or pipe pieces must be welded to the injection molded fittings.





Fitting made of pipe segments





Injection molded fitting
Colour: green

SDR	Art.- No.	D	L	z	Weight [kg]	System		pipe segments	NEW injection molded* (green)	PU	Box unit	Price € m/pc
					butt welding							
7,4	**13130**	**160**	290,00	145,00	3,600	•			•	1		
	13134	**200**	500,00	250,00	9,825	•		•		1		
	13138	**250**	750,00	375,00	24,000	•		•		1		
9	**313130**	**160**	290,00	145,00	3,290	•			•	1		
	313134	**200**	500,00	250,00	9,367	•		•		1		
	313138	**250**	750,00	375,00	21,949	•		•		1		
	313142	**315**	920,00	460,00	42,609	•		•		1		
	313144	**355**	960,00	480,00	56,452	•		•		1		
11	**13131**	**160**	290,00	145,00	3,005	•	•		•	1		
	13135	**200**	500,00	250,00	6,865	•		•		1		
	13139	**250**	750,00	375,00	16,000	•		•		1		
	13143	**315**	920,00	460,00	20,450	•		•		1		
	13145	**355**	960,00	480,00	45,072	•		•		1		
	13147[1)]	**400**	1000,00	500,00	63,100	•		•		1		
	13149[1)]	**450**	1050,00	525,00	83,300	•		•		1		

[1)] *mechanically stabilized through a fibre mix integrated in the middle layer of the fusiolen® PP-R*

11	**2013135**	**200**	500,00	250,00	8,171		•	•		1		
	2013139	**250**	750,00	375,00	18,827		•	•		1		
	2013143	**315**	920,00	460,00	36,674		•	•		1		
	2013145	**355**	960,00	480,00	40,000		•	•		1		
	2013147	**400**	1000,00	500,00	62,100		•	•		1		
	2013149	**450**	1050,00	525,00	82,792		•	•		1		
17,6	**2513130**	**160**	290,00	145,00	2,348		•		•	1		
	2513134	**200**	500,00	250,00	4,660		•	•		1		
	2513138	**250**	750,00	375,00	11,500		•	•		1		
	2513142	**315**	920,00	460,00	19,800		•	•		1		
	2513144	**355**	960,00	480,00	27,500		•	•		1		
	2513146	**400**	1000,00	500,00	40,395		•	•		1		
	2513148	**450**	1050,00	525,00	45,400		•	•		1		
	2513150	**500**	1200,00	600,00	75,726		•	•		1		
	2513152	**560**	1260,00	630,00	99,320		•	•		1		
	2513154	**630**	1330,00	665,00	122,500		•	•		1		

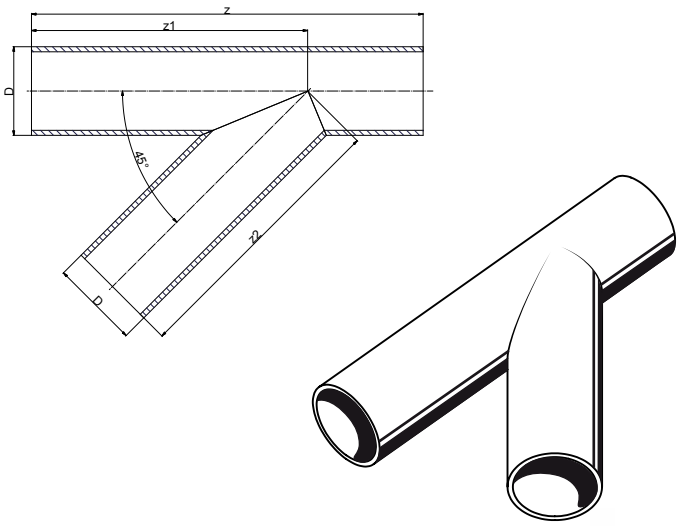
* status quo at the time of printing, further injection molded parts follow

aquatherm blue pipe Y-PIECES

Special fittings on demand

ATTENTION – PLEASE NOTE!

These branches are for special applications in the **unpressurized** areas, e.g. in vacuum dewatering in the ship building. **In no case** they may be exposed to the pressures, given in the operating pressure tables on page 23-25.



Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

Material: Fusiolen® PP-R

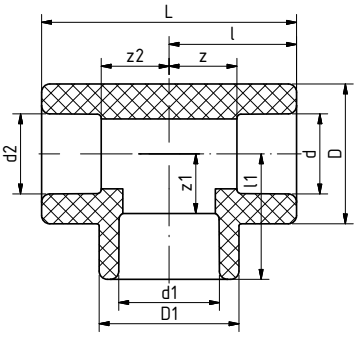
Standard: DIN16962-2

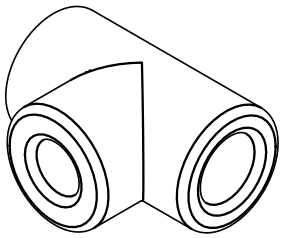
Color: blue/green

SDR	Art. no.	Dimension D [mm]	z	z1	z2	Weight [kg]	System	PU	Box unit	Price € m/pc
					Socket welding					
	2013018	**63**	560,00	380,00	380,00	0,001	• • •	1		
	2013020	**75**	570,00	405,00	405,00	1,210	• • •	1		
	2013022	**90**	577,00	412,00	412,00	1,750	• • •	1		
	2013024	**110**	610,00	435,00	435,00	2,730	• • •	1		
11	**2013026**	**125**	665,00	475,00	475,00	3,840	• • •	1		
					Butt welding					
	2013031	**160**	782,00	551,00	551,00	7,300	• •	1		
	2013035	**200**	925,00	650,00	650,00	13,360	• •	1		
	2013039	**250**	1105,00	780,00	780,00	24,780	• •	1		
					Socket welding					
	2513026	**125**	665,00	475,00	475,00	2,470	• •	1		
					Butt welding					
17.6	**2513030**	**160**	782,00	551,00	551,00	4,700	• •	1		
	2513034	**200**	925,00	650,00	650,00	8,640	• •	1		
	2513038	**250**	1105,00	780,00	780,00	16,010	• •	1		

RED.- T-PIECE, SOCKET WELDING

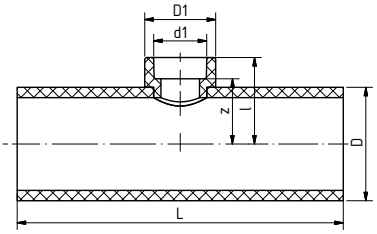
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R
Standard: DIN 16962, DIN EN ISO 15874
Colour: green
Form: injection moulded fittings

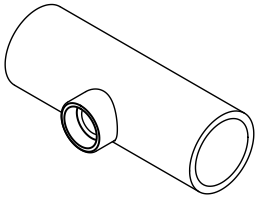




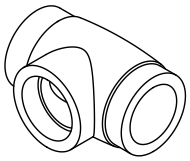
SDR	Art.- No.	d	d1	d2	L	l	l1	z	z1	z2	D	D1	Weight [kg]	System			PU	Box unit	Price € m/pc
									socket welding										
	13506	**20**	**16**	**16**	51,00	25,50	25,25	11,00	12,25	12,50	29,50	29,50	0,025	•			10		
	13508	**20**	**16**	**20**	51,00	25,50	25,25	11,00	12,25	11,00	29,50	29,50	0,024	•			10		
	13510	**20**	**20**	**16**	51,00	25,50	25,25	11,00	10,75	12,50	29,50	29,50	0,023	•			10		
	13511	**20**	**25**	**20**	62,00	31,00	30,50	16,50	14,50	16,50	34,00	34,00	0,040	•	•	•	10		
	13512	**25**	**16**	**16**	62,00	31,00	30,50	15,00	17,50	18,00	34,00	34,00	0,043	•			10		
	13514	**25**	**16**	**20**	62,00	31,00	30,50	15,00	17,50	16,50	34,00	34,00	0,041	•			10		
	13516	**25**	**16**	**25**	62,00	31,00	30,50	15,00	17,50	15,00	34,00	34,00	0,038	•			10		
	13520	**25**	**20**	**20**	62,00	31,00	30,50	15,00	16,00	16,50	34,00	34,00	0,039	•	•	•	10	500	
	13522	**25**	**20**	**25**	62,00	31,00	30,50	15,00	16,00	15,00	34,00	34,00	0,036	•	•	•	10	500	
	13528	**32**	**16**	**32**	70,00	35,00	31,00	17,00	18,00	17,00	43,00	29,50	0,053	•	•	•	5	300	
	13532	**32**	**20**	**20**	73,50	36,75	37,00	18,75	22,50	22,25	43,00	43,00	0,076	•	•	•	5	300	
	13534	**32**	**20**	**32**	70,00	35,00	31,00	17,00	16,50	17,00	43,00	29,50	0,053	•	•	•	5	300	
	13538	**32**	**25**	**25**	70,00	35,00	34,50	17,00	18,50	19,00	43,00	43,00	0,069	•	•	•	5		
	13540	**32**	**25**	**32**	70,00	35,00	32,00	17,00	16,00	17,00	43,00	34,00	0,050	•	•	•	5	300	
	13542	**40**	**20**	**40**	83,00	41,50	36,00	21,00	21,50	21,00	52,00	34,00	0,091	•	•	•	5	200	
	13544	**40**	**25**	**40**	83,00	41,50	36,00	21,00	20,00	21,00	52,00	34,00	0,089	•	•	•	5	200	
	13546	**40**	**32**	**40**	84,00	42,00	40,50	21,50	22,50	21,50	52,00	52,00	0,092	•	•	•	5	200	
	13547	**50**	**20**	**50**	99,00	49,50	40,50	26,00	26,00	26,00	68,00	29,50	0,162	•	•	•	5	100	
	13548	**50**	**25**	**50**	99,00	49,50	44,50	26,00	28,50	26,00	68,00	43,00	0,157	•	•	•	5	100	
	13550	**50**	**32**	**50**	99,00	49,50	44,50	26,00	26,50	26,00	68,00	43,00	0,160	•	•	•	5	100	
6	**13551**	**50**	**40**	**50**	99,00	49,50	49,50	26,00	29,00	26,00	68,00	68,00	0,161	•	•	•	5	100	
7,4	**13552**	**63**	**20**	**63**	120,00	60,00	48,50	32,50	34,00	32,50	84,00	34,00	0,335	•	•	•	1	50	
9	**13554**	**63**	**25**	**63**	120,00	60,00	48,50	32,50	32,50	32,50	84,00	34,00	0,331	•	•	•	1	50	
11	**13556**	**63**	**32**	**63**	120,00	60,00	53,50	32,50	35,50	32,50	84,00	52,00	0,340	•	•	•	1	50	
17,6	**13558**	**63**	**40**	**63**	120,00	60,00	53,50	32,50	33,00	32,50	84,00	52,00	0,332	•	•	•	1	50	
	13560	**63**	**50**	**63**	120,00	60,00	60,00	32,50	36,50	32,50	84,00	68,00	0,398	•	•	•	1		
	13561	**75**	**20**	**75**	137,00	68,50	54,50	38,50	40,00	38,50	100,00	34,00	0,501	•	•	•	1		
	13562	**75**	**25**	**75**	137,00	68,50	54,50	38,50	38,50	38,50	100,00	34,00	0,497	•	•	•	1		
	13564	**75**	**32**	**75**	137,00	68,50	59,00	38,50	41,00	38,50	100,00	52,00	0,505	•	•	•	1		
	13566	**75**	**40**	**75**	137,00	68,50	59,00	38,50	38,50	38,50	100,00	52,00	0,497	•	•	•	1		
	13568	**75**	**50**	**75**	137,00	68,50	66,00	38,50	42,50	38,50	100,00	84,00	0,550	•	•	•	1		
	13570	**75**	**63**	**75**	137,00	68,50	66,00	38,50	38,50	38,50	100,00	84,00	0,515	•	•	•	1		
	13576	**90**	**32**	**90**	158,00	79,00	65,00	46,00	47,00	46,00	120,00	52,00	0,880	•	•	•	1		
	13578	**90**	**40**	**90**	158,00	79,00	65,00	46,00	44,50	46,00	120,00	52,00	0,862	•	•	•	1		
	13580	**90**	**50**	**90**	158,00	79,00	75,00	46,00	51,50	46,00	120,00	84,00	0,905	•	•	•	1		
	13582	**90**	**63**	**90**	158,00	79,00	75,00	46,00	47,50	46,00	120,00	84,00	0,876	•	•	•	1		
	13584	**90**	**75**	**90**	158,00	79,00	81,00	46,00	51,00	46,00	120,00	120,00	0,991	•	•	•	1		
	13586	**110**	**63**	**110**	186,00	93,00	87,50	56,00	60,00	56,00	147,00	100,00	1,562	•	•	•	1		
	13588	**110**	**75**	**110**	186,00	93,00	87,50	56,00	57,50	56,00	147,00	100,00	1,511	•	•	•	1		
	13590	**110**	**90**	**110**	186,00	93,00	89,00	56,00	56,00	56,00	147,00	120,00	1,548	•	•	•	1		
	13592	**125**	**75**	**125**	233,00	116,50	106,50	76,50	76,50	76,50	167,00	100,00	2,427	•	•	•	1		
	13594	**125**	**90**	**125**	233,00	116,50	109,50	76,50	76,50	76,50	167,00	120,00	2,509	•	•	•	1		
	13596	**125**	**110**	**125**	233,00	116,50	113,50	76,50	76,50	76,50	167,00	147,00	2,563	•	•	•	1		

RED.- T-PIECE, SOCKET- & BUTT WELDING





Fitting made of pipe segments



Injection molded fitting

Systems: aquatherm green pipe, aquatherm blue pipe
Standard: DIN 16962, DIN EN ISO 15874
Colour: green
Form: *see table*

Note: There is a gradual conversion of the XXL-fittings made of pipe segments to an injection molded design. The table shows which articles are already available in new design at the time of printing this catalogue. In the aquatherm technews we will inform you of further changes, but first the current stock of the red.-t-pieces made of pipe segments has to be sold.

All fittings, which are converted to the injection molding production, are still available on inquiry as special fittings made of pipe segments. No article-numbers are defined for special fittings of any type.

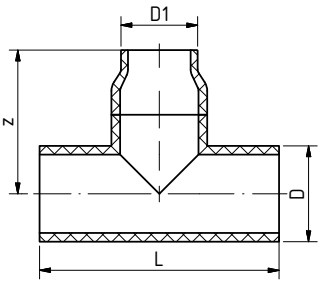
Please note! Electrofusion sockets can not be processed directly with injection molded fittings. When using electrofusion sockets either segment welded special fittings must be used or pipe pieces must be welded to the injection molded fittings.

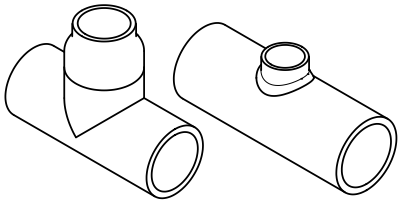
SDR	Art.- No.	D	d1	D1	L	l	z	Weight [kg]	System		pipe segments	injection molded*	PU	Box unit	Price € m/pc
							branch: socket welding								
	13600	**160**	**75**	100,00	460,00	122,00	92,00	4,414	•		•		1		
	13602	**160**	**90**	120,00	460,00	125,00	92,00	4,515	•		•		1		
NEW	**13606**	**160**	**125**	167,00	290,00	120,00	80,00	3,441	•			•	1		
	13608	**200**	**75**	100,00	500,00	142,00	112,00	7,110	•		•		1		
	13610	**200**	**90**	120,00	500,00	145,00	112,00	7,540	•		•		1		
7,4	**13612**	**200**	**110**	147,00	500,00	149,00	112,00	7,325	•		•		1		
	13614	**200**	**125**	167,00	500,00	155,00	115,00	7,645	•		•		1		
	13624	**250**	**75**	100,00	750,00	167,00	137,00	16,600	•		•		1		
	13626	**250**	**90**	120,00	750,00	170,00	137,00	16,800	•		•		1		
	13628	**250**	**110**	147,00	750,00	174,00	137,00	16,800	•		•		1		
	13630	**250**	**125**	167,00	750,00	180,00	140,00	17,000	•		•		1		
	313600	**160**	**75**	100,00	460,00	122,00	92,00	3,903	•		•		1		
	313602	**160**	**90**	120,00	460,00	125,00	92,00	4,039	•		•		1		
	313608	**200**	**75**	100,00	500,00	142,00	112,00	6,476	•		•		1		
	313610	**200**	**90**	120,00	500,00	145,00	112,00	6,581	•		•		1		
	313612	**200**	**110**	147,00	500,00	149,00	112,00	6,863	•		•		1		
	313614	**200**	**125**	167,00	500,00	155,00	115,00	7,114	•		•		1		
9	**313624**	**250**	**75**	100,00	750,00	167,00	137,00	14,802	•		•		1		
	313626	**250**	**90**	120,00	750,00	170,00	137,00	14,932	•		•		1		
	313628	**250**	**110**	147,00	750,00	174,00	137,00	15,178	•		•		1		
	313630	**250**	**125**	167,00	750,00	180,00	140,00	15,398	•		•		1		
	313904	**315**	**125**	167,00	920,00	212,50	172,50	29,196	•		•		1		
	313916	**355**	**125**	167,00	960,00	232,50	192,50	38,466	•		•		1		
	13601	**160**	**75**	100,00	460,00	122,00	92,00	3,140	•	•	•		1		
	13603	**160**	**90**	120,00	460,00	125,00	92,00	3,176	•	•	•		1		
NEW	**13607**	**160**	**125**	167,00	290,00	120,00	80,00	2,842	•	•		•	1		
	13609	**200**	**75**	100,00	500,00	142,00	112,00	5,284	•		•		1		
	13611	**200**	**90**	120,00	500,00	145,00	112,00	5,168	•		•		1		
	13613	**200**	**110**	147,00	500,00	149,00	112,00	5,648	•		•		1		
	13615	**200**	**125**	167,00	500,00	155,00	115,00	5,786	•		•		1		
11	**13625**	**250**	**75**	100,00	750,00	167,00	137,00	12,000	•		•		1		
	13627	**250**	**90**	120,00	750,00	170,00	137,00	12,000	•		•		1		
	13629	**250**	**110**	147,00	750,00	174,00	137,00	13,000	•		•		1		
	13631	**250**	**125**	167,00	750,00	180,00	140,00	12,000	•		•		1		
	13651	**315**	**125**	167,00	920,00	213,00	173,00	25,150	•		•		1		
	13663	**355**	**125**	167,00	960,00	233,00	193,00	30,851	•		•		1		
	13676	**400**	**125**	167,00	1000,00	255,00	215,00	42,169	•		•		1		
	13690	**450**	**125**	167,00	1050,00	280,00	240,00	55,794	•		•		1		

* status quo at the time of printing, further injection molded parts follow

RED.- T-PIECE, BUTT WELDING

Systems: aquatherm green pipe
Standard: DIN 16962, DIN EN ISO 15874
Branch: butt welding
Form: *see table*

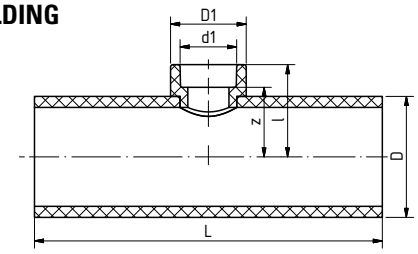


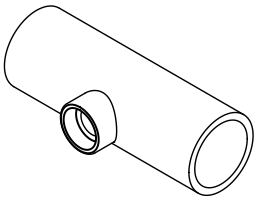


SDR	Art.- No.	D	D1	L	z	Weight [kg]	System	Pipe with reducer	Pipe with weld-in saddle	PU	Box unit	Price € m/pc
						branch: butt welding						
	13618	**200**	**160**	500,00	300,00	10,891	•	•		1		
7,4	**13634**	**250**	**160**	750,00	375,00	28,000	•	•		1		
	13640	**250**	**200**	750,00	375,00	27,000	•	•		1		
	313618	**200**	**160**	500,00	300,00	9,332	•	•		1		
	313634	**250**	**160**	750,00	375,00	21,547	•	•		1		
	313640	**250**	**200**	750,00	376,00	21,853	•	•		1		
	313906	**315**	**160**	920,00	238,00	29,237	•		•	1		
	313908	**315**	**200**	920,00	460,00	42,166	•	•		1		
9	**313910**	**315**	**250**	920,00	460,00	42,557	•	•		1		
	313918	**355**	**160**	960,00	258,00	38,479	•		•	1		
	313920	**355**	**200**	960,00	268,00	39,237	•		•	1		
	313922	**355**	**250**	960,00	480,00	52,683	•	•		1		
	313924	**355**	**315**	960,00	480,00	55,511	•	•		1		
	13619	**200**	**160**	500,00	300,00	7,445	•	•		1		
	13635	**250**	**160**	750,00	375,00	19,500	•	•		1		
	13641	**250**	**200**	750,00	375,00	18,500	•	•		1		
	13653	**315**	**160**	920,00	237,50	24,850	•		•	1		
	13655	**315**	**200**	920,00	460,00	29,400	•	•		1		
	13657	**315**	**250**	920,00	460,00	30,250	•	•		1		
	13665	**355**	**160**	960,00	257,50	30,893	•		•	1		
	13667	**355**	**200**	960,00	267,50	31,651	•		•	1		
	13669	**355**	**250**	960,00	480,00	41,635	•	•		1		
	13671	**355**	**315**	960,00	480,00	44,721	•	•		1		
11	**13678**	**400**	**160**	1000,00	354,00	44,111	•		•	1		
	13680	**400**	**200**	1000,00	318,00	44,111	•		•	1		
	13682	**400**	**250**	1000,00	280,00	44,111	•		•	1		
	13684	**400**	**315**	1000,00	500,00	46,162	•	•		1		
	13685	**400**	**355**	1000,00	500,00	54,361	•	•		1		
	13692	**450**	**160**	1050,00	379,00	57,962	•		•	1		
	13694	**450**	**200**	1050,00	343,00	57,962	•		•	1		
	13696	**450**	**250**	1050,00	305,00	57,962	•		•	1		
	13698	**450**	**315**	1050,00	315,00	58,818	•		•	1		
	13699	**450**	**355**	1050,00	525,00	78,330	•	•		1		
	13700	**450**	**400**	1050,00	525,00	78,330	•	•		1		

aquatherm blue pipe RED.- T-PIECE, SOCKET- & BUTT WELDING

Systems: aquatherm blue pipe
Material: Fusiolen® PP-R
Standard: DIN 16962, DIN EN ISO 15874
Colour: blue/green
Branch: socket welding
Form: pipes with weld-in saddle

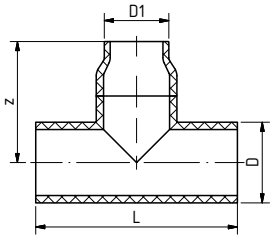


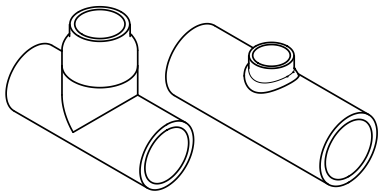


SDR	Art.- No.	D	d1	D1	L	l	z	Weight [kg]	System	PU	Box unit	Price € m/pc
						branch: socket welding						
	2013609	**200**	**75**	**100,00**	500,00	142,00	112,00	5,460	•	1		
	2013611	**200**	**90**	**120,00**	500,00	145,00	112,00	5,580	•	1		
	2013613	**200**	**110**	**147,00**	500,00	149,00	112,00	5,810	•	1		
	2013615	**200**	**125**	**167,00**	500,00	155,00	115,00	6,100	•	1		
	2013625	**250**	**75**	**100,00**	750,00	167,00	137,00	12,440	•	1		
11	**2013627**	**250**	**90**	**120,00**	750,00	170,00	137,00	12,420	•	1		
	2013629	**250**	**110**	**147,00**	750,00	174,00	137,00	12,760	•	1		
	2013631	**250**	**125**	**167,00**	750,00	180,00	140,00	13,030	•	1		
	2013651	**315**	**125**	**167,00**	920,00	213,00	173,00	25,000	•	1		
	2013663	**355**	**125**	**167,00**	960,00	233,00	193,00	32,500	•	1		
	2013676	**400**	**125**	**167,00**	1000,00	255,00	215,00	42,100	•	1		
	2013690	**450**	**125**	**167,00**	1050,00	280,00	240,00	55,700	•	1		

aquatherm blue pipe RED.- T-PIECE, BUTT WELDING

Systems: aquatherm blue pipe
Material: Fusiolen® PP-R
Standard: DIN 16962, DIN EN ISO 15874
Colour: blue/green
Branch: butt welding

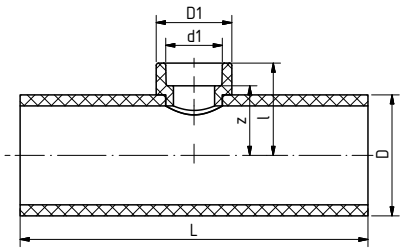


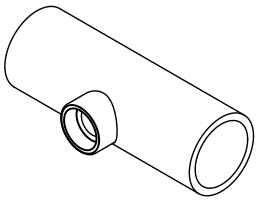


SDR	Art.- No.	D	D1	L	z	Weight [kg]	System	Pipe with reducer	Pipe with weld-in saddle	PU	Box unit	Price € m/pc
						branch: butt welding						
	2013619	**200**	**160**	500,00	300,00	7,650	•	•		1		
	2013635	**250**	**160**	750,00	375,00	19,030	•	•		1		
	2013641	**250**	**200**	750,00	375,00	21,100	•	•		1		
	2013653	**315**	**160**	920,00	237,50	25,000	•		•	1		
	2013655	**315**	**200**	920,00	460,00	33,200	•	•		1		
	2013657	**315**	**250**	920,00	460,00	34,200	•	•		1		
	2013665	**355**	**160**	960,00	257,50	32,500	•		•	1		
	2013667	**355**	**200**	960,00	267,50	30,200	•		•	1		
	2013669	**355**	**250**	960,00	480,00	40,000	•	•		1		
	2013671	**355**	**315**	960,00	480,00	40,000	•	•		1		
11	**2013678**	**400**	**160**	1000,00	354,00	44,100	•		•	1		
	2013680	**400**	**200**	1000,00	318,00	44,100	•		•	1		
	2013682	**400**	**250**	1000,00	280,00	46,000	•		•	1		
	2013684	**400**	**315**	1000,00	500,00	56,000	•	•		1		
	2013685	**400**	**355**	1000,00	500,00	54,300	•	•		1		
	2013692	**450**	**160**	1050,00	379,00	57,900	•		•	1		
	2013694	**450**	**200**	1050,00	343,00	57,900	•		•	1		
	2013696	**450**	**250**	1050,00	305,00	57,900	•		•	1		
	2013698	**450**	**315**	1050,00	315,00	58,400	•		•	1		
	2013699	**450**	**355**	1050,00	525,00	75,000	•	•		1		
	2013700	**450**	**400**	1050,00	525,00	76,000	•	•		1		

aquatherm blue pipe RED.- T-PIECE SOCKET- & BUTT WELDING

Systems: aquatherm blue pipe
Material: Fusiolen® PP-R
Standard: DIN 16962, DIN EN ISO 15874
Colour: blue/green
Branch: socket welding
Form: pipes with weld-in saddle



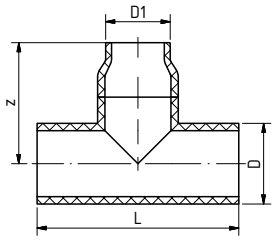


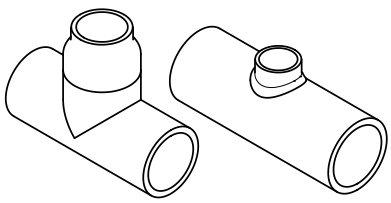
SDR	Art.- No.	D	d1	D1	L	l	z	Weight [kg]	System	pipe segments	injection molded*	PU	Box unit	Price € m/pc
						branch: socket welding								
17,6	**2513600**	**160**	**75**	100,00	460,00	122,00	92,00	2,227	•	•		1		
	2513602	**160**	**90**	120,00	460,00	125,00	92,00	2,364	•	•		1		
NEW	**2513606**	**160**	**125**	167,00	290,00	120,00	80,00	2,309			•	1		
	2513608	**200**	**75**	100,00	500,00	142,00	112,00	3,620	•	•		1		
	2513610	**200**	**90**	120,00	500,00	145,00	112,00	3,742	•	•		1		
	2513612	**200**	**110**	147,00	500,00	149,00	112,00	3,976	•	•		1		
	2513614	**200**	**125**	167,00	500,00	155,00	115,00	4,269	•	•		1		
	2513624	**250**	**75**	100,00	750,00	167,00	137,00	8,149	•	•		1		
	2513626	**250**	**90**	120,00	750,00	170,00	137,00	8,274	•	•		1		
	2513628	**250**	**110**	147,00	750,00	174,00	137,00	8,504	•	•		1		
	2513630	**250**	**125**	167,00	750,00	180,00	140,00	9,000	•	•		1		
	2513651	**315**	**125**	167,00	920,00	213,00	173,00	17,570	•	•		1		
	2513663	**355**	**125**	167,00	960,00	233,00	193,00	21,500	•	•		1		
	2513676	**400**	**125**	167,00	1000,00	255,00	215,00	27,690	•	•		1		
	2513690	**450**	**125**	167,00	1050,00	280,00	240,00	36,470	•	•		1		
	2513804	**500**	**125**	167,00	1200,00	305,00	265,00	51,250	•	•		1		
	2513821	**560**	**125**	167,00	1260,00	335,00	295,00	66,900	•	•		1		
	2513839	**630**	**125**	167,00	1330,00	370,00	330,00	89,170	•	•		1		

* status quo at the time of printing, further injection molded parts follow

aquatherm blue pipe RED.- T-PIECE, BUTT WELDING

Systems: aquatherm blue pipe
Standard: DIN 16962, DIN EN ISO 15874
Colour: blue/green
Branch: butt welding
Form: *see table*

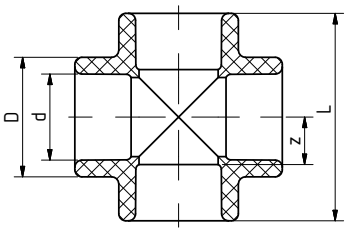


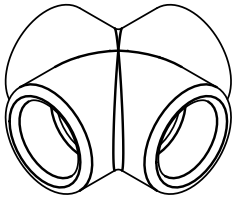


SDR	Art.- No.	D	D1	L	z	Weight [kg]	System	Pipe with reducer	Pipe with weld-in saddle	PU	Box unit	Price € m/pc
						butt welding						
	2513618	**200**	**160**	500,00	250,00	5,000	•	•		1		
	2513634	**250**	**160**	750,00	375,00	11,600	•	•		1		
	2513640	**250**	**200**	750,00	375,00	11,500	•	•		1		
	2513653	**315**	**160**	920,00	237,50	16,500	•		•	1		
	2513655	**315**	**200**	920,00	460,00	23,600	•	•		1		
	2513657	**315**	**250**	920,00	460,00	22,600	•	•		1		
	2513665	**355**	**160**	960,00	257,50	21,500	•		•	1		
	2513667	**355**	**200**	960,00	267,50	21,900	•		•	1		
	2513669	**355**	**250**	960,00	480,00	28,300	•	•		1		
	2513671	**355**	**315**	960,00	480,00	30,500	•	•		1		
	2513678	**400**	**160**	1000,00	354,00	29,700	•		•	1		
	2513680	**400**	**200**	1000,00	318,00	29,700	•		•	1		
	2513682	**400**	**250**	1000,00	280,00	29,000	•		•	1		
	2513684	**400**	**315**	1000,00	500,00	35,800	•	•		1		
	2513685	**400**	**355**	1000,00	500,00	39,700	•	•		1		
	2513692	**450**	**160**	1050,00	379,00	37,000	•		•	1		
	2513694	**450**	**200**	1050,00	343,00	37,000	•		•	1		
	2513696	**450**	**250**	1050,00	305,00	37,000	•		•	1		
	2513698	**450**	**315**	1050,00	315,00	37,000	•		•	1		
	2513699	**450**	**355**	1050,00	525,00	50,500	•	•		1		
	2513700	**450**	**400**	1050,00	525,00	50,100	•	•		1		
17,6	**2513806**	**500**	**160**	1200,00	404,00	53,400	•		•	1		
	2513808	**500**	**200**	1200,00	368,00	53,500	•		•	1		
	2513810	**500**	**250**	1200,00	330,00	53,500	•		•	1		
	2513812	**500**	**315**	1200,00	340,00	54,000	•		•	1		
	2513813	**500**	**355**	1200,00	600,00	72,500	•	•		1		
	2513814	**500**	**400**	1200,00	600,00	72,700	•	•		1		
	2513815	**500**	**450**	1200,00	600,00	71,500	•	•		1		
	2513823	**560**	**160**	1260,00	434,00	69,000	•		•	1		
	2513825	**560**	**200**	1260,00	398,00	69,000	•		•	1		
	2513827	**560**	**250**	1260,00	360,00	69,000	•		•	1		
	2513829	**560**	**315**	1260,00	370,00	66,700	•		•	1		
	2513831	**560**	**400**	1260,00	630,00	96,200	•	•		1		
	2513832	**560**	**450**	1260,00	630,00	97,400	•	•		1		
	2513833	**560**	**500**	1260,00	630,00	96,400	•	•		1		
	2513841	**630**	**160**	1330,00	474,00	91,530	•		•	1		
	2513843	**630**	**200**	1330,00	438,00	91,500	•		•	1		
	2513845	**630**	**250**	1330,00	400,00	91,500	•		•	1		
	2513847	**630**	**315**	1330,00	405,00	92,350	•		•	1		
	2513849	**630**	**400**	1330,00	665,00	133,800	•	•		1		
	2513850	**630**	**450**	1330,00	665,00	133,400	•	•		1		
	2513851	**630**	**500**	1330,00	665,00	130,700	•	•		1		
	2513852	**630**	**560**	1330,00	665,00	128,700	•	•		1		

CROSS

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R
Standard: DIN 16962, DIN EN ISO 15874
Colour: green

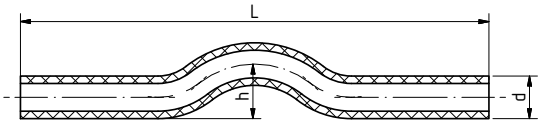


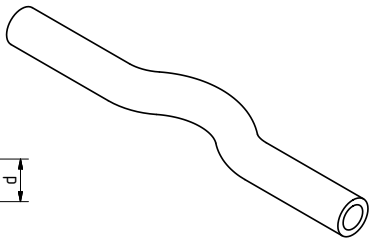


SDR	Art.- No.	Dimension d [mm]	D	L	z	Weight [kg]	System	PU	Box unit	Price € m/pc
					socket welding					
6 7,4 9 11	**13708**	**20**	29,50	51,50	11,25	0,025	• • •	10		
	13710	**25**	34,00	59,00	13,50	0,035	• • •	10		
	13712	**32**	43,00	70,00	17,00	0,062	• • •	5		
	13714	**40**	52,00	83,00	21,00	0,099	• • •	5		

CROSS OVER FITTING

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R
Standard: DIN 16962, DIN EN ISO 15874
Colour: green

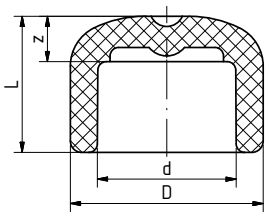


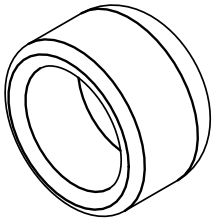


SDR	Art.- No.	Dimension d [mm]	h	L	Weight [kg]	System	PU	Box unit	Price € m/pc
					socket welding				
6 7,4 9 11	**16106**	**16**	17,00	352,00	0,038	•	10		
	16108	**20**	22,00	352,00	0,060	• • •	10		
	16110	**25**	25,00	352,00	0,091	• • •	10		
	16112	**32**	32,00	352,00	0,154	• • •	5		

END CAP

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R & PP-RP
Standard: DIN 16962, DIN EN ISO 15874
Colour: green

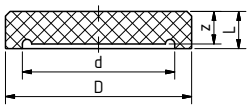


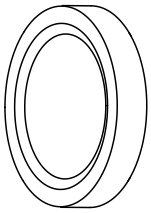


SDR	Art.- No.	Dimension d [mm]	D	z	L	Weight [kg]	System	PU	Box unit	Price € m/pc
					socket welding					
6 7,4 9 11	**14106**	**16**	26,00	13,50	26,50	0,008	•	10	2000	
	14108	**20**	29,50	9,50	24,00	0,009	• • •	10	2000	
	14110	**25**	34,00	8,00	24,00	0,011	• • •	10	1500	
	14112	**32**	43,00	11,00	29,00	0,023	• • •	5	1000	
	14114	**40**	52,00	17,50	38,00	0,042	• • •	5	500	
	14116	**50**	68,00	21,00	44,50	0,082	• • •	5	300	
	14118	**63**	84,00	24,50	52,00	0,146	• • •	1	150	
	14120	**75**	100,00	28,50	58,50	0,243	• • •	1	90	
	14122	**90**	120,00	34,50	67,50	0,365	• • •	1	60	
	14124	**110**	147,00	28,00	65,00	0,635	• • •	1	40	
	14126	**125**	167,00	42,00	82,00	0,872	• • •	1		

END CAP BUTT-WELDING

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R & PP-RP
Standard: DIN 16962, DIN EN ISO 15874
Colour: green





SDR	Art.- No.	Dimension D [mm]	L	z	d	Weight [kg]	System	PU	Box unit	Price € m/pc
7,4	**14130**	**160**	70,00	21,90	116,20	0,876	•	1		
	14134	**200**	80,00	27,40	145,20	1,398	•	1		
	14138	**250**	90,00	34,20	181,60	2,530	•	1		
9	**314130**	**160**	70,00	17,90	124,20	0,847	•	1		
	314134	**200**	80,00	22,40	155,20	1,373	•	1		
	314138	**250**	90,00	27,90	194,20	2,856	•	1		
	314142	**315**	70,00	52,50	244,60	5,080	•	1		
	314144	**355**	80,00	66,50	275,60	7,050	•	1		
11	**14131**	**160**	70,00	14,60	130,80	0,759	• •	1		
	14135	**200**	80,00	18,20	163,60	1,070	• •	1		
	14139	**250**	90,00	22,70	204,60	1,989	• •	1		
	14143	**315**	270,00	28,70	257,80	6,200	• •	1		
	14145	**355**	80,00	67,50	290,60	9,500	• •	1		
	14147	**400**	80,00	70,00	327,40	8,500	• •	1		
	14149	**450**	80,00	70,00	368,20	12,200	• •	1		
17,6	**2514130**	**160**	70,00	9,10	141,80	0,679	•	1		
	2514134	**200**	80,00	11,40	177,20	0,925	•	1		
	2514138	**250**	90,00	14,20	221,60	2,109	•	1		
	2514142	**315**	50,00	40,00	279,20	2,961	•	1		
	2514144	**355**	52,00	42,00	314,80	3,930	•	1		
	2514146	**400**	60,00	50,00	354,60	5,821	•	1		
	2514148	**450**	70,00	56,00	399,00	8,520	•	1		
	2514150	**500**	75,00	62,00	443,20	12,500	•	1		
	2514152	**560**	80,00	69,50	496,60	16,000	•	1		
	2514154	**630**	90,00	78,00	558,60	23,500	•	1		

WELD-IN SADDLE

for pressureless installation

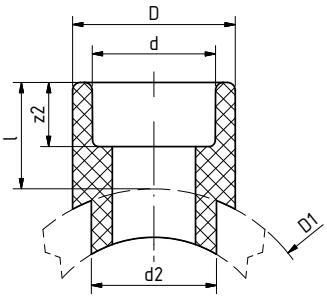
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

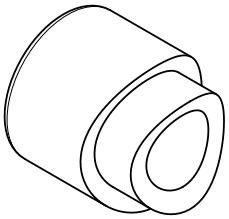
Material: Fusiolen® PP-R

Standard: DIN 16962, DIN EN ISO 15874

Colour: green

Notice *do not use with aquatherm blue pipe OT





SDR	Art.- No.	D1	d	d2	l	z2	D	Weight [kg]	System			PU	Box unit	Price € m/pc
						socket welding								
	15156*	**40**	**20**	**25**	27,00	14,50	29,50	0,016	•	•	•	5		
	15158*	**40**	**25**	**25**	28,50	16,00	34,00	0,017	•	•	•	5		
	15160	**50**	**20**	**25**	27,50	14,50	29,50	0,018	•	•	•	5		
	15162	**50**	**25**	**25**	28,50	16,00	34,00	0,019	•	•	•	5		
	15164	**63**	**20**	**25**	27,50	14,50	29,50	0,017	•	•	•	5		
	15166	**63**	**25**	**25**	28,50	16,00	34,00	0,019	•	•	•	5		
	15168	**63**	**32**	**32**	30,00	18,00	43,00	0,028	•	•	•	5		
	15170	**75**	**20**	**25**	27,50	14,50	29,50	0,018	•	•	•	5		
	15172	**75**	**25**	**25**	28,50	16,00	34,00	0,019	•	•	•	5		
	15174	**75**	**32**	**32**	30,00	18,00	43,00	0,028	•	•	•	5		
	15175	**75**	**40**	**40**	34,00	20,5	52,00	0,049	•	•	•	5		
	15176	**90**	**20**	**25**	27,50	14,50	29,50	0,018	•	•	•	5		
	15178	**90**	**25**	**25**	28,50	16,00	34,00	0,019	•	•	•	5		
	15180	**90**	**32**	**32**	30,00	18,00	43,00	0,029	•	•	•	5		
	15181	**90**	**40**	**40**	34,00	20,50	52,00	0,048	•	•	•	5		
	15182	**110**	**20**	**25**	27,50	14,50	29,50	0,019	•	•	•	5		
	15184	**110**	**25**	**25**	28,50	16,00	34,00	0,020	•	•	•	5		
	15186	**110**	**32**	**32**	30,00	18,00	43,00	0,030	•	•	•	5		
	15188	**110**	**40**	**40**	34,00	20,50	52,00	0,050	•	•	•	5		
	15189	**110**	**50**	**50**	34,00	23,50	68,00	0,091	•	•	•	5		
	15190	**125**	**20**	**25**	27,50	14,50	29,50	0,019	•	•	•	5		
	15192	**125**	**25**	**25**	28,50	16,00	34,00	0,020	•	•	•	5		
	15194	**125**	**32**	**32**	30,00	18,00	43,00	0,029	•	•	•	5		
	15196	**125**	**40**	**40**	34,00	20,50	52,00	0,050	•	•	•	5		
6	**15197**	**125**	**50**	**50**	34,00	23,50	68,00	0,090	•	•	•	5		
7,4	**15198**	**125**	**63**	**63**	38,00	27,50	84,00	0,149	•	•	•	5		
9	**15206**	**160**	**20**	**25**	27,50	14,50	29,50	0,021	•	•		5		
11	**15208**	**160**	**25**	**25**	28,50	16,00	34,00	0,023	•	•		5		
17,6	**15210**	**160**	**32**	**32**	30,00	18,00	43,00	0,034	•	•		5		
	15212	**160**	**40**	**40**	34,00	20,50	52,00	0,054	•	•		5		
	15214	**160**	**50**	**50**	34,00	23,50	68,00	0,094	•	•		5		
	15216	**160**	**63**	**63**	38,00	27,50	84,00	0,157	•	•		5		
	15218	**160**	**75**	**75**	42,00	30,00	100,00	0,238	•	•		5		
	15220	**160**	**90**	**90**	45,00	33,00	120,00	0,360	•	•		5		
	15228	**200-250**	**20**	**25**	27,50	14,50	29,50	0,020	•	•		5		
	15229	**200-250**	**25**	**25**	28,50	16,00	34,00	0,021	•	•		5		
	15230	**200-250**	**32**	**32**	30,00	18,00	43,00	0,031	•	•		5		
	15231	**200**	**40**	**40**	34,00	20,50	52,00	0,049	•	•		5		
	15232	**200**	**50**	**50**	34,00	23,50	68,00	0,087	•	•		5		
	15233	**200**	**63**	**63**	37,50	27,50	84,00	0,146	•	•		5		
	15234	**200**	**75**	**75**	42,00	30,00	100,00	0,225	•	•		5		
	15235	**200**	**90**	**90**	45,00	33,00	120,00	0,356	•	•		5		
	15236	**200**	**110**	**110**	49,00	37,00	147,00	0,638	•	•		5		
	15237	**200**	**125**	**125**	55,00	40,00	167,00	0,862	•	•		5		
	15251	**250**	**40**	**40**	34,00	20,50	52,00	0,053	•	•		5		
	15252	**250**	**50**	**50**	34,00	23,50	68,00	0,090	•	•		5		
	15253	**250**	**63**	**63**	37,50	27,50	84,00	0,152	•	•		5		
	15254	**250**	**75**	**75**	42,00	30,00	100,00	0,222	•	•		5		
	15255	**250**	**90**	**90**	45,00	33,00	120,00	0,348	•	•		5		
	15256	**250**	**110**	**110**	49,00	37,00	147,00	0,602	•	•		5		
	15257	**250**	**125**	**125**	55,00	40,00	167,00	0,820	•	•		5		

WELD-IN SADDLE

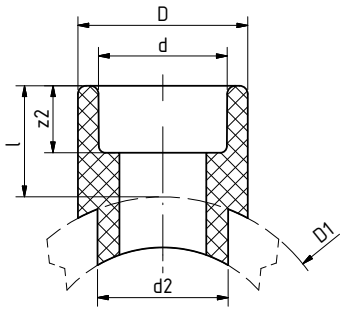
for pressureless installation

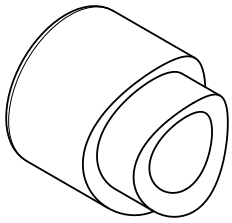
Systems: aquatherm green pipe, aquatherm blue pipe

Material: Fusiolen® PP-R

Standard: DIN 16962, DIN EN ISO 15874

Colour: green





SDR	Art.- No.	D1	d	d2	l	z2	D	Weight [kg]	System	PU	Box unit	Price € m/pc
						socket welding						
6 7,4 9 11 17,6	**15260**	**315-355**	**63**	**63**	37,50	27,50	84,00	0,153	• •	1		
	15261	**315-355**	**75**	**75**	42,00	30,00	100,00	0,230	• •	1		
	15262	**315**	**90**	**90**	45,00	33,00	120,00	0,363	• •	1		
	15263	**315**	**110**	**110**	49,00	37,00	147,00	0,592	• •	1		
	15264	**315**	**125**	**125**	55,00	40,00	167,00	0,830	• •	1		
	15268	**355**	**90**	**90**	45,00	33,00	120,00	0,355	• •	1		
	15269	**355**	**110**	**110**	49,00	37,00	147,00	0,586	• •	1		
	15270	**355**	**125**	**125**	55,00	40,00	167,00	0,813	• •	1		
	15275	**400-500**	**75**	**75**	42,00	30,00	100,00	0,216	• •	1		
	15277	**400-450**	**110**	**110**	49,00	37,00	147,00	0,535	• •	1		
	15278	**400**	**125**	**125**	55,00	40,00	167,00	0,693	• •	1		
	15288	**400-500**	**90**	**90**	45,00	33,00	120,00	0,330	• •	1		
	15290	**450-500**	**125**	**125**	55,00	40,00	167,00	0,671	• •	1		
	15300	**400-630**	**63**	**63**	37,50	27,50	84,00	0,498	• •	1		
	15303	**500-560**	**110**	**110**	49,00	37,50	147,00	0,533	• •	1		
	15315	**560-630**	**75**	**75**	42,00	30,00	100,00	0,260	• •	1		
	15316	**560-630**	**90**	**90**	45,00	33,00	120,00	0,350	• •	1		
	15318	**560-630**	**125**	**125**	55,00	40,00	167,00	0,689	• •	1		
	15331	**630**	**110**	**110**	49,00	37,00	147,00	0,567	• •	1		

With weld-on surface and additional weld-in socket for the fusion with the inner pipe wall.
The necessary tools for the fusion of aquatherm green pipe weld-in saddles are listed from page 171 onwards.

WELD-IN SADDLE BUTT WELDING

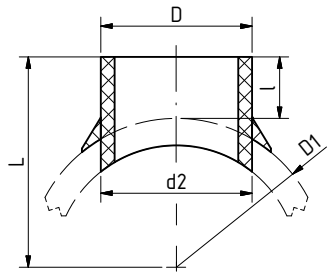
for pressureless installation

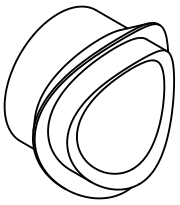
Systems: aquatherm green pipe, aquatherm blue pipe

Material: Fusiolen® PP-R & PP-RP

Standard: DIN 16962, DIN EN ISO 15874

Colour: green





SDR	Art.- No.	D1	D	d2	l	L	Weight [kg]	System	PU	Box unit	Price € m/pc
						butt welding					
9	**315265**	**315**	**160**	**160**	80,00	237,50	0,831	• •	1		
	315271	**355**	**160**	**160**	80,00	257,50	0,845	• •	1		
11	**15265**	**315**	**160**	**160**	80,00	237,50	0,868	• •	1		
	15271	**355**	**160**	**160**	80,00	257,50	0,867	• •	1		

With weld-on surface and additional weld-in socket for the fusion with the inner pipe wall.
The necessary tools for the fusion of aquatherm green pipe weld-in saddles are listed from page 171 onwards.

WELD-IN SADDLE WITH FEMALE THREAD

for pressureless installation

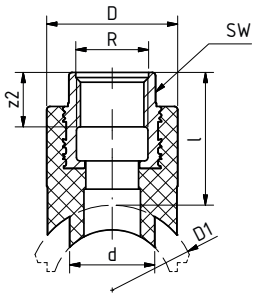
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

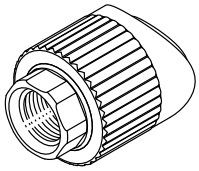
Material: Fusiolen® PP-R

Standard: DIN 16962, DIN EN ISO 15874
Fusiolen® PP-R, brass
Fusiolen® PP-R, stainless steel

Colour: green

Notice *do not use with aquatherm blue pipe OT





SDR	Art. no.	D1	d	l	z2	D	R	SW	Weight [kg]	System			PU	Box unit	Price € m/pc
							socket welding								
							brass								
	28214*	**40**	**25**	39,00	16,00	38,50	1/2“	24	0,088	•	•	•	5		
	28216	**50**	**25**	39,00	16,00	38,50	1/2“	24	0,090	•	•	•	5		
	28218	**63**	**25**	39,00	16,00	38,50	1/2“	24	0,089	•	•	•	5		
	28220	**75**	**25**	39,00	16,00	38,50	1/2“	24	0,083	•	•	•	5		
	28222	**90**	**25**	39,00	16,00	38,50	1/2“	24	0,090	•	•	•	5		
	28224	**110**	**25**	39,00	16,00	38,50	1/2“	24	0,089	•	•	•	5		
	28226	**125**	**25**	39,00	16,00	38,50	1/2“	24	0,092	•	•	•	5		
	28230	**160**	**25**	39,00	16,00	38,50	1/2“	24	0,092	•	•		5		
	28232	**200-250**	**25**	39,00	16,00	38,50	1/2“	24	0,092	•	•		5		
	28234	**40**	**25**	39,00	21,00	43,50	3/4“	31	0,107	•	•	•	5		
	28236	**50**	**25**	39,00	21,00	43,50	3/4“	31	0,110	•	•	•	5		
	28238	**63**	**25**	39,00	21,00	43,50	3/4“	31	0,109	•	•	•	5		
	28240	**75**	**25**	39,00	21,00	43,50	3/4“	31	0,109	•	•	•	5		
	28242	**90**	**25**	39,00	21,00	43,50	3/4“	31	0,110	•	•	•	5		
	28244	**110**	**25**	39,00	21,00	43,50	3/4“	31	0,110	•	•	•	5		
	28246	**125**	**25**	39,00	21,00	43,50	3/4“	31	0,112	•	•	•	5		
	28250	**160**	**25**	39,00	21,00	43,50	3/4“	31	0,112	•	•		5		
	28254	**200-250**	**25**	39,00	21,00	43,50	3/4“	31	0,112	•	•		5		
	28260	**75**	**32**	43,00	22,00	60,00	1“	39	0,223	•	•	•	5		
	28262	**90**	**32**	43,00	22,00	60,00	1“	39	0,223	•	•	•	5		
	28264	**110**	**32**	43,00	22,00	60,00	1“	39	0,223	•	•	•	5		
	28266	**125**	**32**	43,00	22,00	60,00	1“	39	0,224	•	•	•	5		
6	**28270**	**160**	**32**	43,00	22,00	60,00	1“	39	0,226	•	•		5		
7,4	**28274**	**200-250**	**32**	43,00	22,00	60,00	1“	39	0,244	•	•		5		
9							**stainless steel**								
11	**928214***	**40**	**25**	39,00	16,00	38,50	1/2“	24	0,088	•	•	•	5		
17,6	**928216**	**50**	**25**	39,00	16,00	38,50	1/2“	24	0,090	•	•	•	5		
	928218	**63**	**25**	39,00	16,00	38,50	1/2“	24	0,067	•	•	•	5		
	928220	**75**	**25**	39,00	16,00	38,50	1/2“	24	0,067	•	•	•	5		
	928222	**90**	**25**	39,00	16,00	38,50	1/2“	24	0,069	•	•	•	5		
	928224	**110**	**25**	39,00	16,00	38,50	1/2“	24	0,089	•	•	•	5		
	928226	**125**	**25**	39,00	16,00	38,50	1/2“	24	0,069	•	•	•	5		
	928230	**160**	**25**	39,00	16,00	38,50	1/2“	24	0,071	•	•		5		
	928232	**200-250**	**25**	39,00	16,00	38,50	1/2“	24	0,000	•	•		5		
	928234	**40**	**25**	39,00	21,00	43,50	3/4“	31	0,080	•	•	•	5		
	928236	**50**	**25**	39,00	21,00	43,50	3/4“	31	0,083	•	•	•	5		
	928238	**63**	**25**	39,00	21,00	43,50	3/4“	31	0,109	•	•	•	5		
	928240	**75**	**25**	39,00	21,00	43,50	3/4“	31	0,109	•	•	•	5		
	928242	**90**	**25**	39,00	21,00	43,50	3/4“	31	0,084	•	•	•	5		
	928244	**110**	**25**	39,00	21,00	43,50	3/4“	31	0,082	•	•	•	5		
	928246	**125**	**25**	39,00	21,00	43,50	3/4“	31	0,084	•	•	•	5		
	928250	**160**	**25**	39,00	21,00	43,50	3/4“	31	0,085	•	•		5		
	928254	**200-250**	**25**	39,00	21,00	43,50	3/4“	31	0,083	•	•		5		
	928260	**75**	**32**	43,00	22,00	60,00	1“	39	0,217	•	•	•	5		
	928262	**90**	**32**	43,00	22,00	60,00	1“	39	0,088	•	•	•	5		
	928264	**110**	**32**	43,00	22,00	60,00	1“	39	0,088	•	•	•	5		
	928266	**125**	**32**	43,00	22,00	60,00	1“	39	0,056	•	•	•	5		
	928270	**160**	**32**	43,00	22,00	60,00	1“	39	0,057	•	•		5		
	928274	**200-250**	**32**	43,00	22,00	60,00	1“	39	0,057	•	•		5		

WELD-IN SADDLE WITH MALE THREAD

for pressureless installation

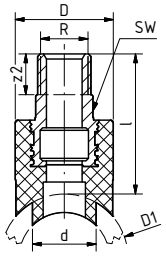
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

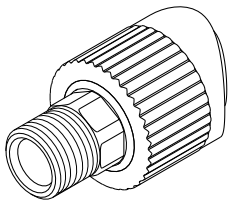
Material: Fusiolen® PP-R

Standard: DIN 16962, DIN EN ISO 15874

Colour: green

Notice *do not use with aquatherm blue pipe OT





SDR	Art. no.	D1	d	l	z2	D	R	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
						socket welding							
6 7.4 9 11 17.6	**28314***	**40**	**25**	55,00	16,00	38,50	1/2“	21	0,088	• • •	5		
	28316	**50**	**25**	55,00	16,00	38,50	1/2“	21	0,090	• • •	5		
	28318	**63**	**25**	55,00	16,00	38,50	1/2“	21	0,089	• • •	5		
	28320	**75**	**25**	55,00	16,00	38,50	1/2“	21	0,097	• • •	5		
	28322	**90**	**25**	55,00	16,00	38,50	1/2“	21	0,090	• • •	5		
	28324	**110**	**25**	55,00	16,00	38,50	1/2“	21	0,089	• • •	5		
	28326	**125**	**25**	55,00	16,00	38,50	1/2“	21	0,092	• • •	5		
	28330	**160**	**25**	55,00	16,00	38,50	1/2“	21	0,092	• • •	5		
	28334	**40**	**25**	56,00	17,00	43,50	3/4“	24	0,107	• • •	5		
	28336	**50**	**25**	56,00	17,00	43,50	3/4“	24	0,110	• • •	5		
	28338	**63**	**25**	56,00	17,00	43,50	3/4“	24	0,109	• • •	5		
	28340	**75**	**25**	56,00	17,00	43,50	3/4“	24	0,109	• • •	5		
	28342	**90**	**25**	56,00	17,00	43,50	3/4“	24	0,110	• • •	5		
	28344	**110**	**25**	56,00	17,00	43,50	3/4“	24	0,110	• • •	5		
	28346	**125**	**25**	56,00	17,00	43,50	3/4“	24	0,112	• • •	5		
	28350	**160**	**25**	56,00	17,00	43,50	3/4“	24	0,112	• •	5		

With hex shaped male thread, weld-in surface and weld-in socket for fusion with the inner wall of the pipe. The necessary tools for the fusion of aquatherm green pipe weld-in saddles are listed from page 171 onwards.

NEW aquatherm WELD-ON SADDLE SET WITH BALL VALVE

for installation under pressure
in use with tapping tool page 175

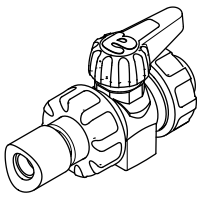
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

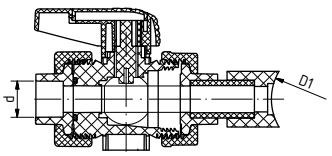
Material: Fusiolen® PP-R

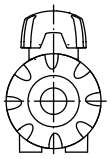
Standard: DIN 16962, DIN EN ISO 15874

Colour: green

Notice do not use with aquatherm blue pipe OT







SDR	Art. no.	d	D1	Weight [kg]	System	PU	Box unit	Price € m/pc
			socket welding					
6 7,4 9 11 17,6	**16175**	**40**	**75**	0,040	• • •	5		
	16181	**40**	**90**	0,040	• • •	5		
	16188	**40**	**110**	0,039	• • •	5		
	16196	**40**	**125**	0,038	• • •	5		
	16198	**63**	**125**	0,119	• • •	5		
	16212	**40**	**160**	0,038	• • •	5		
	16216	**63**	**160**	0,993	• •	5		
	16231	**40**	**200**	0,036	• •	5		
	16233	**63**	**200**	0,108	• •	5		
	16251	**40**	**250**	0,036	• •	5		
	16253	**63**	**250**	0,108	• •	5		
	16260	**63**	**315-355**	0,106	• •	5		
	16300	**63**	**400-630**	0,103	• •	5		

The necessary tools for the fusion of aquatherm green pipe weld-in saddles are listed from page 175 onwards.

FLANGE ADAPTER SOCKET WELDING

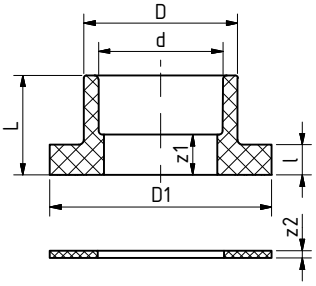
with gasket

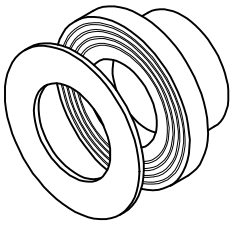
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

Material: Fusiolen® PP-R

Standard: DIN 16962, DIN EN ISO 15874

Colour: green





SDR	Art. no.	Dimension d [mm]	L	l	D	D1	z1	z2	Weight [kg]	System	PU	Box unit	Price € m/pc
						socket welding							
6 7,4 9 11	**15512**	**32**	34,00	10,00	41,00	68,00	16,00	3	0,053	• • •	1		
	15514	**40**	35,50	11,00	50,00	78,00	15,00	3	0,071	• • •	1		
	15516	**50**	39,50	12,00	61,00	88,00	16,00	3	0,071	• • •	1		
	15518	**63**	43,50	14,00	76,00	102,00	16,00	3	0,112	• • •	1		
	15520	**75**	46,00	16,00	90,00	122,00	16,00	3	0,169	• • •	1		
	15522	**90**	50,00	17,00	108,00	138,00	17,00	3	0,261	• • •	1		
	15524	**110**	55,50	18,50	131,00	158,00	18,50	3	0,329	• • •	1		
	15527	**125**	63,00	20,00	165,00	188,00	23,00	3	0,724	• • •	1		

FLANGE ADAPTER SOCKET WELDING

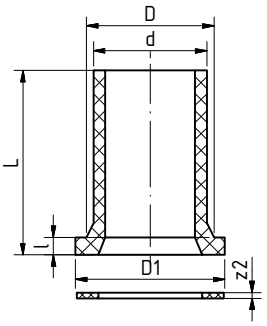
with gasket

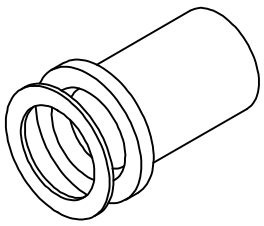
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

Material: Fusiolen® PP-R

Standard: DIN 16962, DIN EN ISO 15874

Colour: green





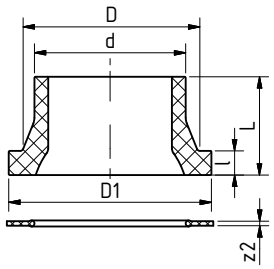
SDR	Art. no.	Dimension d [mm]	L	l	D	D1	z2	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	**15526**	**125**	195,00	18,50	131,00	158,00	3	1,180	• • •	1		

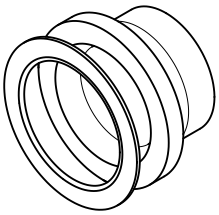
*Only use with fitting 125 mm; with 110 mm flange adapter suitable for Art. no. 15724

Suitable flange adapter for shut-off valves are available on request.

FLANGE ADAPTER BUTT WELDING

with gasket





Systems: aquatherm green pipe, aquatherm blue pipe

Material: Fusiolen® PP-R & PP-RP

Standard: DIN 16962, DIN EN ISO 15874

Colour: green

SDR	Art. no.	Dimension d [mm]	L	l	D	D1	z2	Weight [kg]	System	PU	Box unit	Price € m/pc
						butt welding						
	15530	**160**	93,00	25,00	175,00	212,00	3,00	1,163	•	1		
	15534	**200**	130,00	32,00	232,00	268,00	6,00	2,292	•	1		
	15538	**250**	130,00	35,00	285,00	320,00	6,00	3,298	•	1		
	315530	**160**	93,00	25,00	175,00	212,00	3	1,150	•	1		
	315534	**200**	130,00	32,00	232,00	268,00	6	2,292	•	1		
9	**315538**	**250**	130,00	35,00	285,00	320,00	6	3,313	•	1		
	315542	**315**	172,50	52,00	337,00	370,00	6	5,640	•	1		
	315544	**355**	185,00	42,00	372,00	432,00	6	14,318	•	1		
	15531	**160**	93,00	25,00	175,00	212,00	3	0,955	• •	1		
	15535	**200**	130,00	32,00	232,00	268,00	6	1,957	• •	1		
	15539	**250**	130,00	35,00	285,00	320,00	6	2,717	• •	1		
11	**15543**	**315**	170,00	35,00	335,00	370,00	6	5,650	• •	1		
	15545	**355**	185,00	42,00	372,00	432,00	6	9,000	• •	1		
	15547	**400**	195,00	50,00	425,00	484,00	6	12,000	• •	1		
	15549	**450**	220,00	75,00	512,00	586,00	7	16,500	• •	1		
	2515530	**160**	93,00	25,00	175,00	212,00	3	0,821	•	1		
	2515534	**200**	130,00	32,00	232,00	268,00	6	1,849	•	1		
	2515538	**250**	130,00	35,00	285,00	320,00	6	2,736	•	1		
	2515542	**315**	170,00	35,00	335,00	370,00	6	4,500	•	1		
	2515544	**355**	185,00	42,00	372,00	432,00	6	6,500	•	1		
17,6	**2515546**	**400**	199,00	33,00	425,00	484,00	6	8,500	•	1		
	2515548	**450**	140,00	46,00	512,00	586,00	7	12,000	•	1		
	2515550	**500**	141,00	47,00	525,00	585,00	7	9,800	•	1		
	2515552	**560**	141,00	50,00	612,00	685,00	7	13,800	•	1		
	2515554	**630**	142,00	50,00	640,00	688,00	7	12,600	•	1		

NEW FLANGE ADAPTER INCL. FLANGE PN6

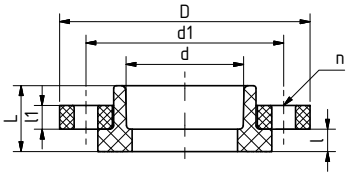
without gasket

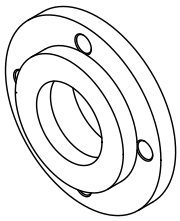
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

Material: Flange: Steel galvanized
Flange adapter: Fusiolen® PP-R

Colour: Flange: silver
Flange adapter: green

Connection dimensions, excluding internal diameter (d1), according to DIN 2641, DN-dependent hole-circle PN 6





SDR	Art. no.	Diameter d	D	d1	L	l1	l	n	Weight [kg]	System	PU	Box unit	Price € m/pc
						socket welding							
	15012	**32**	100,00	75,00	34,00	14,00	10,00	4	1,090	• • •	1		
	15014	**40**	120,00	90,00	35,50	16,00	11,00	4	1,170	• • •	1		
6	**15016**	**50**	130,00	100,00	39,50	16,00	12,00	4	1,360	• • •	1		
7,4	**15018**	**63**	140,00	110,00	43,50	16,00	14,00	4	1,530	• • •	1		
9	**15020**	**75**	160,00	130,00	46,00	16,00	16,00	4	1,930	• • •	1		
11	**15022**	**90**	190,00	150,00	50,00	18,00	17,00	4	3,080	• • •	1		
17,6	**15024**	**110**	210,00	170,00	55,50	18,00	18,50	4	3,430	• • •	1		
	15027	**125**	240,00	200,00	63,00	20,00	20,00	8	3,945	• • •	1		

Delivery time: on request

NEW FLANGE ADAPTER INCL. FLANGE PN6

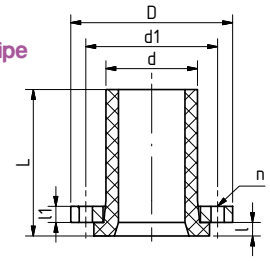
without gasket

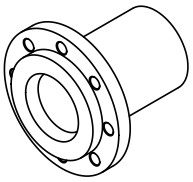
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

Material: Flange: Steel galvanized
Flange adapter: Fusiolen® PP-R

Colour: Flange: silver
Flange adapter: green

Connection dimensions, excluding internal diameter (d1), according to DIN 2641, DN-dependent hole-circle PN 6





SDR	Art. no.	Diameter d	D	d1	L	l1	l	n	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11 17,6	**15026**	**125**	210,00	170,00	195,00	18,00	18,50	4	3,760	• • •	1		

Delivery time: on request

125mm Fitting with 110mm Flange adapter incl. flange PN6
Use only in combination with a fitting

NEW FLANGE ADAPTER INCL. FLANGE PN6

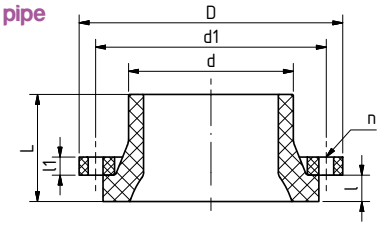
without gasket

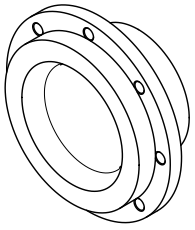
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

Material: Flange: Steel galvanized
Flange adapter: Fusiolen® PP-R

Colour: Flange: silver
Flange adapter: green

Connection dimensions, excluding internal diameter (d1), according to DIN 2641, DN-dependent hole-circle PN 6



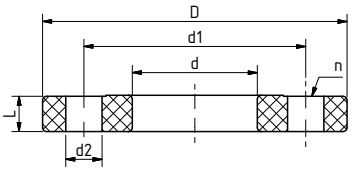


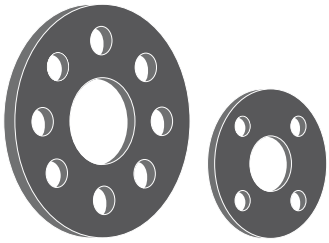
SDR	Art. no.	Diameter d	D	d1	L	l1	l	n	Weight [kg]	System	PU	Box unit	Price € m/pc
						Butt welding							
	15031	160	265,00	225,00	93,00	20,00	25,00	8	4,136	• •	1		
11	**15035**	200	320,00	280,00	130,00	22,00	32,00	8	6,694	• •	1		
	15039	250	375,00	335,00	130,00	24,00	35,00	8	9,500	• •	1		

Delivery time: on request

PLASTIC COATED STEEL FLANGE

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: PP/steel
Colour: grey





Connection dimensions, excluding internal diameter (d1), according to DIN EN1092, DIN2501, DN-dependent hole-circle PN 10/16.

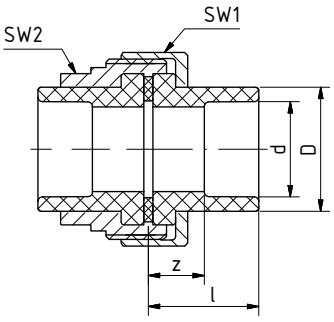
SDR	Art. no.	Dimension	fits to Art-.No.	d	d1	D	d2	L	n	Weight [kg]	System	PU	Box unit	Price € m/pc
						socket welding								
	15712	**32**	15512	42,00	85,00	116,00	14,00	15,50	4	0,469	• • •	1		
	15714	**40**	15514	51,00	100,00	141,00	18,00	17,50	4	0,722	• • •	1		
	15716	**50**	15516	62,00	110,00	151,00	18,00	17,50	4	0,770	• • •	1		
	15718	**63**	15518	78,00	125,00	166,00	18,00	19,00	4	0,911	• • •	1		
	15720	**75**	15520	92,00	145,00	186,00	18,00	19,00	4	1,132	• • •	1		
	15722	**90**	15522	110,00	160,00	201,00	18,00	21,00	8	1,356	• • •	1		
	15724	**110**	15524/26	133,00	180,00	221,00	18,00	22,00	8	1,475	• • •	1		
	15726	**125**	15527	167,00	210,00	251,00	18,00	26,00	8	2,082	• • •	1		
	15730	**160**	15531 315530 2515530	178,00	240,00	286,00	22,00	27,00	8	3,671	• •	1		
6 7,4 9 11 17,6	**15734**	**200**	15535 315534 2515534	235,00	295,00	341,00	22,00	28,00	8	4,709	• •	1		
	15738	**250**	15539 315538 2515538	288,00	350,00	406,00	22,00	31,00	12	7,094	• •	1		
	15742	**315**	15543 315542 2515542	340,00	400,00	460,00	22,00	33,50	12	9,500	• •	1		
	15744	**355**	15545 315544 2515544	380,00	460,00	520,00	22,00	39,00	16	15,300	• •	1		
	15746	**400**	15547 2515546	430,00	515,00	565,00	26,00	34,00	16	19,680	• •	1		
	***15748**	**450**	15549 2515548	517,00	620,00	670,00	26,00	42,00	20	22,880	• •	1		
	***15750**	**500**	2515550	533,00	620,00	670,00	26,00	38,00	20	19,000	• •	1		
	***15752**	**560**	2515552	618,00	725,00	785,00	30,00	50,00	20	37,200	• •	1		
	***15754**	**630**	2515554	645,00	725,00	785,00	30,00	40,00	20	25,800	• •	1		

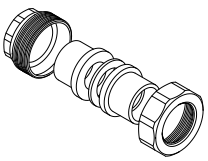
ø200-630mm (Art-. No. 15934-15954) also available on request in PN16.

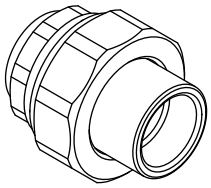
*Material: steel/epoxyd

COUPLING SCREW JOINT

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Standard: DIN 16962, DIN EN ISO 15874
Colour: green, brassy



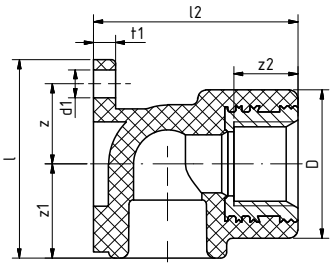


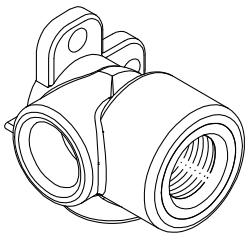


SDR	Art. no.	Dimension d [mm]	l	z	D	SW1	SW2	Weight [kg]	System	PU	Box unit	Price € m/pc
						socket welding						
	15812	**32**	36,50	18,50	41,00	64	50	0,479	• • •	1		
6 7.4 9 11	**15814**	**40**	38,00	17,50	50,00	80	60	0,841	• • •	1		
	15816	**50**	41,00	17,50	61,00	86	70	0,821	• • •	1		
	15818	**63**	45,00	17,50	76,00	108	90	1,498	• • •	1		
	15820	**75**	47,50	17,50	90,00	128	104	1,998	• • •	1		

PRINCIPLE OF FLOW-THROUGH BACK PLATE ELBOW

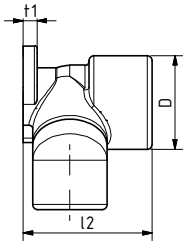


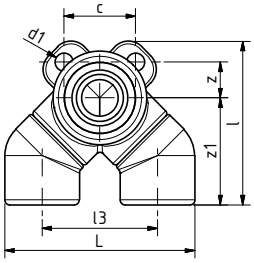


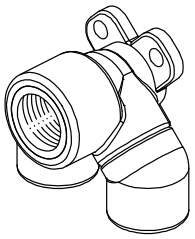


aquatherm green pipe FLOW-THROUGH BACK PLATE ELBOW 90°

Art.- No.	Dimension	D	d1	l	l2	t1	z	z1	z2	PU	Box unit	Price € m/pc
20197	20mm x 1/2"f x 20 mm	37,00	7,00	49,50	51,00	5,50	20,00	23,50	16,00	1		





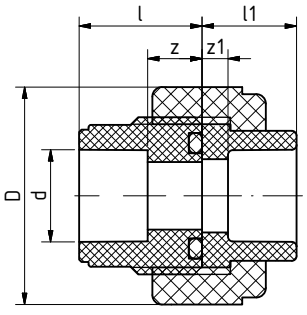


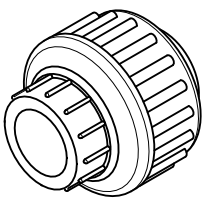
aquatherm green pipe FLOW-THROUGH BACK PLATE ELBOW, PARALLEL

Art.- No.	Dimension	D	d1	L	l	l2	l3	c	t1	z	z1	PU	Box unit	Price € m/pc
20198	20mm x 1/2"f x 20 mm	37,00	7,00	75,00	65,00	51,00	45,60	28,30	5,50	14,00	42,30	1		

COUPLING SCREW JOINT

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R
Standard: DIN 16962, DIN EN ISO 15874
Colour: green

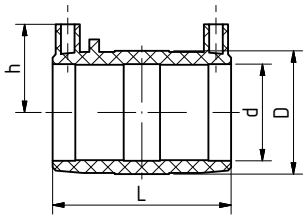


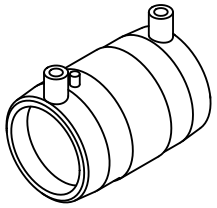


SDR	Art. no.	Dimension d [mm]	l	z	l1	z1	D	Weight [kg]	System	PU	Box unit	Price € m/pc
					socket welding							
6 7.4 9 11	**15838**	**20**	26,00	12,00	20,00	5,50	46,00	0,036	• • •	10		
	15840	**25**	28,00	12,00	21,00	5,00	56,00	0,058	• • •	10		
	15842	**32**	30,00	12,00	23,00	5,00	66,00	0,089	• • •	5		
	15844	**40**	34,00	13,50	25,50	5,00	79,00	0,136	• • •	5		
	15846	**50**	39,00	15,50	28,80	5,00	87,00	0,170	• • •	5		
	15848	**63**	47,50	20,00	32,50	5,00	107,00	0,240	• • •	1		
	15850	**75**	50,00	20,00	36,00	6,00	128,00	0,546	• • •	1		

ELECTROFUSION SOCKET

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R
Standard: DIN 16962, DIN EN ISO 15874
Colour: green
Notice do not use with 160 mm - 250 mm fittings
*do not use with aquatherm blue pipe MF OT

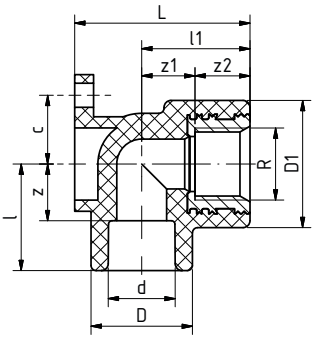


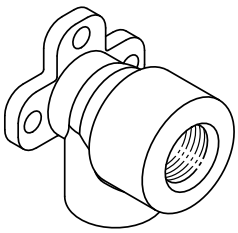


SDR	Art. no.	Dimension d [mm]	L	h	D	Weight [kg]	System	PU	Box unit	Price € m/pc
					Electro-socket welding					
6 7,4 9 11 17,6	**17208**	**20**	70,00	36,00	31,50	0,049	• • •	1		
	17210	**25**	78,00	38,50	36,50	0,057	• • •	1		
	17212	**32**	80,00	42,50	45,00	0,077	• • •	1		
	17214	**40**	92,00	47,00	54,00	0,103	• • •	1		
	17216	**50**	103,00	52,00	65,00	0,142	• • •	1		
	17218	**63**	118,00	58,00	81,50	0,239	• • •	1		
	17220	**75**	130,00	64,50	96,00	0,347	• • •	1		
	17222	**90**	145,00	72,00	113,50	0,501	• • •	1		
	17224	**110**	160,00	82,50	139,00	0,821	• • •	1		
	17226	**125**	172,00	90,00	156,00	1,097	• • •	1		
	17230*	**160**	186,00	109,50	197,00	1,754	• •	1		
	17234*	**200**	210,00	134,00	243,00	3,625	• •	1		
	17238*	**250**	250,00	170,00	315,00	7,142	• •	1		

BACK PLATE ELBOW

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Fusiolen® PP-R, stainless steel
Standard: DIN 16962, DIN EN ISO 15874
Colour: green

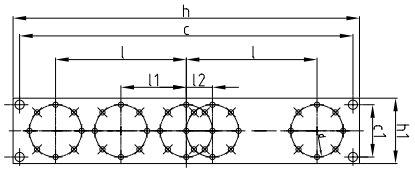


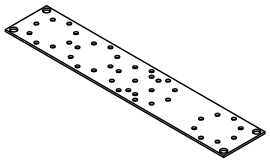


SDR	Art. no.	d	R	l	z	D	l1	z1	z2	D1	L	c	Weight [kg]	System	PU	Box unit	Price € m/pc
								socket welding									
								brass									
6 7,4 11	**20106**	**16**	**1/2"**	31,00	18,00	29,50	31,50	18,50	13,00	37,00	51,00	20,00	0,080	•		200	
	20108	**20**	**1/2"**	31,00	16,50	29,50	31,50	18,50	13,00	37,00	51,00	20,00	0,079	• • •		200	
	20110	**20**	**3/4"**	37,00	22,50	34,00	37,00	24,00	13,00	44,00	54,00	-	0,106	• • •			
	20112	**25**	**3/4"**	37,00	21,00	34,00	37,00	24,00	13,00	44,00	54,00	-	0,105	• • •			
	20113	**25**	**1/2"**	33,50	17,50	34,00	31,00	18,00	13,00	37,00	53,00	20,00	0,080	• • •			
								stainless steel									
	920108	**20**	**1/2"**	31,00	16,50	29,50	31,50	18,50	13,00	37,00	51,00	20,00	0,084	•			
	920110	**20**	**3/4"**	37,00	22,50	34,00	37,00	24,00	13,00	44,00	54,00	-	0,101	• • •			
	920112	**25**	**3/4"**	37,00	21,00	34,00	37,00	24,00	13,00	44,00	54,00	-	0,111	• • •			
	920113	**25**	**1/2"**	33,50	17,50	34,00	31,00	18,00	13,00	37,00	53,00	20,00	0,076	• • •			

MOUNTING PLATE

galvanized; to fix back plate elbows as double connection





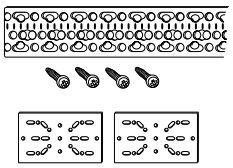
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: iron, galvanized
Colour: zinc

Art. no.	d	l	l1	l2	c	c1	h	h1	Weight [kg]	System	PU	Box unit	Price € m/pc
60010	**40**	100	50	20	255	40	265	50	0,221	• • •	1		

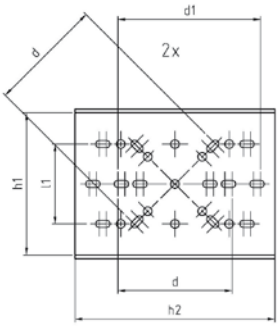
not suitable for connection with sound insulation plate (Art. no. 79080).
We recommend mounting rail Art. no. 79090.

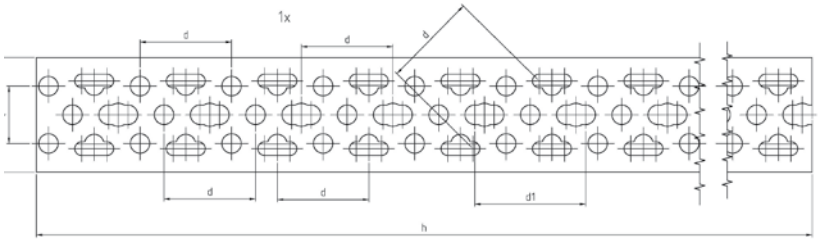
MOUNTING PLATE

galvanized; to fix back plate elbows as double connection including 2 fixing plates and 4 screws



Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: iron, galvanized
Colour: zinc



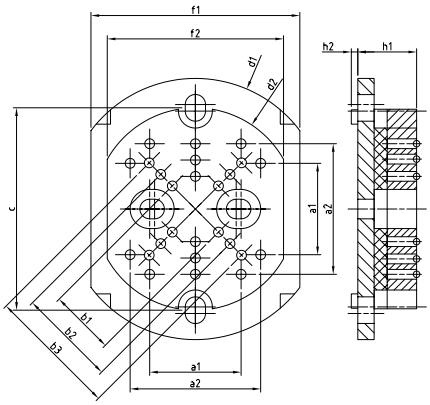


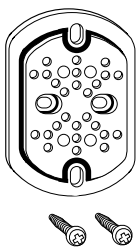
Art. no.	d	d1	l	l1	h	h1	h2	Weight [kg]	System	PU	Box unit	Price € m/pc
79090	**40**	50	25	28	560	70	70	0,546	• • •	1		

SOUND INSULATION PLATE

for aquatherm green pipe-and aquatherm grey pipe-back plate elbow

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: PP
Colour: white

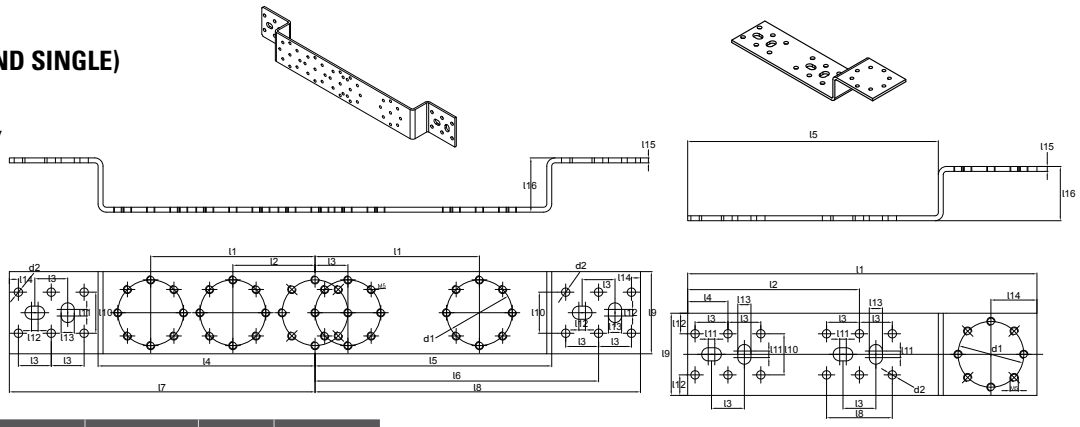




Art. no.	a1	a2	b1	b2	b3	c	d1	d2	f1	f2	h1	h2	Weight [kg]	System	PU	Box unit	Price € m/pc
79080	28	20	30	40	62	62	80	62	64	54	18	2	0,058	• • •	2		

MOUNTING RAIL (DOUBLE AND SINGLE)

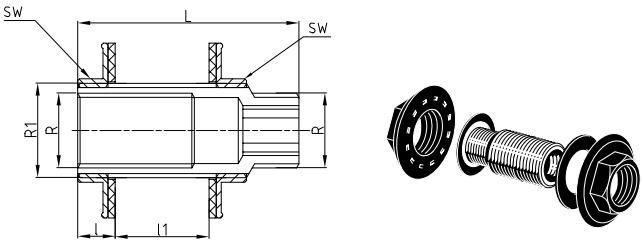
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: iron, galvanized
Colour: zinc



Art. no.	ø d1	ø d2	Weight [kg]	System	PU	Price € m/pc
79095	40	5,1	0,412	• • •	2	
79096	40	5,1	0,235	• • •	2	

DRY CONSTRUCTION WALL FITTING

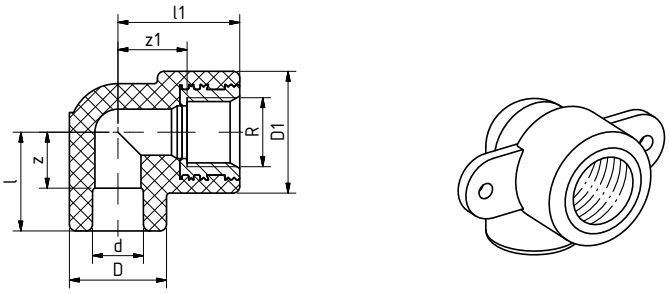
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: brass



Art. no.	R	R1	l	l1	L	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
20114	**1/2"**	3/4"	10,50	26,00	62,00	30	0,213	• • •	10		

BACK PLATE ELBOW FOR DRY CONSTRUCTION

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Fusiolen® PP-R, stainless steel
Standard: DIN 16962, DIN EN ISO 15874
Colour: green

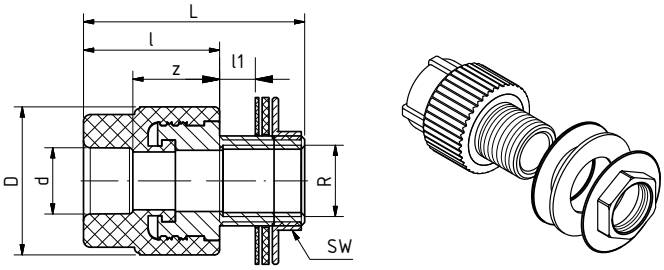


SDR	Art. no.	d	R	l	z	D	l1	z1	D1	Weight [kg]	System	PU	Box unit	Price € m/pc
							socket welding							
							brass							
6 7,4 11	**20156**	**16**	**1/2"**	30,00	17,00	29,50	37,00	24,00	37,00	0,081	•	10		
	20158	**20**	**1/2"**	30,00	15,50	29,50	37,00	24,00	37,00	0,079	• • •	10		
							stainless steel							
	920158	**20**	**1/2"**	30,00	15,50	29,50	37,00	24,00	37,00	0,078	• • •	10		

TRANSITION PIECE

with counternut, gasket and tension washer

Systems: aquatherm green pipe aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Standard: DIN 16962, DIN EN ISO 15874
Colour: green



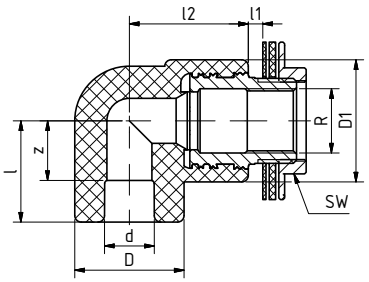
SDR	Art. no.	d	R	l	z	D	l1	L	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
							socket welding							
6 7,4 11	**20204**	**20**	**1/2"**	40,00	25,50	43,50	13,50	65,00	29	0,204	• • •	10		

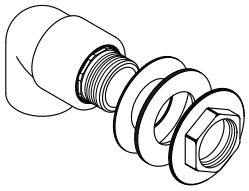
e.g. for connection of a cistern or application with mounting plate (Art. no. 60110-60115)

TRANSITION ELBOW

with counternut, gasket and tension washer

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Standard: DIN 16962, DIN EN ISO 15874
Colour: green



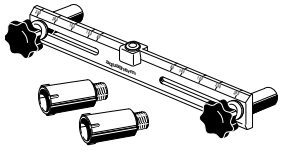


SDR	Art. no.	d	R	l	z	D	l1	l2	D1	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
							socket welding								
6	**20206**	**16**	**1/2"**	37,00	24,00	29,50	3,50	35,00	44,00	29	0,201	•	10		
7,4	**20208**	**20**	**1/2"**	37,00	22,50	29,50	3,50	35,00	44,00	29	0,154	• • •	10		
11	**20209**	**25**	**1/2"**	37,00	21,00	34,00	3,50	37,00	44,00	29	0,206	• • •	10		

e.g. for connection of a cistern or application with mounting plate (Art. no. 60110-60115)

ASSEMBLING JIG

as water level with 2 plugs 1/2"



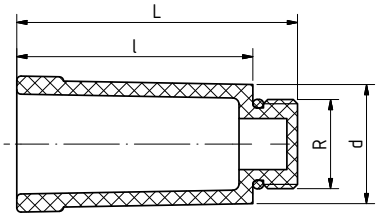
Systems: aquatherm green pipe aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R
Colour: green

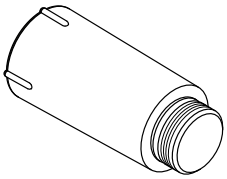
Art. no.	Weight [kg]	System	PU	Box unit	Price € m/pc
50700	0,252	• • •	1		

PLUG FOR PRESSURE TESTS

with gasket

Systems: aquatherm green pipe aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R
Standard: DIN 16962, DIN EN ISO 15874
Colour: green



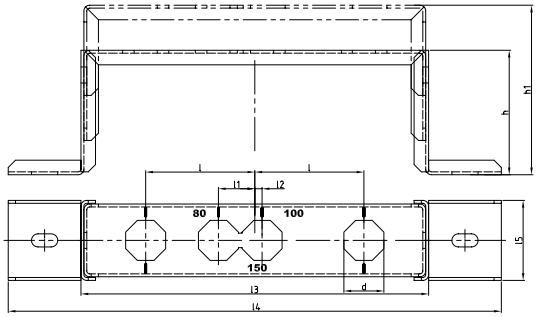


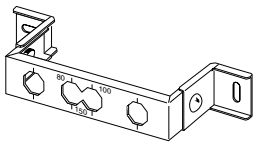
Art. no.	d	R	l	L	Weight [kg]	System	PU	Box unit	Price € m/pc
50708	**28**	**1/2"**	55,50	66,00	0,022	• • •	10		
50710	**34**	**3/4"**	55,50	66,00	0,027	• • •	10		

MOUNTING UNIT

double

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: iron/galvanized
Colour: zinc



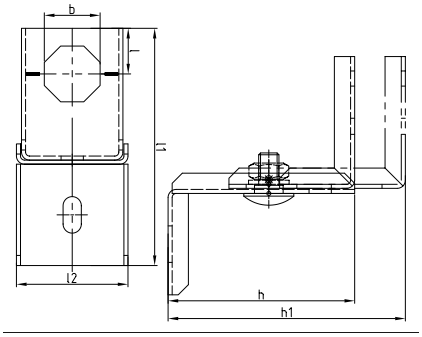


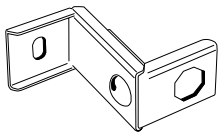
Art. no.	b	l	l1	l2	h	h1	l3	l4	l5	Weight [kg]	System	PU	Box unit	Price € m/pc
60110	27,5	75	25	5	92,5	122,5	239	339	55	0,630	• • •	1		

MOUNTING UNIT

single

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: iron/galvanized
Colour: zinc



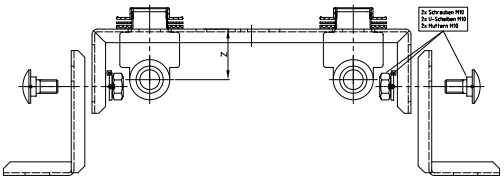


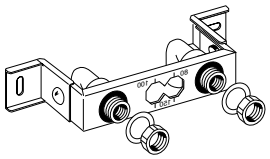
Art. no.	b	l	l1	l2	h	h1	Weight [kg]	System	PU	Box unit	Price € m/pc
60115	27,5	118	22,5	55	92,5	122,5	0,278	• • •	1		

MOUNTING UNIT

with two aquatherm green pipe transition elbows (Art. no. 20208), with counternut, gasket and tension washer

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
iron/galvanized
Colour: green
zinc



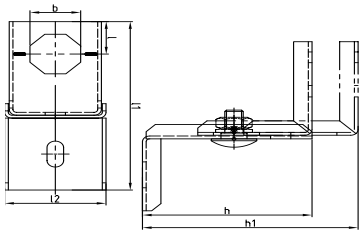


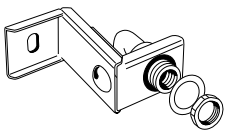
Art. no.	b	l	l1	l2	h	h1	l3	l4	l5	Weight [kg]	System	PU	Box unit	Price € m/pc
60150	27,5	75	25	5	92,5	122,5	239	339	55	0,942	• • •	1		

MOUNTING UNIT

with one aquatherm green pipe transition elbow (Art. no. 20208), with counternut, gasket and tension washer

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
iron/galvanized
Colour: green
zinc



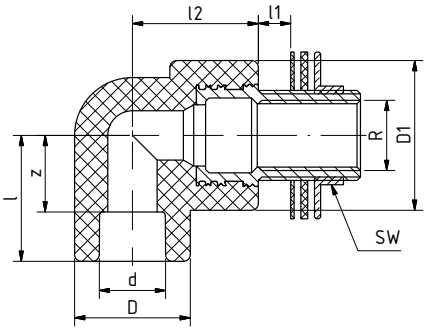


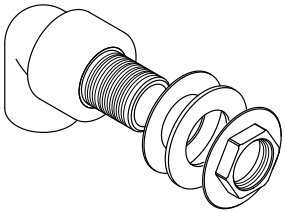
Art. no.	b	l	l1	l2	h	h1	Weight [kg]	System	PU	Box unit	Price € m/pc
60155	27,5	22,5	118	55	92,5	122,5	0,434	• • •	1		

TRANSITION ELBOW

for plasterboard

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Colour: green





SDR	Art. no.	d	R	l	z	D	L	l1	D1	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7.4 11	**20210**	20	1/2“	37,00	22,50	29,50	18,50	35,00	44,00	29	0,223	• • •	10		

with 30 mm thread, counternut, gasket and tension washer

TRANSITION PIECE WITH FEMALE THREAD

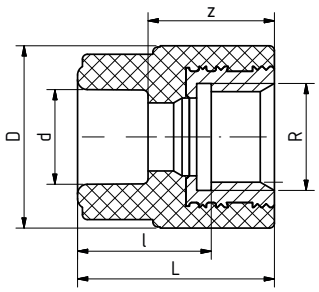
round

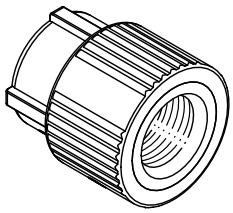
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

Material: Fusiolen® PP-R, brass
Fusiolen® PP-R, stainless steel

Standard: DIN 16962, DIN EN ISO 15874

Colour: green



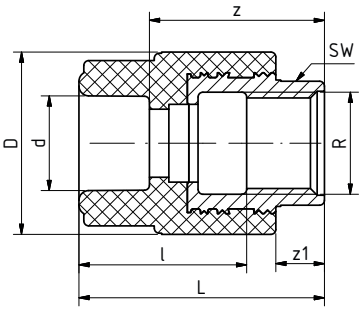


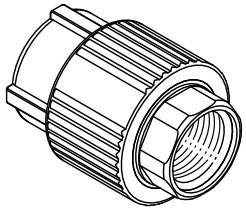
SDR	Art. no.	d	R	l	z	D	L	Weight [kg]	System	PU	Box unit	Price € m/pc
						brass						
6 7,4 9 11	**21006**	**16**	**1/2"**	28,00	28,00	38,50	41,00	0,066	•	10		
	21008	**20**	**1/2"**	27,50	26,00	37,50	40,50	0,064	• • •	10	400	
	21010	**20**	**3/4"**	27,50	26,00	43,50	40,50	0,089	• • •	10	300	
	21011	**25**	**1/2"**	29,50	26,50	38,50	42,50	0,065	• • •	10	400	
	21012	**25**	**3/4"**	27,50	24,50	43,50	40,50	0,087	• • •	10	300	
	21013	**32**	**3/4"**	30,50	25,50	43,50	43,50	0,092	• • •	5	250	
						stainless steel						
	921008	**20**	**1/2"**	27,50	26,00	37,50	40,50	0,069	• • •	10		
	921010	**20**	**3/4"**	27,50	26,00	43,50	40,50	0,090	• • •	10		
	921011	**25**	**1/2"**	29,50	26,50	38,50	42,50	0,069	• • •	10		
	921012	**25**	**3/4"**	27,50	24,50	43,50	40,50	0,086	• • •	10		
	921013	**32**	**3/4"**	30,50	25,50	43,50	43,50	0,092	• • •	5		
	921014	**32**	**1/2"**	28,00	23,00	37,00	41,00	0,078	• • •	5		

TRANSITION PIECE WITH FEMALE THREAD

hex shaped threaded transition

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Fusiolen® PP-R, stainless steel
Standard: DIN 16962, DIN EN ISO 15874
Colour: green



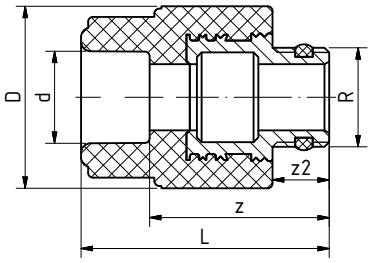


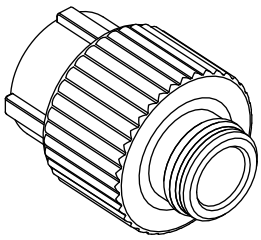
SDR	Art. no.	d	R	l	z	z1	D	L	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
							brass							
	21106	**16**	**1/2"**	34,50	37,50	10,00	38,50	50,50	24	0,089	•	10		
	21108	**20**	**1/2"**	34,50	36,00	10,00	38,50	50,50	24	0,078	• • •	10	400	
	21110	**20**	**3/4"**	29,00	35,50	10,00	43,50	50,00	31	0,112	• • •	10	300	
	21111	**25**	**1/2"**	36,00	36,00	10,00	38,50	52,00	24	0,081	• • •	10	300	
	21112	**25**	**3/4"**	29,00	34,00	10,00	43,50	50,00	31	0,109	• • •	10	300	
	21113	**32**	**3/4"**	32,00	35,00	10,00	43,50	53,00	31	0,114	• • •	5	250	
	21114	**32**	**1"**	37,50	41,50	14,00	60,00	59,50	39	0,239	• • •	5	125	
	21115	**40**	**1"**	40,00	41,50	14,00	60,00	62,00	39	0,227	• • •	5		
	21116	**40**	**1 1/4"**	40,00	42,50	15,00	74,00	63,00	50	0,385	• • •	5		
	21117	**50**	**1 1/4"**	43,00	42,50	15,00	74,00	66,00	50	0,404	• • •	5		
6	**21118**	**50**	**1 1/2"**	45,00	43,50	15,00	84,00	67,00	55	0,418	• • •	5		
7,4	**21119**	**63**	**1 1/2"**	51,50	46,00	15,00	84,00	73,50	55	0,442	• • •	1		
9	**21120**	**63**	**2"**	51,00	49,50	19,00	101,00	77,00	67	0,600	• • •	1		
11	**21122**	**75**	**2"**	51,00	47,00	19,00	100,00	77,00	67	0,608	• • •	1		
							stainless steel							
	921114	**32**	**1"**	37,50	41,50	14,00	60,00	59,50	39	0,232	• • •	5		
	921115	**40**	**1"**	40,00	41,50	14,00	60,00	62,00	39	0,219	• • •	5		
	921116	**40**	**1 1/4"**	40,00	42,50	15,00	74,00	63,00	50	0,331	• • •	5		
	921117	**50**	**1 1/4"**	43,00	42,50	15,00	74,00	66,00	50	0,351	• • •	5		
	921118	**50**	**1 1/2"**	45,00	43,50	15,00	84,00	67,00	55	0,445	• • •	5		
	921119	**63**	**1 1/2"**	51,50	46,00	15,00	84,00	73,50	55	0,425	• • •	1		
	921120	**63**	**2"**	51,00	49,50	19,00	101,00	77,00	67	0,196	• • •	1		
	921122	**75**	**2"**	51,00	47,00	19,00	100,00	77,00	67	0,676	• • •	1		

TRANSITION PIECE WITH MALE THREAD

round, self sealing

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Standard: DIN 16962, DIN EN ISO 15874
Colour: green





SDR	Art. no.	d	R	L	z	z2	D	Weight [kg]	System	PU	Box unit	Price € m/pc
6	**21258**	**20**	**1/2"**	52,50	38,00	12,00	38,50	0,090	• • •	10		
7,4	**21261**	**25**	**1/2"**	54,00	38,00	12,00	38,50	0,078	• • •	10		
11	**21262**	**25**	**3/4"**	53,50	37,50	13,00	38,50	0,085	• • •	10		

TRANSITION PIECE WITH MALE THREAD

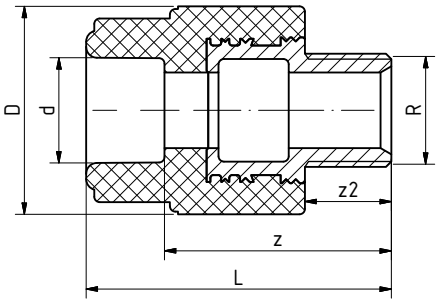
round

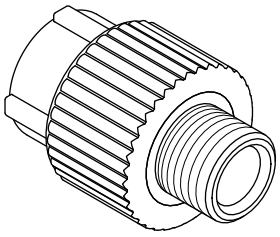
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

Material: Fusiolen® PP-R, brass
Fusiolen® PP-R, stainless steel

Standard: DIN 16962, DIN EN ISO 15874

Colour: green





SDR	Art. no.	d	R	L	z	z2	D	Weight [kg]	System	PU	Box unit	Price € m/pc
						brass						
6 7,4 9 11	**21206**	**16**	**1/2“**	56,50	43,50	16,00	38,50	0,097	•	10		
	21208	**20**	**1/2“**	56,50	42,00	16,00	38,50	0,084	• • •	10	350	
	21210	**20**	**3/4“**	57,50	43,00	17,00	38,50	0,109	• • •	10	300	
	21211	**25**	**1/2“**	58,00	42,00	16,00	38,50	0,098	• • •	10	300	
	21212	**25**	**3/4“**	57,50	41,50	17,00	38,50	0,090	• • •	10	350	
	21213	**32**	**3/4“**	59,50	41,50	17,00	38,50	0,115	• • •	5	250	
						stainless steel						
	921208	**20**	**1/2“**	56,50	42,00	16,00	38,50	0,096	• • •	10		
	921210	**20**	**3/4“**	57,50	43,00	17,00	38,50	0,108	• • •	10		
	921211	**25**	**1/2“**	58,00	42,00	16,00	38,50	0,098	• • •	10		
	921212	**25**	**3/4“**	57,50	41,50	17,00	38,50	0,108	• • •	10		
	921213	**32**	**3/4“**	59,50	41,50	17,00	38,50	0,115	• • •	5		

TRANSITION PIECE WITH MALE THREAD

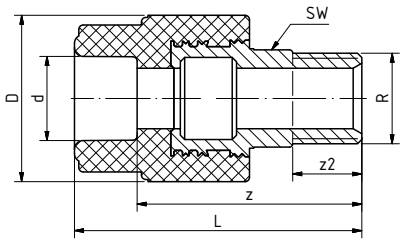
*with hexagon or *octagon*

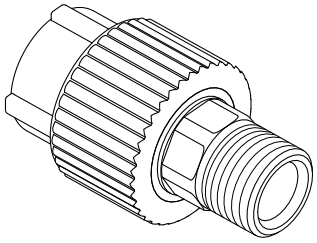
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

Material: Fusiolen® PP-R, brass
Fusiolen® PP-R, stainless steel

Standard: DIN 16962, DIN EN ISO 15874

Colour: green



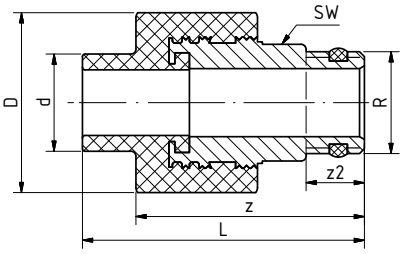


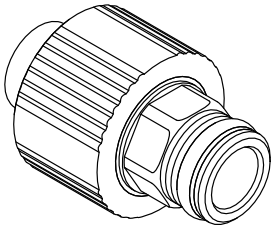
SDR	Art. no.	d	R	SW	L	z	z2	D	Weight [kg]	System	PU	Box unit	Price € m/pc
							brass						
	21306	**16**	**1/2"**	22	66,50	53,50	16,00	38,50	0,119	•	10		
	21308	**20**	**1/2"**	22	66,50	52,00	16,00	38,50	0,104	• • •	10		
	21310	**20**	**3/4"**	24	67,50	53,00	18,00	38,50	0,129	• • •	10		
	21312	**25**	**3/4"**	24	67,50	51,50	18,00	38,50	0,103	• • •	10	300	
	21314	**32**	**1"**	30	78,50	60,50	20,00	53,00	0,216	• • •	5	125	
	21316	**32**	**1 1/4"**	41	81,00	63,00	21,00	68,00	0,318	• • •	5	100	
	21317	**40**	**1"**	30	81,00	60,50	20,00	52,00	0,222	• • •	5	100	
	21318	**40**	**1 1/4"**	41	84,50	64,00	21,00	68,00	0,324	• • •	5	80	
	21319	**50**	**1 1/4"**	41	85,50	62,00	21,00	68,00	0,351	• • •	5		
	21320	**50**	**1 1/2"**	46	88,50	65,00	22,00	74,00	0,425	• • •	5		
	21321	**63**	**1 1/2"**	46	94,50	67,00	27,00	72,50	0,467	• • •	1		
6	**21322**	**63**	**2"**	50	102,50	75,00	23,50	84,00	0,685	• • •	1		
7,4	**21323**	**75**	**2"**	50	102,00	72,00	23,50	84,00	0,733	• • •	1		
9	**21324**	**75**	**2 1/2"**	65	105,00	75,00	26,70	100,00	0,970	• • •	1		
11	**21325***	**90**	**3"**	85	121,00	88,00	30,00	120,00	1,326	• • •	1		
	21327*	**110**	**4"**	105	148,00	111,00	39,00	147,00	2,730	• • •	1		
							stainless steel						
	921314	**32**	**1"**	32	78,50	60,50	20,00	53,00	0,204	• • •	5		
	921316	**32**	**1 1/4"**	41	81,00	63,00	21,00	68,00	0,360	• • •	5		
	921317	**40**	**1"**	32	81,00	60,50	20,00	52,00	0,251	• • •	5		
	921318	**40**	**1 1/4"**	41	84,50	64,00	21,00	68,00	0,362	• • •	5		
	921319	**50**	**1 1/4"**	41	85,50	62,00	21,00	68,00	0,389	• • •	5		
	921320	**50**	**1 1/2"**	46	88,50	65,00	22,00	74,00	0,480	• • •	5		
	921321	**63**	**1 1/2"**	46	94,50	67,00	27,00	72,50	0,523	• • •	1		
	921322	**63**	**2"**	50	102,50	75,00	23,50	84,00	0,708	• • •	1		
	921323	**75**	**2"**	50	102,00	72,00	23,50	84,00	0,699	• • •	1		

TRANSITION PIECE WITH MALE THREAD

self-sealing, with hex shaped threaded transition male/male

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Standard: DIN 16962, DIN EN ISO 15874
Colour: green



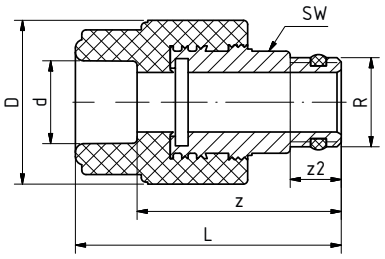


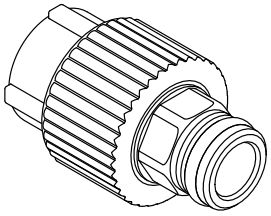
SDR	Art. no.	d	R	L	z	z2	D	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 11	**21355**	**20**	**1/2"**	59,00	48,00	13,00	38,50	22	0,107	• • •	10		

TRANSITION PIECE WITH MALE THREAD

self-sealing, with hex shaped threaded transition female/male

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Standard: DIN 16962, DIN EN ISO 15874
Colour: green

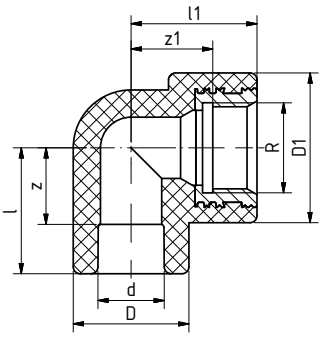


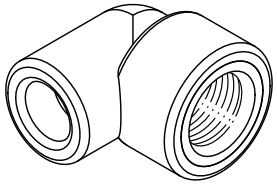


SDR	Art. no.	d	R	L	z	z2	D	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4	**21356**	**16**	**1/2"**	63,50	50,50	13,00	38,50	22	0,112	•	10		
11	**21358**	**20**	**1/2"**	63,50	49,00	13,00	38,50	22	0,111	• • •	10		

TRANSITION ELBOW WITH FEMALE THREAD

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Fusiolen® PP-R, stainless steel
Standard: DIN 16962, DIN EN ISO 15874
Colour: green

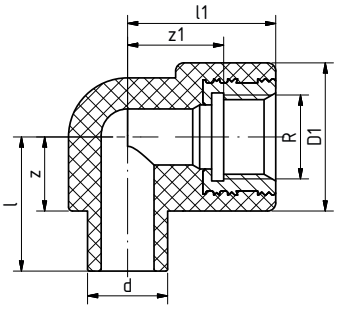


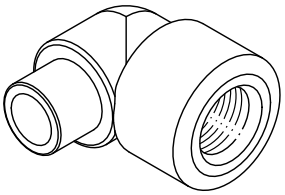


SDR	Art. no.	d	R	l	z	D	l1	z1	D1	Weight [kg]	System	PU	Box unit	Price € m/pc
							brass							
	23006	**16**	**1/2"**	31,50	18,50	29,50	37,00	24,00	37,00	0,072	•	10		
	23008	**20**	**3/4"**	37,00	22,50	34,00	37,00	24,00	44,00	0,102	• • •	10		
	23010	**20**	**1/2"**	31,00	16,50	29,50	31,50	18,50	37,00	0,076	• • •	10	300	
	23012	**25**	**3/4"**	37,00	21,00	34,00	37,00	24,00	44,00	0,100	• • •	10	200	
	23014	**25**	**1/2"**	33,50	17,50	34,00	31,50	18,50	37,00	0,075	• • •	10	250	
	23016	**32**	**3/4"**	27,50	9,50	43,00	51,00	38,00	44,00	0,104	• • •	5		
6	**23018**	**32**	**1"**	34,00	16,00	43,00	66,50	44,50	60,50	0,249	• • •	5		
7,4							**stainless steel**							
9														
11	**923008**	**20**	**3/4"**	37,00	22,50	29,50	37,00	24,00	37,00	0,095	• • •	10		
	923010	**20**	**1/2"**	31,00	16,50	29,50	31,50	18,50	37,00	0,081	• • •	10		
	923012	**25**	**3/4"**	37,00	21,00	34,00	37,00	24,00	44,00	0,101	• • •	10		
	923014	**25**	**1/2"**	33,50	17,5	34,00	31,50	18,5	37,00	0,082	• • •	10		
	923015	**32**	**1/2"**	35,00	17,00	43,00	37,00	24,00	37,00	0,112	• • •	5		
	923016	**32**	**3/4"**	27,50	9,50	43,00	51,00	38,00	44,00	0,097	• • •	5		
	923018	**32**	**1"**	34,00	16,00	43,00	66,50	44,50	60,50	0,240	• • •	5		

TRANSITION ELBOW WITH FEMALE THREAD

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Standard: DIN 16962, DIN EN ISO 15874
Colour: green

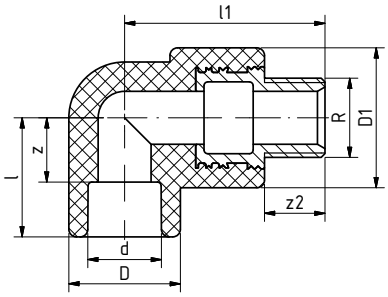


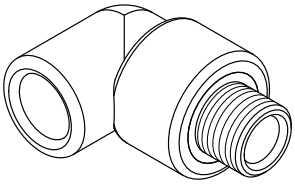


SDR	Art. no.	d	R	l	z	l1	z1	D1	Weight [kg]	System	PU	Box unit	Price € m/pc
6													
7,4	**23208**	**20**	**1/2"**	33,50	18,50	37,00	24,00	37,00	0,076	• • •	10		
11													

TRANSITION ELBOW WITH MALE THREAD

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Fusiolen® PP-R, stainless steel
Standard: DIN 16962, DIN EN ISO 15874
Colour: green

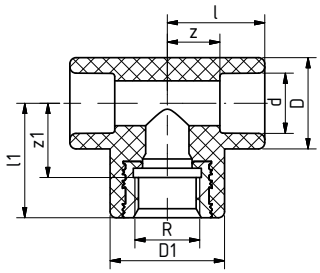


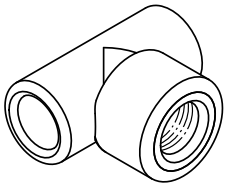


SDR	Art. no.	d	R	l	l1	z	z2	D	D1	Weight [kg]	System	PU	Box unit	Price € m/pc
							brass							
	23504	**16**	**1/2"**	31,50	53,00	18,50	16,00	29,50	37,00	0,109	•	10		
	23506	**20**	**1/2"**	31,50	53,00	17,00	16,00	29,50	37,00	0,108	• • •	10		
	23508	**20**	**3/4"**	31,50	54,00	17,00	17,00	34,00	38,00	0,128	• • •	10		
	23510	**25**	**3/4"**	31,50	54,00	15,50	17,00	34,00	38,00	0,104	• • •	10		
6	**23512**	**32**	**3/4"**	27,50	68,00	9,50	17,00	43,00	38,00	0,112	• • •	5		
7,4	**23514**	**32**	**1"**	31,00	85,50	13,00	20,00	43,00	52,00	0,231	• • •	5		
9														
11							**stainless steel**							
	923506	**20**	**1/2"**	31,50	53,00	17,00	16,00	29,50	37,00	0,035	• • •	10		
	923508	**20**	**3/4"**	31,50	54,00	17,00	17,00	34,00	38,00	0,123	• • •	10		
	923510	**25**	**3/4"**	31,50	54,00	15,50	17,00	34,00	38,00	0,121	• • •	10		
	923512	**32**	**3/4"**	27,50	68,00	9,50	17,00	43,00	38,00	0,128	• • •	5		

THREADED BRANCH TEE WITH FEMALE THREAD

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Fusiolen® PP-R, stainless steel
Standard: DIN 16962, DIN EN ISO 15874
Colour: green

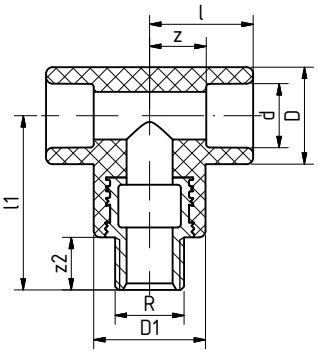


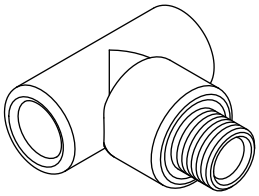


SDR	Art. no.	d	R	l	z	D	l1	z1	D1	Weight [kg]	System	PU	Box unit	Price € m/pc
							brass							
	25004	**16**	**1/2"**	31,50	18,50	29,50	37,00	24,00	37,00	0,089	•	10		
	25006	**20**	**1/2"**	31,50	17,00	29,50	37,00	24,00	37,00	0,086	• • •	10	250	
	25008	**20**	**3/4"**	37,00	22,50	34,00	37,00	24,00	44,00	0,121	• • •	10	170	
	25010	**25**	**1/2"**	34,50	18,50	34,00	38,00	25,00	37,00	0,090	• • •	10	200	
	25012	**25**	**3/4"**	37,00	21,00	34,00	37,00	24,00	44,00	0,109	• • •	10	150	
	25013	**32**	**1/2"**	35,00	17,00	43,00	37,00	24,00	37,00	0,103	• • •	5		
	25014	**32**	**3/4"**	27,50	9,50	43,00	51,00	38,00	44,00	0,111	• • •	5		
	25016	**32**	**1"**	31,50	13,50	43,00	67,00	45,00	60,00	0,255	• • •	5		
	25018	**40**	**1/2"**	41,50	21,00	52,00	40,00	27,00	37,00	0,142	• • •	5		
	25019	**40**	**3/4"**	40,50	20,00	52,00	40,50	27,50	52,00	0,147	• • •	5		
6	**25020**	**40**	**1"**	41,50	21,00	52,00	56,00	34,00	60,00	0,276	• • •	5		
7,4	**25022**	**50**	**1"**	49,50	26,00	68,00	63,50	41,50	68,30	0,385	• • •	5		
9	**25030**	**50**	**1/2"**	49,50	26,00	68,00	44,50	31,50	43,00	0,237	• • •	5		
11	**25031**	**50**	**3/4"**	49,50	26,00	68,00	44,50	31,50	43,00	0,243	• • •	5		
							stainless steel							
	925006	**20**	**1/2"**	31,50	17,00	29,50	37,00	24,00	37,00	0,087	• • •	10		
	925008	**20**	**3/4"**	37,00	22,50	34,00	37,00	24,00	44,00	0,108	• • •	10		
	925010	**25**	**1/2"**	34,50	18,50	34,00	38,00	25,00	37,00	0,093	• • •	10		
	925012	**25**	**3/4"**	37,00	21,00	34,00	37,00	24,00	44,00	0,111	• • •	10		
	925013	**32**	**1/2"**	35,00	17,00	43,00	37,00	24,00	37,00	0,113	• • •	5		
	925014	**32**	**3/4"**	27,50	9,50	43,00	51,00	38,00	44,00	0,111	• • •	5		
	925016	**32**	**1"**	31,50	13,50	43,00	67,00	45,00	60,00	0,082	• • •	5		

THREADED BRANCH TEE WITH MALE THREAD

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Standard: DIN 16962, DIN EN ISO 15874
Colour: green



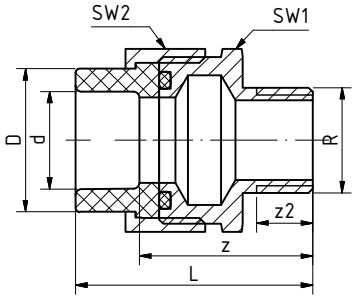


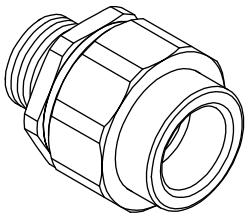
SDR	Art. no.	d	R	l	z	D	z2	D1	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7.4 11	**25506**	**20**	**1/2"**	31,50	17,00	29,50	16,00	37,00	0,102	• • •	10		

TRANSITION COUPLING WITH MALE THREAD

with union nut and welding socket

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Standard: DIN 16962, DIN EN ISO 15874
Colour: green



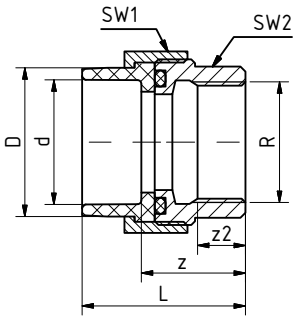


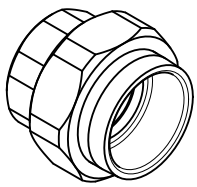
SDR	Art. no.	d	R	L	z	z2	D	SW1	SW2	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	**26608**	**20**	**1/2"**	52,50	38,00	13,50	27,50	34	36	0,145	• • •	1		
	26610	**25**	**3/4"**	59,50	43,50	14,50	36,00	42	46	0,243	• • •	1		
	26612	**32**	**1"**	64,50	46,50	16,80	41,50	48	52	0,336	• • •	1		
	26614	**40**	**1 1/4"**	70,00	49,50	19,10	53,00	60	64	0,632	• • •	1		
	26616	**50**	**1 1/2"**	84,80	61,30	22,00	59,00	48	72	0,624	• • •	1		
	26618	**63**	**2"**	95,50	68,00	25,00	74,00	62	89	1,045	• • •	1		

TRANSITION COUPLING WITH FEMALE THREAD

with union nut and welding socket

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Standard: DIN 16962, DIN EN ISO 15874
Colour: green





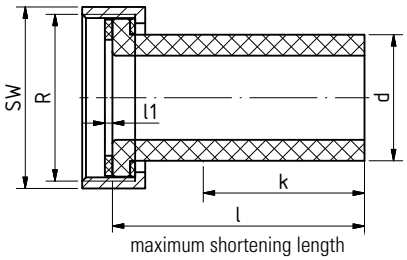
SDR	Art. no.	d	R	z	z2	D	L	SW1	SW2	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	**26638**	**20**	**1/2"**	30,50	15,00	27,50	45,00	36	24	0,112	• • •	1		
	26640	**25**	**3/4"**	33,00	15,50	36,00	49,00	46	32	0,193	• • •	1		
	26642	**32**	**1"**	36,00	15,00	41,50	54,00	52	40	0,291	• • •	1		
	26644	**40**	**1 1/4"**	36,00	20,00	53,00	56,50	64	47	0,423	• • •	1		
	26646	**50**	**1 1/2"**	41,30	19,00	59,00	64,80	72	57	0,610	• • •	1		
	26648	**63**	**2"**	47,00	18,00	74,00	74,50	89	68	0,924	• • •	1		

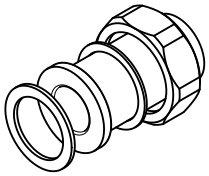
Notice: aquatherm green pipe-metal compound fittings are manufactured from fusiolen PP-R and brass. Metal inserts, without hex shaped spanner flat, with 1/2" and 3/4" f are also available in stainless steel.

LOOSE NUT ADAPTER

length: 100 mm, with gasket

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Standard: DIN 16962, DIN EN ISO 15874
Colour: green



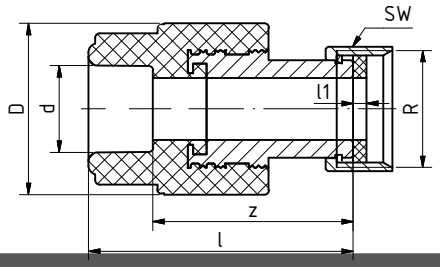


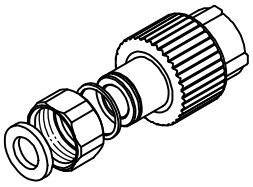
SDR	Art. no.	d	Nut R	l	l1	k	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	**26708**	**20**	**1“**	100,00	3,00	65,00	36	0,079	• • •	1		
	26710	**25**	**1 1/4“**	100,00	3,00	62,00	46	0,104	• • •	1		
	26712	**32**	**1 1/2“**	100,00	3,00	58,00	52	0,175	• • •	1		
	26714	**40**	**2“**	100,00	3,00	53,00	64	0,258	• • •	1		
	26716	**50**	**2 1/4“**	100,00	3,00	49,00	72	0,344	• • •	1		
	26718	**63**	**2 3/4“**	100,00	3,00	43,00	89	0,583	• • •	1		
	26720	**75**	**3 1/2“**	100,00	3,00	34,00	110	0,918	• • •	1		
	26722	**90**	**4“**	100,00	3,00	26,00	120	1,238	• • •	1		

WATER METER NUT ADAPTER

with gasket

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Standard: DIN 16962, DIN EN ISO 15874
Colour: green



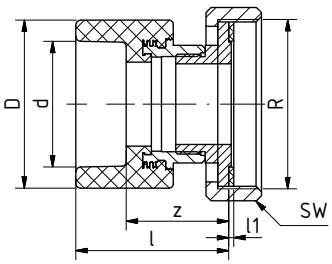


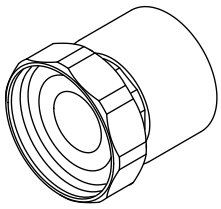
SDR	Art. no.	d	l	l1	z	D	R	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	**26808**	**20**	59,50	3,00	45,00	38,50	3/4“	30	0,136	• • •	1		
	26810	**25**	61,00	3,00	45,00	38,50	3/4“	30	0,155	• • •	1		
	26812	**32**	62,00	3,00	44,00	43,50	3/4“	30	0,162	• • •	1		

NUT ADAPTER

ISO-standard

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Standard: DIN 16962, DIN EN ISO 15874
Colour: green



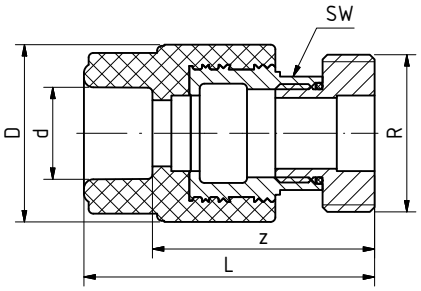


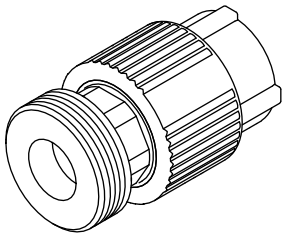
SDR	Art. no.	d	Nut R	l	l1	z	D	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	**27010**	**20**	**1“**	58,50	3,00	34,00	38,50	36	0,182	• • •	10		
	27011	**25**	**1“**	60,00	3,00	44,00	38,50	36	0,186	• • •	10		
	27012	**25**	**1 1/4“**	60,00	3,00	44,00	43,50	46	0,274	• • •	10		
	27013	**32**	**1 1/4“**	63,00	3,00	45,00	43,50	46	0,279	• • •	5		
	27014	**32**	**1 1/2“**	69,50	3,00	51,50	60,00	52	0,446	• • •	5		
	27015	**40**	**1 1/2“**	72,00	3,00	51,50	60,00	52	0,421	• • •	5		
	27016	**40**	**2“**	72,00	3,00	51,50	74,00	64	0,719	• • •	5		
	27017	**50**	**2“**	77,00	3,00	53,50	74,00	64	0,736	• • •	5		
	27018	**50**	**2 1/4“**	77,00	3,00	53,50	84,00	72	0,831	• • •	5		
	27019	**63**	**2 1/4“**	83,50	3,00	56,00	84,00	72	0,889	• • •	1		
	27020	**63**	**2 3/4“**	82,50	3,00	55,00	101,00	89	1,306	• • •	1		
	27021	**75**	**2 3/4“**	85,00	3,00	55,00	100,00	89	1,275	• • •	1		
	27022	**75**	**3 1/2“**	91,00	3,00	61,00	100,00	110	1,818	• • •	1		

COUNTERPART

with welding socket and male thread for ISO-standard adapter

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Standard: DIN 16962, DIN EN ISO 15874
Colour: green



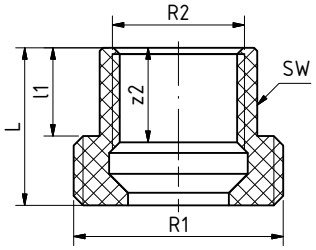


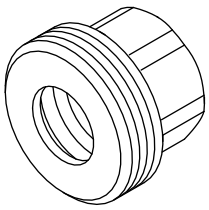
SDR	Art. no.	d	Thread R	L	z	D	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	**27310**	**20**	**1“**	61,50	47,00	38,50	24	0,151	• • •	10		
	27311	**25**	**1“**	63,00	47,00	38,50	24	0,153	• • •	10		
	27312	**25**	**1 1/4“**	63,00	47,00	43,50	31	0,221	• • •	10		
	27313	**32**	**1 1/4“**	66,00	48,00	43,50	31	0,226	• • •	5		
	27314	**32**	**1 1/2“**	76,50	58,50	60,00	39	0,408	• • •	5		
	27315	**40**	**1 1/2“**	79,00	58,50	60,00	39	0,414	• • •	5		
	27316	**40**	**2“**	81,00	60,50	74,00	50	0,650	• • •	5		
	27317	**50**	**2“**	84,00	60,50	74,00	50	0,634	• • •	5		
	27318	**50**	**2 1/4“**	83,00	59,50	84,00	55	0,750	• • •	5		
	27319	**63**	**2 1/4“**	89,50	62,00	84,00	55	0,728	• • •	1		
	27320	**63**	**2 3/4“**	94,00	66,50	101,00	67	1,093	• • •	1		
	27321	**75**	**2 3/4“**	95,00	65,00	100,00	67	1,117	• • •	1		
	27322	**75**	**3 1/2“**	100,00	70,00	100,00	67	1,436	• • •	1		

BRASS COUNTERPART

with female thread, for ISO-standard adapter / loose nut adapter

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: brass





SDR	Art. no.	Male thread R1	Female thread R2	L	l1	z2	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	**27510**	**1“**	**1/2“**	25,00	14,00	15,00	25	0,063	• • •	10		
	27512	**1 1/4“**	**3/4“**	26,00	12,50	14,00	32	0,119	• • •	10		
	27514	**1 1/2“**	**1“**	31,00	15,00	17,00	40	0,175	• • •	5		
	27516	**2“**	**1 1/4“**	33,00	17,00	22,00	47	0,263	• • •	5		
	27518	**2 1/4“**	**1 1/2“**	36,00	20,00	19,00	57	0,333	• • •	5		
	27520	**2 3/4“**	**2“**	42,00	24,00	24,00	68	0,517	• • •	1		
	27522	**3 1/2“**	**2 1/2“**	46,00	24,00	27,00	84	0,801	• • •	1		
	27524	**4“**	**3“**	46,00	27,00	27,00	97	0,943	• • •	1		

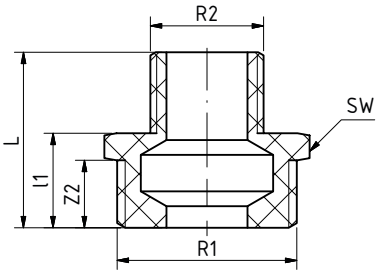
Notice: aquatherm green pipe-metal compound fittings are manufactured from fusiolen PP-R and brass. Metal inserts, without hex shaped spanner flat, with 1/2“ and 3/4“ f are also available in stainless steel.

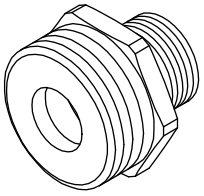
BRASS COUNTERPART

with male thread, for ISO-standard adapter / loose nut adapter

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

Material: brass





SDR	Art. no.	Thread R1	Thread R2	L	l1	Z2	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	**27710**	**1"**	**1/2"**	32,50	17,50	0,00	34	0,109	• • •	10		
	27712	**1 1/4"**	**3/4"**	38,50	21,00	0,00	42	0,188	• • •	10		
	27714	**1 1/2"**	**1"**	41,50	22,50	0,00	48	0,211	• • •	5		
	27716	**2"**	**1 1/4"**	44,50	22,50	0,00	60	0,363	• • •	5		
	27718	**2 1/4"**	**1 1/2"**	56,00	34,00	0,00	48	0,472	• • •	5		
	27720	**2 3/4"**	**2"**	63,00	38,00	0,00	62	0,803	• • •	1		
	27722	**3 1/2"**	**2 1/2"**	70,00	42,00	0,00	82	1,189	• • •	1		
	27724	**4"**	**3"**	74,00	42,00	0,00	97	1,398	• • •	1		

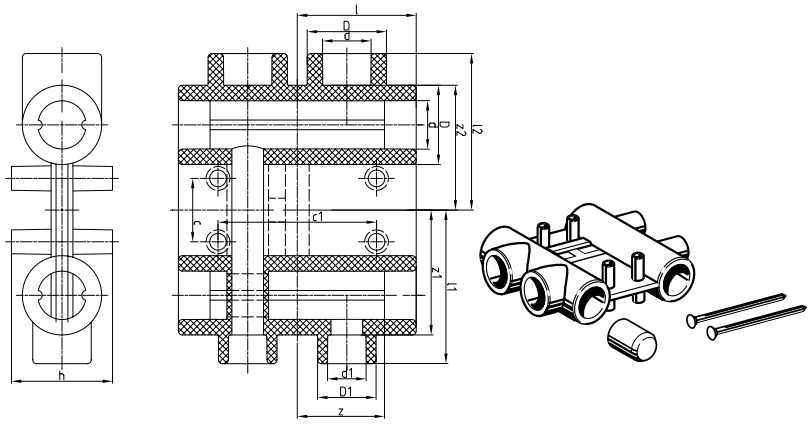
DISTRIBUTION BLOCK PLUMBING

including 1 plug and 2 fastenings

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

Material: Fusiolen® PP-R

Colour: green



SDR	Art. no.	d	l	z	D	d1	l1	z1	D1	l2	z2	c	c1	cl	l3	h	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7.4 11	**30115**	**25**	60	44	40	20	77,5	63	29,5	79	63	32	80	100	36	51	0,273	• • •	1		

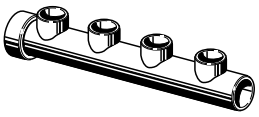
FOUR-PORT MANIFOLD

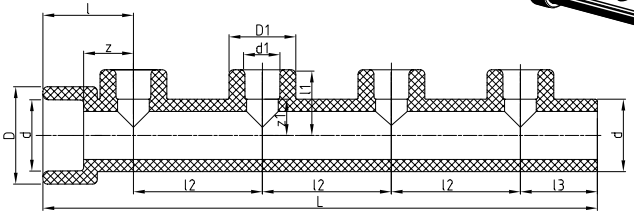
length: 246 mm, with 4 branches

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

Material: Fusiolen® PP-R

Colour: green





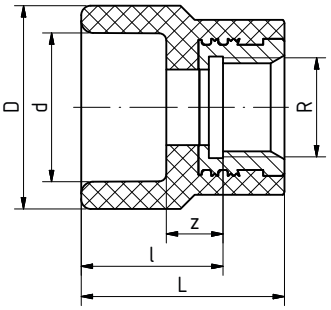
SDR	Art. no.	d	d1	l	z	D	l1	z1	D1	l2	l3	L	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7.4	**30602**	**32**	**16**	40	22	43	29	16	29,5	57	36	245	0,148	•	1		
9 11	**30604**	**32**	**20**	40	22	43	29	14,5	29,5	57	36	245	0,134	• • •	1		

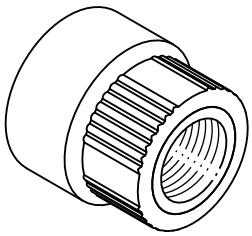
The four-port manifold can be shortened or extended by fusion with further four-port manifolds, if required.

MANIFOLD END PIECE WITH FEMALE THREAD*

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Standard: DIN 16962, DIN EN ISO 15874

Colour: green





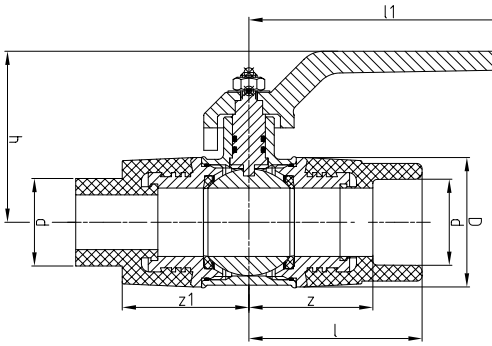
SDR	Art. no.	d	R	l	z	D	L	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7.4 9 11	**30804**	**32**	**1/2“**	30,00	12,00	43,00	43,00	0,073	• • •	1		

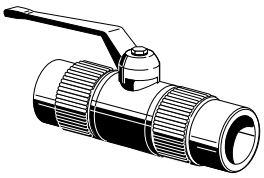
* transition piece as manifold endpiece with female thread

BALL VALVE FOR MANIFOLD

female/male

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Colour: green



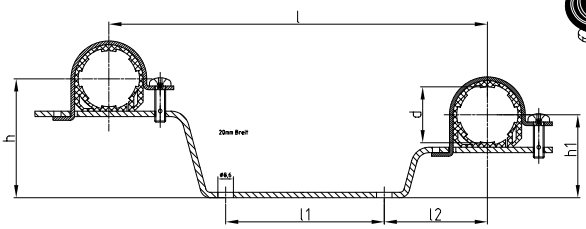


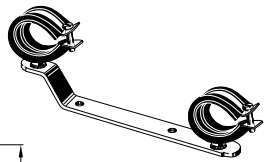
SDR	Art. no.	d	l	z	D	z1	h	l1	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7.4 9 11	**78000**	**32**	63,00	45,00	47,50	46,50	78,00	108,00	0,575	• • •	2		

SUPPORTING STRAP FOR FOUR-PORT MANIFOLD

with clamps, galvanized, double

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe



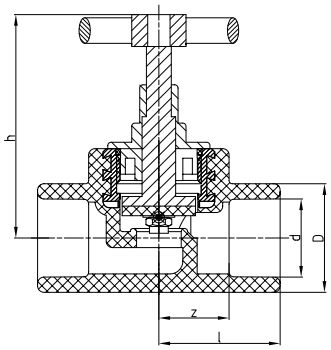


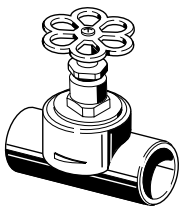
Art. no.	d	l	l1	l2	h	h1	Weight [kg]	System	PU	Box unit	Price € m/pc
60210	**32**	210,00	80,00	57,00	66,00	46,00	0,226	• • •	2		

GLOBE VALVE

for surface installation

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Colour: green



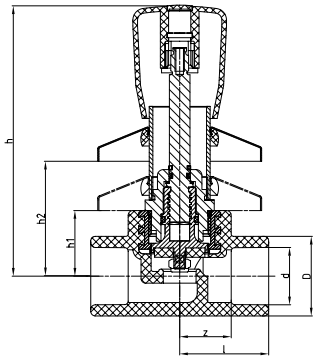


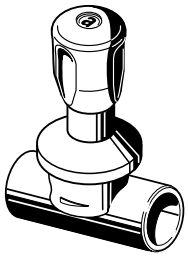
SDR	Art. no.	d	l	z	D	h	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7.4 9 11	**40808**	**20**	35,00	20,50	29,50	75,25	0,165	• • •	1	100	
	40810	**25**	38,00	22,00	34,00	75,00	0,172	• • •	1	100	
	40812	**32**	49,00	31,00	43,00	97,00	0,314	• • •	1	60	
	40814	**40**	60,00	39,50	52,00	111,50	0,585	• • •	1		

CONCEALED VALVE

chromium plated

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Colour: green



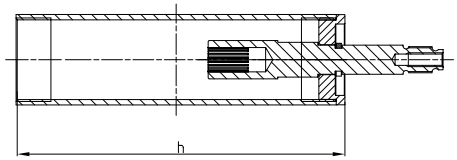


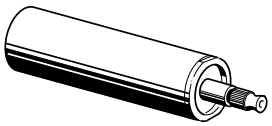
SDR	Art. no.	d	l	z	D	h	h1	h2	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7.4 9 11	**40858**	**20**	35,00	20,50	29,50	116,00	28,00	59,00	0,319	• • •	1		
	40860	**25**	38,00	22,00	34,00	116,00	28,00	59,00	0,330	• • •	1		
	40862	**32**	49,00	31,00	43,00	121,00	34,00	59,00	0,416	• • •	1		

EXTENSION FOR CONCEALED VALVE

chromium-plated for Art. no. 40858-40862

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: brass
Colour: chrom



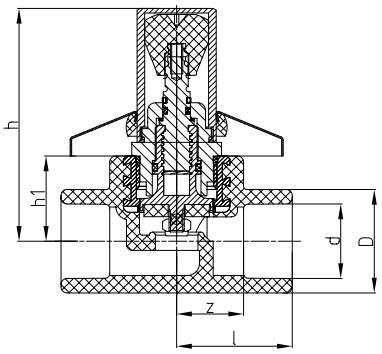


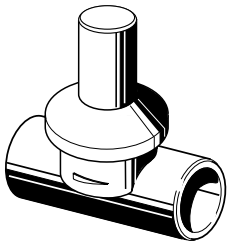
Art. no.	h	Weight [kg]	System	PU	Box unit	Price € m/pc
40900	92,00	0,148	• • •	1		
40902	132,00	0,209	• • •	1		

CONCEALED VALVE

tamper proof/ chromium-plated/ short design

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Colour: green, chrom



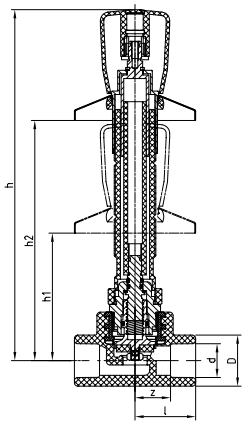


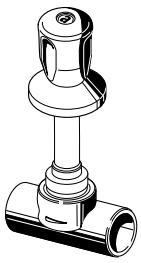
SDR	Art. no.	d	l	z	D	h	h1	Weight [kg]	System	PU	Box unit	Price € m/pc
6	**40868**	**20**	35,00	20,50	29,50	71,50	28,00	0,258	• • •	1	50	
7.4 9	**40870**	**25**	38,00	22,00	34,00	71,50	28,00	0,288	• • •	1		
11	**40872**	**32**	49,00	31,00	43,00	82,50	34,00	0,376	• • •	1		

CONCEALED VALVE

suitable for construction depth of 55 mm to 100 mm

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Colour: green, chrom



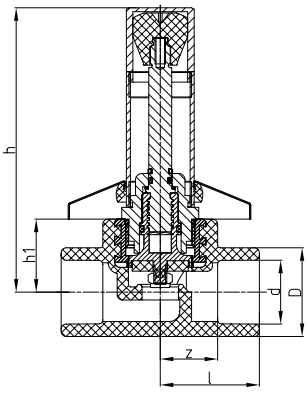


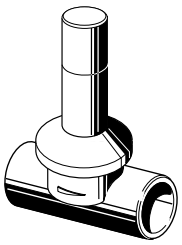
SDR	Art. no.	d	l	z	D	h	h1	h2	Weight [kg]	System	PU	Box unit	Price € m/pc
6	**40878**	**20**	35,00	20,50	29,50	213,00	59,00	147,00	0,357	• • •	1		
7.4 9	**40880**	**25**	38,00	22,00	34,00	213,00	59,00	147,00	0,369	• • •	1		
11	**40882**	**32**	49,00	31,00	43,00	219,00	65,00	153,00	0,455	• • •	1		

CONCEALED VALVE

tamper proof, chromium-plated

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Colour: green, chrom

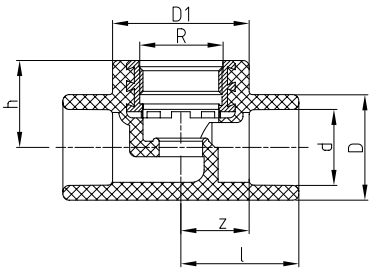


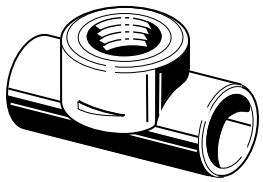


SDR	Art. no.	d	l	z	D	h	h1	Weight [kg]	System	PU	Box unit	Price € m/pc
6	**40888**	**20**	35,00	20,50	29,50	109,00	28,00	0,342	• • •	1		
7.4 9	**40890**	**25**	38,00	22,00	34,00	109,00	28,00	0,350	• • •	1		
11	**40892**	**32**	49,00	31,00	43,00	115,00	34,00	0,432	• • •	1		

STOP VALVE BODY

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Colour: green



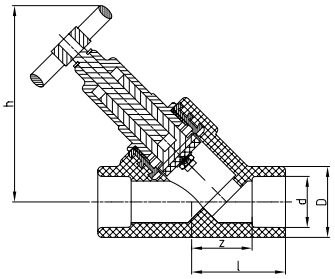


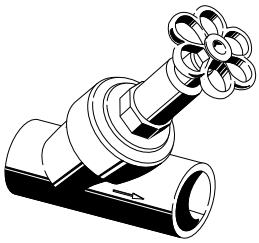
SDR	Art. no.	d	R	l	z	D	h	D1	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7.4 9 11	**40908**	**20**	**3/4"**	35,00	20,00	29,50	28,00	44,00	0,093	• • •	1		
	40910	**25**	**3/4"**	38,00	22,00	34,00	28,00	44,00	0,101	• • •	1		
	40912	**32**	**1"**	49,00	31,00	43,00	34,00	52,00	0,146	• • •	1		
	40914	**40**	**1 1/4"**	60,00	39,50	52,00	41,00	69,00	0,313	• • •	1		

INCLINED VALVE

without drain

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Colour: green



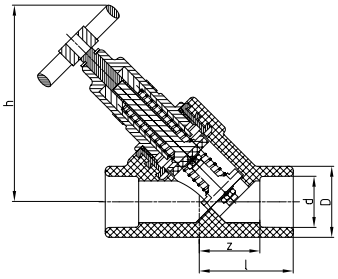


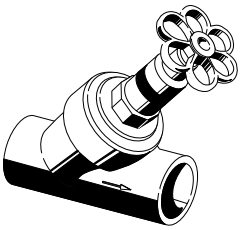
SDR	Art. no.	d	l	z	D	h	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7.4 9 11	**41108**	**20**	45,00	30,50	34,00	95,50	0,294	• • •	1		
	41110	**25**	45,00	29,00	34,00	95,50	0,283	• • •	1		
	41112	**32**	56,00	38,00	43,00	111,50	0,421	• • •	1		
	41114	**40**	65,00	44,50	52,00	135,00	0,834	• • •	1		

NON-RETURN VALVE

without drain

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Colour: green

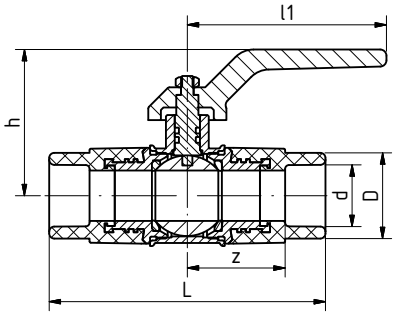


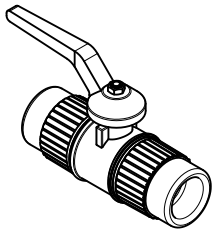


SDR	Art. no.	d	l	z	D	h	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7.4 9 11	**41208**	**20**	45,00	30,50	34,00	95,50	0,297	• • •	1		
	41210	**25**	45,00	29,00	34,00	95,50	0,292	• • •	1		
	41212	**32**	56,00	38,00	43,00	111,50	0,432	• • •	1		
	41214	**40**	65,00	44,50	52,00	135,00	0,840	• • •	1		

BALL VALVE PP/BRASS

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R, brass
Colour: green



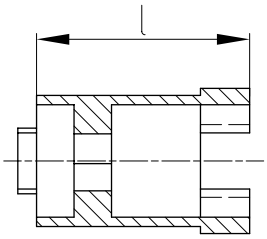


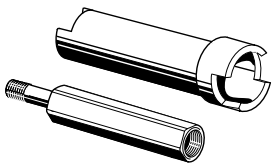
SDR	Art. no.	d	L	z	D	h	l1	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	**41308**	**20**	110,00	40,50	29,50	56,00	79,00	0,280	• • •	1		
	41310	**25**	110,00	39,00	34,00	58,00	79,00	0,375	• • •	1		
	41312	**32**	127,00	45,50	43,00	66,00	103,00	0,592	• • •	1		
	41314	**40**	145,00	52,00	52,00	71,00	104,00	1,015	• • •	1		
	41316	**50**	167,00	60,00	68,00	79,00	140,00	1,689	• • •	1		
	41318	**63**	205,00	75,00	84,00	88,00	140,00	2,874	• • •	1		

EXTENSION FOR AQUATHERM GREEN PIPE-BALL VALVE

chromium-plated for Art. no. 41308-41318

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: brass
Colour: chrom



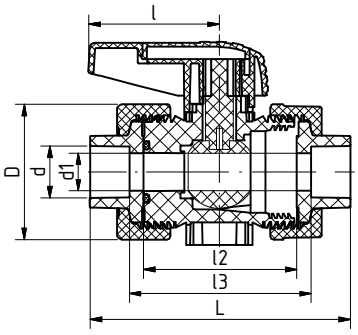


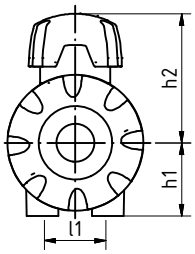
Art. no.	l	for Art-.No.	Weight [kg]	System	PU	Box unit	Price € m/pc
41378	35,00	41308-41310	0,120	• • •	1		
41382	35,00	41312-41314	0,120	• • •	1		
41386	46,00	41316-41318	0,273	• • •	1		

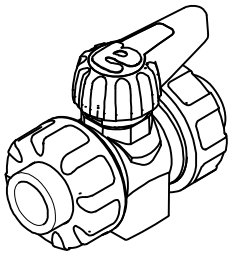
PP-BALL VALVE

with union nut and welding socket

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R
Colour: green



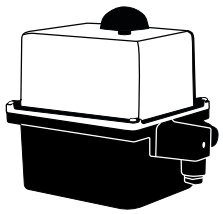




SDR	Art. no.	d	d1	D	h1	h2	l1	l2	l3	L	l	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	**41488**	**20**	13,50	50,30	27,00	48,00	25,00	56,50	68,00	97,00	48,00	0,118	• • •	1		
	41490	**25**	18,50	59,00	30,00	56,50	25,00	65,50	78,00	110,00	59,00	0,184	• • •	1		
	41492	**32**	23,90	70,30	40,00	64,50	26,00	72,00	84,50	120,50	59,00	0,274	• • •	1		
	41494	**40**	31,00	85,90	46,00	83,30	45,00	85,00	100,00	141,00	63,50	0,483	• • •	1		
	41496	**50**	38,50	99,50	55,00	89,40	45,00	89,00	107,00	154,00	63,50	0,648	• • •	1		
	41498	**63**	50,00	125,50	70,00	115,00	45,00	101,00	118,00	173,00	108,00	1,206	• • •	1		

NEW ELECTRICAL DRIVE FOR BALL VALVE

incl. fixtures
For Art. no. 41488-41498



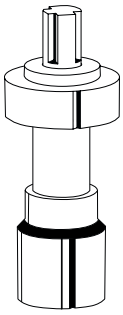
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

Art. no.	Dimension	for Art. no.	Weight [kg]	System	PU	Box unit	Price € m/pc
			230 Volt				
41489	**20**	incl. fixtures for 41488	1,500	• • •	1		
41491	**25**	incl. fixtures for 41490	1,600	• • •	1		
41493	**32**	incl. fixtures for 41492	1,600	• • •	1		
41495	**40**	incl. fixtures for 41494	1,600	• • •	1		
41497	**50**	incl. fixtures for 41496	1,700	• • •	1		
41499	**63**	incl. fixtures for 41498	1,700	• • •	1		
			24 Volt				
41589	**20**	incl. fixtures for 41488	1,500	• • •	1		
41591	**25**	incl. fixtures for 41490	1,600	• • •	1		
41593	**32**	incl. fixtures for 41492	1,600	• • •	1		
41595	**40**	incl. fixtures for 41494	1,600	• • •	1		
41597	**50**	incl. fixtures for 41496	1,700	• • •	1		
41599	**63**	incl. fixtures for 41498	1,700	• • •	1		

Delivery time: on request

NEW EXTENSION FOR BALL VALVE

For Art. no. 41488-41498



Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: PVC
Colour: grey

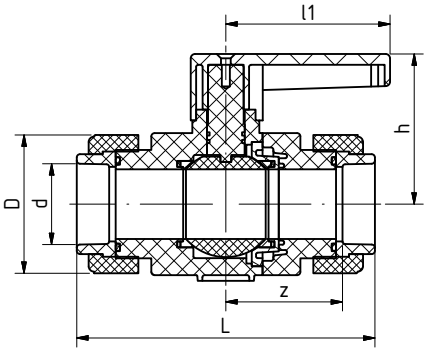
Art. no.	l	for Art. no.	Weight [kg]	System	PU	Box unit	Price € m/pc
98900	100	41488	0,020	• • •	1		
98901	100	41490/41492	0,025	• • •	1		
98902	100	41494/41496	0,030	• • •	1		
98903	100	41498	0,040	• • •	1		

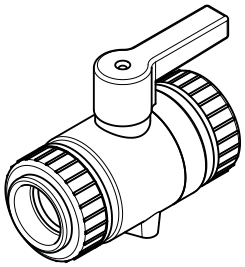
Delivery time: on request

PP-BALL VALVE

with union nut and welding socket

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe
Material: Fusiolen® PP-R
Colour: green





SDR	Art. no.	d	L	z	D	h	l1	Inch R	DN	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7.4 9 11	**41400**	**75**	276,00	108,00	129,00	139,00	152,00	0,00	65	2,441	• • •	1		

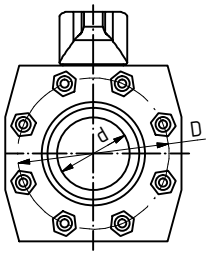
PP-BALL VALVE

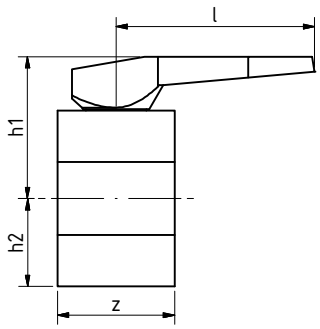
with flange connection on both sides

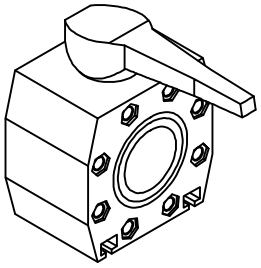
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

Material: Fusiolen® PP-R

Colour: green







SDR	Art. no.	for ø	d	l	z	D	h1	h2	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7.4 9 11	**41602**	**90**	77,00	210,00	124,00	160,00	150,00	93,00	4,196	• • •	1		
	41604	**110**	94,00	260,00	145,00	180,00	165,00	103,00	5,612	• • •	1		
	41607	**160**	135,00	310,00	205,00	240,00	210,00	136,50	13,420	• • •	1		

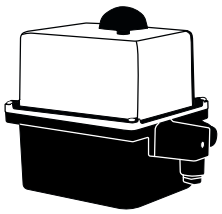
For dimension 125 mm the PP-ball valve Art. no. 41604 with flange adapter Art. no. 15526 and flange Art. no. 15724 is used.
For connection with aquatherm green pipe-weldable flange adapter (Art. no. 15520-15531) and aquatherm green pipe plastic coated steel flange (Art. no. 15720-15730)

Hexagon screw M 16x60 mm for Art. no. 41602/41604
Hexagon screw M 20x80 mm for Art. no. 41607
corresponding flat washer M 16

NOTICE: These are not included in delivery.

NEW ELECTRICAL DRIVE FOR BALL VALVE

incl. fixtures
For Art. no. 41602-41607



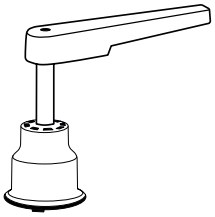
Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

Art. no.	Dimension	for Art. no.	Weight [kg]	System	PU	Box unit	Price € m/pc
			230 Volt				
41603	**90**	incl. fixtures for 41602	3,300	• • •	1		
41605	**110**	incl. fixtures for 41604	3,400	• • •	1		
41608	**160**	incl. fixtures for 41607	3,700	• • •	1		
			24 Volt				
41703	**90**	incl. fixtures for 41602	3,300	• • •	1		
41705	**110**	incl. fixtures for 41604	3,400	• • •	1		
41708	**160**	incl. fixtures for 41607	3,700	• • •	1		

Delivery time: on request

NEW EXTENSION FOR BALL VALVE

For Art. no. 41602-41607



Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

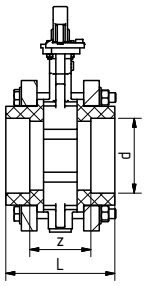
Art. no.	l	for Art. no.	Weight [kg]	System	PU	Box unit	Price € m/pc
98904	150	41602	0,788	• • •	1		
98905	150	41604	1,120	• • •	1		
98906	150	41607	1,391	• • •	1		

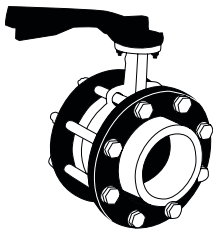
Delivery time: on request

NEW aquatherm blue pipe SHUT-OFF VALVE WITH LEVER

Set consists of: 2 x flange adapter, 2 x flanges, fixing screws

Systems: aquatherm blue pipe
Material: Fusiolen® PP-R, Steel



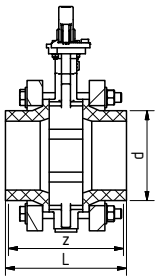


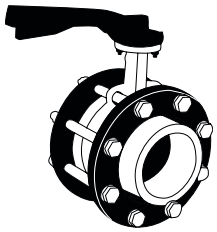
SDR	Art. no.	d	z	L	Weight [kg]	System	PU	Box unit	Price € m/pc
					socket welding				
6 7,4 9 11 17,6	**2041820**	**75**	**78**	**138**	6,600	•	1		
	2041822	**90**	**80**	**146**	9,000	•	1		
	2041824	**110**	**89**	**163**	10,400	•	1		
	2041826	**125**	**104**	**184**	15,000	•	1		

NEW aquatherm blue pipe SHUT-OFF VALVE WITH LEVER

Set consists of: 2 x flange adapter, 2 x flanges, fixing screws

Systems: aquatherm blue pipe
Material: Fusiolen® PP-R, Steel



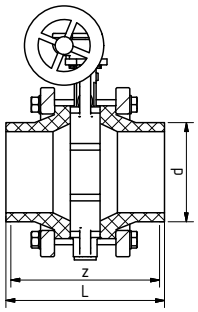


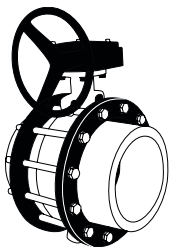
SDR	Art. no.	d	z	L	Weight [kg]	System	PU	Box unit	Price € m/pc
					Butt welding				
11	**2041830**	**160**	**227**	**242**	22,000	•	1		
17,6	**2541830**	**160**	**227**	**242**	21,700	•	1		

NEW aquatherm blue pipe SHUT-OFF VALVE WITH DRIVE

Set consists of: 2 x flange adapter, 2 x flanges, fixing screws

Systems: aquatherm blue pipe
Material: Fusiolen® PP-R, Steel





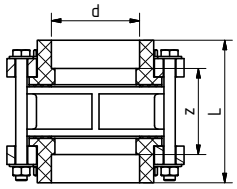
SDR	Art. no.	d	z	L	Weight [kg]	System	PU	Box unit	Price € m/pc
11	**2041834**	**200**	**305**	**320**	41,400	•	1		
	2041838	**250**	**313**	**328**	59,200	•	1		
	2041842	**315**	**398**	**418**	81,800	•	1		
17,6	**2541834**	**200**	**305**	**320**	40,900	•	1		
	2541838	**250**	**313**	**328**	58,400	•	1		
	2541842	**315**	**398**	**418**	78,600	•	1		

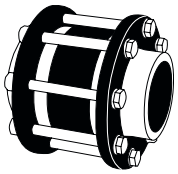
NEW aquatherm blue pipe NON-RETURN VALVE

Set consists of: 2 x flange adapter + seal, 2 x flanges, fixing screws

Systems: aquatherm blue pipe

Material: Fusiolen® PP-R, Steel





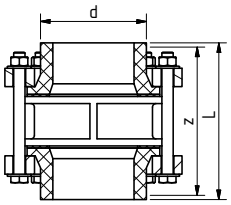
SDR	Art. no.	d	z	L	Weight [kg]	System	PU	Box unit	Price € m/pc
					socket welding				
6 7,4 9 11 17,6	**2041920**	**75**	**92**	**152**	6,200	•	1		
	2041922	**90**	**97**	**163**	8,800	•	1		
	2041924	**110**	**107**	**181**	11,000	•	1		
	2041926	**125**	**124**	**204**	15,600	•	1		

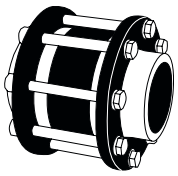
NEW aquatherm blue pipe NON-RETURN VALVE

Set consists of: 2 x flange adapter + seal, 2 x flanges, fixing screws

Systems: aquatherm blue pipe

Material: Fusiolen® PP-R, Steel





SDR	Art. no.	d	z	L	Weight [kg]	System	PU	Box unit	Price € m/pc
					Butt welding				
11	**2041930**	**160**	**253**	**268**	24,200	•	1		
	2041934	**200**	**352**	**367**	37,000	•	1		
	2041938	**250**	**365**	**380**	58,600	•	1		
	2041942	**315**	**476**	**496**	83,400	•	1		
17,6	**2541930**	**160**	**253**	**268**	23,900	•	1		
	2541934	**200**	**352**	**367**	36,500	•	1		
	2541938	**250**	**365**	**380**	57,800	•	1		
	2541942	**315**	**476**	**496**	80,200	•	1		

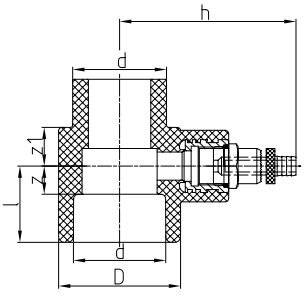
DRAINING BRANCH

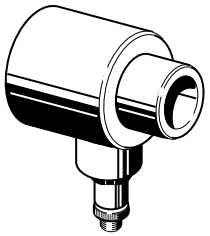
to weld in aquatherm green pipe valves

Systems: aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe

Material: Fusiolen® PP-R, brass

Colour: green

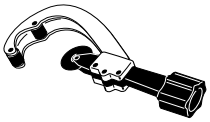


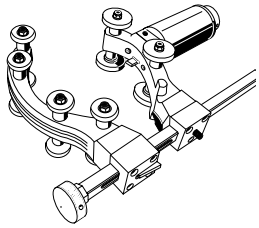


SDR	Art. no.	d	z	l	D	z1	h	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7.4 9 11	**41408**	**20**	11,50	26,00	34,00	16,50	67,00	0,098	• • •	1		
	41410	**25**	10,00	26,00	34,00	16,50	67,00	0,096	• • •	1		
	41412	**32**	14,00	32,00	43,00	17,00	70,50	0,118	• • •	1		
	41414	**40**	12,00	32,50	52,00	16,50	76,50	0,140	• • •	1		
	41416	**50**	15,50	39,00	68,00	17,00	83,75	0,202	• • •	1		
	41418	**63**	16,50	44,00	84,00	16,50	93,00	0,288	• • •	1		

Important: Do not cut the aquatherm-pipes with customary hack saws.
aquatherm-pipes can be cut with customary saws equipped with saw blades suitable for plastic.

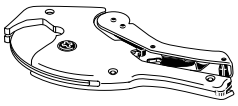
PIPE CUTTER





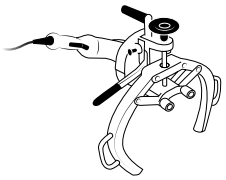
Art. no.	for pipe dimensions	PU	Box unit	Price € m/pc
50102	16-40mm	1		
50105	50-125mm	1		
50106	110-200mm	1		

PIPE CUTTER



Art. no.	for pipe dimensions	PU	Box unit	Price € m/pc
50104	16-40mm	1		

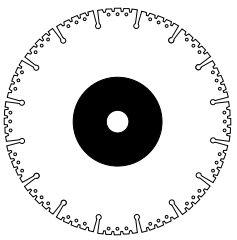
ORBITAL CIRCULAR SAW



Art. no.	for pipe dimensions	PU	Box unit	Price € m/pc
50108	160-355mm	1		

This orbital circular saw can be ordered directly from Rothenberger with Art. no. 55620 (www.rothenberger.com).
High-performance orbital circular saw for fast, precise, perfectly aligned and right-angled cutting of plastic pipes 160 - 355 mm at the building site or in the workshop.

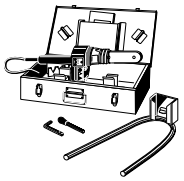
CUTTING DISC FOR PLASTIC



Art. no.	Dimension	borehole	PU	Box unit	Price € m/pc
50107	ø 125mm	22,2 mm	1		
50109	ø 230mm	22,2 mm	1		

Application: for each angle grinder
Design: diamant galvanized cutting disc

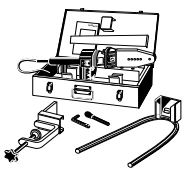
MANUAL WELDING DEVICE (500 W)



Art. no.	for pipe dimensions	PU	Box unit	Price € m/pc
50336	ø 16-32mm	1		

for one tool, with base and case for tools
Also available: 110 V (Art. no. 450336)

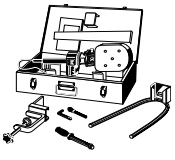
MANUAL WELDING DEVICE (800 W)



Art. no.	for pipe dimensions	PU	Box unit	Price € m/pc
50337	ø 16-63mm	1		

Also available: 110 V (Art. no. 450337)

MANUAL WELDING DEVICE (1400 W)



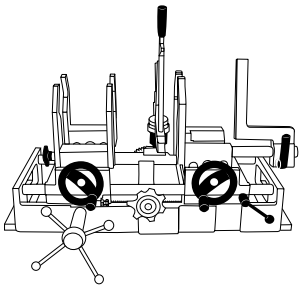
Art. no.	for pipe dimensions	PU	Box unit	Price € m/pc
50341	ø 50-125mm	1		

Also available: 110 V (Art. no. 450341)

WELDING MACHINE (1400 W)

Art. no.	for pipe dimensions	PU	Box unit	Price € m/pc
50148	ø 50-125 mm - 230 V	1		

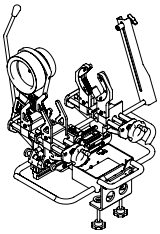
including welding tools 50-125 mm, roll stand and wooden transport case
Also available: 110 V (Art. no. 450148)



WELDING MACHINE (1400 W) LIGHT

Art. no.	for pipe dimensions	PU	Box unit	Price € m/pc
50145	ø 63-125mm	1		

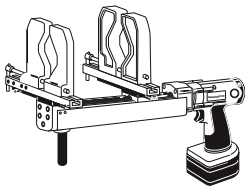
including manual welding device (1400 W) and wooden transport case
Also available: 110 V (Art. no. 450145)



ELECTRIC WELDING JIG

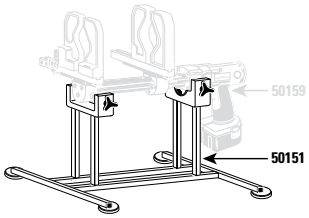
Art. no.	for pipe dimensions	PU	Box unit	Price € m/pc
50159	ø 63-125mm	1		

including standby accumulator, charging station and metal case
Also available: 110 V (Art. no. 450159)



BASE FOR ART. NO. 50159

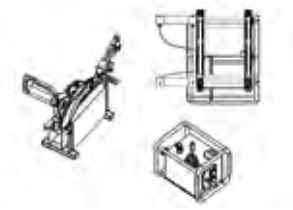
Art. no.	Dimension	PU	Box unit	Price € m/pc
50151		1		



BUTT-WELDING MACHINE-TWO-RING-MACHINE WIDOS

Art. no..	Dimension	PU	Box unit	Price € m/pc
50350*	ø 160 - 250 mm	1		
50351*	ø 160 - 315 mm	1		

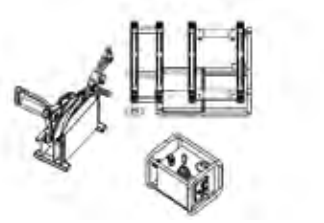
The butt-welding-two-ring machine can be purchased directly from Widos (www.widos.de)
* Also available in design with 110 volt (Art. no.. **4**50350 = ø 160-250mm / **4**50351 = ø 160-315mm)



BUTT WELDING MACHINE WIDOS

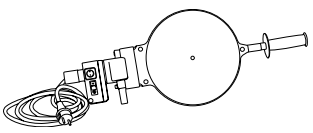
Art. no..	Dimension	PU	Box unit	Price € m/pc
50352*	ø 160-250mm	1		
50353*	ø 160-315mm	1		
50354*	ø 160-355mm	1		
50355*	ø 200-450mm	1		
50356**	ø 200-500mm	1		
50357**	ø 315-630mm	1		

The butt-welding-machine can be purchased directly from Widos (www.widos.de)
* Also available in design with 110 volt (Art. no. **4**50352 = ø 160-250 mm / **4**50353 = ø 160-315 mm / **4**50354 = ø 160-355 mm / **4**50355 = ø 200-450 mm)
** special voltage on demand



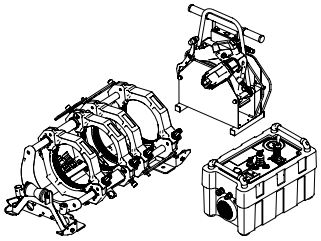
MANUAL WELDING DEVICE (1500 W) FOR SADDLE WELDING Ø 50-160 MM

Art. no.	for pipe dimensions	PU	Box unit	Price € m/pc
50330	ø 50-160mm	1		



BUTT WELDING MACHINE RITMO

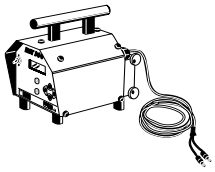
Art. no.	for pipe dimensions	PU	Box unit	Price € m/pc
50165*	ø 160-250mm	1		
50166*	ø 160-315mm	1		
50177	ø 160-355mm	1		
50169	ø 400-630mm	1		



including wooden transport box. The butt welding machine can be obtained directly from Ritmo (www.ritmo.it)
* Also available: 110 V (Art. no. 450165 for ø 160-250 mm / Art. no. 450166 for ø 160-315 mm)

ELECTROFUSION DEVICE

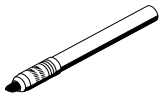
Art. no.	for pipe dimensions	PU	Box unit	Price € m/pc
50175	ø 20-250mm	1		



For processing with electro-fusion-sockets Art. no. 17208-17238.
Special calibration-tools - optainable on request - are required

TEMPERATURE PENCIL

Art. no.	Dimension	PU	Box unit	Price € m/pc
50190		1		



to check the correct welding temperature

SURFACE THERMOMETER

Art. no.	Dimension	PU	Box unit	Price € m/pc
50188		1		

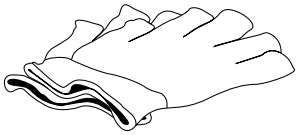


to check the correct welding temperature

TEMPERATURE PREDECTIVE GLOVE

for tool change

Art. no.	Dimension	PU	Box unit	Price € m/pc
50195		2		



CLEANING WIPES

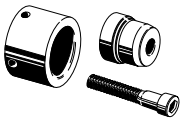
Art. no.	Dimension	PU	Box unit	Price € m/pc
50193	Box/100 towels	1		



for electrofusion sockets

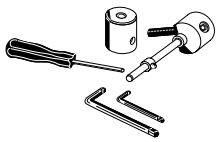
WELDING TOOLS

Art. no.	Dimension	PU	Box unit	Price € m/pc
50206	16 mm	1		
50208	20 mm	1		
50210	25 mm	1		
50212	32 mm	1		
50214	40 mm	1		
50216	50 mm	1		
50218	63 mm	1		
50220	75 mm	1		
50222	90 mm	1		
50224	110 mm	1		
50226	125 mm	1		



REPAIR SET

Art. no.	Dimension	PU	Box unit	Price € m/pc
50307	7mm	1		
50311	11mm	1		



to close holes of up to 10 mm in the pipe (pipe repair stick Art. no. 60600)

PIPE REPAIR STICK

for pipe repairs

Art. no.	Dimension	PU	Box unit	Price € m/pc
60600	7/11mm	10		



aquatherm UNIVERSAL PEELING TOOLS

for aquatherm green pipe MF UV, aquatherm green pipe MF RP UV, aquatherm blue pipe MF UV and aquatherm blue pipe MF OT



Required for the socket welding
(in combination with socket welding fittings from page 114 onwards,
e.g. sockets, elbows , T-pieces, transition pieces with thread)

Also suitable for manual peeling (bolts included)

Art. no.	Dimension	PU	Box unit	Price € m/pc
50479	20 mm	1		
50480	25 mm	1		
50481	32 mm	1		
50482	40 mm	1		
50483	50 mm	1		
50484	63 mm	1		
50485	75mm	1		
50486	90 mm	1		
50487	110 mm	1		
50488	125 mm	1		
50501	Spare blade with screw	1		



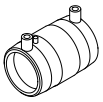
incl. bolts
for manual peeling

not suitable for aquatherm green pipe S, aquatherm blue pipe S, aquatherm green pipe MF, aquatherm blue pipe MF, aquatherm green pipe MF RP, aquatherm green pipe TI, aquatherm blue pipe TI

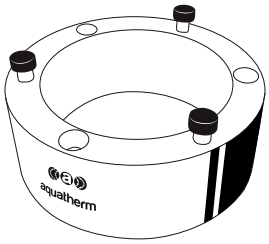
S = single, **MF** = multilayer fibre, **OT** = oxygen tight, **UV** = ultraviolet protected, **TI** = thermal insulation, **RP** = raised pressure

aquatherm EXTENSION FOR UNIVERSAL PEELING TOOL

Required for the electrofusion socket welding
(aquatherm electrofusion sockets on page 140)



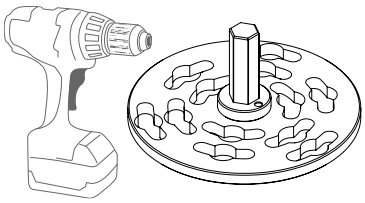
When electrofusion welding a longer welding depth is required, which is achieved by the combination of the universal peeling tool and the extension for the universal peeling tool (e.g. Art. no. 50479+50489)



Art. no.	Dimension	PU	Box unit	Price € m/pc
50489	for peeling tool 20 mm Art. no. 50479	1		
50490	for peeling tool 25 mm Art. no. 50480	1		
50491	for peeling tool 32 mm Art. no. 50481	1		
50492	for peeling tool 40 mm Art. no. 50482	1		
50493	for peeling tool 50 mm Art. no. 50483	1		
50494	for peeling tool 63 mm Art. no. 50484	1		
50495	for peeling tool 75 mm Art. no. 50485	1		
50496	for peeling tool 90 mm Art. no. 50486	1		
50497	for peeling tool 110 mm Art. no. 50487	1		
50498	for peeling tool 125 mm Art. no. 50488	1		

ATTACHMENT PLATE FOR UNIVERSAL PEELING TOOL

In combination with or without extension for universal peeling tools for drilling machine



Art. no.	Dimension	PU	Box unit	Price € m/pc
50499	for universal peeling tool 50479 – 50484	1		
50500	for universal peeling tool 50485 – 50488	1		

Delivery without drilling machine!

UNIVERSAL PEELING TOOL-SET

20-63 mm



Art. no..	Dimension	PU	Box unit	Price € m/pc
50477	for ø 20-63 mm	1		

consisting of:

1x case
Each 1x 50479-50484 peeling tool 20-63 mm
1x 50499 attachment plate for universal peeling tool 50479-50484
1x 50503 1 toggle-set
1x 50504 torx wrench
1x 50505 hexagon Allen key size 4
6x 99793 6 fixing screws for Art. no. 50489-50494 M5x25

UNIVERSAL PEELING TOOL-SET

75-125 mm



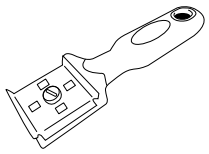
Art. no..	Dimension	PU	Box unit	Price € m/pc
50478	for ø 75 - 125 mm	1		

consisting of:

1 x case
Each 1x 50485-50488 peeling tool 75-125 mm
1x 50500 attachment plate for universal peeling tool 50485-50488
1x 50503 1 toggle-set
1x 50504 torx wrench
1x 50505 hexagon Allen key size 4
6x 99794 6 fixing screws for Art. no. 50495-50498 M5x35

MANUAL SCRAPER FOR aquatherm blue pipe OT PIPES

Art. no..	Dimension	PU	Box unit	Price € m/pc
50509	with 4-fold blade, 35 mm wide	1		



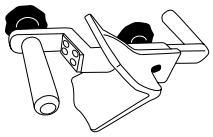
For removal of OT-coat before butt-welding.
In addition the manual scraper can be used for removal of oxid coating for the E-socket welding.

SPARE BLADE SET FOR ART. NO. 50509

Art. no..	Dimension	PU	Box unit	Price € m/pc
99909	2 pieces = 1 set	1		

CHAMFERING TOOL FOR aquatherm blue pipe OT PIPES

Art. no..	Dimension	PU	Box unit	Price € m/pc
50510	32-250mm	1		



For removal of oxid coating before butt-welding.

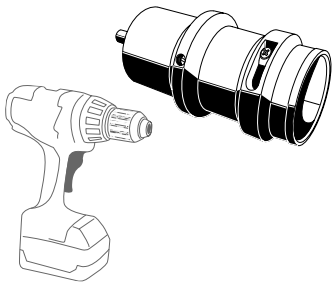
aquatherm PEELING TOOLS FOR ELECTROFUSION SOCKET WELDING (ART. NO.17208-17238)

for aquatherm green pipe S, aquatherm green pipe MF, aquatherm green pipe MF RP, aquatherm green pipe MF TI, aquatherm blue pipe S, aquatherm blue pipe MF and aquatherm blue pipe MF TI

Required to remove the **oxid coating**
(aquatherm electrofusion sockets on page 140)

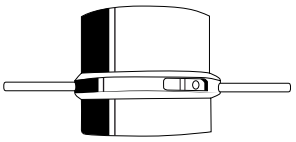


Art. no.	Dimension	PU	Box unit	Price € m/pc
	In combination with a drilling machine			
50558	20 mm	1		
50560	25 mm	1		
50562	32 mm	1		
50564	40 mm	1		
50566	50 mm	1		
50568	63 mm	1		
50570	75 mm	1		
50572	90 mm	1		
50440	spare blade	1		
	For manual peeling			
50574	110 mm	1		
50576	125 mm	1		
50580	160 mm	1		
50441	spare blade	1		
	For manual peeling			
50592	200 + 250 mm	1		
99739	spare blade	1		

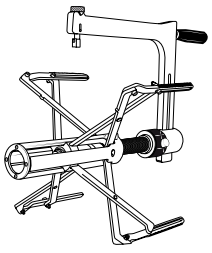


Art. no. 50558-50572

In combination with a drilling machine (not included!)



Art. no. 50574-50580



Art. no. 50592

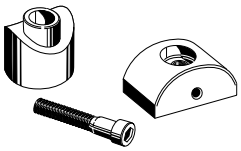
Not suitable for aquatherm green pipe UV, aquatherm blue pipe UV and aquatherm blue pipe OT.

S = single, **MF** = multilayer fibre, **OT** = oxygen tight, **UV** = ultraviolet protected, **TI** = thermal insulation, **RP** = raised pressure

Spare parts such as blades can be requested under service@aquatherm.de!

SADDLE WELDING TOOLS

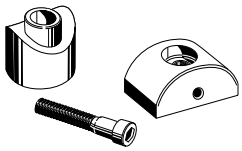
for welding saddles



Art. no.	Dimension	PU	Box unit	Price € m/pc
50614	40x20/25mm	1		
50616	50x20/25mm	1		
50619	63x20/25mm	1		
50620	63x32mm	1		
50623	75x20/25mm	1		
50624	75x32mm	1		
50625	75x40mm	1		
50627	90x20/25mm	1		
50628	90x32mm	1		
50629	90x40mm	1		
50631	110x20/25mm	1		
50632	110x32mm	1		
50634	110x40mm	1		
50635	110x50mm	1		
50636	125x20/25mm	1		
50638	125x32mm	1		
50640	125x40mm	1		
50642	125x50mm	1		
50644	125x63mm	1		
50648	160x20/25mm	1		
50650	160x32mm	1		
50652	160x40mm	1		
50654	160x50mm	1		
50656	160x63mm	1		
50657	160x75mm	1		
50658	160x90mm	1		
50660	200x20/25mm	1		
50662	200x32mm	1		
50664	200x40mm	1		
50666	200x50mm	1		
50667	200x75mm	1		
50668	200x63mm	1		
50669	200x90mm	1		
50670	200x110mm	1		
50671	200x125mm	1		
50672	250x20/25mm	1		
50674	250x32mm	1		
50676	250x40mm	1		
50678	250x50mm	1		
50680	250x63mm	1		
50682	250x75mm	1		

SADDLE WELDING TOOLS

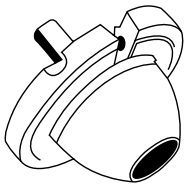
for welding saddles



Art. no.	Dimension	PU	Box unit	Price € m/pc
50684	250x90mm	1		
50686	250x110mm	1		
50688	250x125mm	1		
50690	315x63mm	1		
50692	315x75mm	1		
50694	315x90mm	1		
50696	315x110mm	1		
50698	315x125mm	1		
50699	315x160mm	1		
50712	355x63mm	1		
50714	355x75mm	1		
50716	355x90mm	1		
50718	355x110mm	1		
50720	355x125mm	1		
50722	355x160mm	1		
50726	400-630x63mm	1		
50728	400-500x75mm	1		
50730	560-630x75mm	1		
50732	400-500x90mm	1		
50734	560-630x90mm	1		
50736	400-450x110mm	1		
50738	500-560x110mm	1		
50740	630x110mm	1		
50742	400x125mm	1		
50744	450-500x125mm	1		
50746	560-630x125mm	1		

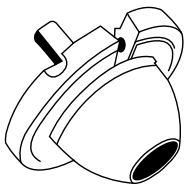
SADDLE PEELING TOOLS FOR OT AND UV PIPES Ø 50-125 mm

Art. no.	Dimension	PU	Box unit	Price € m/pc
50921	for welding saddles 20 & 25 mm	1		
50922	for ø 32 mm	1		
50924	for ø 40 mm	1		
50926	for ø 50 mm	1		
50928	for ø 63 mm	1		



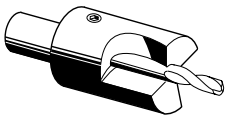
SADDLE PEELING TOOLS FOR OT AND UV PIPES Ø 160-250 mm

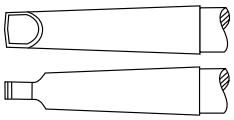
Art. no.	Dimension	PU	Box unit	Price € m/pc
50421	for welding saddles ø 20 & 25 mm	1		
50422	for welding saddles ø 32 mm	1		
50424	for welding saddles ø 40 mm	1		
50426	for welding saddles ø 50 mm	1		
50428	for welding saddles ø 63 mm	1		



DRILLS *for installation of weld-in saddles*

Art. no.	Dimension	PU	Box unit	Price € m/pc
50940	20&25mm (40-160mm)	1		
50941	20&25mm (63-250mm)	1		
50942	32mm	1		
50944	40mm	1		
50946*	50mm	1		
50948*	63mm	1		
50950*/**	75mm	1		
50952*/**	90mm	1		
50954*/**	110mm	1		
50956*/**	125mm	1		
50958*/**	160mm	1		



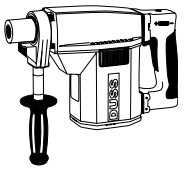


** may only be used in fixed drilling machines! ** tool holder MK4*

Please note: *Art.- No. 50950-50958* are discontinued articles who are no longer available after sale of stocks.

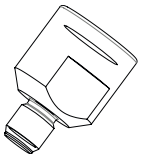
DRILL DUSS DIA303

Art. no.	Dimension	PU	Box unit	Price € m/pc
50978		1		



CHUCK ADAPTER FOR ART.- NR. 50971

Art. no.	Dimension	PU	Box unit	Price € m/pc
50969		1		

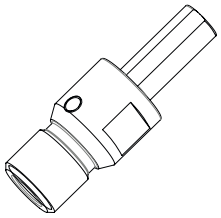


KEYLESS CHUCK clamping range 1,5-13mm

Art. no.	Dimension	PU	Box unit	Price € m/pc
50971		1		

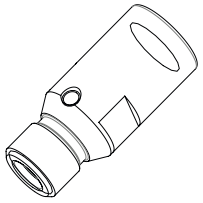


HOLE SAW HOLDER LSA3



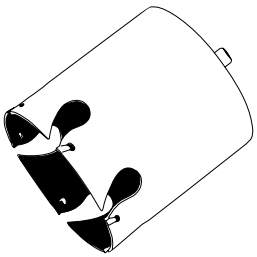
Art. no.	Dimension	PU	Box unit	Price € m/pc
50976	1/2“ for drill chuck	1		

HOLE SAW HOLDER LSA2



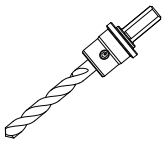
Art. no.	Dimension	PU	Box unit	Price € m/pc
50974	1/2“ for DUSS-machines	1		

SADDLE-HOLE SAW FOR BRANCH *for assembly of weld-in saddles*



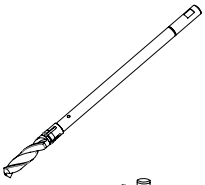
Art. no.	Dimension	PU	Box unit	Price € m/pc
50987	75mm	1		
50988	90mm	1		
50989	110mm	1		
50990	125mm	1		
50991	160mm	1		

QUICK CHANGE ADAPTER 75-90MM



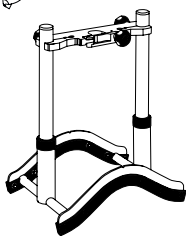
Art. no.	Dimension	PU	Box unit	Price € m/pc
50973	for Art.- No. 50987-50988	1		

CENTER DRILL LSZ 1



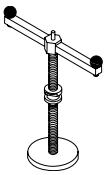
Art. no.	Dimension	PU	Box unit	Price € m/pc
50975	with capture sleeve	1		

DRILL RIG FOR DUSS-DRILL



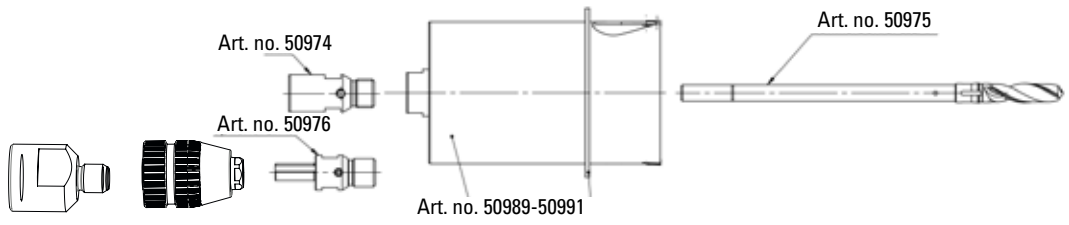
Art. no.	Dimension	PU	Box unit	Price € m/pc
50977		1		

WELDING FIXTURE FOR DRILL RIG 50977



Art. no.	Dimension	PU	Box unit	Price € m/pc
50979		1		

HOLE SAW SYSTEM





HOT TAPPING TOOL
for drilling of pipes under pressure

The hot tapping tool (Art. no. 50890) is used for drilling pipes for branche connections in the dimensions 40 and 63 mm.
The PP-main pipes aquatherm green pipe, blue pipe and lilac pipe with the **pipe structure S and MF UV** from 75 mm to 630 mm can be drilled under **medium pressure (water) of maximum 6 bar** and a **medium temperature of 10 – 60° C.**

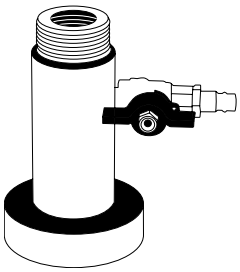
Both instructions for use of company Hütz + Baumgarten and aquatherm have to be read carefully before first starting. Be familiar with the controls and workflows before using the tool. The hot tapping tool may only be operated by persons which are trained, instructed and empowered. These persons must be familiar with the instructions for use and act accordingly.

NEW HOT TAPPING TOOL
for weld-on saddles under pressure



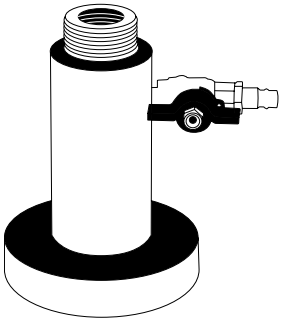
Art. no.	Dimension	PU	Box unit	Price € m/pc
50890	for dimension 40 + 63mm	1		

NEW ADAPTER FOR BALL VALVE 40MM
for weld-on saddles under pressure
for Art. no. 41494



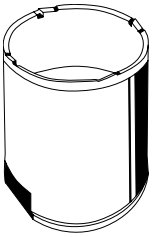
Art. no.	Dimension	PU	Box unit	Price € m/pc
50891	for ball valve 40 mm	1		

NEW ADAPTER FOR BALL VALVE 63MM
for weld-on saddles under pressure
for Art. no. 41498



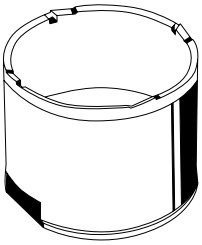
Art. no.	Dimension	PU	Box unit	Price € m/pc
50892	for ball valve 63 mm	1		

NEW PP-MILLING CUTTER 40MM
for weld-on saddles under pressure
for Art. no. 50891



Art. no.	Dimension	PU	Box unit	Price € m/pc
50893	40 mm	1		

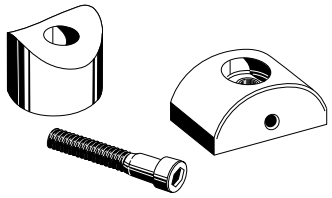
NEW PP-MILLING CUTTER 63MM
for weld-on saddles under pressure
for Art. no. 50892



Art. no.	Dimension	PU	Box unit	Price € m/pc
50894	63 mm	1		

NEW aquatherm WELD-ON SADDLE TOOL

for weld-on saddles under pressure



Art. no.	Dimension	PU	Box unit	Price € m/pc
50760	75x40mm for 50890	1		
50761	90x40mm for 50890	1		
50762	110x40mm for 50890	1		
50763	125x40mm for 50890	1		
50764	125x63mm for 50890	1		
50765	160x40mm for 50890	1		
50766	160x63mm for 50890	1		
50767	200x40mm for 50890	1		
50768	200x63mm for 50890	1		
50769	250x40mm for 50890	1		
50770	250x63mm for 50890	1		
50771	315x63mm for 50890	1		
50772	355x63mm for 50890	1		
50773	400-630x63mm for 50890	1		

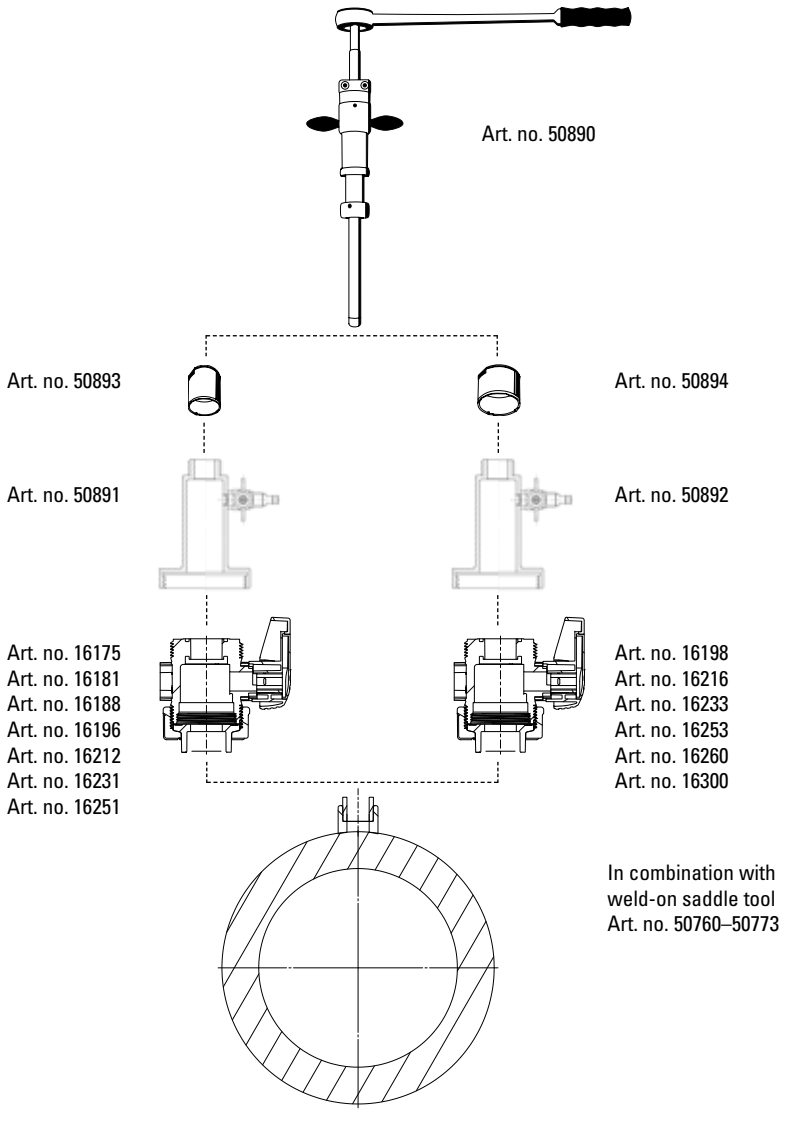
HOT TAPPING TOOL

for drilling pipes under pressure

The hot tapping tool (Art. no. 50890) is for drilling of pipelines. PP-main pipes from 75 mm to 630 mm can be drilled under pressure.

The following accessories are required for processing:

adapter for ball valve 40 mm	Art. no. 50891
adapter for ball valve 63 mm	Art. no. 50892
PP-milling cutter 40 mm	Art. no. 50893
PP-milling cutter 63 mm	Art. no. 50894
aquatherm weld-on saddle tool	Art. no. 50760-50773
aquatherm weld-on saddles with ball valve	Art. no. 16175–16300





AQUATHERM PREFABRICATION - CUSTOM MADE

Time is money – a maxim coming true every day especially in the building industry. The plumbing and heating installation of each construction project is always a temporal and logistical challenge – not only for the architect and planner.

The realization at site is often a problem for the site managers. Neither the external circumstances nor the temporal requirements allow them to concern detailed with the construction of a complicated manifold.

In addition there are high costs for the temporary expenses and diverse problems at site, which in most cases can only be solved by higher expenses.

Now, aquatherm offers an alternative to its customers.

Save time and money

We design and construct your complete manifolds in our company according to your specifications and dispatch them pre-finished to any place of the world.

You only have to send us the respective drawings and/or sketches with specifications. We return the offer including material list and drawing. A qualified team of experienced technicians likes to assist you.

For detailed information referring "prefabrication" please contact our technical hotline: **+49 (0) 2722 950-200,** ask for our catalogue, **order no. E18198** or visit our website **www.aquatherm.de**



Assembly in the …



… aquatherm manifold construction.



Loading and …



… delivery direct to the construction site.

Form: special manifold

Manifold inquiry Heating/Cold Dia. 20–630 mm:

The offer and respective drawing, as well as one revision are free of charge. As of the second revision, incurred expenses will be invoiced acc. to time and effort involved.

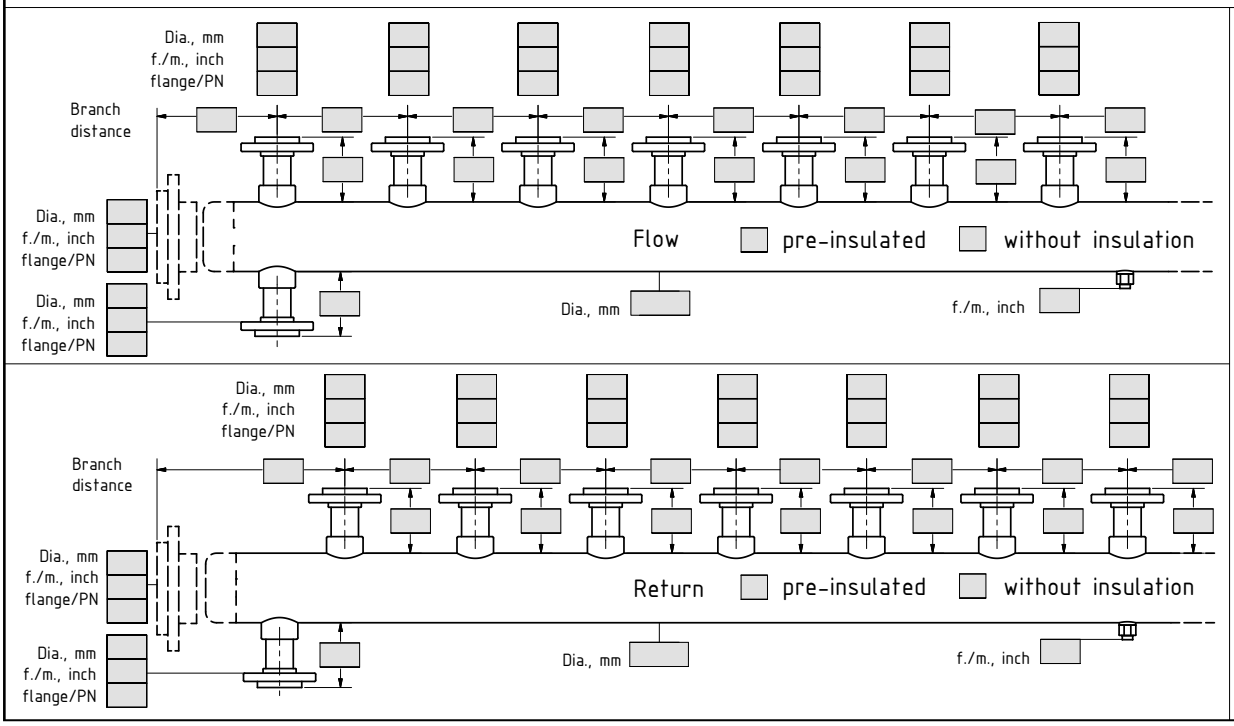
Client: .....
.....
Project: .....
.....

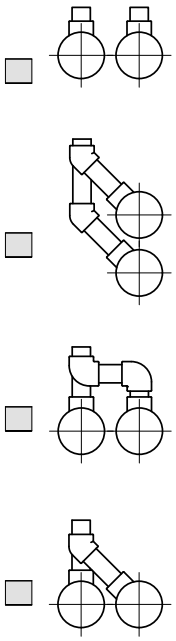
Date: .....
Building owner: .....
.....
.....

Type of pipe/system: .....
Max. service temperature: .....

Total length of manifold,mm: .....
Shut-off valves(type/brand): .....

Max. service overpressure: .....
Remarks: .....





Manifold inquiry Sanitary Dia. 20–630 mm:

The offer and respective drawing, as well as one revision are free of charge. As of the second revision, incurred expenses will be invoiced acc. to time and effort involved.

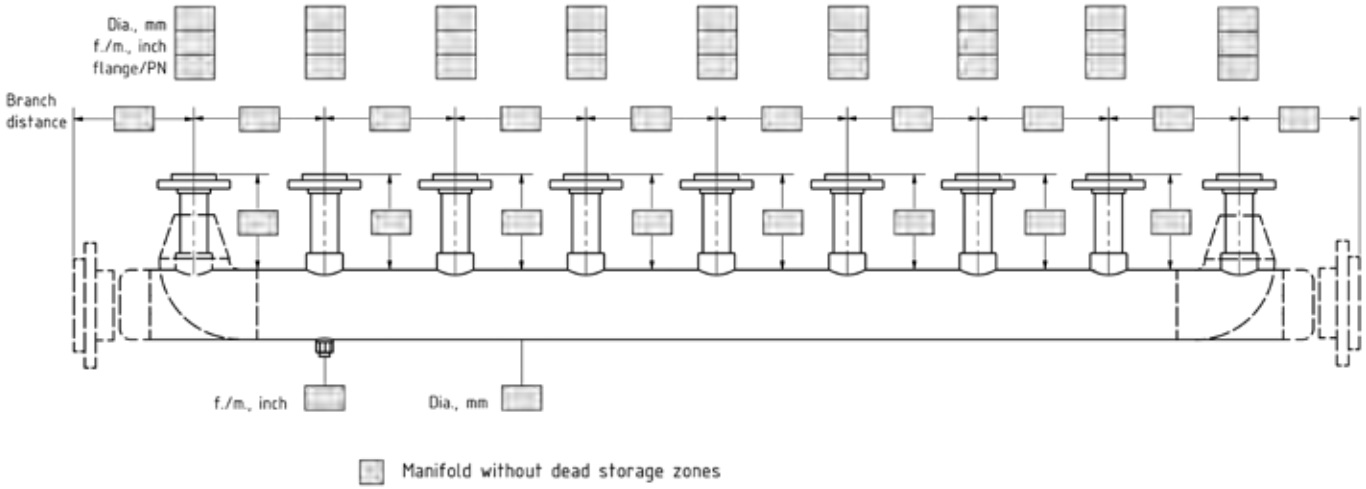
Client: .....
.....
Project: .....
.....

Date: .....
Building owner: .....
.....
.....

Type of pipe/system: .....
Max. service temperature: .....

Total length of manifold,mm: .....
Shut-off valves(type/brand): .....

Max. service overpressure: .....
Remarks: .....



Advantages aquatherm Prefabrication: Planning, fabrication and service

Investors

- Support from planning to commissioning
- Service technicians provide advice and support on site
- Development of customized solutions
- Time- and cost savings due to pre-fabrication
- Cost transparency
- Quick and easy installation into existing systems
- Reduce dead-time
- Over 40 years of proven quality and experience
- Insurance cover up to 20 million Euros per individual case

Architects and planners

- Planning support from the aquatherm design team
- Support for the plausibility and completeness check
- Provision of CAD- and planning data
- Detailed planning data for testing and production release
- 3D drawings minimize design errors
- Early detailed planning means planning and cost reliability
- High precision of the components due to pre-fabrication
- Time saving through pre-fabrication
- Years of experience in manifold and plant construction

Advantages of aquatherm manifolds and special components

- Consistent quality by industrial prefabrication „Made in Germany“
- Certified and inspected – ISO 9001/ISO 14001/ISO 50001
- Resistance to corrosion, chemicals and aggressive media
- Pre-insulated available
- Thinner insulation
- UV-resistance available
- Heat-/sound-insulating properties
- Oxygen-tight[1]
- Hygienic[2]
- Weight reduction due to the use of PP-R
- No silting by corrosion products
- Less pipe roughness and high abrasion resistance
- High impact strength
- Tight connection of pipe and fitting by fusion
- Three-layer pipe structure with glass fiber-reinforced middle-layer
- Flame resistant according to DIN 4102-1, building material class B 1[3]
- Recyclable
- Durable

Plumbers/Plant engineers

- High, tested quality with a 10 years warranty
- Support and advice of service technicians on site
- Highest accuracy due to detailed planning
- Order monitoring and delivery by the specialized wholesale
- No delays due to missing parts
- Low tooling costs
- Rapid add-on by aquatherm saddle-technique
- Weight reduction due to the use of PP-R, thus easier handling during transport and on site
- No improvise on site
- Fast installation times
- Installation in confined spaces is possible
- Compensation of skills shortage

[1] aquatherm blue pipe OT
[2] aquatherm green pipe
[3] aquatherm red pipe



aquatherm green / **blue pipe** MF **TWO-SIDED** WITH FLANGE ADAPTER AND LOOSE FLANGE **5.8 M**

MF = multilayer fibre / S = single layer pipe as single pipe in 5.8 m length

Outside diameter	aquatherm green pipe SDR 9 MF RP		aquatherm green pipe SDR 11 S / MF		aquatherm blue pipe SDR 11 MF		aquatherm blue pipe ot SDR 11 MF		aquatherm blue pipe SDR 17,6 MF		PU
Medium pipe	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	m/pc
160 mm	**7270729**		**7310229***		**8370129**		**8570129**		**8470129**		5.8
200 mm	**7270733**		**7310233***		**8370133**		**8570133**		**8470133**		5.8
250 mm	**7270737**		**7310237***		**8370137**		**8570137**		**8470137**		5.8
315 mm	**7270741**		**7310241***		**8370141**				**8470141**		5.8
355 mm	**7270743**		**7310243***		**8370143**				**8470143**		5.8
400 mm			**7310245**		**8370145**				**8470145**		5.8
450 mm			**7310247**		**8370147**				**8470147**		5.8
500 mm									**8470149**		5.8
560 mm									**8470151**		5.8
630 mm									**8470153**		5.8

* single layer



aquatherm green / **blue pipe** MF **TWO-SIDED** WITH FLANGE ADAPTER AND LOOSE FLANGE **11.6 M**

MF = multilayer fibre / S = single layer pipe as single pipe in 11.6 m length

Outside diameter	aquatherm green pipe SDR 9 MF RP		aquatherm green pipe SDR 11 S / MF		aquatherm blue pipe SDR 11 MF		aquatherm blue pipe ot SDR 11 MF		aquatherm blue pipe SDR 17,6 MF		PU
Medium pipe	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	m/pc
160 mm	**7270730**		**7310230***		**8370130**		**8570130**		**8470130**		11.6
200 mm	**7270734**		**7310234***		**8370134**		**8570134**		**8470134**		11.6
250 mm	**7270738**		**7310238***		**8370138**		**8570138**		**8470138**		11.6
315 mm	**7270742**		**7310242***		**8370142**				**8470142**		11.6
355 mm	**7270744**		**7310244***		**8370144**				**8470144**		11.6
400 mm			**7310246**		**8370146**				**8470146**		11.6
450 mm			**7310248**		**8370148**				**8470148**		11.6
500 mm									**8470150**		11.6
560 mm									**8470152**		11.6
630 mm									**8470154**		11.6

* single layer

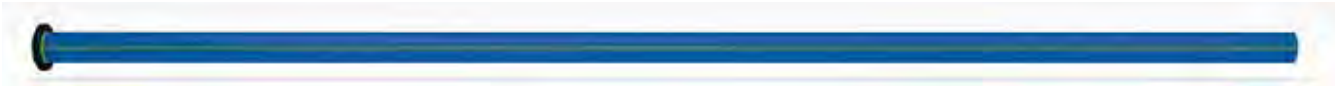


aquatherm green / **blue pipe** MF **ONE-SIDED** WITH FLANGE ADAPTER AND LOOSE FLANGE **5.8 M**

MF = multilayer fibre / S = single layer pipe as single pipe in 5.8 m length

Outside diameter	aquatherm green pipe SDR 9 MF RP		aquatherm green pipe SDR 11 S / MF		aquatherm blue pipe SDR 11 MF		aquatherm blue pipe ot SDR 11 MF		aquatherm blue pipe SDR 17,6 MF		PU
Medium pipe	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	m/pc
160 mm	**7270829**		**7310329***		**8370329**		**8570329**		**8470329**		5.8
200 mm	**7270833**		**7310333***		**8370333**		**8570333**		**8470333**		5.8
250 mm	**7270837**		**7310337***		**8370337**		**8570337**		**8470337**		5.8
315 mm	**7270841**		**7310341***		**8370341**				**8470341**		5.8
355 mm	**7270843**		**7310343***		**8370343**				**8470343**		5.8
400 mm			**7310345**		**8370345**				**8470345**		5.8
450 mm			**7310347**		**8370347**				**8470347**		5.8
500 mm									**8470349**		5.8
560 mm									**8470351**		5.8
630 mm									**8470353**		5.8

* single layer

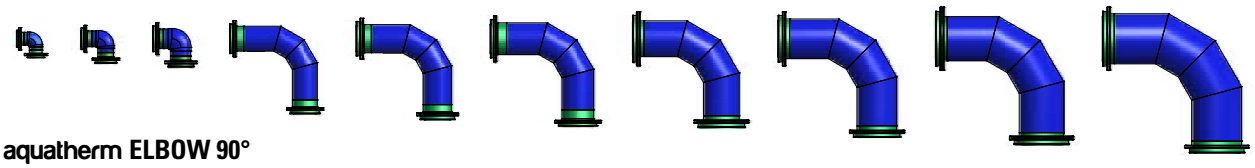


aquatherm green / blue pipe MF **ONE-SIDED** WITH FLANGE ADAPTER AND LOOSE FLANGE **11.6 M**

MF = multilayer fibre / S = single layer pipe as single pipe in 11.6 m length

Outside diameter	aquatherm green pipe SDR 9 MF RP		aquatherm green pipe SDR 11 S / MF		aquatherm blue pipe SDR 11 MF		aquatherm blue pipe ot SDR 11 MF		aquatherm blue pipe SDR 17,6 MF		PU
Medium pipe	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	m/pc
160 mm	**7270830**		**7310330***		**8370330**		**8570330**		**8470330**		11.6
200 mm	**7270834**		**7310334***		**8370334**		**8570334**		**8470334**		11.6
250 mm	**7270838**		**7310338***		**8370338**		**8570338**		**8470338**		11.6
315 mm	**7270842**		**7310342***		**8370342**				**8470342**		11.6
355 mm	**7270844**		**7310344***		**8370344**				**8470344**		11.6
400 mm			**7310346**		**8370346**				**8470346**		11.6
450 mm			**7310348**		**8370348**				**8470348**		11.6
500 mm									**8470350**		11.6
560 mm									**8470352**		11.6
630 mm									**8470354**		11.6

* single layer



aquatherm ELBOW 90°

Outside diameter	aquatherm green pipe SDR 9 MF RP		aquatherm green pipe SDR 11 S / MF		aquatherm blue pipe SDR 11 MF		aquatherm blue pipe ot SDR 11 MF		aquatherm blue pipe SDR 17,6 MF		PU
Medium pipe	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	pc
160 mm	**7212130**		**7312131**		**8312131**		**8512131**		**8412130**		1
200 mm	**7212134**		**7312135**		**8312135**		**8512135**		**8412134**		1
250 mm	**7212138**		**7312139**		**8312139**		**8512139**		**8412138**		1
315 mm	**7212142**		**7312143**		**8312143**				**8412142**		1
355 mm	**7212144**		**7312145**		**8312145**				**8412144**		1
400 mm			**7312147**		**8312147**				**8412146**		1
450 mm			**7312149**		**8312149**				**8412148**		1
500 mm									**8412150**		1
560 mm									**8412152**		1
630 mm									**8412154**		1

On demand also available in design 60° und 75°.



aquatherm TI FIBER COMPOSITE PIPE **TWO-SIDED** WITH FLANGE ADAPTER AND LOOSE FLANGE **5.8 M**

Fiber composite pipe as single pipe in 5.8 m length with PUR- rigid foam insulation and PE-casing pipe.

Outside diameter		aquatherm green pipe ti SDR 9 MF RP		aquatherm blue pipe ti SDR 11 MF		aquatherm blue pipe ot ti SDR 11 MF		aquatherm blue pipe ti SDR 17,6 MF		PU
Medium pipe	Casing pipe	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	m/pc
160 mm	250 mm	**7470729**		**8770129**		**8970129**		**8870129**		5.8
200 mm	315 mm	**7470733**		**8770133**		**8970133**		**8870133**		5.8
250 mm	400 mm	**7470737**		**8770137**		**8970137**		**8870137**		5.8
315 mm	450 mm	**7470741**		**8770141**				**8870141**		5.8
355 mm	500 mm	**7470743**		**8770143**				**8870143**		5.8



aquatherm TI FIBER COMPOSITE PIPE **TWO-SIDED** WITH FLANGE ADAPTER AND LOOSE FLANGE **11.6 M**

Fiber composite pipe as single pipe in 11.6 m length with PUR-rigid foam insulation and PE-casing pipe.

Outside diameter		aquatherm green pipe ti SDR 9 MF RP		aquatherm blue pipe ti SDR 11 MF		aquatherm blue pipe ot ti SDR 11 MF		aquatherm blue pipe ti SDR 17,6 MF		PU
Medium pipe	Casing pipe	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	m/pc
160 mm	250 mm	**7470730**		**8770130**		**8970130**		**8870130**		11.6
200 mm	315 mm	**7470734**		**8770134**		**8970134**		**8870134**		11.6
250 mm	400 mm	**7470738**		**8770138**		**8970138**		**8870138**		11.6
315 mm	450 mm	**7470742**		**8770142**				**8870142**		11.6
355 mm	500 mm	**7470744**		**8770144**				**8870144**		11.6



aquatherm TI FIBER COMPOSITE PIPE **ONE-SIDED** WITH FLANGE ADAPTER AND LOOSE FLANGE **5.8 M**

Fiber composite pipe as single pipe in 5.8 m length with PUR-rigid foam insulation and PE-casing pipe.

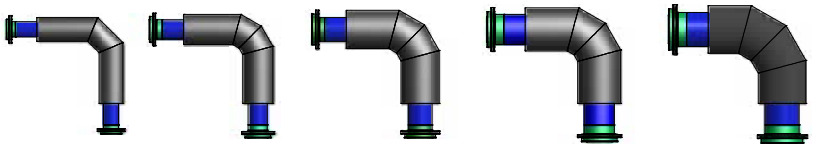
Outside diameter		aquatherm green pipe ti SDR 9 MF RP		aquatherm blue pipe ti SDR 11 MF		aquatherm blue pipe ot ti SDR 11 MF		aquatherm blue pipe ti SDR 17,6 MF		PU
Medium pipe	Casing pipe	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	m/pc
160 mm	250 mm	**7470829**		**8770329**		**8970329**		**8870329**		5.8
200 mm	315 mm	**7470833**		**8770333**		**8970333**		**8870333**		5.8
250 mm	400 mm	**7470837**		**8770337**		**8970337**		**8870337**		5.8
315 mm	450 mm	**7470841**		**8770341**				**8870341**		5.8
355 mm	500 mm	**7470843**		**8770343**				**8870343**		5.8



aquatherm TI FIBER COMPOSITE PIPE **ONE-SIDED** WITH FLANGE ADAPTER AND LOOSE FLANGE **11.6 M**

Fiber composite pipe as single pipe in 11.6 m length with PUR-rigid foam insulation and PE-casing pipe.

Outside diameter		aquatherm green pipe ti SDR 9 MF RP		aquatherm blue pipe ti SDR 11 MF		aquatherm blue pipe ot ti SDR 11 MF		aquatherm blue pipe ti SDR 17,6 MF		PU
Medium pipe	Casing pipe	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	m/pc
160 mm	250 mm	**7470830**		**8770330**		**8970330**		**8870330**		11.6
200 mm	315 mm	**7470834**		**8770334**		**8970334**		**8870334**		11.6
250 mm	400 mm	**7470838**		**8770338**		**8970338**		**8870338**		11.6
315 mm	450 mm	**7470842**		**8770342**				**8870342**		11.6
355 mm	500 mm	**7470844**		**8770344**				**8870344**		11.6





aquatherm ti ELBOW 90°

with PUR-rigid foam insulation and PE-casing pipe

Outside diameter		aquatherm green pipe ti SDR 9 MF RP		aquatherm blue pipe ti SDR 11 MF		aquatherm blue pipe ot ti SDR 11 MF		aquatherm blue pipe ti SDR 17,6 MF		PU
Medium pipe	Casing pipe	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	Art. no.	Price € m/pc	pc
160 mm	250 mm	**7412130**		**8712131**		**8912131**		**8812130**		1
200 mm	315 mm	**7412134**		**8712135**		**8912135**		**8812134**		1
250 mm	400 mm	**7412138**		**8712139**		**8912139**		**8812138**		1
315 mm	450 mm	**7412142**		**8712143**				**8812142**		1
355 mm	500 mm	**7412144**		**8712145**				**8812144**		1

On demand also available in design 60° und 75°.



Management System
ISO 9001:2008
ISO 14001:2004
ISO 50001:2011

www.tuv.com
ID 0091005348

aquatherm GmbH

Biggen 5 | D-57439 Attendorn | Phone: +49 (0) 2722 950-0 | Fax: +49 (0) 2722 950-100
info@aquatherm.de www.aquatherm.de

Order-No.: E10101
Edition: 5.2017

aquatherm - Pipe systems made of polypropylene