



## 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

### E10101

aquatherm green pipe

aquatherm blue pipe

aquatherm lilac pipe

#### Page Change

23&25	Since the aquatherm green pipe SDR 9 MF RP received the SKZ quality and inspection mark, the values were adjusted in the operating pressure tables according to the SKZ-specifications.
30	Information for wrapping of pipe pieces or fittings with UV-adhesive tape was added.
40	The manual welding device 1400W with the Art.-No. 50341 now is supplied with handle.
48	The new saddle milling cutter with the Art.-No. 50421-50428 was added in the table.
56	The text concerning the electrofusion-socket welding has been adjusted: 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.
57	The text concerning the electrofusion-socket welding has been adjusted: Pipes and fittings must be welded stress-free.
58	One page on the use of flange adapter was added.
62/63	A double page for the estimation of welding seams was added.
64/65	A table of the welding parameter of available welding machines was added.
72	A new page about pipe clamps was added.
73	A new bending side picture was added.
77	The tables of support distances of the aquatherm blue pipe SDR 17.6 MF was added by the dimension 125 mm.
79	The information for insulation of hot water pipelines was added by a table of the minimum insulation thickness against condensation.
81-84	The instructions and records concerning the leak test were updated.
from 100	The article list was updated.



Dear customers and partners,

thank you for your interest in our family enterprise. For a long time the classification of enterprises as a family has rather been hidden than actively marketed. Only in recent years family enterprises experience a comeback. From employee perspective, they are generally a flat hierarchy, provide independent and responsible work under a cooperative management style, but above all they are considered safe employers who commit permanently to their employees.

By definition, family enterprises are distinguished primarily by the unity of ownership and management in the hands of a family; this criterion the aquatherm group still meets after the transition from the first to the second generation (pictured above).

Our self-image of a family enterprise, however, clearly exceeds this description. Our claim describes a proactive organization that bases in the responsible contact in everyday life, that challenges encouraging, thereby accompanies developments in a promoting way and sets on a personal influenced by nearby corporate culture. If these business properties meet determined people that daily inspire through initiative, diligence and passion, until we speak of a living family enterprise, until we speak with pride of the aquatherm family.

We look forward to presenting you on the following pages some insight into our colorful, slightly green-tinted aquatherm world!

**Christof Rosenberg**  
Managing Director

**Dirk Rosenberg**  
Managing Director

**Maik Rosenberg**  
Managing Director

**Gerhard Rosenberg**  
President of the Advisory Board

**1973**

Founding of aquatherm by Gerhard Rosenberg

**1978**

Transfer to the first factory in Biggen / D-Attendorf

**1985**

Completion of factory 1 in Biggen / D-Attendorf

**1992**

Founding of the branch in Radeberg near D-Dresden

**1996**

Founding of the metal processing company aquatherm metal, D-Attendorf

**1998**

Founding of a subsidiary in Carrara / Italy

**1999**

Completion of the main site in D-Attendorf as one complex (Factories 1+2, Production and Store, Laboratory and Training Centre)

**2001**

Completion of the extension Factory 2 in D-Attendorf

**2001**

Opening of the new training centre in D-Radeberg

**2002**

Completion of the logistics centre in D-Attendorf

**2003**

Completion of rebuilding and finishing of the training centre in D-Attendorf

**2003**

30 year celebration of the company aquatherm

**2005**

Adding of 2 storeys on the administration building

**2005/06**

Completion of the 4-storey hall on the premises in Attendorf

Basement: Store

Ground floor: Assembly/Packing

1st Floor: Laboratory and Technical department

2nd Floor: Special manifold construction

**2008**

Aquisition of the former storehouse of the forwarding agent Kost, which also accomodates the room of the plant maintenance.

**2009**

Opening of the new expertise centre for technical application.

**2013**

40 year celebration of the company aquatherm.

# SERVICE

## TECHNICAL HOTLINE +49 (0)2722 950 200

info@aquatherm.de www.aquatherm.de

### Parent plant Attendorf

**aquatherm GmbH**  
Biggen 5  
D-57439 Attendorf  
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 Attendorf 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 Attendorf 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](http://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 responsibility for our customers, partners and the environment.



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



### 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.



### Miscellaneous

Different aquatherm-CD's, prospects, catalogues, poster, leaflets, mailings, calendars, a.s.m. are investigated and produced from the internal advertising department.  
All information regarding the company, the technology, the products, the various trainings and fairs as well as all catalogues in pdf-form can be called and downloaded from the aquatherm-website: [www.aquatherm.de](http://www.aquatherm.de).

# SERVICE

## TABLE OF CONTENTS

<b>Systems</b>	<b>8-22</b>
- Rebranding	8-9
- Short cuts & Symbols	10
- aquatherm pipe systems	11
- Comparison 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
<b>Features</b>	<b>23-33</b>
- 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
- <b>System overview</b>	<b>26-27</b>
- Characteristic	26
- Installation	26
- Composite Technology	26
- Quality	26
- Guarantee	27
- Price	27
- Planning and software	27
- <b>Material</b>	<b>27</b>
- Fusiolen®	28
- Certificates / aquatherm & Ecology	29
- UV-resistance / Hygienic suitability / Sound Isolation	30
- Fire protection	31
- Fire load	32
- Chemical and thermal disinfection	33
<b>Quality assurance</b>	<b>34-38</b>
- Quality assurance	34
- Compliance with the system standard / aquatherm quality management	35
- System control / Internal control	36-37
- External control	38
<b>Welding technology</b>	<b>39-59</b>
- <b>Fusion</b>	<b>40-65</b>
- 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)	50-52
- Part E: aquatherm welding machine	53
- Part E: Welding machine prisma-light	54
- Part E: Electrofusion device	55-57
- Part E: Flange connections	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

## TABLE OF CONTENTS

<b>Installation principles</b>	<b>66-90</b>
- Fastening technique / Fixed points / Sliding points	66
- Installation advice / Linear expansion / Concealed installation	66
- Installation in ducts	67
- Open installation / Calculation of the linear expansion	68
- aquatherm green pipe & aquatherm blue pipe	69
- aquatherm green pipe MF (faser composite pipe)	70
- aquatherm blue pipe MF (faser composite pipe)	70
- aquatherm green pipe MS (stabi 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
<b>Planning</b>	<b>91-99</b>
- 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
<b>Product list</b>	<b>100</b>
<b>aquatherm green pipe</b> -pipes	101
<b>aquatherm blue pipe</b> -pipes	106
<b>aquatherm lilac pipe</b> -pipes	110
Fastening material	111
Fittings	112
Weld-in saddle	128
Threaded connections and accessories	134
Transition pieces	139
Screwed connections and counter parts	143
Distributors	146
Valves and accessories	147
Cutting tools, welding devices	153
Welding machines and welding jig	154
Butt welding machines & electrofusion device	154
Peeling tools	156
Saddle welding tools	158
Drills & saddle peeling tool	160

# 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.

new branding structure								
brand name		appendix						
no.:	company	system	Standard Dimension Ratio	structure of pipe	special feature of pipe	Material / Glas fibre content GF%/ fire class. Acc. ISO 11925	old brand name	article-no.
1	aquatherm	green pipe	SDR 11	S		PP-R/GF0/E	fusiotherm SDR11	10208 . . . 10248
2	aquatherm	green pipe	SDR 7,4	S		PP-R/GF0/E	fusiotherm SDR7,4	10806 . . . 10908
3	aquatherm	green pipe	SDR 6	S		PP-R/GF0/E	fusiotherm SDR6	10006 . . . 10110
4	aquatherm	green pipe	SDR 7,4	MS			fusiotherm Stabi-composite pipe	70806 . . . 70856
5	aquatherm	green pipe	SDR 7,4	MF		PP-R/GF7/E	fusiotherm faser composite pipe	70708 . . . 70738
6	aquatherm	green pipe	SDR 7,4	MF	UV	inliner like 5 with black PE-coating	fusiotherm faser composite pipe UV	70758 . . . 70788
7	aquatherm	green pipe	SDR 9	MF	TI	inliner like 5 with PU-Insulation and black PE-casing	fusiotherm faser composite pipe ISO	1370711 . . . 1370738
8	aquatherm	green pipe	SDR 9	MF	RP	PP-RP/GF7/E	aquatherm green pipe faser composite pipe	370712 . . . 370744
9	aquatherm	green pipe	SDR 9	MF	RP UV	inliner like 8 with black PE-coating	aquatherm green pipe faser composite pipe UV	370762 . . . 370794
10	aquatherm	blue pipe	SDR 11	S		PP-R/GF0/E	Climatherm SDR11	2010208 . . . 2010312
11	aquatherm	blue pipe	SDR 7,4 / SDR 11 / SDR 17.6	MF		PP-R/GF7/E	Climatherm faser composite pipe SDR 7,4 / SDR 11 / SDR 17.6	2070708 . . . 2570154
12	aquatherm	blue pipe	SDR 7,4 / SDR 11	MF	UV	inliner like 11 with black PE-coating	Climatherm faser composite pipe SDR7,4/SDR11 UV	2070162 . . . 2070762
13	aquatherm	blue pipe	SDR 7,4 / SDR 11	MF	OT	inliner like 11 with EVOH O2-barrier	Climatherm faser composite pipe SDR7,4/SDR11 OT	2170114 . . . 2170712
14	aquatherm	blue pipe	SDR7,4/ SDR11	MF	TI	inliner like 11 with PU-Insulation and black PE-casing	Climatherm faser composite pipe SDR7,4/SDR11 ISO	2270111 . . . 2270142
15	aquatherm	blue pipe	SDR7,4/ SDR11	MF	OT-TI	inliner like 13 with PU-insulation and black PE-casing	Climatherm faser composite pipe SDR7,4/SDR11 OT ISO	2470711 . . . 2470138
16	aquatherm	red pipe	SDR7,4	MF	HI	PP-R/GF7/B-s1,d0	aquatherm firestop	4170130 . . . 4170726
17	aquatherm	lilac pipe	SDR7,4/ SDR11	S		PP-R/GF0/E	aquatherm lilac	9010212 . . . 9010808
18	aquatherm	black system			OT		climasystem	
19	aquatherm	orange system		S	OT		aquatherm floor heating	
20	aquatherm	grey pipe					aquatherm SHT	



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

During the transition period, the products will have the old and the new system name. This will help to facilitate familiarization and orientation in the market.

LEGEND:			
<b>S</b>	single layer	<b>UV</b>	ultraviolet protected
<b>MS</b>	multilayer stabi	<b>TI</b>	isolated with PUR and external PE pipe
<b>MF</b>	multilayer faser	<b>RP</b>	raised pressure (resistance)
<b>OT</b>	oxygen tight	<b>HI</b>	hardly inflammable

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

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

SHORT CUTS & SYMBOLS

short cuts <b>structure of pipe</b>	
S	single
M	multilayer
MF	multilayer faser
MS	multilayer stabi
OT	oxygen tight
UV	UV resistant
TI	thermal insulation
HI	hardly inflammable

short cuts <b>material</b>	
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

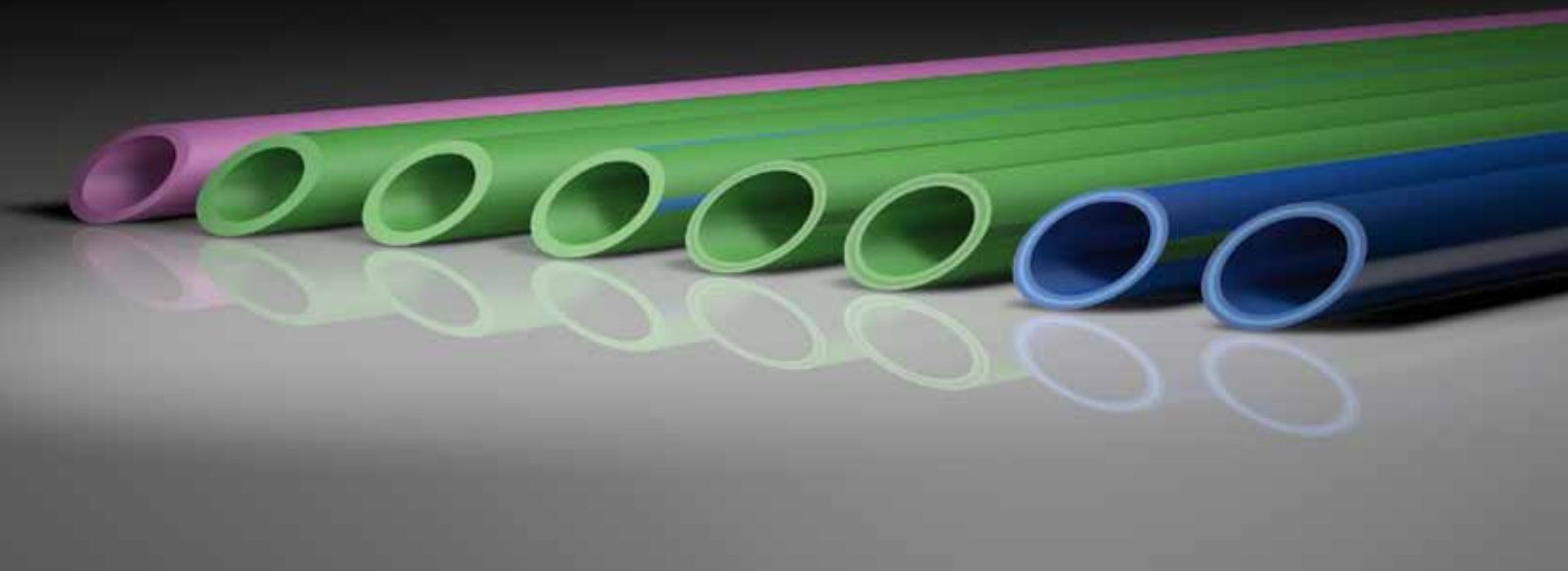


district heating pipeline systems



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

	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	●	●	●

## COMPARISON OF THE WATER CONTENT PER METER

Ø Dimension mm	aquatherm green pipe SDR 6 S	aquatherm green pipe SDR 7,4 MF SDR 7,4 MS  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  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

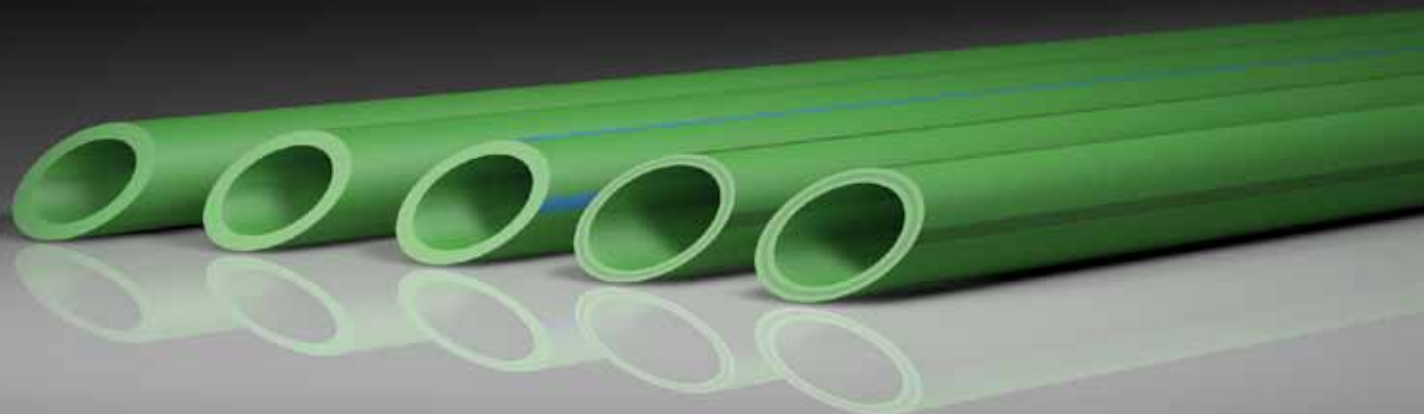
**MS** = multilayer stabi - integrated aluminium-layer

**MF** = multilayer faser

**MF RP** = multilayer faser - raised pressure (resistance)

**OT** = oxygen tight

# aquatherm green pipe



fusiotherm®- the innovative multi-purpose pipe that was a revolution for the plastic pipe industry and has evolved over decades will be called

## aquatherm green pipe

The pipe launched under this new name in several international markets years ago and quickly came to be recognized for the highest quality and environmental responsibility. Its environmental benefits as well as the world-famous and often copied colour of the pipe system are the basis for the new name.

The pipe system has proved its excellent technical suitability in worldwide applications for more than 30 years and is highly recognized by experts as 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.

### NEW

#### 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 story 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 circulation pipe.

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

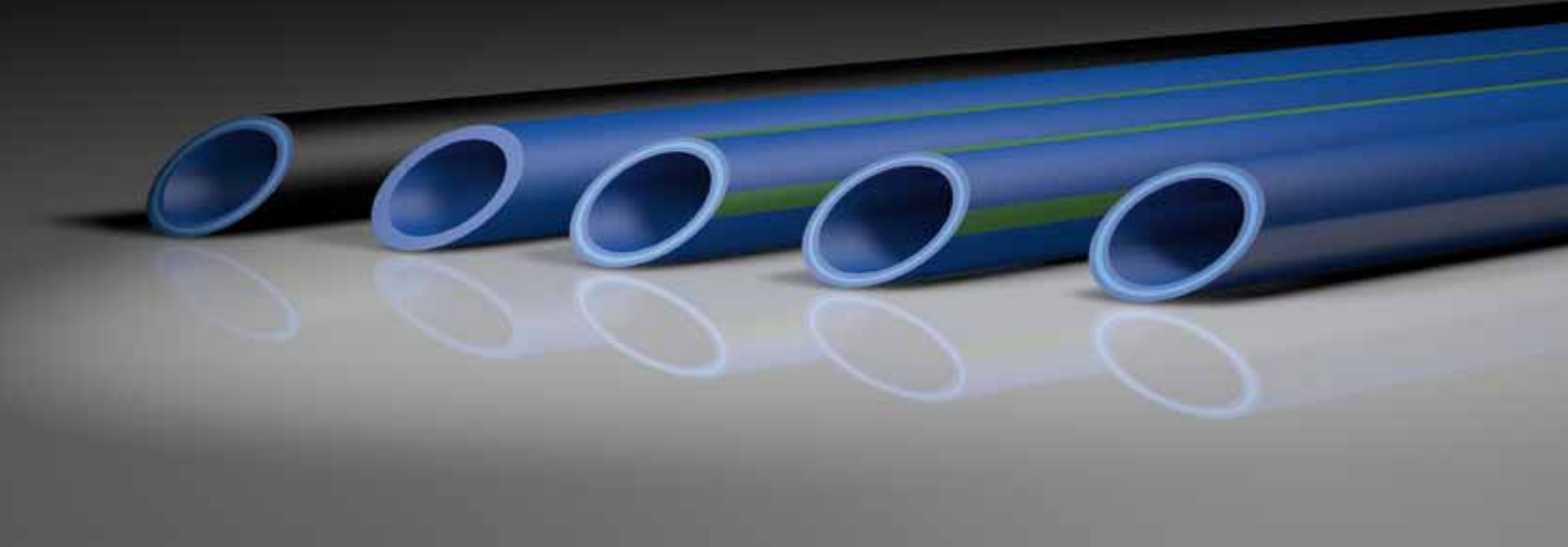


Floor distribution with distribution blocks



aquatherm grey pipe connection

# aquatherm blue pipe



climatherm our specialty for distributing cooling and heating in closed systems as well as in several industrial applications, will become

## aquatherm blue pipe

This system was developed 10 years ago in order to prevent corrosion in air conditioning 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.

The aquatherm blue pipe system has been developed especially for applications outside the potable water installation.

In addition to the general advantages of the PP-R pipesystem (see page 26) aquatherm blue pipe in comparison with the aquatherm green pipe system 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 stops 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.

### Fields of application



### 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





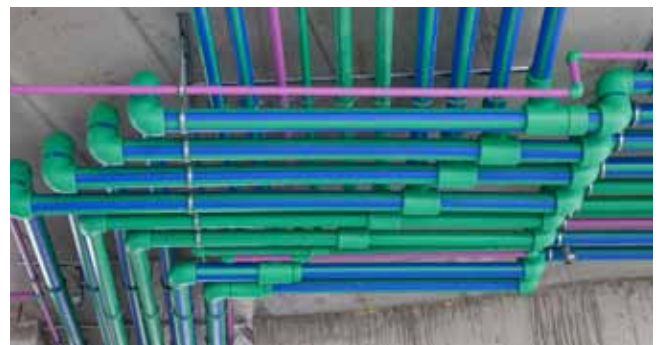


## aquatherm blue pipe

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 - fiber 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 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.

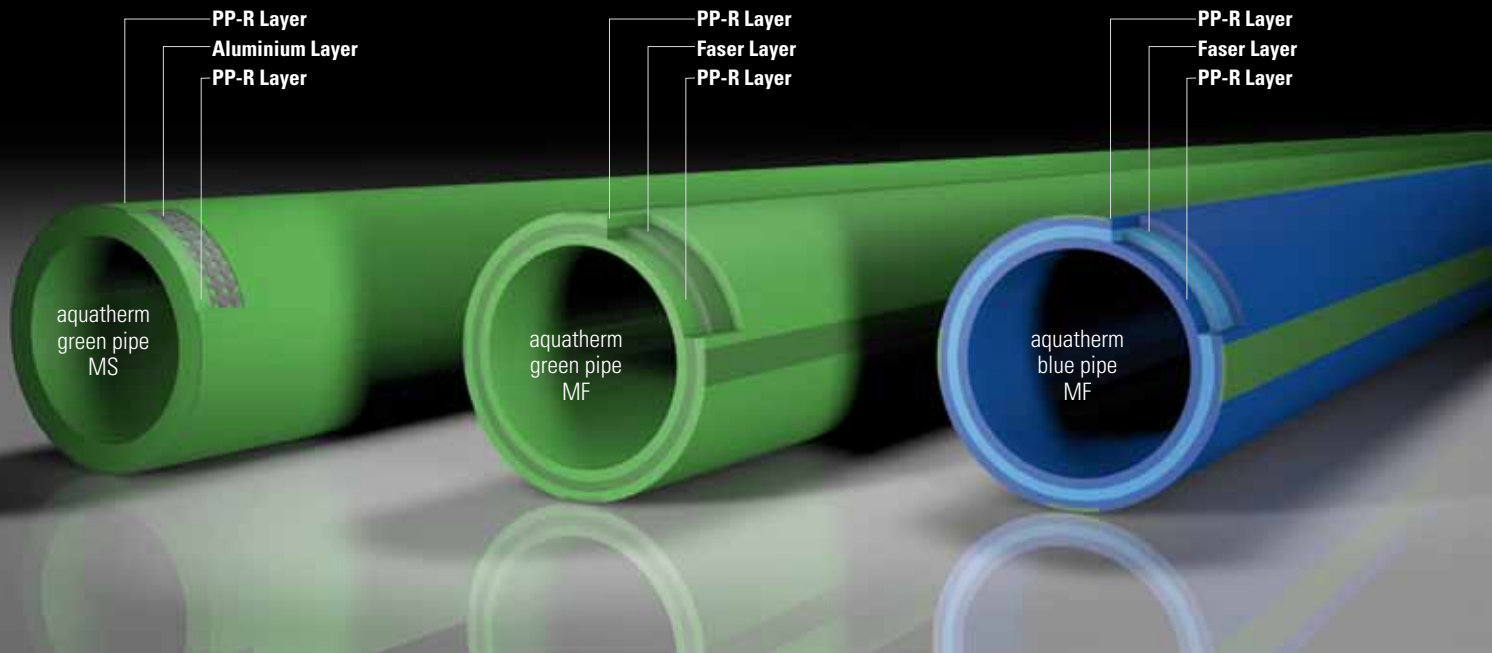
### Under soil heating

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:

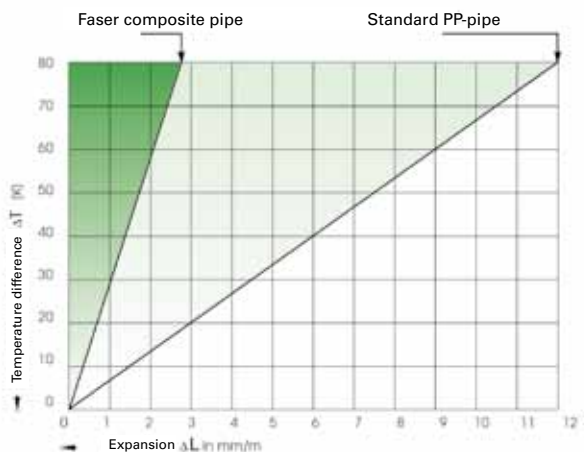
- Reduced expansion
- Higher flow rate due to increased inner diameter
- Greater support spacings
- Less weight

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



## STABI COMPOSITE TECHNOLOGY

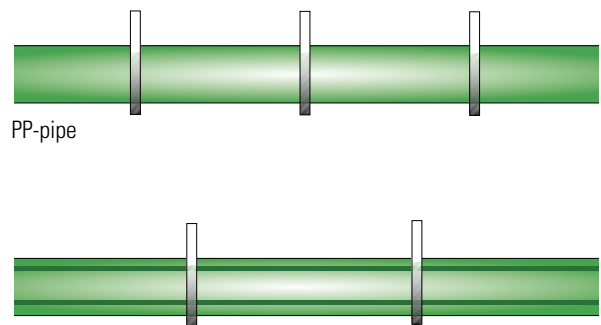
The stabi-composite pipe is more stabilized by the aluminium in the middle-layer. As with the faser-reinforced pipe here are also the following advantages:

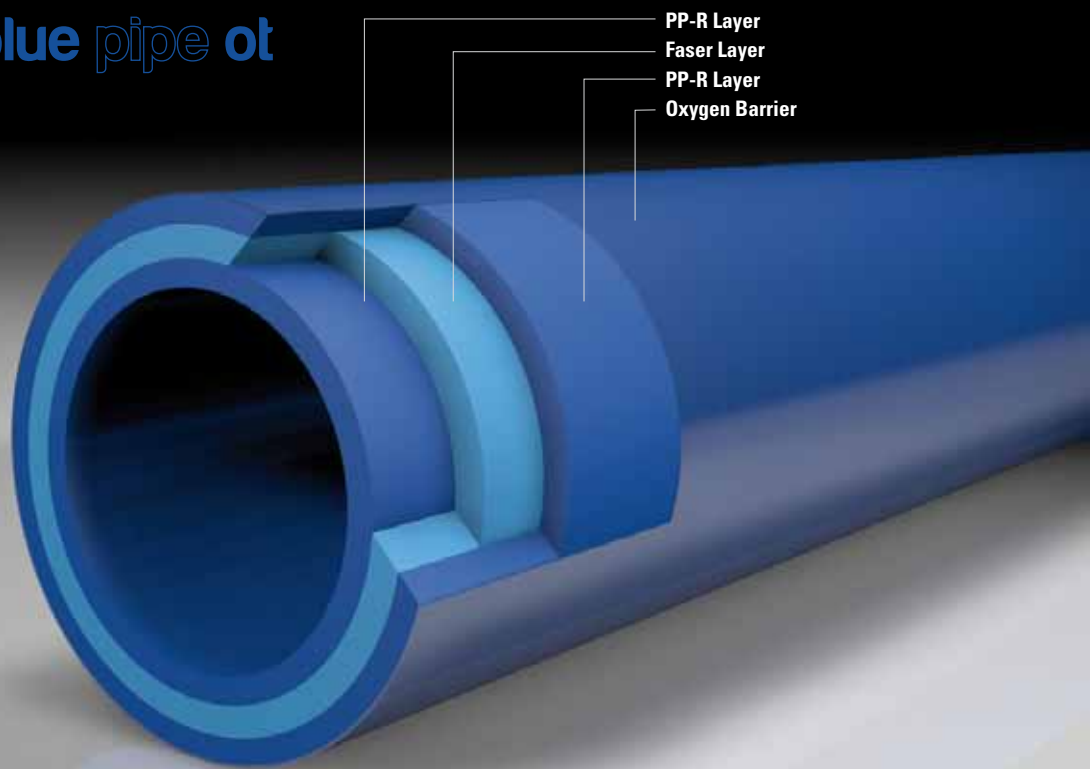
- Reduced expansion
- Higher flow rate due to increased inner diameter
- Greater support spacings
- Less weight

The following type of pipe is produced according to this technology:

- aquatherm green pipe MS (stabi composite pipe)

## Support spacings PP-pipe and faser composite-pipe





PP-R Layer  
Faser Layer  
PP-R Layer  
Oxygen Barrier

## 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

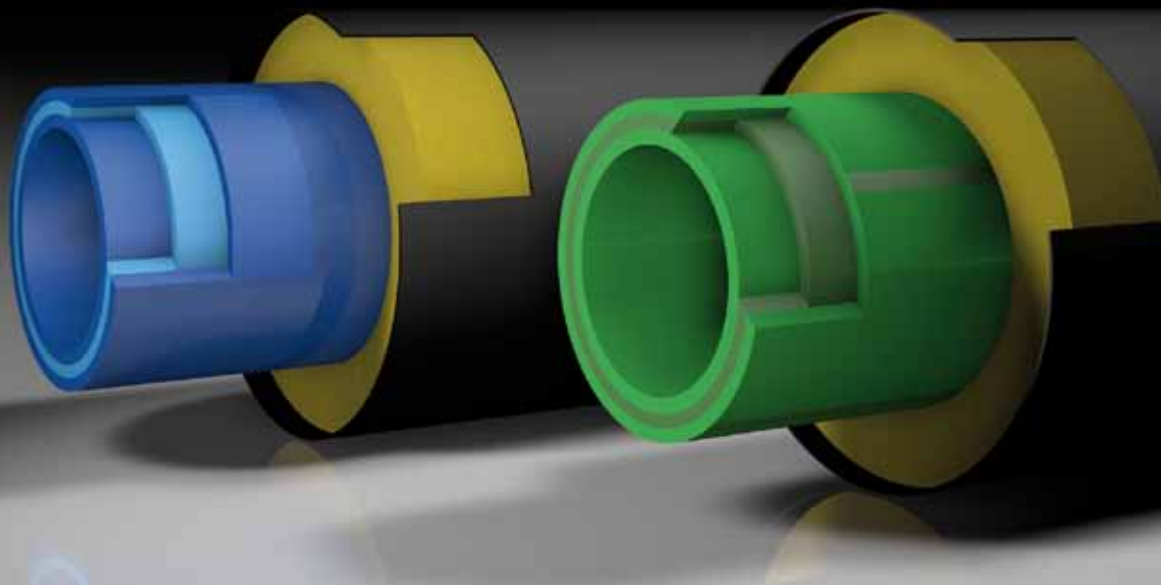
#### Easy and quick installation technology

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 32-250 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

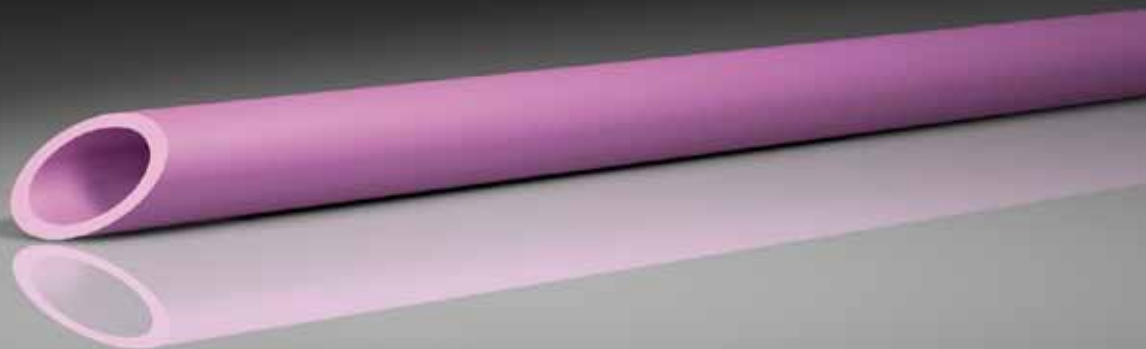
	aquatherm green pipe ti	aquatherm blue pipe ti	aquatherm blue pipe ot ti
Potable water application	●		
Climate technology	○	●	●
Chilled water technology	○	●	●
Swimming pool technology	●	●	
Rainwater application	●	●	
Irrigation	●	●	
District heating pipeline systems	○	●	●
Application in the field of Shipbuilding	●	●	●
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 website **www.aquatherm.de**.

# aquatherm lilac pipe



lilac was developed exclusively for the field of water recycling and is officially called

## aquatherm lilac pipe

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, giving us both the colour and name for our reclaimed water service lines.

Reclaimed and recycled water sources, and rainwater catchment systems are being specified and installed much more frequently as building and plumbing codes are updated to allow this as a means for improving water conservation. The codes will require that the system be kept entirely separate from the potable water supply, and that the piping be color-coded and labeled to identify it as non-potable.

The new aquatherm lilac pipe has been developed exclusively for these applications. The piping uses the same durable, corrosion-resistant polypropylene material that has been successfully used for hot-and-cold water distribution for over 30 years. This, combined with design modifications, coloring, marking, and independent third-party certification by NSF International, make lilac the ideal choice for water conservation.

### 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	Service life	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 MS		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)
Potable water (cold) Potable water (warm)	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 and Stabi composite pipe: high working stress at lower wall thickness and higher flow rate

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

S = single layer

MS = multilayer stabi - integrated aluminium-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	Service life	aquatherm blue pipe SDR 11 MF, OT & S		aquatherm blue pipe SDR 17,6 MF		aquatherm green pipe SDR 7,4 MF & MS		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)		
	85 °C 185 °F	42,5	6,49	(94)	3,72	(54)	9,79	(142)	10,90	(158)		
		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)		
	90 °C 194 °F	37,5	6,07	(88)	3,49	(51)	9,18	(133)	10,00	(145)		
		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)		
	constant operating temperature 70 °C / 158 °F incl. 60 days per year at	75 °C 167 °F	35	5,39	(78)	3,09	(45)	8,16	(118)	9,10	(132)	
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)		
80 °C 176 °F		45	6,60	(96)	3,79	(55)	10,05	(146)	11,50	(167)		
		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)		
85 °C 185 °F		40	6,18	(90)	3,55	(51)	9,41	(136)	10,70	(155)		
		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)		
90 °C 194 °F		35	5,57	(81)	3,20	(46)	8,48	(123)	9,80	(142)		
		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)		
constant operating temperature 70 °C / 158 °F incl. 90 days per year at	75 °C 167 °F	30	4,90	(71)	2,81	(41)	7,46	(108)	9,00	(131)		
		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)		
	80 °C 176 °F	45	6,45	(94)	3,70	(54)	9,82	(142)	11,40	(165)		
		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)		
	85 °C 185 °F	37,5	5,98	(87)	3,43	(50)	9,09	(132)	10,60	(154)		
		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)		
	90 °C 194 °F	32,5	5,28	(77)	3,03	(44)	8,03	(116)	9,70	(141)		
		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)

$SDR = 2 \times S + 1 \approx d/s$  (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	Service life	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)
15 °C 59 °F	100	10,8	(157)	23,5	(341)	25,2	(366)	26,3	(381)
	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)
20 °C 68 °F	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)
	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)
30 °C 86 °F	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)
	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)
40 °C 104 °F	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)
	1	7,9	(115)	17,1	(248)	20,5	(297)	18,6	(270)
50 °C 122 °F	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)
60 °C 140 °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)
70 °C 158 °F	100	5,5	(80)	11,9	(173)	14,1	(205)	14,3	(207)
	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)
75 °C 167 °F	50	4,7	(68)	10,3	(149)	12,1	(175)	12,2	(177)
	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)
80 °C 176 °F	50	3,1	(45)	6,8	(99)	8,1	(117)	10,2	(148)
	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)
90 °C 194 °F	50	2,5	(36)	5,4	(78)	6,7	(97)	9,3	(135)
	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)
90 °C 194 °F	10	2,0	(29)	4,3	(62)	5,1	(74)	7,3	(106)

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

S = single layer

MS = multilayer stabi - integrated aluminium-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.

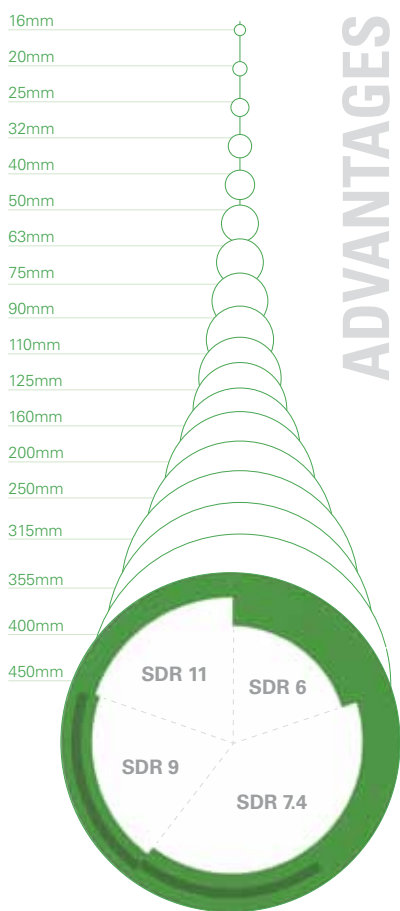
## aquatherm green pipe

**Pipe system made of polypropylene**  
for potable water supply

**SDR:** 6 / 7.4  
**ø:** 16-110 mm  
**Type of pipe:**  
**Old:** Fusiotherm®  
**New:** aquatherm green pipe S

**SDR:** 11  
**ø:** 20-450 mm  
**Type of pipe:**  
**Old:** Fusiotherm® SDR 11  
**New:** aquatherm green pipe S SDR 11

**SDR:** 7.4  
**ø:** 16-110 mm  
**Type of pipe:**  
**Old:** Fusiotherm® stabi composite pipe  
**New:** aquatherm green pipe MS



## 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 aluminium resp. 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

### Important:

**No peeling on using faser composite pipe.**

## aquatherm blue pipe

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

**SDR:** 11  
**ø:** 20-32mm  
**Type of pipe:**  
**Old:** climatherm pipe  
**New:** aquatherm blue pipe S

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

**SDR:** 7.4 / 11  
**ø:** 20-250 mm  
**Type of pipe:**  
**Old:** climatherm faser composite pipe OT  
**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:** 7.4 / 9  
**ø:** 32-250 mm  
**Type of pipe:**  
**Old:** Fusiotherm® ISO faser composite pipe  
**New:** aquatherm green pipe MF TI



### Advantages PP-RP

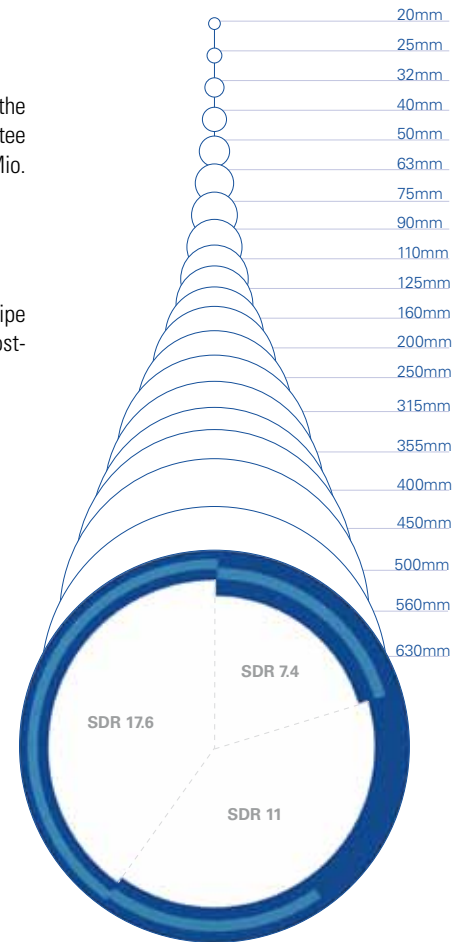
- lower wall-thickness
- 14% higher flow rate at same velocity compared to faser composite pipe SDR 7.4
- the permissible working pressures are on the same level like those of PP-R faser composite pipes SDR 7.4 or are even exceeding them in the higher temperature range
- identical expansion as faser 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.



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

### aquatherm lilac pipe

Pipe system made of polypropylene for reclaimed water

**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.

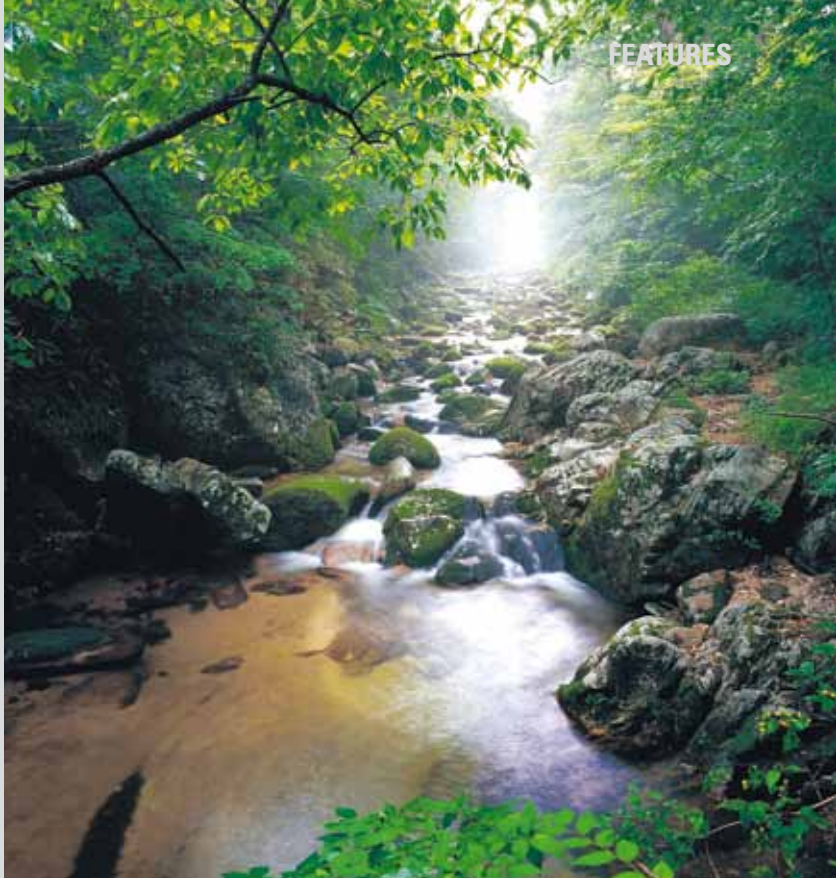
Permanent temperatures from 70°C up to 90° C reduce the service life of the pipe (see table "Permissible Working Pressure", page 23-25).

Using aquatherm PP-R pipes for heating or air conditioning applications the pressure- and temperature conditions according to table "Permissible Working Pressure" are valid.

# 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.**



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.

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

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

## 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.

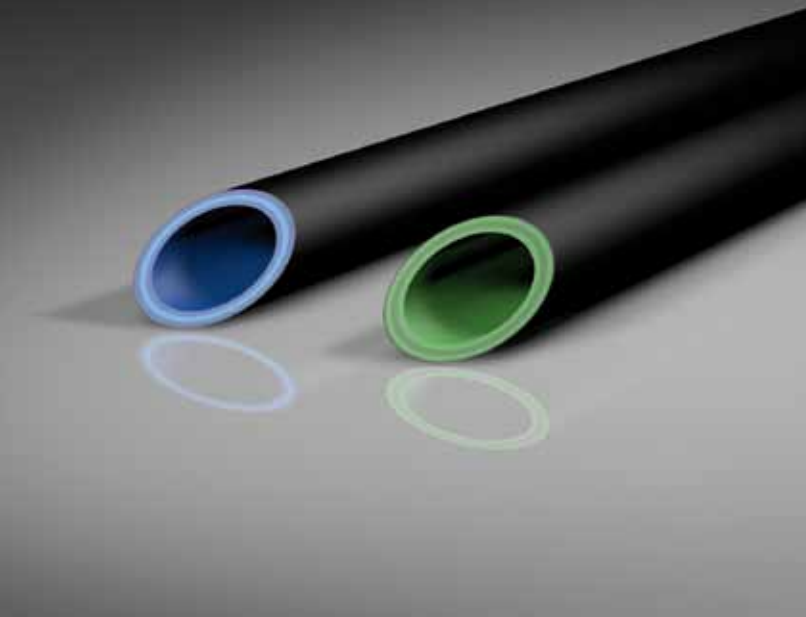
From the origin of the company aquatherm placed emphasis on the fact that its products and manufacturing processes should not pollute our sensitive eco-systems, and ensured development of fully recyclable materials which can thus be added, problem-free, to new production.

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.



### 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 111.

### HYGIENIC SUITABILITY

According to DIN 1988 T2 all installation parts coming directly 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.

#### Material:

The hygienic 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.

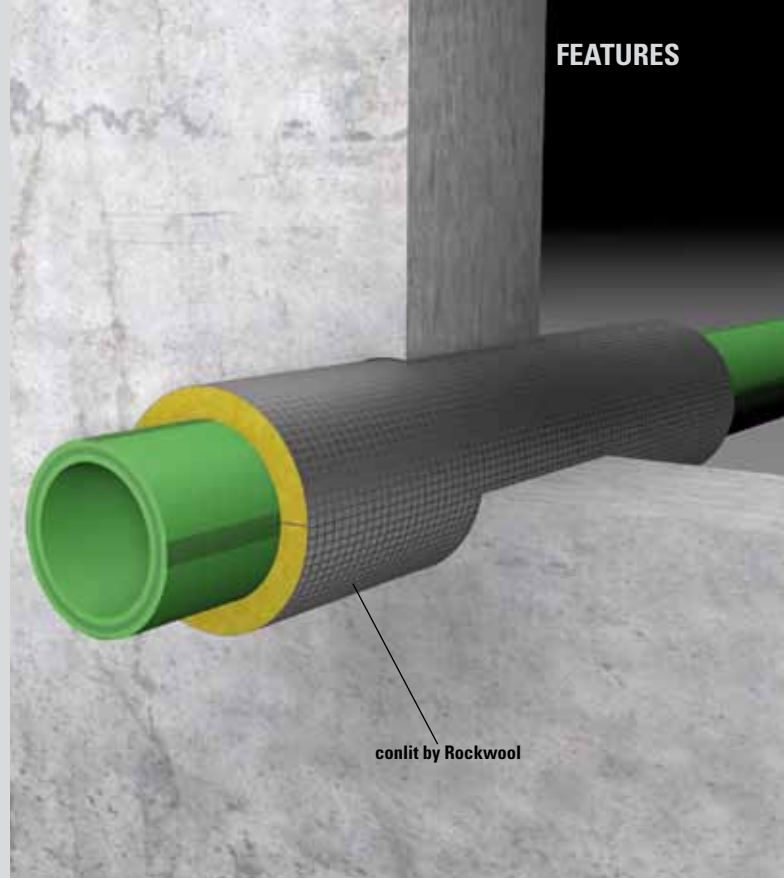
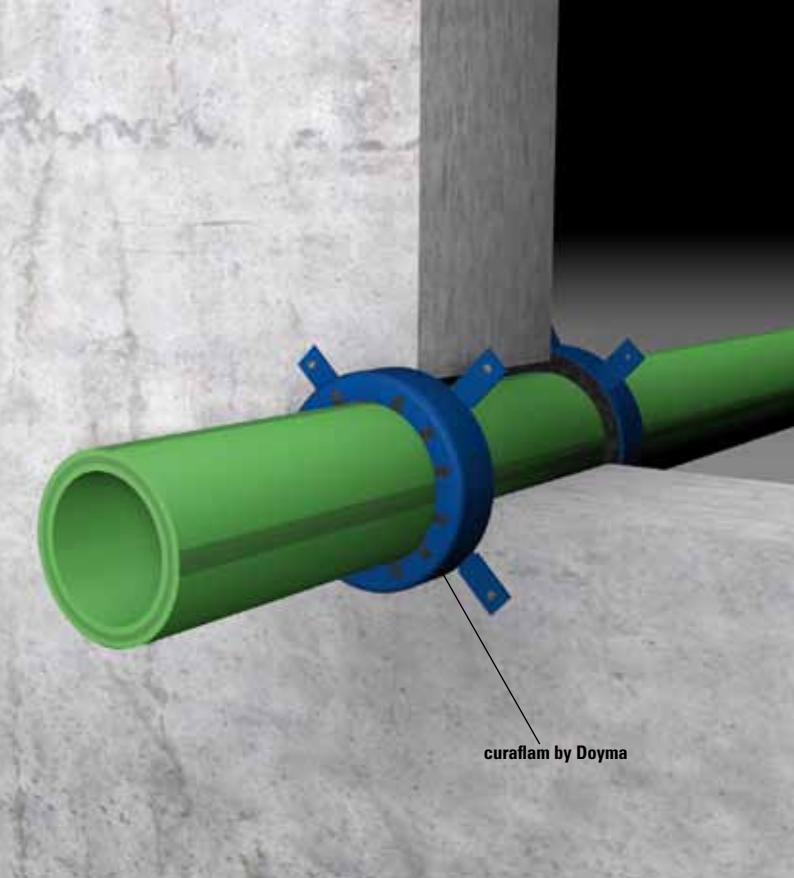
Potable water - our most precious commodity good:

The increasing use of PP in the field of foodpacking confirms the hygienic qualities of the material. This makes aquatherm 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.



## 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. Detailed 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 GmbH & Co. OHG  
Postfach 207  
45952 Gladbeck  
Phone: 02043 408-0 · Fax: 02043 408-444  
Website: [www.rockwool.de](http://www.rockwool.de)
- Doyma GmbH u. Co  
Industriestr. 43-57  
28876 Oyten  
Phone: 04207 9166-0 · Fax: 04207 9166-199  
Website: [www.doyma.de](http://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

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

The integrated layers of aluminium or faser in aquatherm-stabi-composite or 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  $m_{\text{factor}}$  and is taken as 0.8 for polypropylene.

## FIRE PROTECTION

### 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 pipes

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 7,4 MS	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 blue pipe SDR 11 MF SDR 11 MF OT	aquatherm blue pipe SDR 17,6 MF
16	-	1,17	1,5	1,62	-	-	-	-
20	1,32	1,82	2,12	2,04	-	1,76	-	-
25	2,01	2,83	3,27	3,18	-	2,74	-	-
32	3,18	4,54	5,33	5,04	3,12	4,39	3,14	-
40	5,05	7,05	8,24	7,57	5,69	-	4,83	-
50	7,82	10,99	12,77	11,06	8,80	-	7,48	-
63	12,35	17,28	20,26	17,27	14,03	-	11,82	-
75	17,21	24,58	28,68	24,80	19,71	-	16,48	-
90	24,92	35,21	41,22	36,84	28,41	-	23,86	-
110	36,89	52,68	61,45	58,75	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



## 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 more than 12 hours.

Alternatively, 150 mg/l hydrogen peroxide (H<sub>2</sub>O<sub>2</sub>) 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. It is not recommended using chlorine dioxide.

### 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.

The use of chlorine dioxide is not recommended.

A prophylactic and permanent disinfection is contradictory to the requirement of minimization of the drinking water ordinance and is consequently not to be carried out.

### 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.

## CHLORINE DIOXIDE AS DISINFECTANT

The use of chlorine dioxide as disinfectant in the drinking water supply was increasing in some countries over the last years. Reasons for that are the easy and low-priced production and dosing of chlorine dioxide, compared to chlorine. In addition the chemical reactivity, and thus the disinfecting effect, is about three times higher than in case of chlorine.

Materials in the drinking water system are however affected due to this high oxidation potential, too. Along with sealing materials, piping components are damaged, regardless of whether these are made of plastic or metal.

Therefore, chlorine dioxide should not be used in our system as a disinfection agent.

## 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 10508 Plastic 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 potable 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

### System-specific 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.

#### System-specific 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.

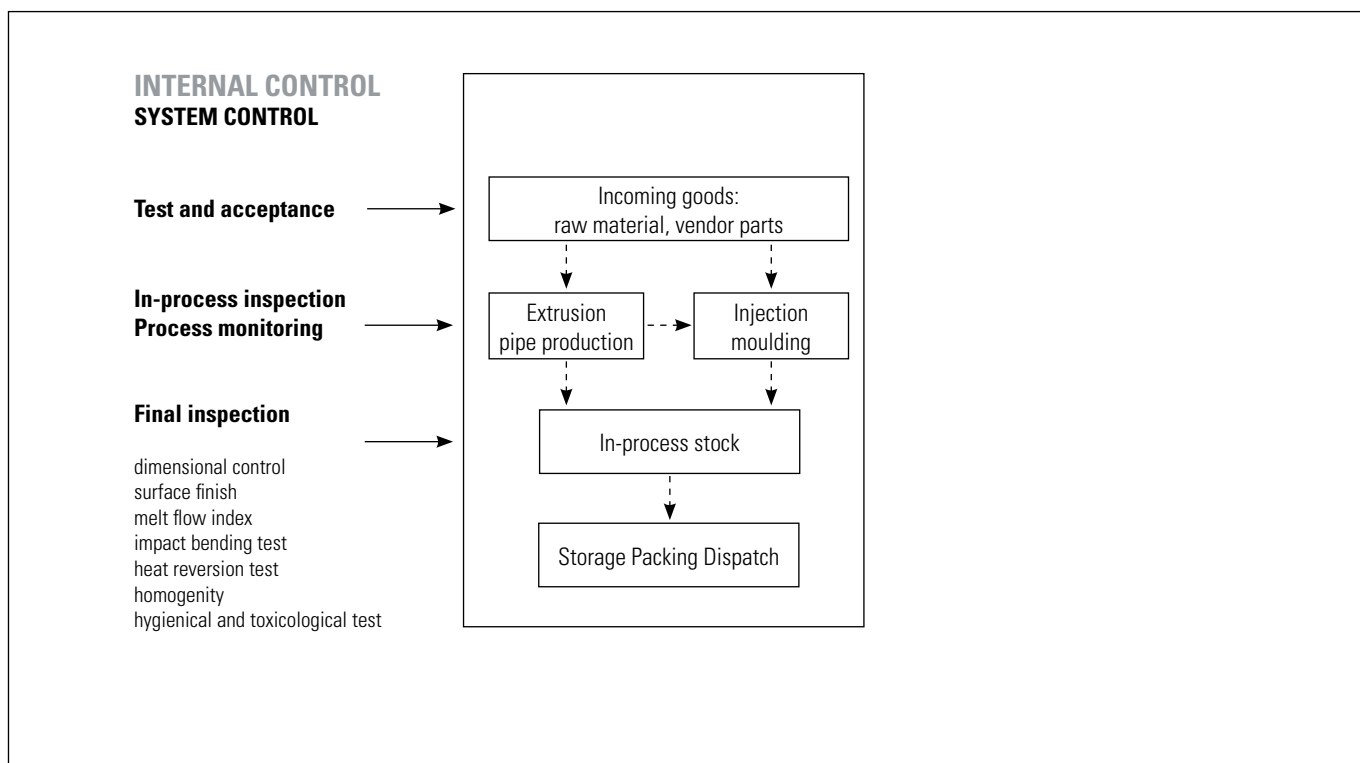
\*(Additional regional decrees and recommendations are disregarded.)

## 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 are carried out regularly in the company's own sensory analysis 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 type Light 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 adjoining 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:

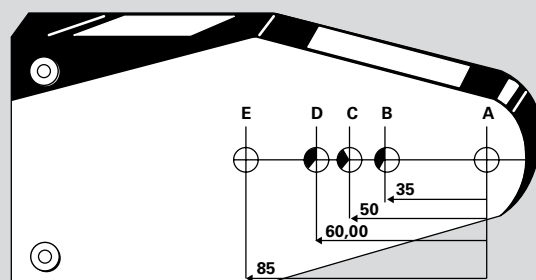
The power supply must coincide with the data on the type plate of the welding device and must be protected according to the local regulations. To avoid high power loss, the conductor cross-section of the used extension cables must be selected according to the power input of the welding devices.

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

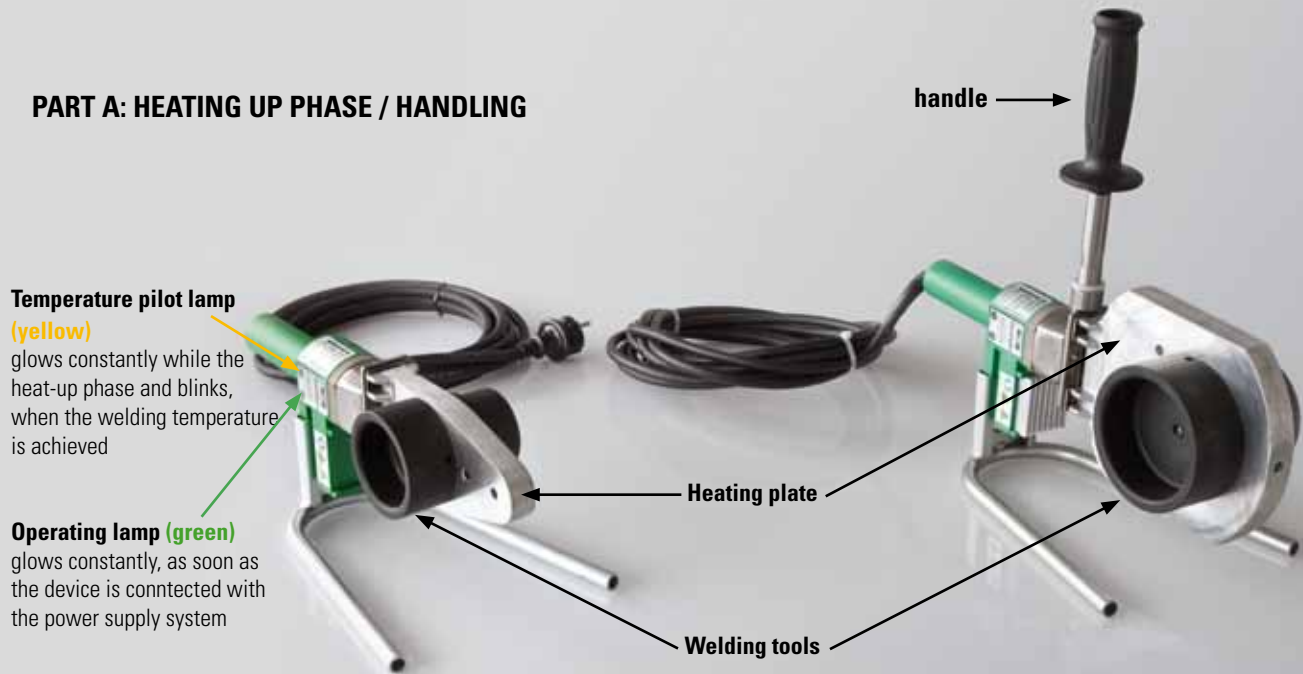
A

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
85124	Ø 20 mm	A + B	Ø 16 mm	A + C

B



**PART A: HEATING UP PHASE / HANDLING**



**Temperature pilot lamp (yellow)**  
glows constantly while the heat-up phase and blinks, when the welding temperature is achieved

**Operating lamp (green)**  
glows constantly, as soon as the device is connected with the power supply system

**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

### 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.



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



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
		sec. DVS	sec. AQE*		
mm	mm			sec.	min.
16	13,0	5	8	4	2
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



Heating-up of pipe and fitting



Joining, fixing and...



...aligning



The result: a permanent connection!

\*heating times recommended by aquatherm at ambient temperatures below + 5 °C

**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), UV (UV-resistant) and MS (multilayer stabi) pipes 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  $\varnothing$  20- $\varnothing$  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  $\varnothing$ 20-  $\varnothing$ 63 mm (Art.-No. 50499) and  $\varnothing$ 75-  $\varnothing$ 125 (Art.-No. 50500) mm are available. For the mechanical 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

## 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.

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

When using aquatherm green pipe-stabi composite pipes remove the rest of the aluminium remaining at the bore hole with the aquatherm-chamfering device.

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 from the aquatherm blue pipe ot

**aquatherm** saddle peeling tools for **aquatherm blue pipe ot** 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 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



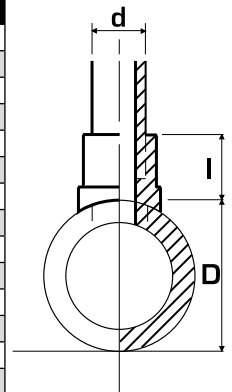
Joining



Ready!

**PART C: WELD-IN SADDLES**

Art.-No.	Dimension	D	d	l	Drill	Chamfering Device <sup>1</sup>	Special peeling drill <sup>2</sup>	Tool
		mm	mm	mm	Art.-No.	Art.-No.	Art.-No.	Art.-No.
15156	40/20 mm	40	25	27.0	50940	50910	50921	50614
15158	40/25 mm	40	25	28.0	50940	50910	50921	50614
15160	50/20 mm	50	20	27.0	50940	50910	50921	50616
15162	50/25 mm	50	25	28.0	50940	50910	50921	50616
15164	63/20 mm	63	20	27.0	50940/15941	50910	50921	50619
15166	63/25 mm	63	25	28.0	50940/15941	50910	50921	50619
15168	63/32 mm	63	32	30.0	50942	50912	50922	50620
15170	75/20 mm	75	20	27.0	50940/15941	50910	50921	50623
15172	75/25 mm	75	25	28.0	50940/15941	50910	50921	50623
15174	75/32 mm	75	32	30.0	50942	50912	50922	50624
15175	75/40 mm	75	40	34.0	50944	50914	50924	50625
15176	90/20 mm	90	20	27.0	50940/15941	50910	50921	50627
15178	90/25 mm	90	25	28.0	50940/15941	50910	50921	50627
15180	90/32 mm	90	32	30.0	50942	50912	50922	50628
15181	90/40 mm	90	40	34.0	50944	50914	50924	50629
15182	110/20 mm	110	20	27.0	50940/15941	50910	50921	50631
15184	110/25 mm	110	25	28.0	50940/15941	50910	50921	50631
15186	110/32 mm	110	32	30.0	50942	50912	50922	50632
15188	110/40 mm	110	40	34.0	50944	50914	50924	50634
15189	110/50 mm	110	50	34.0	50946	-	50926	50635
15190	125/20 mm	125	20	27.0	50940/15941	-	50921	50636
15192	125/25 mm	125	25	28.0	50940/15941	-	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	50940/15941	-	50421	50648
15208	160/25 mm	160	25	28.5	50940/15941	-	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	50950	-	-	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

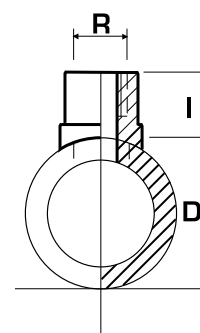


1 only for stabl-composite-pipes Art.-No. 70806-70856  
 2 only for aquatherm blue pipe OT faser composite pipes, Art.-No. 2170708-2170138  
 \*\* tool holder MK4

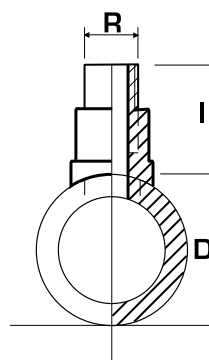


**PART C: WELD-IN SADDLES**

Art.-No.	Dimension	D	d	l	Sensor-wells	Drill	Chamfering Device <sup>1</sup>	Special peeling drill <sup>2</sup>	Tool
		mm	mm	mm	Art.-No.	Art.-No.	Art.-No.	Art.-No.	Art.-No.
28214	40/25 x 1/2" IG.	40	1/2"	39,0	14	50940	50910	50921	50614
28216	50/25 x 1/2" IG.	50	1/2"	39,0	14	50940	50910	50921	50616
28218	63/25 x 1/2" IG.	63	1/2"	39,0	14	50940/15941	50910	50921	50619
28220	75/25 x 1/2" IG.	75	1/2"	39,0	14	50940/15941	50910	50921	50623
28222	90/25 x 1/2" IG.	90	1/2"	39,0	14	50940/15941	50910	50921	50627
28224	110/25 x 1/2" IG.	110	1/2"	39,0	14	50940/15941	50910	50921	50631
28226	125/25 x 1/2" IG.	125	1/2"	39,0	14	50940/15941	-	50921	50636
28230	160/25 x 1/2" IG.	160	1/2"	39,0	14	50940/15941	-	50921	50648
28232	200-250/25 mm x 1/2" IG.	200-250	1/2"	39,0	14	50941	-	50921	50660 / 50672
28234	40/25 x 3/4" IG.	40	3/4"	39,0	16	50940	50910	50920	50614
28236	50/25 x 3/4" IG.	50	3/4"	39,0	16	50940	50910	50921	50616
28238	63/25 x 3/4" IG.	63	3/4"	39,0	16	50940/15941	50910	50921	50619
28240	75/25 x 3/4" IG.	75	3/4"	39,0	16	50940/15941	50910	50921	50623
28242	90/25 x 3/4" IG.	90	3/4"	39,0	16	50940/15941	50910	50921	50627
28244	110/25 x 3/4" IG.	110	3/4"	39,0	16	50940/15941	50910	50921	50631
28246	125/25 x 3/4" IG.	125	3/4"	39,0	16	50940/15941	-	50921	50636
28250	160/25 x 3/4" IG.	160	3/4"	39,0	16	50940/15941	-	50921	50648
28254	200-250/25 mm x 3/4" IG.	200-250	3/4"	39,0	16	50941	-	50921	50660 / 50672
28260	75/32 x 1" IG.	75	1"	43,0	20	50942	50912	50922	50624
28262	90/32 x 1" IG.	90	1"	43,0	20	50942	50912	50922	50628
28264	110/32 x 1" IG.	110	1"	43,0	20	50942	50912	50922	50632
28266	125/32 x 1" IG.	125	1"	43,0	20	50942	-	50922	50638
28270	160/32 x 1" IG.	160	1"	43,0	20	50942	-	50922	50650
28274	200-250/32 mm x 1" IG.	200-250	1"	43,0	20	50942	-	50922	50662 / 50674



Art.-No.	Dimension	D	d	l	Drill	Chamfering Device <sup>1</sup>	Special peeling drill <sup>2</sup>	Tool
		mm	mm	mm	Art.-No.	Art.-No.	Art.-No.	Art.-No.
28314	40/25 x 1/2" AG.	40	1/2"	55,0	15940	50910	50921	50614
28316	50/25 x 1/2" AG.	50	1/2"	55,0	15940	50910	50921	50616
28318	63/25 x 1/2" AG.	63	1/2"	55,0	15940/15941	50910	50921	50619
28320	75/25 x 1/2" AG.	75	1/2"	55,0	15940/15941	50910	50921	50623
28322	90/25 x 1/2" AG.	90	1/2"	55,0	15940/15941	50910	50921	50627
28324	110/25 x 1/2" AG.	110	1/2"	55,0	15940/15941	50910	50921	50631
28326	125/25 x 1/2" AG.	125	1/2"	55,0	15940/15941	-	50921	50636
28330	160/25 x 1/2" AG.	160	1/2"	55,0	15940/15941	-	50921	50648
28334	40/25 x 3/4" AG.	40	3/4"	56,0	15940	50910	50921	50614
28336	50/25 x 3/4" AG.	50	3/4"	56,0	15940	50910	50921	50616
28338	63/25 x 3/4" AG.	63	3/4"	56,0	15940/15941	50910	50921	50619
28340	75/25 x 3/4" AG.	75	3/4"	56,0	15940/15941	50910	50921	50623
28342	90/25 x 3/4" AG.	90	3/4"	56,0	15940/15941	50910	50921	50627
28344	110/25 x 3/4" AG.	110	3/4"	56,0	15940/15941	50910	50921	50631
28346	125/25 x 3/4" AG.	125	3/4"	56,0	15940/15941	-	50921	50636
28350	160/25 x 3/4" AG.	160	3/4"	56,0	15940/15941	-	50921	50648



<sup>1</sup> only for stabi-composite-pipes Art.-No. 70806-70856

<sup>2</sup> only for aquatherm blue pipe OT faser composite pipes, Art.-No. 2170708-2170138

## 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

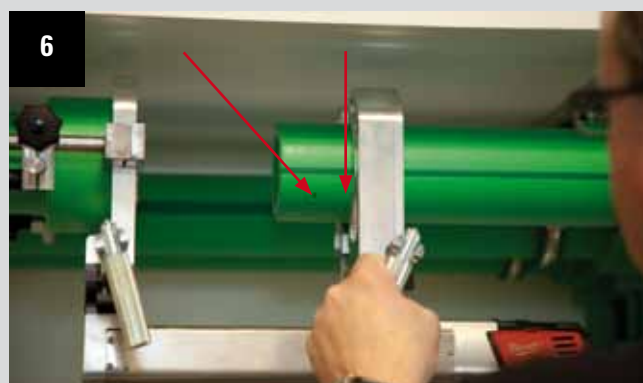
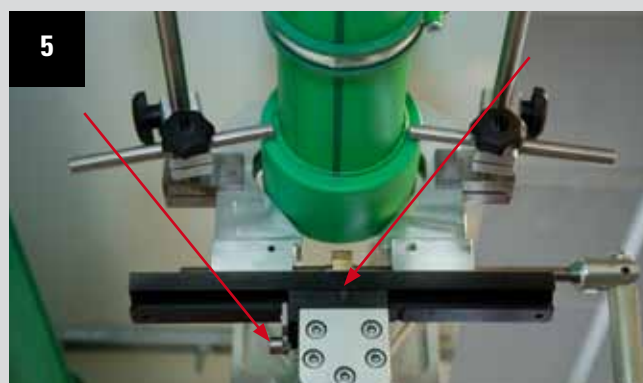
The pulling jig is now placed on the fitting or pipe to be welded with the clamping jaws (Fig. 4).

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).



**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).



Pipe external mm	Welding depth mm	Heating time		Welding time	Cooling time
		sec. DVS	sec. AQE*	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

\*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.**

## PART E: AQUATHERM-WELDING MACHINE

for stationary processing 50 – 125 mm

precise pre-assembly and facilitation by hand creek

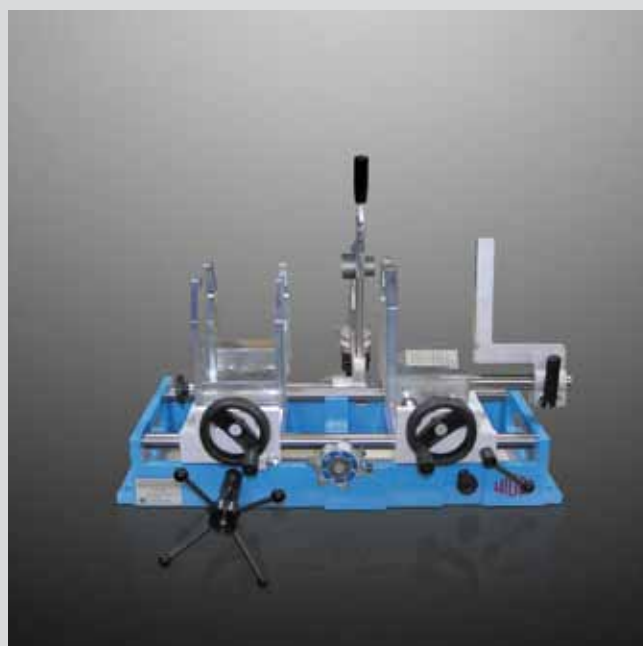
clamping jaws 50 – 125 mm, tools 50 – 125 mm

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
		sec. DVS	sec. AQE*		
mm	mm			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

The general guidelines for heated tool socket welding acc. to DVS 2207 part 11 are applied hereupon.

\*heating times recommended by aquatherm at ambient temperatures below + 5 °C

#### 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 centrally 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 Hz - 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. 50572-50592 (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, the aluminium-PP-composite layer of the stabi-composite pipe 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.

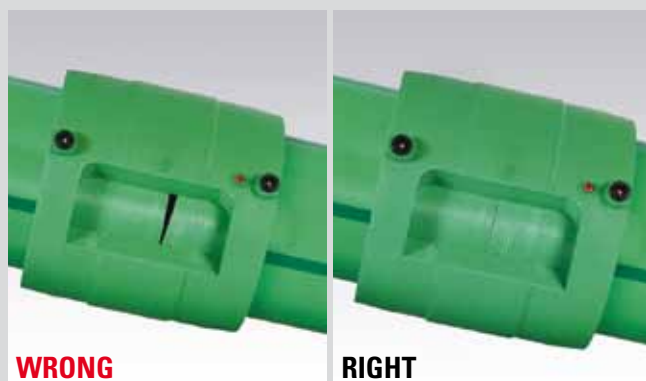
### Working pressure

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

## 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.

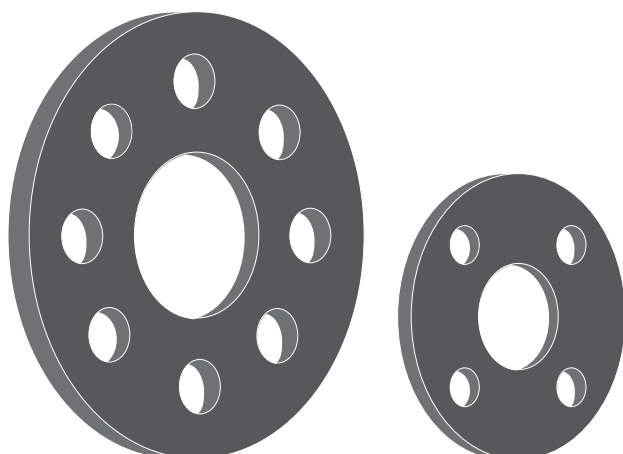
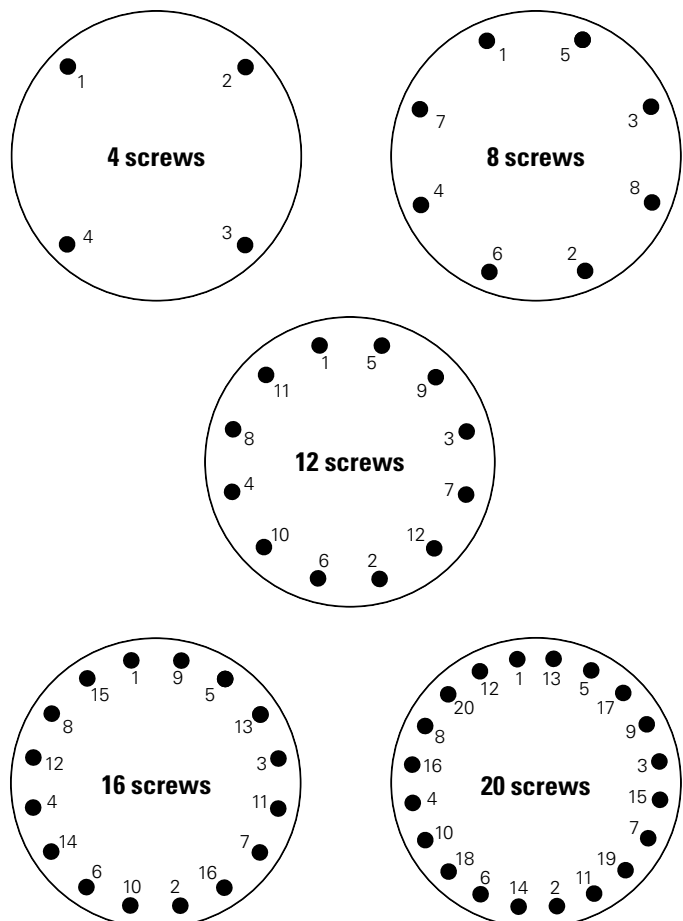
### TORQUE FLANGE according to manufacturer's instructions

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

### TIGHTENING SEQUENCE

Number of screws	Criss-Cross Pattern Tightening Sequence
4	1 - 2 - 3 - 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 - 10 - 15 - 20 >> 2 - 12 - 7 - 17 >> 4 - 14 - 9 - 19

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



## 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 of a 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

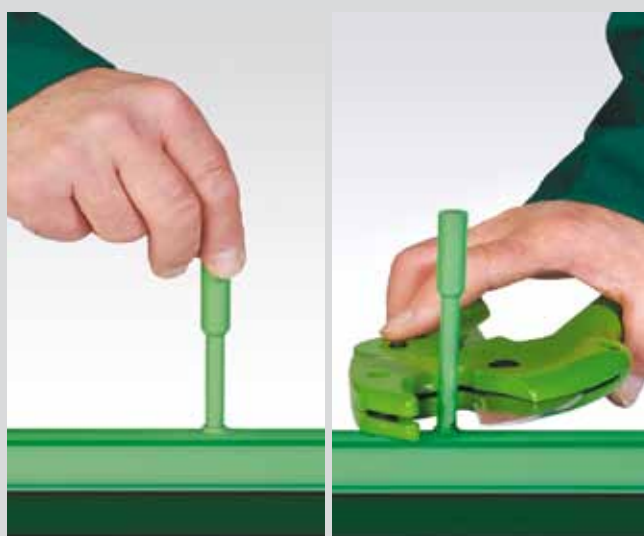
### pipe repair stick.

The necessary welding tool (Art.-No. 50307/11) and repair stick (Art.-No. 60600) are described on page 156.

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 MF faser-composite pipe

aquatherm green pipe SDR 9 MF faser-composite pipe

aquatherm blue pipe SDR 11 MF faser-composite pipe

aquatherm blue pipe SDR 11 MF OT faser-composite pipe

aquatherm blue pipe SDR 17.6 MF faser-composite pipe

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

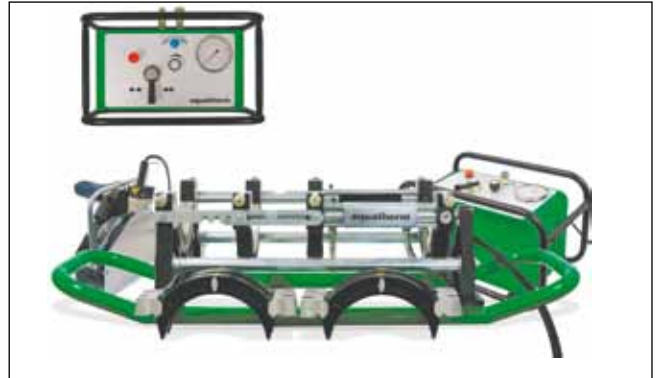
1. Protect your place of work from weather influences
2. Check, if welding machine works properly and heat it up
3. Cut pipes into required length
4. Plastic pipes are aligned and fixed by means of the clamping elements
5. Use the milling machine for planing the pipe end to be plane-parallel
6. Remove 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, aquatherm blue pipe OT pipes have to be burred at the front. 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



## 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 Rothenberger  
 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

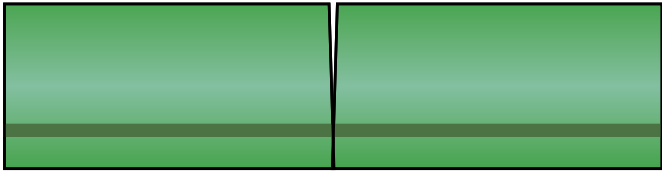


Join the pipes, cool down under pressure

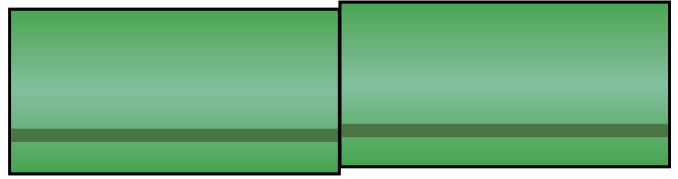


Unclamp and work on...

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



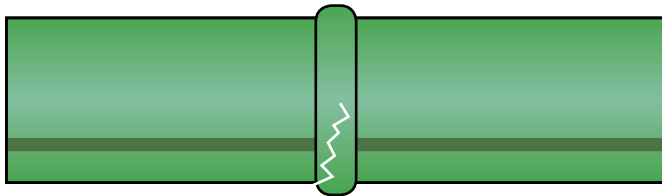
Gap width up to 355 mm outer diameter = 0.5 mm  
 Gap width from 400 mm to 630 mm outer diameter = 1 mm



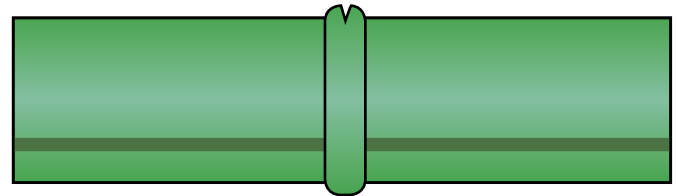
The misalignment cannot be more than 10% of the wall thickness or max. 2 mm

### Welding defects during butt-welding

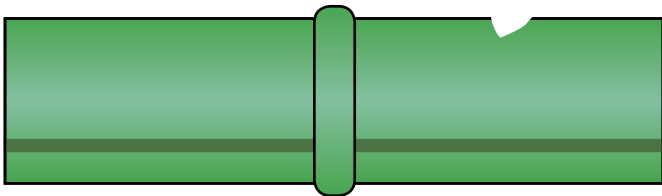
Normally a bead around the entire circumference is formed at the edge of the socket during the welding process. This bead indicates the proper welding. It is important to assure that the following welding defects are avoided:



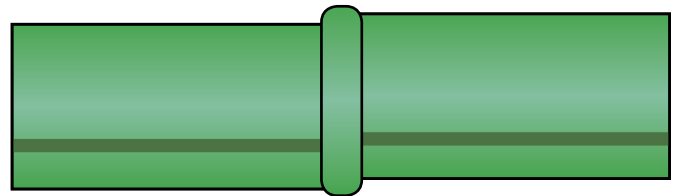
Cracks



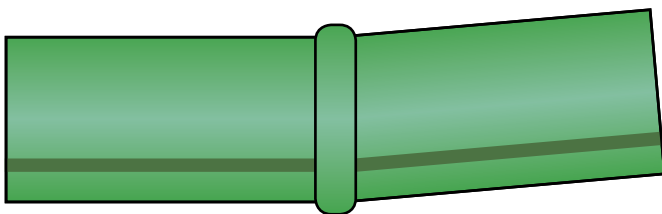
Grooves in the bead



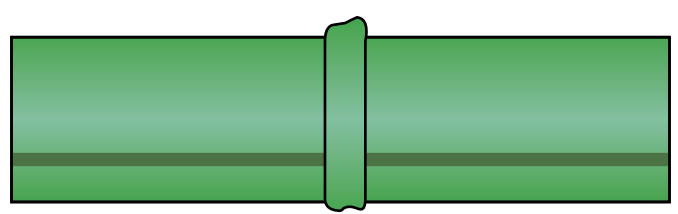
Grooves and scratches



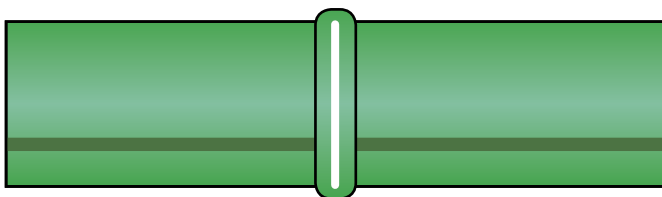
Misalignment of the joining area



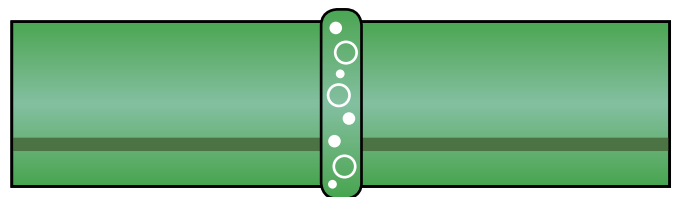
Tilting of the joining area



Uneven welding bead

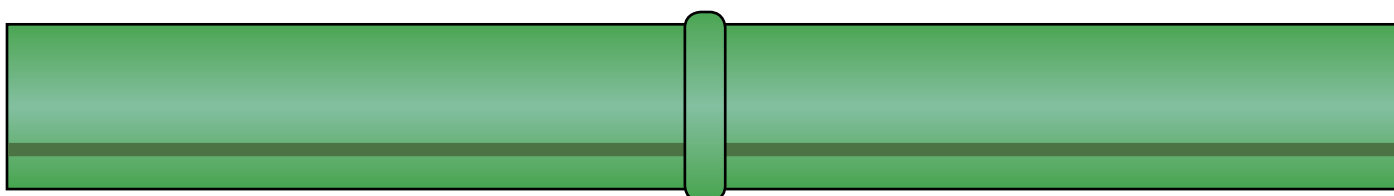


Lack of fusion at the joining area



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.



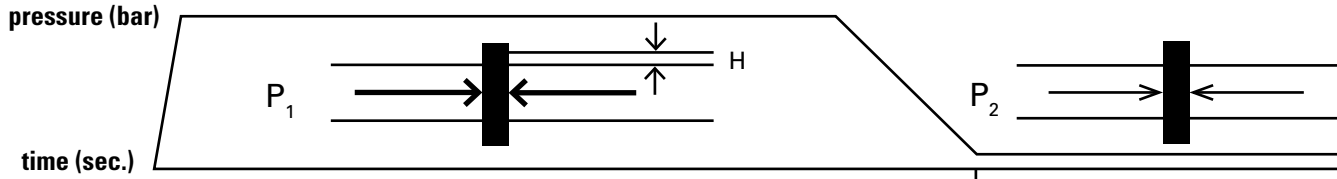
For perfect welding joints, both the welding areas and tools must be clean and free of grease.

**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**

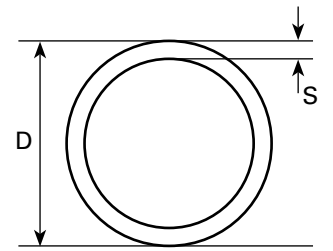


Dimension (mm)	Pipe series SDR	P1 Adjustment pressure (bar)					Height of bead (mm)	P2 Heating pressure (bar)		
		Rothenberger Art.-No. 50163, 50167 + 50178	Ritmo Art.-No. 50165	Ritmo Art.-No. 50166	Ritmo Art.-No. 50177	Ritmo Art.-No. 50169		Rothenberger Art.-No. 50163, 50167 + 50178	Ritmo Art.-No. 50165	Ritmo Art.-No. 50166
160x9,1	17,6	7	7	6	3		1	1	1	
160x14,6	11	11	11	10	5		1	1	1	
160x17,9	9	13	13	12	6		1	1	1	
160x21,9	7,4	15	16	14	7		1,5	2	2	
200x11,4	17,6	11	11	10	5		1	1	1	
200x18,2	11	17	18	16	7		1	2	2	
200x22,4	9	20	21	19	9		1,5	2	2	
200x27,4	7,4	24	25	22	11		2	2	3	
250x14,2	17,6	17	18	16	7		1	2	2	
250x22,7	11	26	28	24	11		1,5	3	3	
250x27,9	9	31	33	29	14		2	3	3	
250x34,2	7,4	37	39	35	16		2	4	4	
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 joint connection is manufactured under factory conditions and
- the removal from the welding machine and the temporary storage cause only a slight load to the joint connection and
- the joining parts have a wall thickness  $\geq 15$  mm



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

		$t_2$			$t_3$					$t_4$	
					P <sub>3</sub>						
					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.)	
		t <sub>1</sub>	t <sub>2</sub>	t <sub>3</sub>						t <sub>4</sub>	
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	

## FASTENING TECHNIQUE / FIXED POINTS / SLIDING POINTS

### Fastening technique

Pipe clamps for aquatherm 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)	MS Pipes (stabi composite pipe)
Sliding Point	1 distance ring	2 distance rings
Fixed point	no distance ring	1 distance ring

### Linear expansion

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

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

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 MS & MF** **aquatherm blue pipe MF**

The linear expansion of aquatherm-stabi-composite pipes and 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.

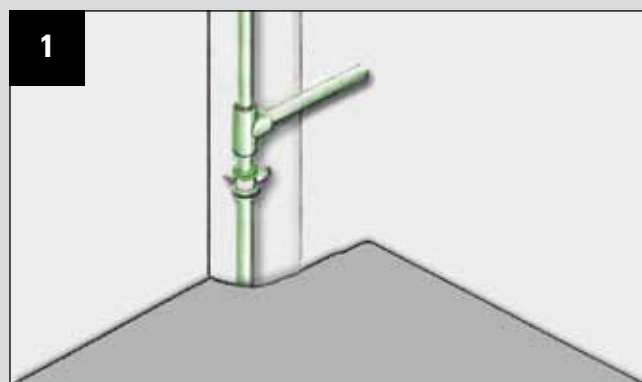
#### **aquatherm green pipe** **aquatherm blue pipe** **aquatherm lilac pipe**

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

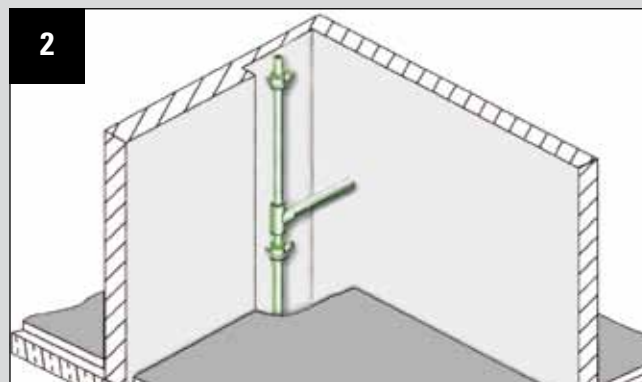
This can be ensured by a favourable fixing of the riser in the duct (see 2).

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

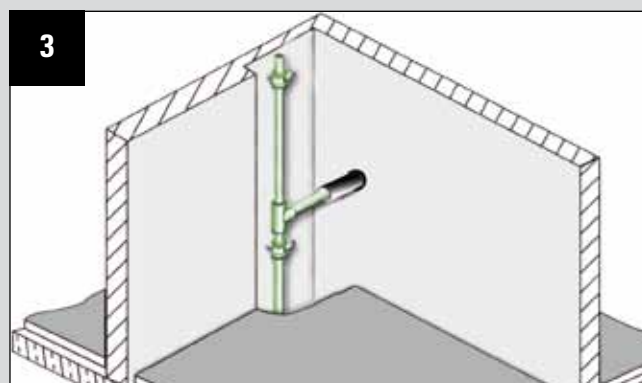
Furthermore the installation of a spring leg gives the appropriate elasticity (see 4).



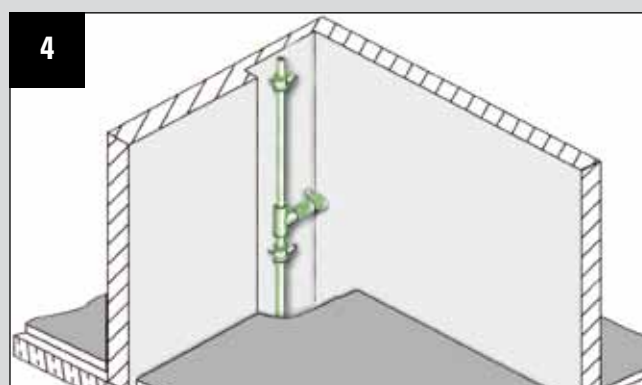
Positioning of the fixed point clamp



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-stabi composite/faser composite pipes for hot water and heating plants make this possible. The coefficient (a) of linear expansion of aquatherm-composite pipes is only

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

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

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

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

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

aquatherm-stabi/-faser composite pipes must have enough space to expand (see below). An expansion control must be required for long and straight stabi composite/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
$\Delta L$	Linear expansion	?	[mm]
$\alpha_1$	Coefficient of linear expansion aquatherm green pipe MS-stabi composite pipe	0,03	mm/mK
$\alpha_2$	Coefficient of linear expansion aquatherm-faser composite pipe	0,035	mm/mK
$\alpha_3$	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
$\Delta T$	Temperature difference between working and installation temperature ( $\Delta T = T_W - T_M$ )	40	K

The linear expansion  $\Delta L$  is calculated according to the following formula:

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

#### Material:

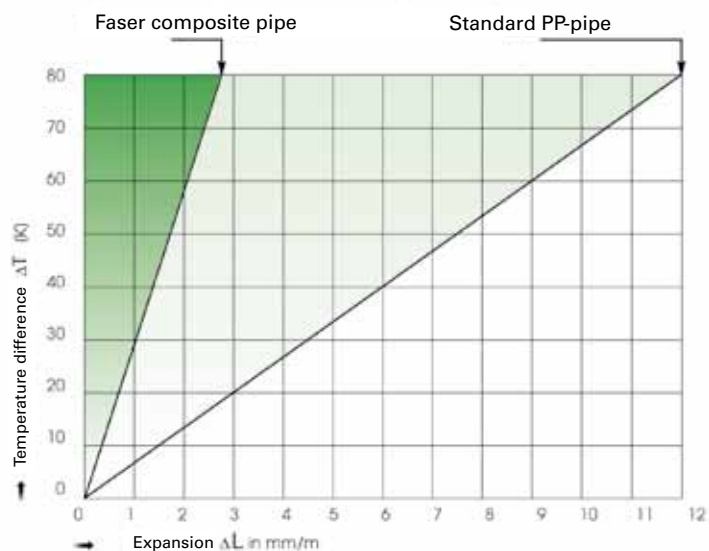
aquatherm green pipe MS- faser composite pipe (a = 0.03 mm/mK)

$$\Delta L = 0,035 \text{ mm/mK} \times 25,0 \text{ m} \times 40 \text{ K}$$

$$\Delta L = 35,0 \text{ mm}$$

### Linear expansion comparison:

#### faser composite- to standard PP- pipe

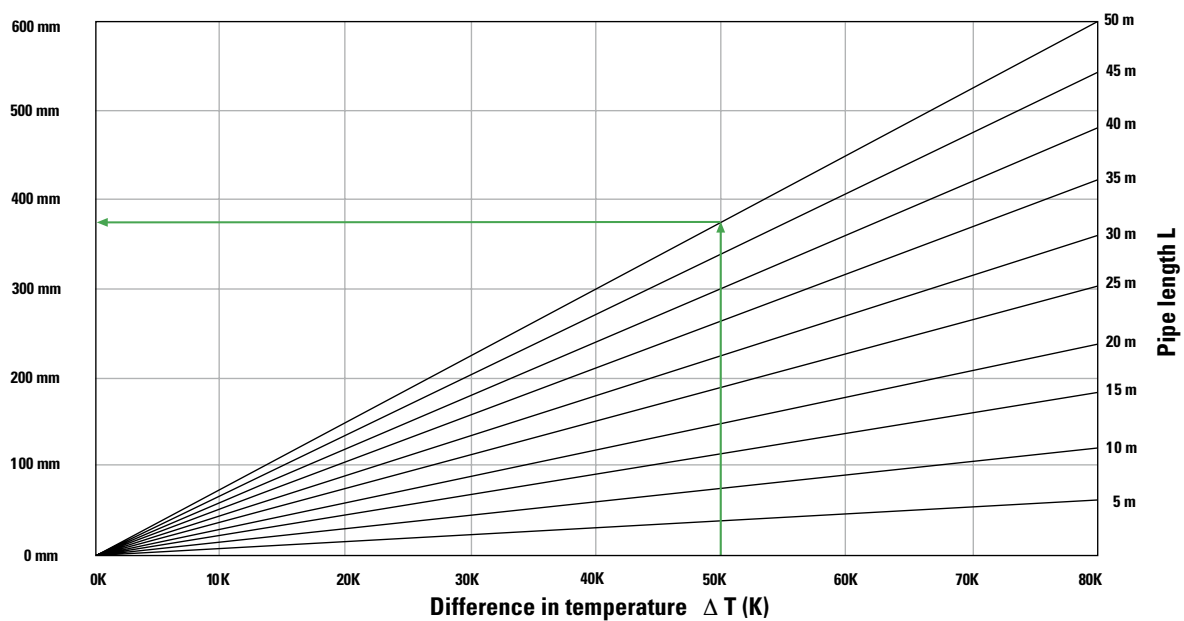


**aquatherm green pipe & aquatherm blue pipe**  
(without faser)

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

**Linear expansion**  $\Delta L$  in [mm]: green- and blue pipe -  $\alpha = 0,150$  mm/mK

Pipe length	Difference in temperature $\Delta T = T_{\text{operating temperature}} - T_{\text{installation temperature}}$							
	10 K	20 K	30 K	40 K	50 K	60 K	70 K	80 K
	Linear expansion $\Delta L$ (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

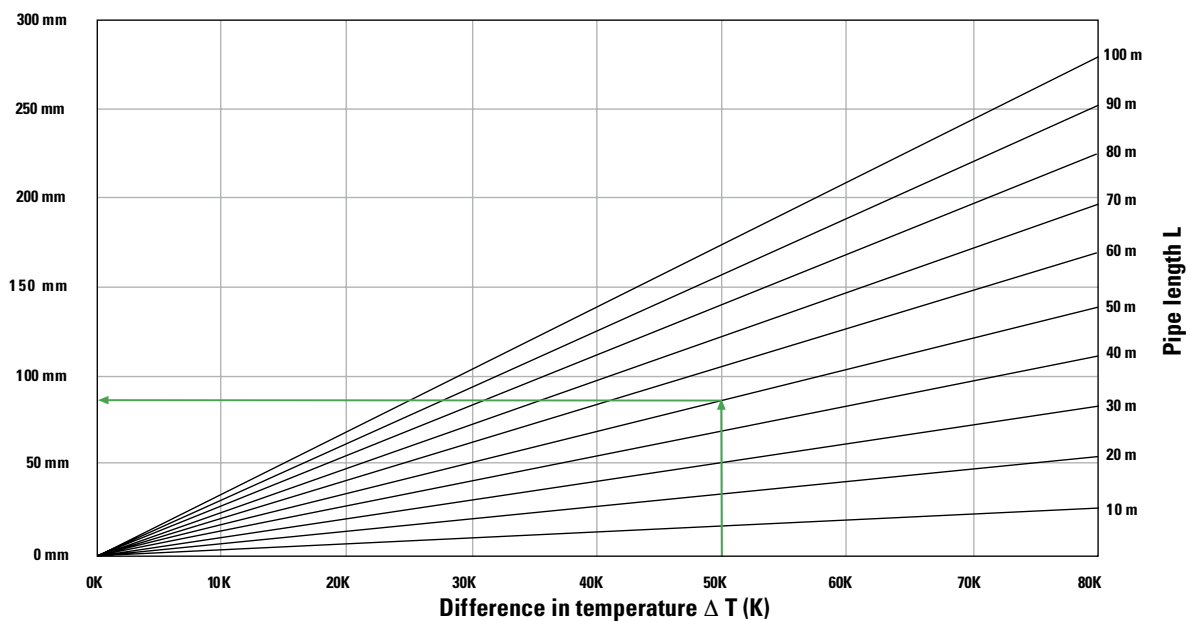


**aquatherm green pipe MF (faser composite pipe)**  
**aquatherm blue pipe MF (faser composite pipe)**

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  $\frac{1}{5}$  of the mere PP-pipes.

Linear expansion  $\Delta L$  in [mm]: aquatherm-faser composite pipes -  $\alpha = 0.035 \text{ mm/mK}$

Pipe length	Difference in temperature $\Delta T = T_{\text{operating temperature}} - T_{\text{installation temperature}}$							
	10 K	20 K	30 K	40 K	50 K	60 K	70 K	80 K
	Linear expansion $\Delta L$ (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

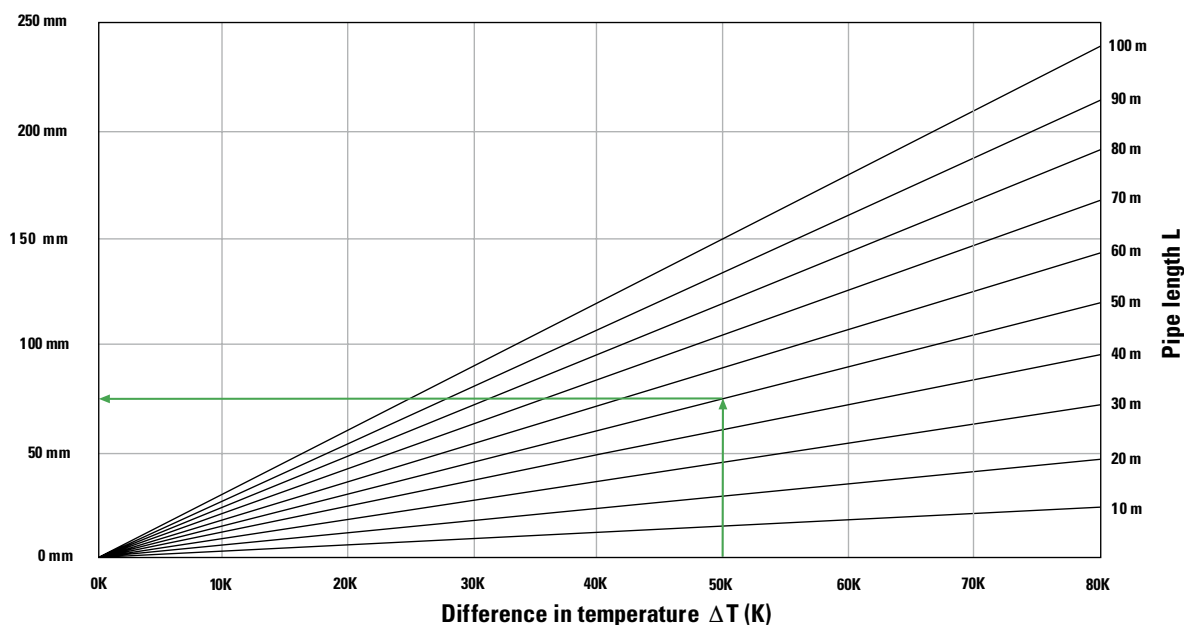


## aquatherm green pipe MS (stabi composite pipe)

Due to the integration and positive bond of the different materials, the aquatherm-stabi composite pipe offers much higher stability. The linear expansion reduces its value to  $\frac{1}{5}$  of the mere PP-pipes.

Linear expansion  $\Delta L$  in [mm]: aquatherm green pipe MS - stabi composite pipe -  $\alpha = 0,030 \text{ mm/mK}$

Pipe length	Difference in temperature $\Delta T = T_{\text{operating temperature}} - T_{\text{installation temperature}}$							
	10 K	20 K	30 K	40 K	50 K	60 K	70 K	80 K
	Linear expansion $\Delta L$ (mm)							
10 m	3	6	9	12	15	18	21	24
20 m	6	12	18	24	30	36	42	48
30 m	9	18	27	36	45	54	63	72
40 m	12	24	36	48	60	72	84	96
50 m	15	30	45	60	75	90	105	120
60 m	18	36	54	72	90	108	126	144
70 m	21	42	63	84	105	126	147	168
80 m	24	48	72	96	120	144	168	192
90 m	27	54	81	108	135	162	189	216
100 m	30	60	90	120	150	180	210	240



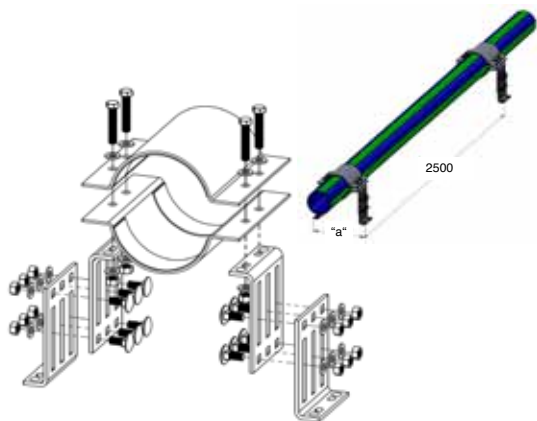
**PIPE CLAMPS suitable as fixing point**

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.

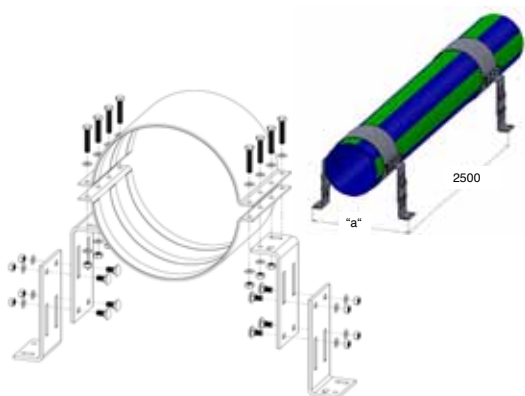
**Advantages:**

- 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





## BENDING SIDE

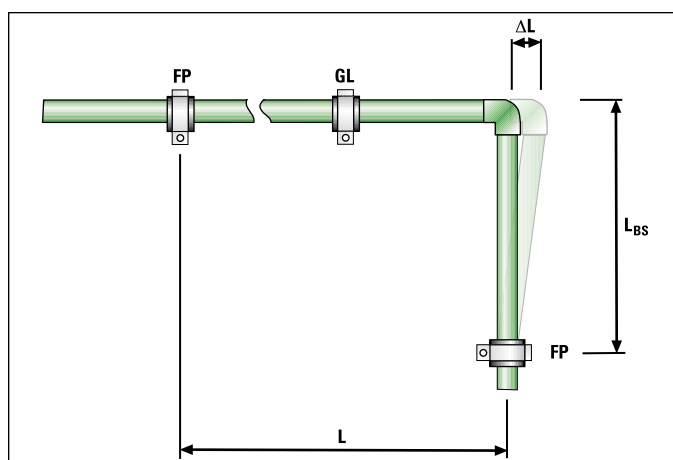
Linear expansion due to temperature difference between operating temperature and installation temperature can be compensated by different installation techniques.

### Bending side

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

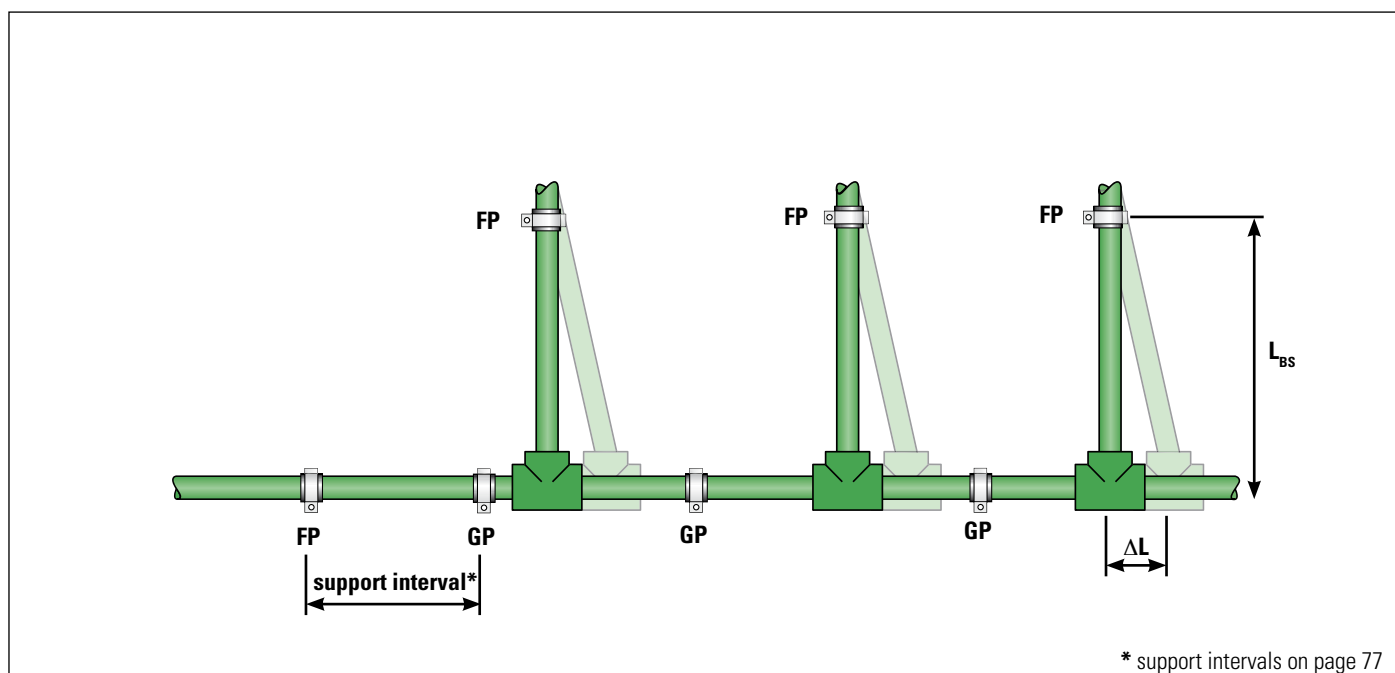
The values of the bending side can be taken directly from the tables and graphs on the following pages.

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

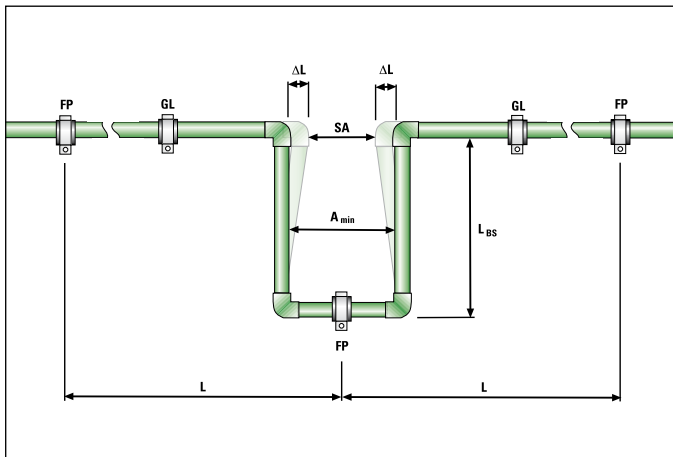
In addition to the length of the bending side  $L_{BS}$  the width of the pipe bend  $A_{min}$  must be considered.

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:

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

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



### Pre-stress

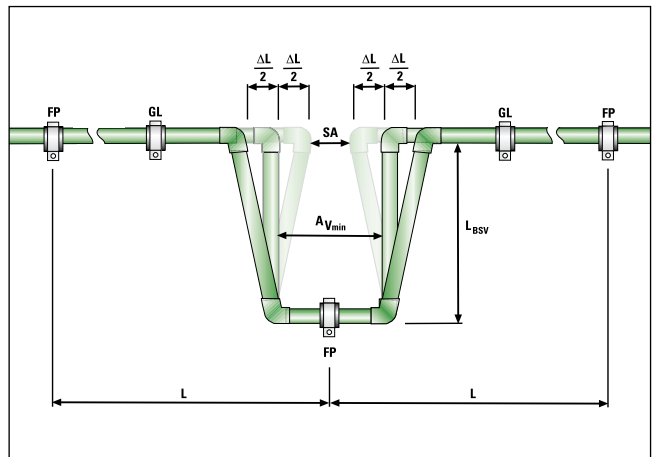
Where space is limited, it is possible to shorten the total width  $A_{min}$  as well as the length of the bending side  $L_{BSV}$  by pre-stressing.

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 with pre-stress is calculated acc. to the following example:

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



### Below expansion joint

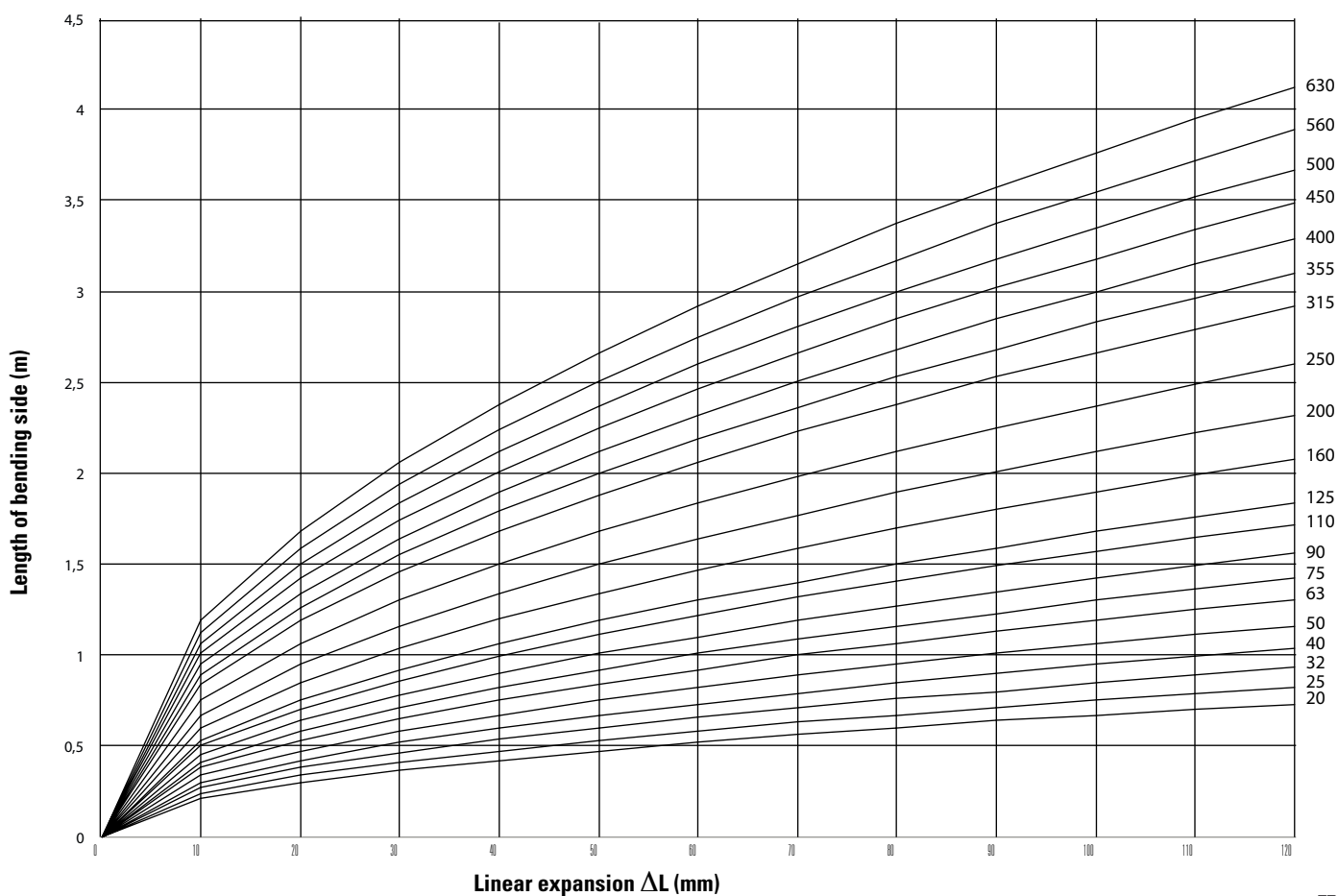
All bellow expansion joints for corrugated pipes designed for metal materials are unsuitable for aquatherm PP-R-pipes.

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.

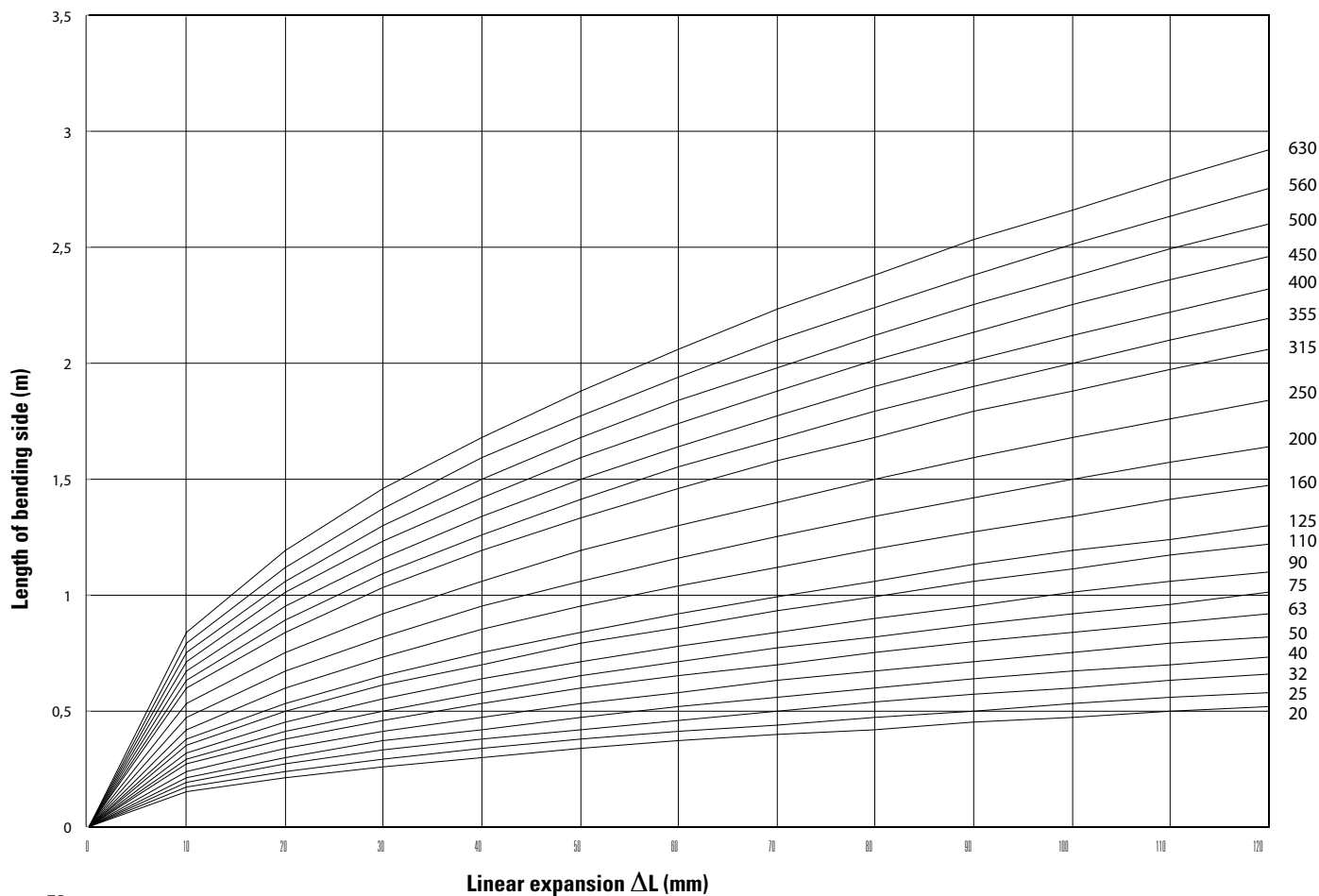
Pipe Dimension	Linear expansion (mm)											
	10	20	30	40	50	60	70	80	90	100	110	120
	Length of bending side (mm)											
20 mm	0,21	0,30	0,37	0,42	0,47	0,52	0,56	0,60	0,64	0,67	0,70	0,73
25 mm	0,24	0,34	0,41	0,47	0,53	0,58	0,63	0,67	0,71	0,75	0,79	0,82
32 mm	0,27	0,38	0,46	0,54	0,60	0,66	0,71	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
	<b>Length of bending side (mm)</b>											
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	0,38	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 $\Delta T$ [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, blue pipe & 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 $\Delta T$ [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	

### aquatherm green pipe SDR 7.4 MS (stabi composite pipe)

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

Difference in temperature $\Delta T$ [K]	Pipe diameter d (mm)									
	16	20	25	32	40	50	63	75	90	110
	Support intervals in cm									
0	130	155	170	195	220	245	270	285	300	325
20	100	120	130	150	170	190	210	220	230	250
30	100	120	130	150	170	190	210	220	230	240
40	100	110	120	140	160	180	200	210	220	230
50	100	110	120	140	160	180	200	210	215	225
60	80	100	110	130	150	170	190	200	205	215
70	70	90	100	120	140	160	180	190	200	205

**SUPPORT INTERVALS**

**aqualtherm green pipe SDR 7.4 MF & blue pipe SDR 7.4 MF (faser composite pipe)**

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

Difference in temperature $\Delta T$ [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.

**aqualtherm green pip SDR 9 MF RP (faser composite pipe)**

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

Difference in temperature $\Delta T$ [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.

**aqualtherm blue pipe SDR 11 MF (faser composite pipe)**

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

Difference in temperature $\Delta T$ [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
75mm	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
110mm	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
160mm	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 polypropylene pipes acc. to test report no.: G.2 - 136/97 of FIW-Munich



## LEAKAGE TEST

All sprinkler pipelines shall be subjected to a hydraulic 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

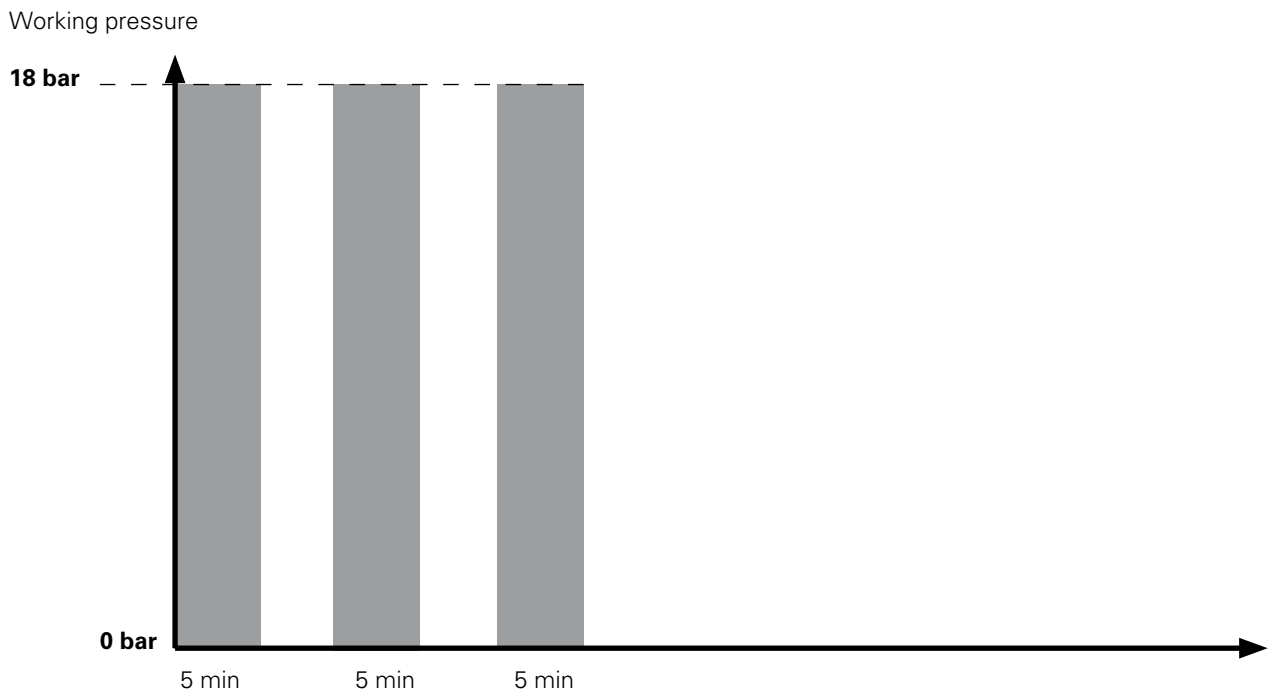
Measuring has to be done with a manometer allowing a perfect reading of a pressure change of 0.1 bar. The manometer has to be placed at the deepest point of the installation.

### Test record

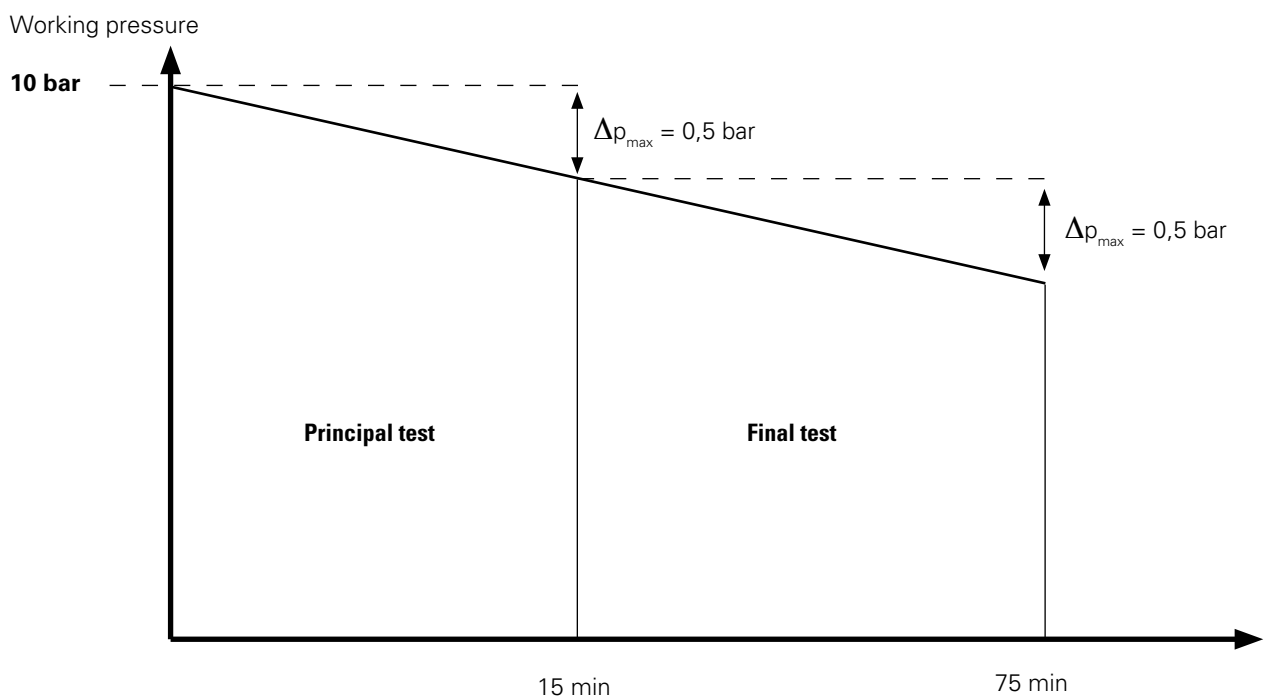
A record of the hydraulic pressure test has to be prepared and signed by the client and contractor stating place and date (see page 83).

### 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.

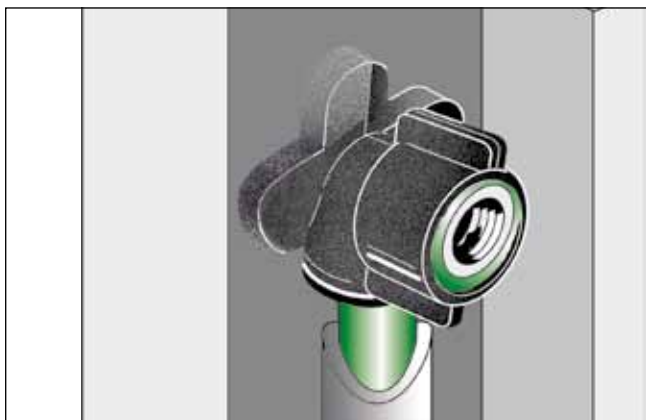
At temperatures below 0 °C it is possible to damage the pipes through strong impacts. The material has to be treated with caution at low temperatures.

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

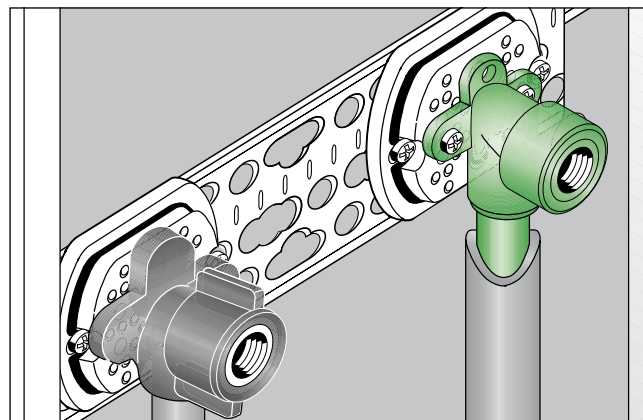
UV-radiation has effects on all high polymer plastics. Do not store permanently outdoor. Maximum storage time (outdoor) is 6 months.



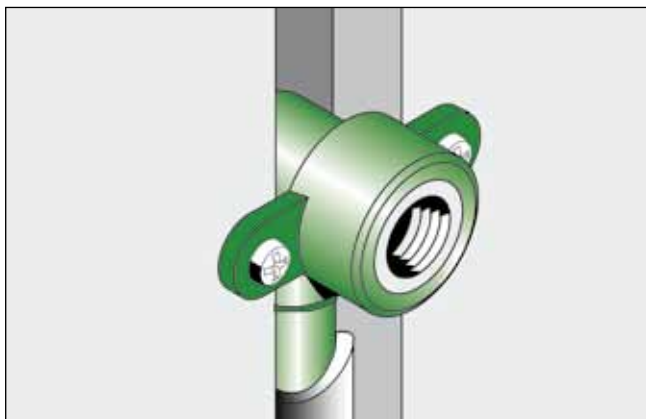
**WATER POINT CONNECTIONS**



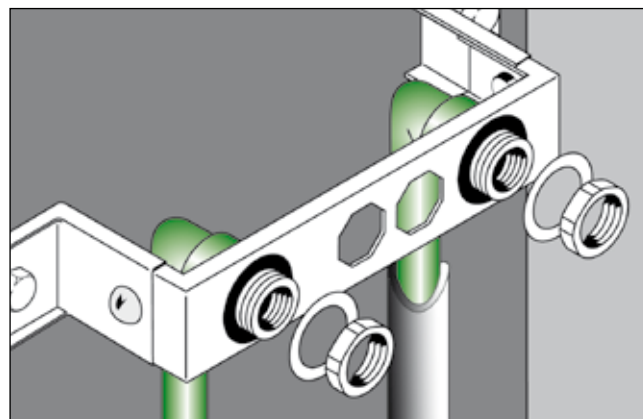
aquatherm green pipe-back plate elbow in sound insulation cover (Art.-No. 20120), e.g. in a pipe chase or for concealed installation



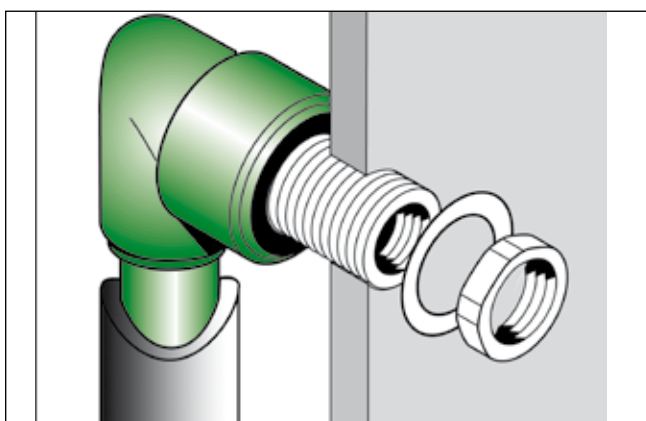
aquatherm green pipe-back plate elbow for twin water point connections with galvanized mounting plate and sound insulation plate (Art.-No. 79080) from the fixing program (gauge for bore holes 220-153-80 mm)



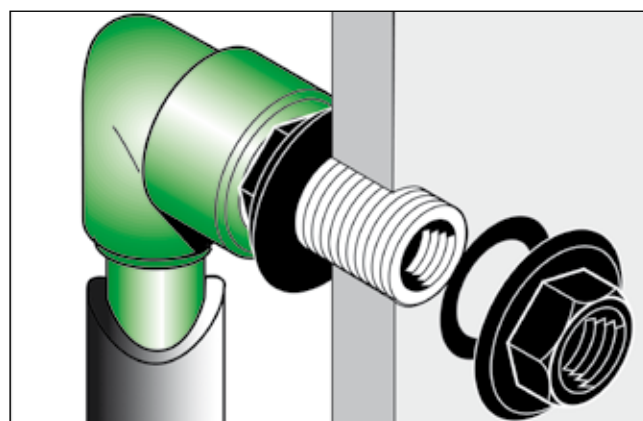
aquatherm green pipe-back plate elbow for dry construction installed in a pipe chase



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.

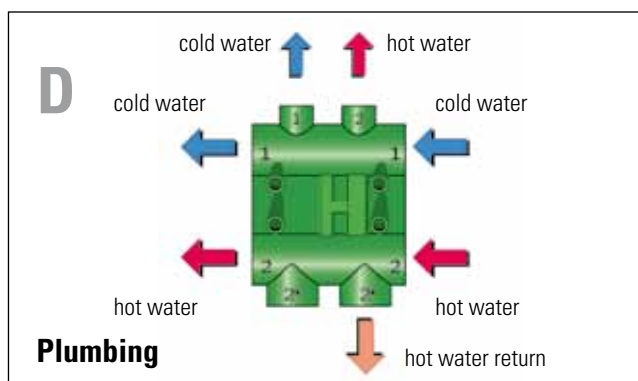
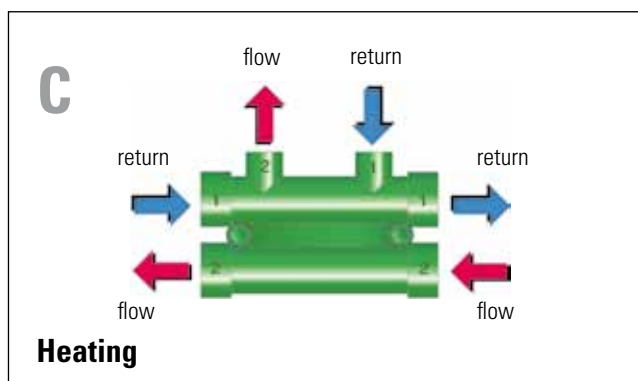
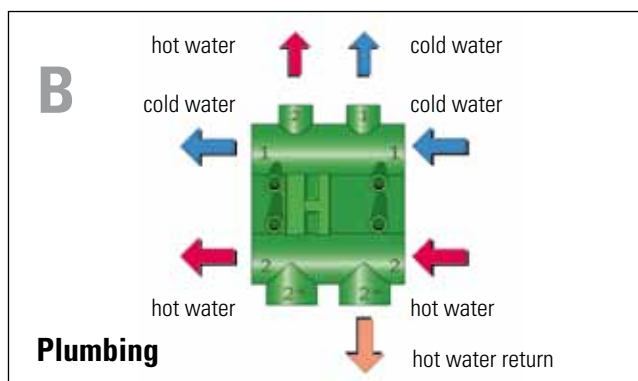
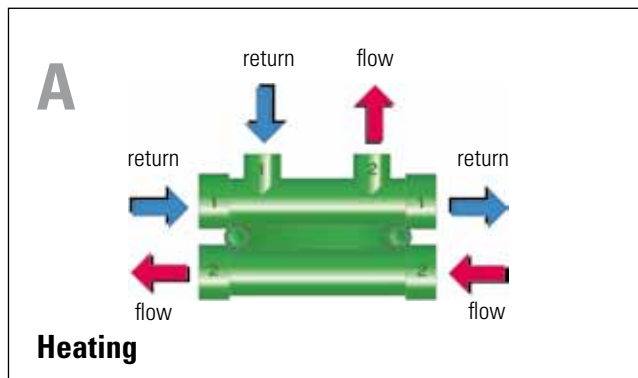
In case of the "heating" connection variant (top A), the return is connected to the supply channel marked 1 and the flow to supply channel marked 2. The connections can also be used reverse.

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.

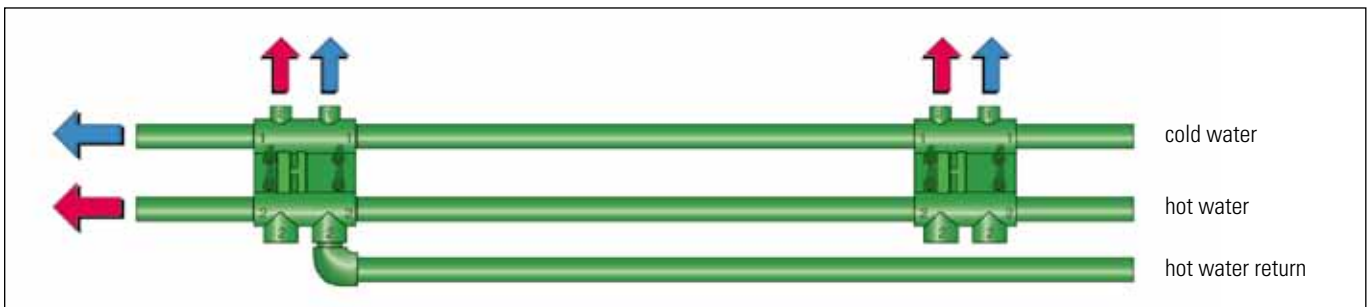
The flow and return connections of the aquatherm green pipe-distribution block heating are installed with Ø 20 mm pipes. For radiator connections Ø 16 mm pipes have to be welded into the outflow sockets of the distribution block.

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.

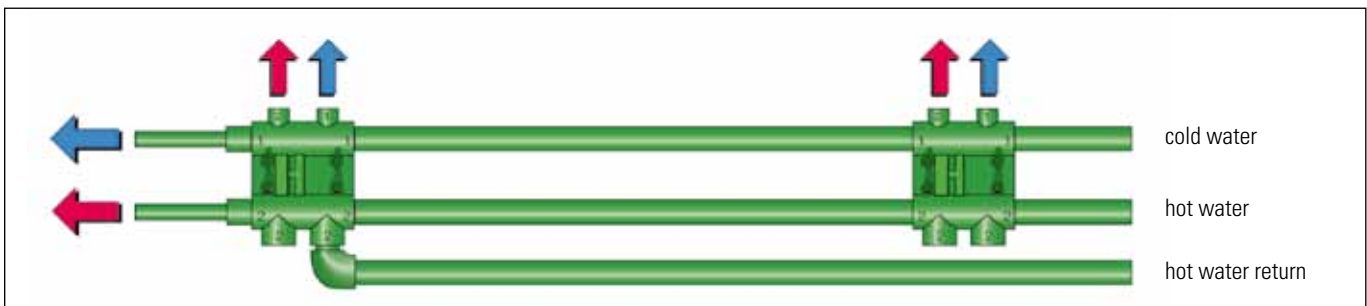


**DISTRIBUTION BLOCK:**

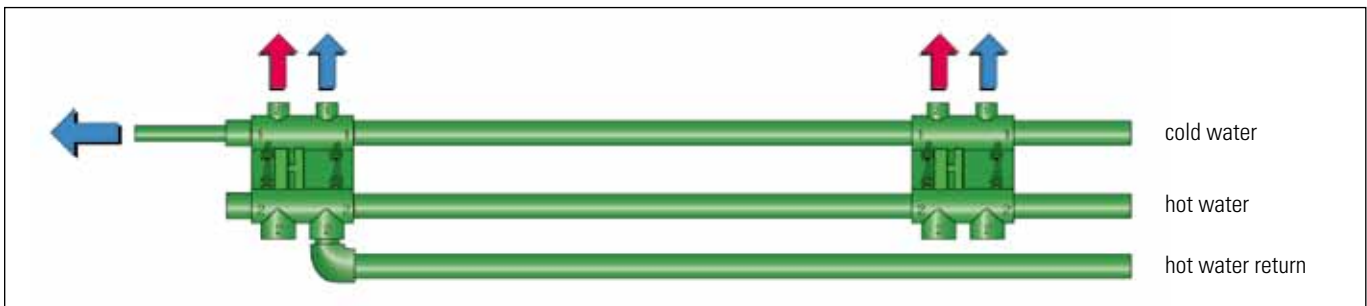
**EXAMPLE OF APPLICATIONS - POTABLE WATER**



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.



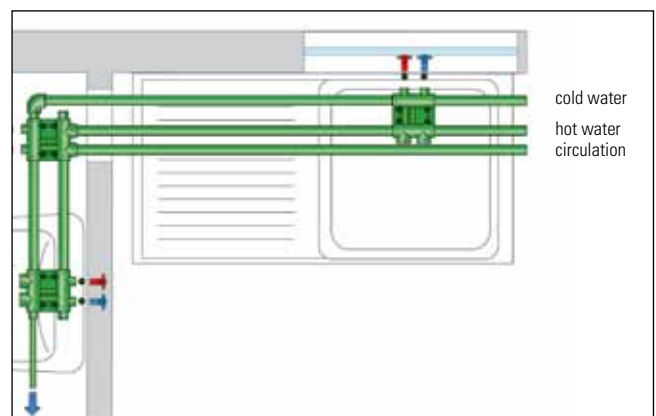
Reducers for further pipe systems can be welded directly onto the distribution block.



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.

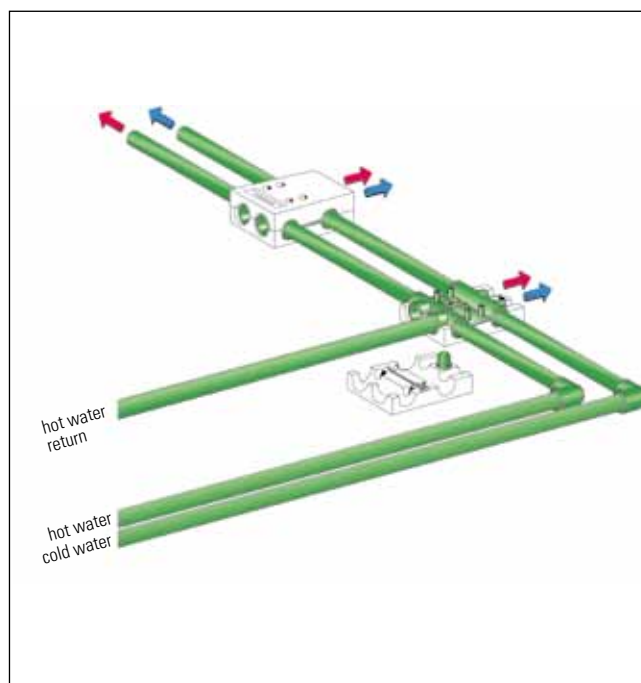
Thermal conductivity: WLG 040

Length: 184 mm

Width: 119 mm

Height: 70 mm

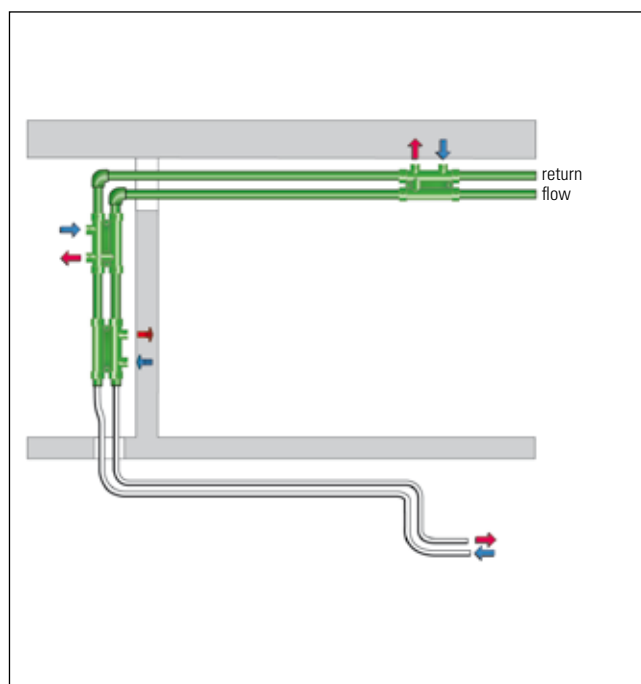
The accessories (1 plug, 2 fastening plugs) are integrated in the insulation of supply unit aquatherm green pipe-distribution block with insulation block (Art.-No. 30130, see picture).



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).

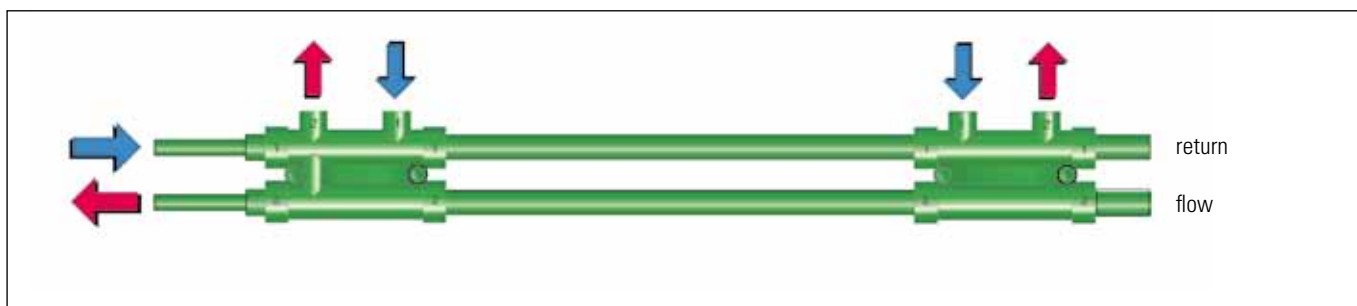


distribution block

**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 1988 T3**

Part 3 of the DIN 1988 (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.

Section of the installation	max. calculated flow rate at run	
	m 15 min. m/s	L 15 min. m/s
Connecting pipes	2	2
Service pipes: Parts with poor drag reducing passage armatures (l 2.5) *	5	2
Parts with passage armatures with a higher correction value loss **	2.5	2

i. e. piston valves acc. to DIN 3500. ball cock. inclined valves acc. to DIN 3502 (from DN 20)

\*\* 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 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 our Dendrit - Customers:

aquatherm naturally still offers you qualified support with your Dendrit - Software.

For both, liNear and Dendrit, please call our information service:

+ 49 (0) 2722 950-200

We like to help you!



## MINIMUM FLOW PRESSURE

### Calculated flows of common water points

Minimum flow pressure $p_{\min FI}$	Type of water point		Calculated flow on taking:		
			mixed water <sup>1)</sup>		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) <sup>2)</sup>	DN 15	-	-	0.30
0.5	without air inlet (airator) <sup>2)</sup>	DN 20	-	-	0.50
0.5	without air inlet (airator) <sup>2)</sup>	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 <sup>3)</sup>

#### 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 manufacturer`s instructions.

<sup>1)</sup> The calculated flows of mixed water points are based on 15 °C for cold potable water and 60 °C for hot potable water.

<sup>2)</sup> 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.

<sup>3)</sup> In case of fully opened flow control valve.

**MINIMUM FLOW PRESSURE**

**Determination of the peak flow rate  $V_S$  from the total flow  $\Sigma V_R$  for buildings**

acc. to DIN 1988 Teil 3  $V_S = 0.682 \cdot (\Sigma V_R)^{0.45} - 0.14$  [l/s]

$\Sigma V_R$	$V_S$	$\Sigma V_R$	$V_S$	$\Sigma V_R$	$V_S$	$\Sigma V_R$	$V_S$	$\Sigma V_R$	$V_S$	$\Sigma V_R$	$V_S$	$\Sigma V_R$	$V_S$	$\Sigma V_R$	$V_S$
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



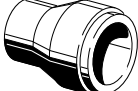
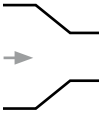











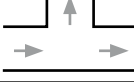
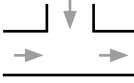

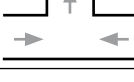
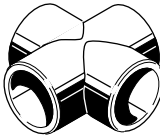
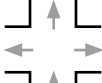
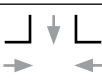
#### Determination of the peak flow rate $V_S$ from the total flow $\Sigma V_R$ for buildings

acc. to DIN 1988 Teil 3  $V_S = 1.7 \cdot (\Sigma V_R)^{0.21} - 0.7$  [l/s]

$\Sigma V_R$	$V_S$	$\Sigma V_R$	$V_S$	$\Sigma V_R$	$V_S$	$\Sigma V_R$	$V_S$	$\Sigma V_R$	$V_S$	$\Sigma V_R$	$V_S$	$\Sigma V_R$	$V_S$	$\Sigma V_R$	$V_S$
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	5,37
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	116,00	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.

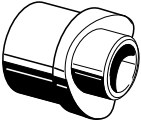
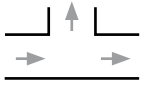
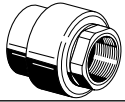

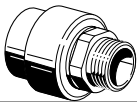

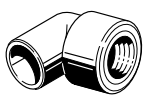
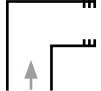
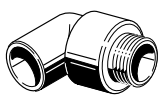
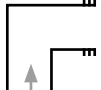
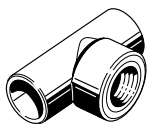
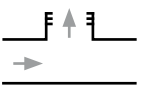
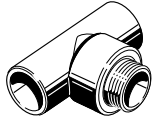

**Coefficient of loss  $\zeta$  aquatherm green pipe-fittings**

Fitting	Picture	Symbol	Comment	$\zeta$ -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)

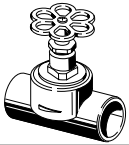
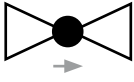

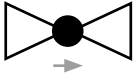


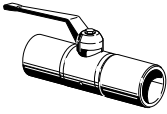
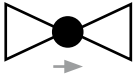




**Coefficient of loss  $\zeta$  aquatherm green pipe-fittings**

Fitting	Picture	Symbol	Comment	$\zeta$ -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 1/2" x 16 - 20 x 3/4" x 20	1.40
			- 20 x 1/2" x 20 - 25 x 3/4" x 25 - 32 x 1" x 32	1.60
			- 25 x 1/2" x 25 - 32 x 3/4" x 32	1.80
Threaded branch tee with male thread			Separation of flow - 20 x 1/2" x 20	1.80

( → = flow direction)

**Coefficient of loss  $\zeta$  aquatherm green pipe-fittings**

Fitting	Picture	Symbol	Comment	$\zeta$ -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

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

Z = Pressure lost in [Pa]

$\zeta$  = Coefficient of loss of fitting

v = Flow rate [m/s]

$\delta$  = Density of medium [kg/m<sup>3</sup>]


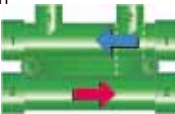

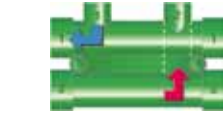
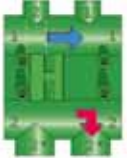
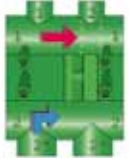

(K<sub>v</sub> = Cold Water Volume Rate circulatory [m<sup>3</sup>/h] of water [5 °C - 30 °C] at a pressure difference of 1 bar)

**Note:**

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

1bar = 10<sup>5</sup> Pa = 14,5 psi = 10 N/cm<sup>2</sup>)

**Coefficient of loss  $\zeta$  aquatherm green pipe-distribution block**

Picture	Comment	Picture	Comment	$\zeta$ -Value	
Potable water installation Cold water Hot water 	Reduced 25 mm passage in case of separation of flow	Heating installation Return Flow 	Reduced 20 mm passage in case of separation of flow	1.00	
	25 mm passage in case of separation of flow		20 mm passage in case of separation of flow	0.25	
Potable water installation Cold water Hot water 	20 mm passage in case of separation of flow	Heating installation Return Flow 	16 mm branch in case of separation of flow	0.80	
	20 mm branch in case of conjunction of flow		16 mm branch in case of conjunction of flow	1.60	
	Reduced 20 mm passage in case of separation of flow		16 mm branch in case of separation of flow	2.20	
Potable water installation Cold water Hot water 		Heating installation Hot water Cold water 		25 mm branch in case of separation of flow	1.20
Hot water return 				16 mm branch in case of conjunction of flow	0.80

## TABLE OF CONTENTS

- aquatherm green pipe-pipes
- aquatherm blue pipe-pipes
- aquatherm lilac pipe-pipes
- Fastening material
- Fittings
- Weld-in saddle
- 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

**fusiotherm®**- the innovative multi-purpose pipe that was a revolution for the plastic pipe industry and has evolved over decades will be called **aquatherm green pipe**. The pipe launched under this new name in several international markets three years ago and quickly came to be recognized for the highest quality and environmental responsibility. Its environmental benefits as well as the world-famous and often copied colour of the pipe system are the basis for the new name.

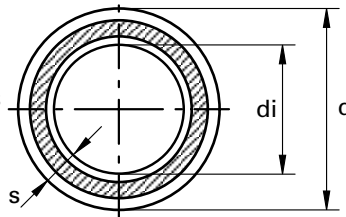
# aquatherm green pipe

**Pipe system made of polypropylene**  
for potable water supply

article-no.	old brand name	new branding structure					
		new brand name		Standard Dimension Ratio	structure of pipe	special feature of pipe	material
		company	system				
10006 . . . 10908	fusiotherm SDR 6 / 7,4 / 11	aquatherm	green pipe	SDR 6 / 7,4 / 11	S		PP-R
70806 . . . 70824	fusiotherm stabi composite pipe	aquatherm	green pipe	SDR 7,4	MS		PP-R
70708 . . . 70744	fusiotherm faser composite pipe	aquatherm	green pipe	SDR 7,4	MF		PP-R
70758 . . . 70794	fusiotherm faser composite pipe UV	aquatherm	green pipe	SDR 7,4	MF	UV	PP-R
1270711 . . . 1270737	fusiotherm faser composite pipe ISO	aquatherm	green pipe	SDR 7,4	MF	TI	PP-R
370712 . . . 370744	aquatherm green pipe	aquatherm	green pipe	SDR 9	MF	RP	PP-RP
370762 . . . 370794	aquatherm green pipe UV	aquatherm	green pipe	SDR 9	MF	RP UV	PP-RP

## aquatherm green pipe - SDR 9 MF RP

Structure of pipe: MF = multilayer, with fibre reinforced  
 Special feature of pipe: RP (raised pressure)  
 Material: fusiolen PP-R  
 Pipe series: SDR 9/S 4  
 Standard: SKZ HR 3.28, ASTM F 2389, ISO 21003  
 SKZ A632/A644  
 Colour: green with 4 dark green stripes  
 Form supplied: ø 32-125 mm straight lengths 4 m  
 ø 160-355 mm straight lengths 5.8 m  
 Packing Unit: PU in meter  
 Application:

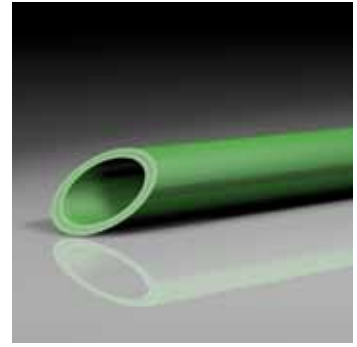
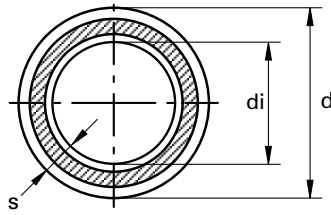


Mechanically stabilized through a fibre mix integrated in the middle layer of the fusiolen® PP-R.

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
9	Socket welding								
	370712	32	3,6	24,8	0,483	0,328	25	40	
	370714	40	4,5	31,0	0,754	0,511	32	40	
	370716	50	5,6	38,8	1,182	0,791	40	20	
	370718	63	7,1	48,8	1,869	1,261	50	20	
	370720	75	8,4	58,2	2,659	1,771	-	20	
	370722	90	10,1	69,8	3,825	2,553	65	12	
	370724	110	12,3	85,4	5,725	3,789	80	8	
	370726	125	14,0	97,0	7,386	4,886	100	4	
	Butt welding								
	370730	160	17,9	124,2	12,109	7,987	125	5,8	
	370734	200	22,4	155,2	18,908	12,489	150	5,8	
	370738	250	27,9	194,2	29,605	19,423	200	5,8	
	370742	315	35,2	244,6	46,966	30,877	250	5,8	
370744	355	39,7	275,6	59,625	39,203	-	5,8		

## 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  
 Colour: green with 4 dark green stripes  
 Form supplied: ø 20-125 mm straight lengths 4 m  
 ø 160-250 mm straight lengths 5.8 m  
 Packing Unit: PU in meter  
 Application:

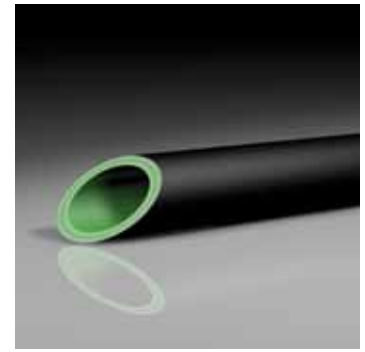


Mechanically stabilized through a fibre mix integrated in the middle layer of the fusiolen® PP-R.

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	0,159	15	100	
	70710	25	3,5	18,0	0,254	0,247	20	100	
	70712	32	4,4	23,2	0,423	0,395	25	40	
	70714	40	5,5	29,0	0,660	0,610	32	40	
	70716	50	6,9	36,2	1,029	0,950	40	20	
	70718	63	8,6	45,8	1,647	1,490	50	20	
	70720	75	10,3	54,4	2,323	2,115	-	20	
	70722	90	12,3	65,4	3,358	3,030	65	12	
	70724	110	15,1	79,8	4,999	4,530	80	8	
	70726	125	17,1	90,8	6,472	6,211	-	4	
	Butt welding								
	70730	160	21,9	116,2	10,599	9,750	125	5,8	
	70734	200	27,4	145,2	16,558	15,005	150	5,8	
70738	250	34,2	181,6	25,901	23,470	175	5,8		
	315-355	Dimensions 315 and 355 mm see aquatherm green pipe SDR 9 MF RP on page 101							

## aquatherm green pipe - SDR 9 MF RP UV

Structure of pipe: MF = multilayer, with fibre reinforced  
 Special feature of pipe: RP (raised pressure), UV resistant  
 Material: fusiolen PP-RP  
 Pipe series: SDR 9/S 4  
 Standards: SKZ HR 3.28, ASTM F 2389, ISO 21003, SKZ A632/A644  
 Colour: inner layer: green with 4 dark green stripes  
 outer layer: black  
 Form supplied: ø 32-125 mm straight lengths 4 m  
 ø 160-355 mm straight lengths 5.8 m  
 Packing Unit: PU in meter  
 Application:

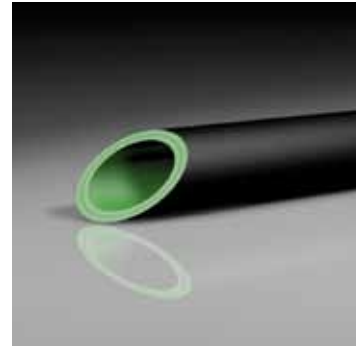
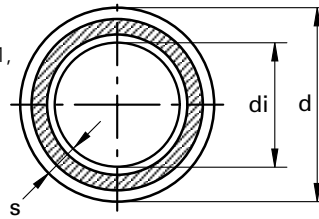


Resistant against UV-rays. Mechanically stabilized through a faser mix integrated in the middle layer of the fusiolen® PP-R.

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
9	Socket welding								
	370762	32	3,6	24,8	0,483	0,388	25	40	
	370764	40	4,5	31,0	0,754	0,588	32	40	
	370766	50	5,6	38,8	1,182	0,891	40	20	
	370768	63	7,1	48,8	1,869	1,391	50	20	
	370770	75	8,4	58,2	2,659	1,908	-	20	
	370772	90	10,1	69,8	3,825	2,746	65	12	
	370774	110	12,3	85,4	5,725	4,116	80	8	
	370776	125	14,0	97,0	7,386	5,287	100	4	
	Butt welding								
	370780	160	17,9	124,2	12,109	8,466	125	5,8	
	370784	200	22,4	155,2	18,908	13,087	150	5,8	
	370788	250	27,9	194,2	29,605	20,170	200	5,8	
	370792	315	35,2	244,6	46,966	31,818	250	5,8	
	370794	355	39,7	275,6	59,625	40,263	-	5,8	

## aquatherm green pipe - SDR 7,4 MF UV

Structure of pipe: MF = multilayer, with fibre reinforced  
 Special feature of pipe: UV resistant  
 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  
 Colour: outer layer: black  
 inner layer: green  
 Form supplied: ø 20-125 mm straight lengths 4 m  
 ø 160-250 mm straight lengths 5.8 m  
 Packing Unit: PU in meter  
 Application:

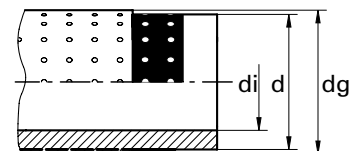
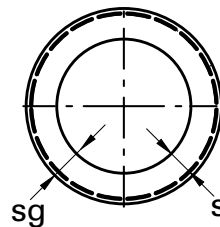


Resistant against UV-rays. Mechanically stabilized through a faser mix integrated in the middle layer of the fusiolen® PP-R.

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									
	70758	20	2,8	14,4	0,163	0,211	15	100		
	70760	25	3,5	18,0	0,254	0,316	20	100		
	70762	32	4,4	23,2	0,423	0,488	25	40		
	70764	40	5,5	29,0	0,660	0,733	32	40		
	70766	50	6,9	36,2	1,029	1,108	40	20		
	70768	63	8,6	45,8	1,647	1,697	50	20		
	70770	75	10,3	54,4	2,323	2,363	50	20		
	70772	90	12,3	65,4	3,358	3,400	65	12		
	70774	110	15,1	79,8	4,999	5,093	80	8		
	70776	125	17,1	90,8	6,472	6,450	-	4		
		Butt welding								
		70780	160	21,9	116,2	10,599	10,415	100	5,8	
		70784	200	27,4	145,2	16,550	15,987	150	5,8	
	70788	250	34,2	181,6	25,888	24,932	175	5,8		
	315-355	Dimensions 315 and 355 mm see aquatherm green pipe SDR 9 MF RP UV on page 103								

## aquatherm green pipe - SDR 7,4 MS

Structure of pipe: MS = multilayer stabi  
 Material: fusiolen PP-R, aluminium  
 Pipe series: SDR 7,4/S 3,2  
 Standards: DIN 8077/78, DIN EN ISO 15874, ASTM F 2389, CSA B 137.11  
 Colour: green  
 Form supplied: 4 m straight lengths, also\* in coils  
 Packing Unit: PU in Meter  
 Application:



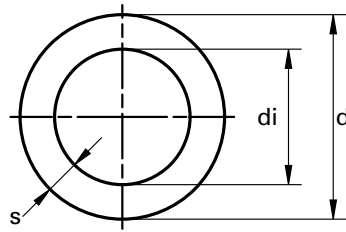
Mechanically stabilized through integrated aluminium-layer

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	70806	16	2,2	11,6	0,106	0,144	12	100	
	70808	20	2,8	14,4	0,163	0,216	15	100	
	70810	25	3,5	18,0	0,254	0,296	20	100	
	70812	32	4,5	23,0	0,415	0,471	25	40	
	70814	40	5,6	28,8	0,651	0,670	32	40	
	70816	50	6,9	36,2	1,029	1,025	40	20	
	70818	63	8,7	45,6	1,632	1,530	50	20	
	70820	75	10,4	54,4	2,306	2,197	-	20	
	70822	90	12,5	65,4	3,317	3,226	65	12	
	70824	110	15,2	79,8	4,974	4,735	80	8	
	70856*	16	2,2	11,6	0,106	0,150	12	100	



## aquatherm green pipe - SDR 6 / 7,4 S

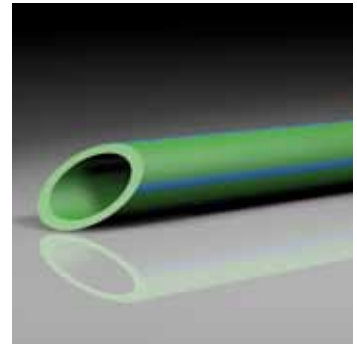
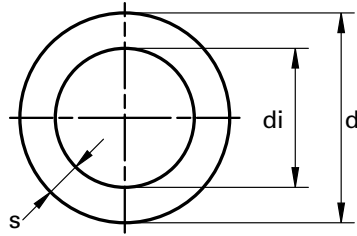
Structure of pipe: s (single)  
 Material: fusiolen PP-R  
 Pipe series: SDR 6/S 2,5 & SDR 7,4/S 3,2  
 Standards: DIN 8077, DIN 8078, DIN EN ISO 15874, ASTM F 2389, CSA B 137.11  
 Colour: green  
 Form supplied: 4 m straight lengths, also\* in coils  
 Packing Unit: PU in meter  
 Application:



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
6	10006	16	2,7	10,6	0,088	0,111	10	100	
	10008	20	3,4	13,2	0,137	0,171	12	100	
	10010	25	4,2	16,6	0,216	0,266	15	100	
	10012	32	5,4	21,2	0,353	0,428	20	40	
	10014	40	6,7	26,6	0,555	0,660	25	40	
	10016	50	8,3	33,4	0,876	1,054	32	20	
	10018	63	10,5	42,0	1,385	1,697	40	20	
	10020	75	12,5	50,0	1,963	2,328	50	20	
	10022	90	15,0	60,0	2,826	3,415	60	12	
	10024	110	18,3	73,4	4,229	5,150	65	8	
	10106*	16	2,7	10,6	0,088	0,012	0,172	10	100
10108*	20	3,4	13,2	0,137	0,172	12	100		
10110*	25	4,2	16,6	0,216	0,260	15	100		
7,4	10806	16	2,2	11,6	0,106	0,098	12	100	
	10808	20	2,8	14,4	0,163	0,152	15	100	
	10810	25	3,5	18,0	0,254	0,235	20	100	
	10812	32	4,4	23,2	0,423	0,375	25	40	
	10814	40	5,5	29,0	0,660	0,580	32	40	
	10816	50	6,9	36,2	1,029	0,905	40	20	
	10818	63	8,6	45,8	1,647	1,420	50	20	
	10906*	16	2,2	11,6	0,106	0,100	12	100	
10908*	20	2,8	14,4	0,163	0,149	15	100		

## aquatherm green pipe - SDR 11 S

Structure of pipe: s (single)  
 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:  $\varnothing$  20-125 mm 4 m straight lengths, also\* in coils  
 $\varnothing$  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
11	Socket welding								
	10208	20	1,9	16,2	0,206	0,109	15	100	
	10210	25	2,3	20,4	0,327	0,165	20	100	
	10212	32	2,9	26,2	0,539	0,265	25	40	
	10214	40	3,7	32,6	0,834	0,415	32	40	
	10216	50	4,6	40,8	1,307	0,645	40	20	
	10218	63	5,8	51,4	2,074	1,015	50	20	
	10220	75	6,8	61,4	2,959	1,415	65	20	
	10222	90	8,2	73,6	4,252	2,045	80	12	
	10224	110	10,0	90,0	6,359	3,136	-	8	
	10226	125	11,4	102,2	8,199	3,927	100	4	
	10308*	20	1,9	16,2	0,206	0,109	15	100	
	10310*	25	2,3	20,4	0,327	0,158	20	100	
	10312*	32	2,9	26,2	0,539	0,257	25	50	
	Butt welding								
	10230	160	14,6	130,8	13,430	6,416	125	5,8	
	10234	200	18,2	163,6	21,010	9,991	150	5,8	
	10238	250	22,7	204,6	32,861	15,540	200	5,8	
	10242	315	28,6	257,8	52,172	25,700	250	5,8	
10244	355	32,2	290,6	66,325	31,300	300	5,8		
10246	400	36,3	327,6	84,290	41,400	300	5,8		
10248	450	40,9	368,2	106,477	52,400	400	5,8		

**climatherm** our specialty for distributing cooling and heating in closed systems as well as in several industrial applications, will become **aquatherm blue pipe**. This system was developed 10 years ago in order to prevent corrosion in air conditioning 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.

# aquatherm blue pipe

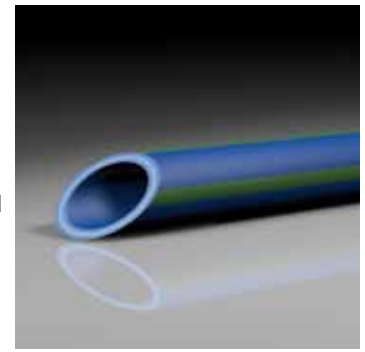
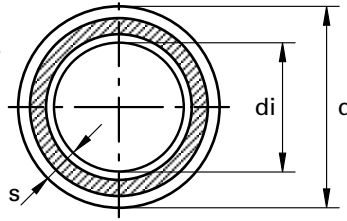
## Pipe system made of polypropylene

for chilled, hot fluid and various industrial applications

article-no.	old brand name	new branding structure					
		new brand name		Standard Dimension Ratio	structure of pipe	special feature of pipe	material
		company	system				
2010208 ... 2010212	climatherm SDR11	aquatherm	blue pipe	SDR 11	S		PP-R
2070112 ... 2070712	climatherm faser composite pipe SDR7,4/SDR11	aquatherm	blue pipe	SDR 7,4/SDR 11	MF		PP-R
2070162 ... 2070762	climatherm faser composite pipe SDR7,4/SDR11/SDR17,6 UV	aquatherm	blue pipe	SDR 7,4/SDR 11/SDR 17,6	MF	UV	PP-R
2170114 ... 2170712	climatherm faser composite pipe SDR7,4/SDR11 OT	aquatherm	blue pipe	SDR 7,4/SDR 11	MF	OT	PP-R
2570130 ... 2570154	climatherm faser composite pipe SDR17,6	aquatherm	blue pipe	SDR 17,6	MF		PP-R
2270111 ... 2270142	climatherm faser composite pipe SDR7,4/SDR11 ISO	aquatherm	blue pipe	SDR 7,4/SDR 11	MF	TI	PP-R
2470711 ... 2470126	climatherm faser composite pipe SDR7,4/SDR11 OT ISO	aquatherm	blue pipe	SDR 7,4/SDR 11	MF	OT-TI	PP-R

## aquatherm blue pipe - SDR 7,4 / 11 / 17,6 MF

Structure of pipe: MF = multilayer, with fibre reinforced  
 Material: fusiolen PP-R  
 Pipe series: SDR 7,4/S 3.2 & SDR11 / S 5 & SDR 17,6 / S 8.3  
 Standards: SKZ HR 3.28, ASTM F 2389, CSA B 137.11, ISO 21003  
 Colour: blue with 4 wider green stripes  
 Form supplied: ø 20-125 mm straight lengths 4 m  
 ø 160-630 mm straight lengths 5.8 m  
 Packing Unit: PU in meter



Application:

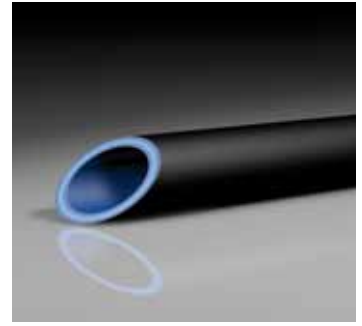
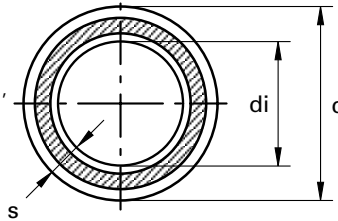


Mechanically stabilized through a fibre mix integrated in the middle layer of the fusiolen® PP-R.

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									
	2070708	20	2,8	14,4	0,163	0,159	15	100		
	2070710	25	3,5	18,0	0,254	0,244	20	100		
11	2070712	32	4,4	23,2	0,423	0,275	25	40		
	2070112	32	2,9	26,2	0,539	0,285	25	40		
	2070114	40	3,7	32,6	0,834	0,435	32	40		
	2070116	50	4,6	40,8	1,307	0,675	40	20		
	2070118	63	5,8	51,4	2,074	1,065	50	20		
	2070120	75	6,8	61,4	2,959	1,482	65	20		
	2070122	90	8,2	73,6	4,252	2,145	80	12		
	2070124	110	10,0	90,0	6,359	3,175	-	8		
	2070126	125	11,4	102,2	8,199	4,118	100	4		
	11	Butt welding								
		2070130	160	14,6	130,8	13,430	6,728	125	5,8	
2070134		200	18,2	163,6	21,010	10,480	150	5,8		
2070138		250	22,7	204,6	32,861	16,300	200	5,8		
2070142		315	28,6	257,8	52,172	25,700	250	5,8		
2070144		355	32,2	290,6	66,29	33,034	300	5,8		
2070146		400	36,3	327,6	84,290	41,400	300	5,8		
2070148		450	40,9	368,2	106,477	52,400	400	5,8		
17,6	Socket welding									
	<b>NEW</b> 2570126	125	7,1	110,8	9,637	2,698	100	4		
	Butt welding									
	2570130	160	9,1	141,8	15,792	4,360	150	5,8		
	2570134	200	11,4	177,2	24,661	6,800	200	5,8		
	2570138	250	14,2	221,6	38,568	10,570	250	5,8		
	2570142	315	17,9	279,2	61,223	16,740	300	5,8		
	2570144	355	20,1	314,8	77,832	21,210	350	5,8		
	2570146	400	22,7	354,6	98,756	26,930	350	5,8		
	2570148	450	25,5	399,0	125,036	34,020	400	5,8		
	2570150	500	28,4	443,2	154,272	42,070	450	5,8		
	2570152	560	31,7	496,6	193,688	52,550	500	5,8		
	2570154	630	35,7	558,6	245,070	66,540	500	5,8		

## aquatherm blue pipe - SDR 7,4/11/17,6 MF UV

Structure of pipe: MF = multilayer, with fibre reinforced  
 Special feature of pipe: UV resistant  
 Material: fusiolen PP-R  
 Pipe series: SDR 7,4/S 3.2 & SDR11/SDR 17,6 / S 8.3  
 Standards: SKZ HR 3.28, ASTM F 2389, CSA B 137.11, ISO 21003  
 Colour: outside: black, inside: blue  
 Form supplied: ø 20-125 mm straight lengths 4 m  
 ø 160-250 mm straight lengths 5.8 m  
 Packing Unit: PU in meter  
 Application:

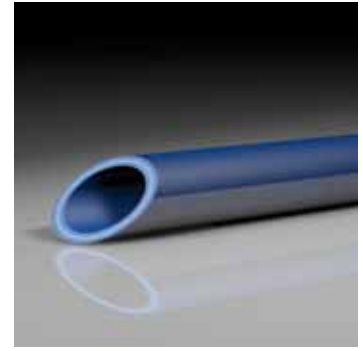
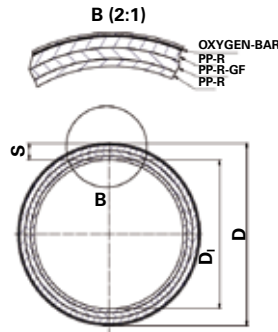


UV-resistant. Mechanically stabilized by a fibre mixture, integrated in the middle layer of fusiolen® PP-R.

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									
	2070758	20	2,8	14,4	0,163	0,209	15	100		
	2070760	25	3,5	18,0	0,254	0,313	20	100		
	2070762	32	4,4	23,2	0,423	0,345	20	40		
11	2070162	32	2,9	26,2	0,539	0,375	25	40		
	2070164	40	3,7	32,6	0,834	0,554	32	40		
	2070166	50	4,6	40,8	1,307	0,825	40	20		
	2070168	63	5,8	51,4	2,074	1,257	50	20		
	2070170	75	6,8	61,4	2,959	1,707	65	20		
	2070172	90	8,2	73,6	4,252	2,483	80	12		
	2070174	110	10,0	90,0	6,359	3,688		8		
	2070176	125	11,4	102,2	8,199	4,673	100	4		
		Butt welding								
		2070180	160	14,6	130,8	13,430	7,512	125	5,8	
	2070184	200	18,2	163,6	21,010	11,411	150	5,8		
	2070188	250	22,7	204,6	32,861	17,754	200	5,8		
	2070192	315	28,6	257,8	52,172	26,619	250	5,8		
	2070194	355	32,2	290,6	66,292	33,668	300	5,8		
	2070196	400	36,3	327,4	84,145	42,566	300	5,8		
	2070198	450	40,9	368,2	106,423	53,709	400	5,8		
17,6	2570180	160	9,1	141,8	15,784	4,839	150	5,8		
	2570184	200	11,4	177,2	24,649	7,396	200	5,8		
	2570188	250	14,2	221,6	38,549	11,321	250	5,8		
	2570192	315	17,9	279,2	61,193	17,676	300	5,8		
	2570194	355	20,1	314,8	77,793	22,266	350	5,8		
	2570196	400	22,7	354,6	98,707	28,124	350	5,8		
	2570198	450	25,5	399	124,973	35,364	400	5,8		
	2570200	500	28,4	443,2	154,195	43,563	450	5,8		
	2570202	560	31,7	496,6	193,590	54,224	500	5,8		
2570204	630	35,7	558,6	244,947	68,420	500	5,8			

## aquatherm blue pipe - SDR 7,4 / 11 MF OT

Structure of pipe: MF = multilayer, with fibre reinforced  
 Special feature of pipe: OT = oxygen tight  
 Material: fusiolen PP-R  
 Pipe series: SDR 7,4/S 3,2 & SDR11 / S 5  
 Standards: DIN 8077/78, DIN EN ISO 15874, ASTM F 2389, CSA B 137.11, ISO 21003  
 Colour: blue  
 Form supplied: ø 20-125 mm straight lengths 4 m  
 ø 160-250 mm straight lengths 5.8 m  
 Packing Unit: PU in meter  
 Application:

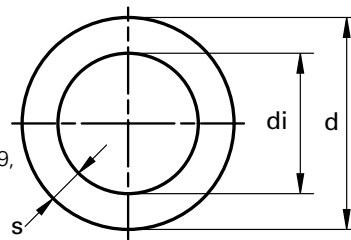


Oxygen tight by diffusion barrier.  
 Mechanically stabilized through a fibre mix integrated in the middle layer of fusiolen® PP-R.

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	
Socket welding										
7,4	2170708	20	2,8	14,4	0,163	0,199	15	100		
	2170710	25	3,5	18,0	0,254	0,299	20	100		
	2170712	32	4,4	23,2	0,423	0,466	20	40		
11	2170114	40	3,7	32,6	0,834	0,530	32	40		
	2170116	50	4,6	40,8	1,307	0,794	40	20		
	2170118	63	5,8	51,4	2,074	1,218	50	20		
	2170120	75	6,8	61,4	2,959	1,649	65	20		
	2170122	90	8,2	73,6	4,252	2,379	80	12		
	2170124	110	10	90,0	6,359	3,550		8		
	2170126	125	11,4	102,2	8,199	4,576	100	4		
	Butt welding									
		2170130	160	14,6	130,8	13,430	7,284	125	5,8	
		2170134	200	18,2	163,6	21,010	11,000	150	5,8	
	2170138	250	22,7	204,6	32,861	16,700	200	5,8		

## aquatherm blue pipe - SDR 11 S

Structure of pipe: S (single)  
 Material: fusiolen PP-R  
 Pipe series: SDR 11/S 5  
 Standards: DIN 8077/78, DIN EN ISO 15874, ASTM F 2389, CSA B 137.11, NSF 14, ISO 21003  
 Colour: blue  
 Form supplied: 4 m straight lengths, also\* in coils  
 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
11	2010208	20	1,9	16,2	0,206	0,110	15	100	
	2010210	25	2,3	20,4	0,327	0,167	20	100	
	2010212	32	2,9	26,2	0,539	0,265	25	40	
	2010308*	20	1,9	16,2	0,206	0,107	15	100	
	2010310*	25	2,3	20,4	0,327	0,164	20	100	
	2010312*	32	2,9	26,2	0,539	0,257	25	50	

**lilac** was developed exclusively for the field of water recycling and is officially called **aquatherm lilac pipe**. 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 reclaimed water pipes, giving us both the colour and name for our reclaimed water service lines.

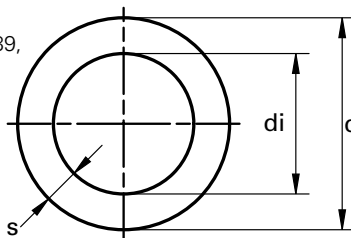
# aquatherm lilac pipe

**Pipe system made of polypropylene**  
for reclaimed water

article-no.	old brand name	new branding structure				
		new brand name		Standard Dimension Ratio	structure of pipe	material
		company	system			
9010808 . . . 9010226	aquatherm lilac	<b>aquatherm</b>	<b>lilac pipe</b>	SDR 7,4/ SDR 11	S	PP-R

## aquatherm lilac pipe - SDR 7,4 / 11 S

Structure of pipe: S (single)  
 Material: fusiolen PP-R  
 Pipe series: SDR 7,4/S3,5 & SDR 11/S 5  
 Standards: DIN 8077/78, DIN EN ISO 15874, ASTM F 2389, CSA B 137.11, NSF 14  
 Colour: lilac  
 Form supplied: 4 m straight lengths  
 Packing Unit: PU in meter  
 Application:

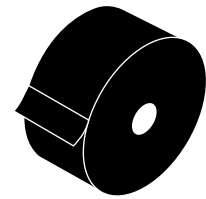


SDR	Art.-No.	Dimension d [mm]	Wall thickness s [mm]	Internal diameter di [mm]	Water content [l/m]	Weight [kg]	DN	PU [m]	Price € m/pc
7,4	<b>9010808</b>	<b>20</b>	2,8	14,4	0,163	0,152	15	100	
	<b>9010810</b>	<b>25</b>	3,5	18,0	0,254	0,226	20	100	
11	<b>9010212</b>	<b>32</b>	2,9	26,2	0,539	0,265	25	40	
	<b>9010214</b>	<b>40</b>	3,7	32,6	0,834	0,415	32	40	
	<b>9010216</b>	<b>50</b>	4,6	40,8	1,307	0,645	40	20	
	<b>9010218</b>	<b>63</b>	5,8	51,4	2,074	1,015	50	20	
	<b>9010220</b>	<b>75</b>	6,8	61,4	2,959	1,415	65	20	
	<b>9010222</b>	<b>90</b>	8,2	73,6	4,252	2,045	80	12	
	<b>9010224</b>	<b>110</b>	10,0	90,0	6,359	3,136	-	8	
	<b>9010226</b>	<b>125</b>	11,4	102,2	8,199	3,927	100	4	

## ADHESIVE TAPE TO PROTECT AGAINST UV-RADIATION

for aquatherm-pipes MF UV

Art.-No.	Dimension	PU	Price € m/pc
<b>10870</b>	Width: 30mm Length: 10m	10m/pckg	
<b>10871</b>	Width: 50mm Length: 10m	10m/pckg	

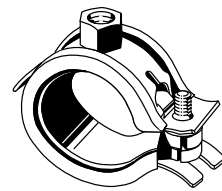


## PIPE CLAMPS

Suitable for sliding and fixed point installation.

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

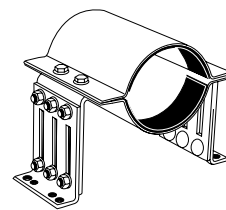
Art.-No.	for pipe dimension	PU	Box unit	Price € m/pc
<b>60516</b>	<b>16 mm</b>	50		
<b>60520</b>	<b>20 mm</b>	50		
<b>60525</b>	<b>25 mm</b>	50		
<b>60532</b>	<b>32 mm</b>	50		
<b>60540</b>	<b>40 mm</b>	50		
<b>60550</b>	<b>50 mm</b>	50		
<b>60563</b>	<b>63 mm</b>	25		
<b>60575</b>	<b>75 mm</b>	25		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



## PIPE CLAMPS

suitable for fixed point installation

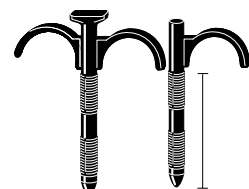
Art.-No.	for pipe dimension	PU	Box unit	Price € m/pc
<b>60768</b>	<b>160 mm</b>	1	1	
<b>60770</b>	<b>200 mm</b>	1	1	
<b>60774</b>	<b>250 mm</b>	1	1	
<b>60778</b>	<b>315 mm</b>	1	1	
<b>60780</b>	<b>355 mm</b>	1	1	
<b>60782</b>	<b>400 mm</b>	1	1	
<b>60784</b>	<b>450 mm</b>	1	1	
<b>60786</b>	<b>500 mm</b>	1	1	
<b>60788</b>	<b>560 mm</b>	1	1	
<b>60790</b>	<b>630 mm</b>	1	1	



## PIPE FASTENING BOW

suitable for ø 16 - 32 mm pipes

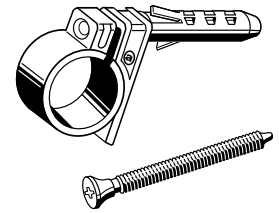
Art.-No.	for pipe dimension	PU	Box unit	Price € m/pc
<b>60604</b>	onefold - length = 45 mm	50		
<b>60606</b>	onefold - length = 75 mm	50		
<b>60608</b>	double - length = 45 mm	50		
<b>60610</b>	double - length = 75 mm	50		



## PLASTIC PIPE CLAMPS

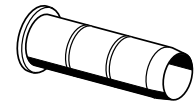
suitable for  $\varnothing$  16 - 40 mm pipes

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



## PIPE SUPPORT

Art.-No.	for pipe dimension	PU	Box unit	Price € m/pc
85110	$\varnothing$ 16 x 2,2 mm - $\varnothing$ 11,4 mm	10		
10186	$\varnothing$ 16 x 2,7 mm - $\varnothing$ 10,4 mm	10		



## SOCKET

Systems:

**aquatherm green pipe,**  
**aquatherm blue pipe, aquatherm lilac pipe**

Material:

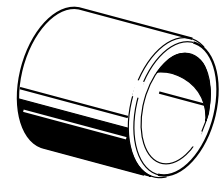
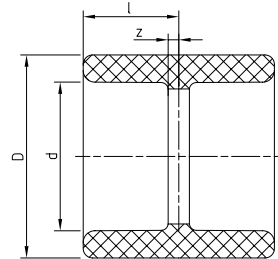
Fusiolen® PP-R

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	15,00	2,00	24,50	0,008	•	10	2000	
	11008	20	16,00	1,50	29,50	0,011	• • •	10	1500	
	11010	25	17,50	1,50	34,00	0,014	• • •	10	1000	
	11012	32	20,25	2,25	43,00	0,026	• • •	5	600	
	11014	40	23,75	3,25	52,00	0,044	• • •	5	400	
	11016	50	26,50	3,00	68,00	0,084	• • •	5	200	
	11018	63	30,25	2,75	84,00	0,139	• • •	1	100	
	11020	75	33,25	3,25	100,00	0,226	• • •	1	70	
	11022	90	36,25	3,25	120,00	0,343	• • •	1	50	
	11024	110	41,00	4,00	147,00	0,583	• • •	1	30	
	11026	125	45,00	5,00	167,00	0,844	• • •	1	25	

## REDUCING SOCKET FEMALE/FEMALE

Systems:

**aquatherm green pipe,**  
**aquatherm blue pipe, aquatherm lilac pipe**

Material:

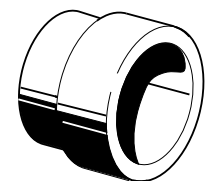
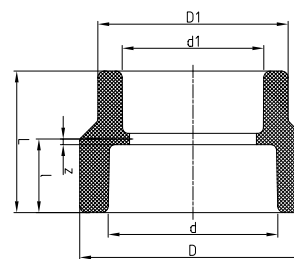
Fusiolen® PP-R

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	24,00	3,50	52,00	43,00	0,050	• • •	1	40	
	11228	50	32	47,00	26,50	3,00	68,00	43,00	0,093	• • •	1	25	
	11230	50	40	50,50	26,50	3,00	68,00	52,00	0,098	• • •	1	100	
	11236	63	40	54,00	30,50	3,00	84,00	52,00	0,163	• • •	1	100	
	11238	63	50	56,00	30,00	2,50	84,00	68,00	0,171	• • •	1	100	
	11240	75	50	60,00	33,50	3,50	100,00	68,00	0,258	• • •	1	80	
	11242	75	63	62,50	32,50	2,50	100,00	84,00	0,268	• • •	1	80	
	11252	90	63	66,50	36,50	3,50	120,00	84,00	0,414	• • •	1	30	
	11253	90	75	69,00	36,00	3,00	120,00	100,00	0,430	• • •	1	50	
	11257	110	75	74,50	41,00	4,00	147,00	100,00	0,733	• • •	1	45	
11259	110	90	77,50	41,00	4,00	147,00	120,00	0,729	• • •	1	35		
11263	125	90	83,00	46,00	6,00	167,00	120,00	1,075	• • •	1	25		
11265	125	110	87,00	46,00	6,00	167,00	147,00	1,090	• • •	1	20		



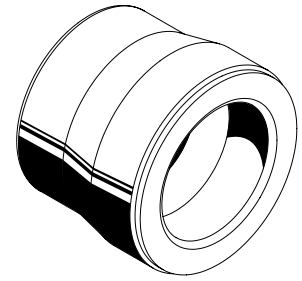
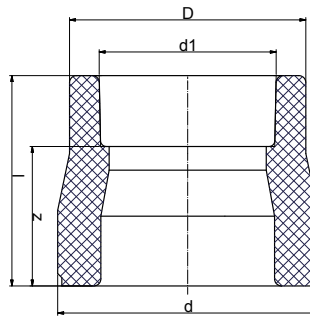
## REDUCING SOCKET, SOCKET WELDING

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

Material: Fusiolen® PP-R

Standard: DIN 16962, DIN EN ISO 15874

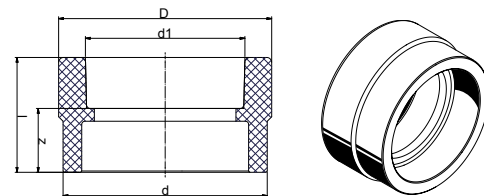
Colour: green



SDR	Art.-No.	Dimension d [mm]	Dimension d1 [mm]	l	z	D	Weight [kg]	System	PU	Box unit	Price € m/pc
double-sided socket welding											
6 7,4 9 11 17,6	11109	20	16	39,00	26,00	24,50	0,009	•	10	2000	
	11110	25	16	38,00	25,00	26,00	0,012	•	10	2000	
	11112	25	20	38,50	24,00	29,50	0,012	• • •	10	1500	
	11114	32	20	37,50	23,00	29,50	0,015	• • •	5	1000	
	11116	32	25	38,00	22,00	34,00	0,016	• • •	5	1000	
	11118	40	20	45,00	30,50	29,50	0,025	• • •	5	750	
	11120	40	25	50,00	34,00	34,00	0,028	• • •	5	600	
	11122	40	32	50,00	32,00	43,00	0,032	• • •	5	500	
	11124	50	20	55,00	40,50	29,50	0,045	• • •	5	500	
	11126	50	25	55,00	39,00	34,00	0,044	• • •	5	500	
	11128	50	32	54,00	36,00	43,00	0,048	• • •	5	350	
	11130	50	40	52,50	32,00	52,00	0,053	• • •	5	300	
	11131	63	20	65,00	50,50	29,50	0,073	• • •	1	200	
	11132	63	25	65,00	49,00	34,00	0,071	• • •	1	200	
	11134	63	32	62,00	44,00	43,00	0,076	• • •	1	200	
	11136	63	40	65,00	44,50	52,00	0,089	• • •	1	200	
	11138	63	50	63,50	40,00	68,00	0,107	• • •	1	150	
	11139	75	40	69,50	49,00	52,00	0,130	• • •	1	150	
	11140	75	50	63,00	39,50	68,00	0,141	• • •	1	100	
	11142	75	63	71,00	43,50	84,00	0,171	• • •	1	100	
11143	75	20	65,50	51,00	34,50	0,115	• • •	1	200		
11144	75	25	65,50	49,50	34,50	0,109	• • •	1	200		
11145	75	32	69,50	51,50	52,00	0,140	• • •	1	150		
11151	90	50	75,00	51,50	68,00	0,196	• • •	1	100		
11152	90	63	78,00	50,50	84,00	0,226	• • •	1	75		
11153	90	75	81,50	51,50	100,00	0,272	• • •	1	60		
11155	110	63	86,00	58,50	84,00	0,356	• • •	1	50		
11157	110	75	89,00	59,00	100,00	0,383	• • •	1	50		
11159	110	90	99,00	66,00	120,00	0,502	• • •	1	40		
11161	125	75	101,00	71,00	100,00	0,528	• • •	1	35		
11163	125	90	99,00	66,00	120,00	0,588	• • •	1	35		
11165	125	110	112,00	75,00	147,00	0,833	• • •	1	25		

## REDUCING SOCKET, SOCKET & BUTT WELDING

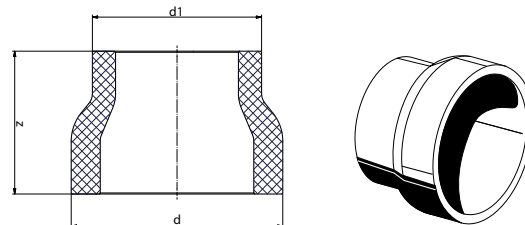
Systems: **aquatherm green pipe**, **aquatherm blue pipe**  
 Material: Fusiolen® PP-R & PP-RP  
 Standard: DIN 16962, DIN EN ISO 15874  
 Colour: green



SDR	Art.-No.	Dimension d [mm]	Dimension d1 [mm]	l	z	D	Weight [kg]	System	PU	Box unit	Price € m/pc
onesided socket welding, other side butt welding											
7,4	11174	160	110	87,00	50,00	147,00	0,721	• •	1	25	
	11176	160	125	90,00	50,00	167,00	0,818	• •	1	20	
	11182	200	125	135,00	95,00	167,00	1,599	• •	1	25	
9	311174	160	110	87,00	50,00	147,00	0,669	•	1		
	311176	160	125	90,00	50,00	167,00	0,754	•	1		
	311182	200	125	135,00	95,00	167,00	1,453	•	1		
11	11175	160	110	90,00	53,00	147,00	0,595	• •	1	25	
	11177	160	125	90,00	50,00	167,00	0,705	• •	1	20	
	11183	200	125	135,00	95,00	167,00	1,358	• •	1		
17,6	2511174	160	110	90,00	53,00	147,00		•	1	25	
	2511176	160	125	90,00	50,00	167,00	0,628	•	1	25	
	2511182	200	125	135,00	95,00	167,00	1,055	•	1		

## REDUCING SOCKET, BUTT WELDING

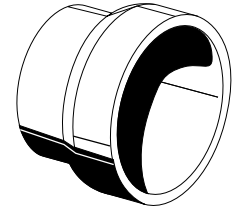
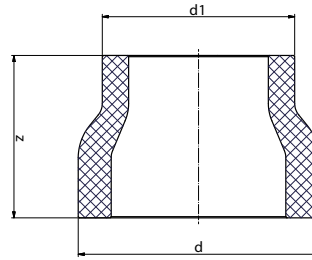
Systems: **aquatherm green pipe**, **aquatherm blue pipe**  
 Material: Fusiolen® PP-R & PP-RP  
 Standard: DIN 16962, DIN EN ISO 15874  
 Colour: green



SDR	Art.-No.	Dimension d [mm]	Dimension d1 [mm]	z	Weight [kg]	System	PU	Box unit	Price € m/pc
double-sided butt welding									
7,4	11184	200	160	135,00	1,588	•	1	12	
	11188	250	160	172,50	2,900	•	1		
	11190	250	200	172,50	3,212	•	1	5	
9	311184	200	160	135,00	1,329	•	1		
	311188	250	160	172,50	2,419	•	1		
	311190	250	200	172,50	2,623	•	1		
	311192	315	200	225,00	4,947	•	1		
	311194	315	250	225,00	5,382	•	1		
	311196	355	250	170,00	5,385	•	1		
	311198	355	315	160,00	4,066	•	1		
11	11185	200	160	135,00	1,163	• •	1	12	
	11189	250	160	172,50	3,472	• •	1	5	
	11191	250	200	172,50	2,341	• •	1	5	
	11193	315	200	225,00	3,412	• •	1		
	11195	315	250	233,00	4,650	• •	1	1	
	11197	355	250	245,00	3,940	• •	1		
	11199	355	315	160,00	4,344	• •	1	3	
	11201	400	250	260,00		• •	1		
	11203	400	315	260,00		• •	1		
	11204	400	355	260,00		• •	1		
	11206	450	315	230,00		• •	1		
	11207	450	355	230,00		• •	1		
11208	450	400	230,00		• •	1			

## REDUCING SOCKET, BUTT WELDING

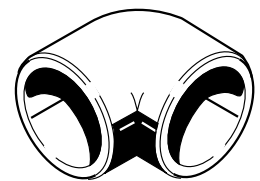
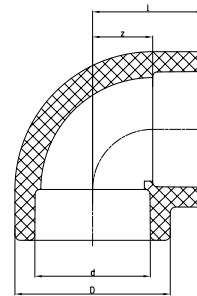
Systems: **aquatherm blue pipe**  
 Material: Fusiolen® PP-R  
 Standard: DIN 16962, DIN EN ISO 15874  
 Colour: green



SDR	Art.-No.	Dimension d [mm]	Dimension d1 [mm]	z	Weight [kg]	System	PU	Box unit	Price € m/pc
double-sided butt welding									
17,6	2511184	200	160	135,00	0,786	•	1		
	2511188	250	160	172,50	1,500	•	1		
	2511190	250	200	172,50	1,338	•	1		
	2511193	315	200	225,00		•	1		
	2511195	315	250	225,00		•	1		
	2511197	355	250	245,00	3,099	•	1		
	2511199	355	315	160,00	3,108	•	1		
	2511201	400	250	260,00	4,482	•	1		
	2511203	400	315	260,00	3,366	•	1		
	2511204	400	355	260,00	2,982	•	1		
	2511206	450	315	230,00	4,891	•	1		
	2511207	450	355	230,00	4,688	•	1		
	2511208	450	400	230,00	4,287	•	1		
	2511209	500	315	230,00	8,100	•	1		
	2511210	500	355	230,00	6,500	•	1		
	2511211	500	400	230,00	6,700	•	1		
	2511212	500	450	230,00	5,500	•	1		
	2511213	560	400	230,00	9,000	•	1		
	2511214	560	450	200,00	8,600	•	1		
2511215	560	500	200,00	7,600	•	1			
2511216	630	400	230,00	15,100	•	1			
2511217	630	450	200,00	13,700	•	1			
2511218	630	500	200,00	11,000	•	1			
2511219	630	560	200,00	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	29,50	0,018	• • •	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	0,071	• • •	5	250	
	12116	50	26,00	49,50	68,00	0,163	• • •	5	125	
	12118	63	32,50	60,00	84,00	0,290	• • •	1	75	
	12120	75	38,50	68,50	100,00	0,446	• • •	1	40	
	12122	90	46,00	79,00	120,00	0,743	• • •	1	25	
	12124	110	56,00	93,00	147,00	1,282	• • •	1	15	
	12126	125	76,50	116,50	167,00	2,006	• • •	1	10	

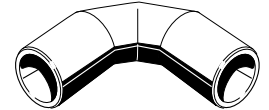
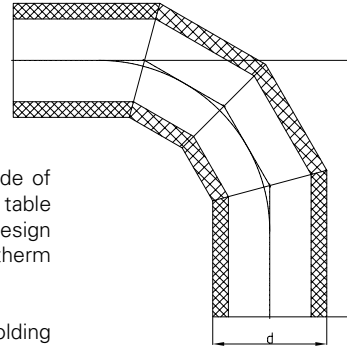
## ELBOW 90° BUTT WELDING

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

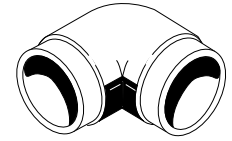
There is a gradual conversion of the XXL-fittings made of pipe segments to an injection molded design. The table shows which articles are already available in new design at the time of printing this catalogue. In the aqualtherm technews we will inform you of further changes.

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



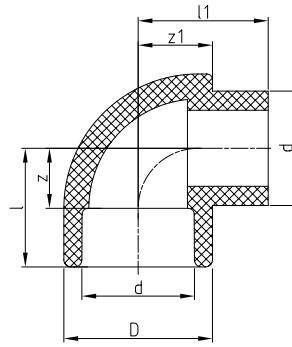
Injection molded fitting

SDR	Art.-No.	Dimension d [mm]	z	Weight [kg]	System	Pipe segments	Injection molded*	PU	Box unit	Price € m/pc
<b>NEW</b>										
butt welding										
7,4	<b>12130</b>	<b>160</b>	145,00	2,558	•	•		1	8	
	<b>12134</b>	<b>200</b>	450,00	11,685	•	•		1	16	
	<b>12138</b>	<b>250</b>	625,00	26,000	•	•		1	7	
<b>NEW</b> 9	<b>312130</b>	<b>160</b>	390,00	4,941	•		•	1		
	<b>312134</b>	<b>200</b>	450,00	8,896	•	•		1		
	<b>312138</b>	<b>250</b>	625,00	10,418	•	•		1		
	<b>312142</b>	<b>315</b>	773,00	39,717	•	•		1		
	<b>312144</b>	<b>355</b>	833,00	52,135	•	•		1		
<b>NEW</b> 11	<b>12131</b>	<b>160</b>	145,00	1,912	•	•	•	1	8	
	<b>12135</b>	<b>200</b>	450,00	8,140	•	•		1	12	
	<b>12139</b>	<b>250</b>	625,00	18,000	•	•		1	6	
	<b>12143</b>	<b>315</b>	773,00	37,850	•	•		1	2	
	<b>12145</b>	<b>355</b>	833,00	37,400	•	•		1		
	<b>12147</b> <sup>1)</sup>	<b>400</b>	900,00	40,624	•	•		1		
	<b>12149</b> <sup>1)</sup>	<b>450</b>	975,00	54,430	•	•		1		
1) mechanically stabilized through a fibre mix integrated in the middle layer of the fusiolen® PP-R										
11	<b>2012135</b>	<b>200</b>	450,00	8,014		•		1		
	<b>2012139</b>	<b>250</b>	625,00	18,000		•		1		
	<b>2012143</b>	<b>315</b>	773,00	37,300		•		1		
	<b>2012145</b>	<b>355</b>	833,00	26,650		•		1		
	<b>2012147</b>	<b>400</b>	900,00	74,500		•		1		
	<b>2012149</b>	<b>450</b>	975,00			•		1		
<b>NEW</b> 17,6	<b>2512130</b>	<b>160</b>	390,00	3,200		•	•	1		
	<b>2512134</b>	<b>200</b>	450,00			•		1		
	<b>2512138</b>	<b>250</b>	625,00			•		1		
	<b>2512142</b>	<b>315</b>	773,00	24,000		•		1		
	<b>2512144</b>	<b>355</b>	833,00	32,000		•		1		
	<b>2512146</b>	<b>400</b>	900,00			•		1		
	<b>2512148</b>	<b>450</b>	975,00			•		1		
	<b>2512150</b>	<b>500</b>	1100,00			•		1		
	<b>2512152</b>	<b>560</b>	1190,00			•		1		
<b>2512154</b>	<b>630</b>	1295,00			•		1			

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

## ELBOW 90° FEMALE/MALE

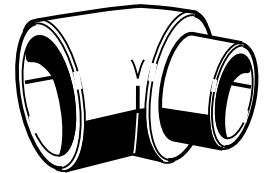
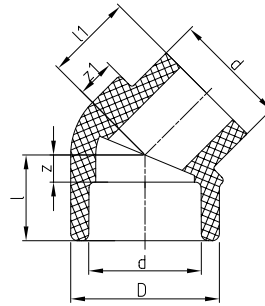
Systems: **aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe**  
 Material: Fusiolen® PP-R  
 Standard: DIN 16962, DIN EN ISO 15874  
 Colour: green



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	<b>12306</b>	<b>16</b>	9,00	22,00	24,50	21,75	12,00	0,010	• • •	10	2000	
	<b>12308</b>	<b>20</b>	11,00	25,50	29,50	25,50	15,00	0,017	• • •	10	1200	
	<b>12310</b>	<b>25</b>	13,50	29,50	34,00	29,50	17,00	0,023	• • •	10	800	
	<b>12312</b>	<b>32</b>	17,00	35,00	43,00	39,00	21,50	0,047	• • •	5	400	
	<b>12314</b>	<b>40</b>	21,00	41,50	52,00	45,50	26,00	0,080	• • •	5	300	

## ELBOW 45° FEMALE/MALE

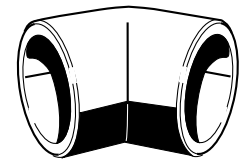
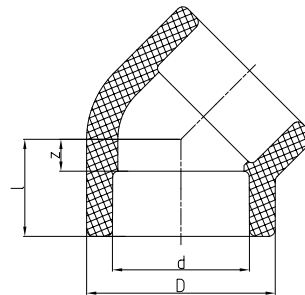
Systems: **aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe**  
 Material: Fusiolen® PP-R  
 Standard: DIN 16962, DIN EN ISO 15874  
 Colour: green



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	<b>12708</b>	<b>20</b>	5,00	19,50	29,50	19,50	9,00	0,013	• • •	10	1500	
	<b>12710</b>	<b>25</b>	6,00	22,00	34,00	22,00	8,50	0,017	• • •	10	1000	
	<b>12712</b>	<b>32</b>	7,50	25,50	43,00	28,50	11,50	0,036	• • •	5	500	
	<b>12714</b>	<b>40</b>	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	<b>12506</b>	<b>16</b>	4,50	17,50	24,50	0,009	• • •	10	2000	
	<b>12508</b>	<b>20</b>	5,00	19,50	29,50	0,014	• • •	10	1500	
	<b>12510</b>	<b>25</b>	6,00	22,00	34,00	0,018	• • •	10	1000	
	<b>12512</b>	<b>32</b>	7,50	25,50	43,00	0,035	• • •	5	500	
	<b>12514</b>	<b>40</b>	9,50	30,00	52,00	0,053	• • •	5	300	
	<b>12516</b>	<b>50</b>	11,50	35,00	68,00	0,113	• • •	5	150	
	<b>12518</b>	<b>63</b>	14,00	41,50	84,00	0,226	• • •	1	75	
	<b>12520</b>	<b>75</b>	16,50	46,50	100,00	0,350	• • •	1	60	
	<b>12522</b>	<b>90</b>	19,50	52,50	120,00	0,571	• • •	1	30	
	<b>12524</b>	<b>110</b>	23,50	60,50	147,00	1,022	• • •	1	20	
	<b>12526</b>	<b>125</b>	27,00	67,00	167,00	1,309	• • •	1	15	

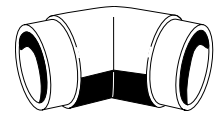
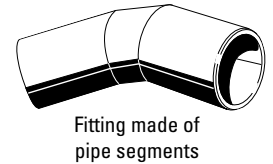
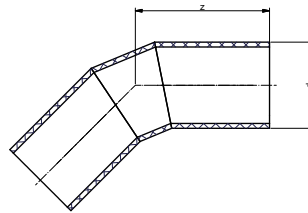
## ELBOW 45° BUTT WELDING

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.

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.



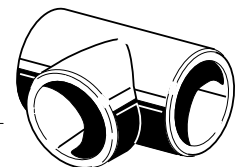
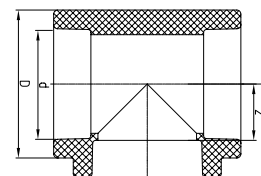
Injection molded fitting

SDR	Art.-No.	Dimension d [mm]	z	Weight [kg]	System			Pipe segments	Injection molded*	PU	Box unit	Price € m/pc
butt welding												
7,4	12530	160	95,00	1,876	•			•		1		
	12534	200	274,00	8,175	•			•		1		
	12538	250	412,00	2,800	•			•		1		
9	312530	160	250,00	3,564	•			•		1		
	312534	200	274,00	6,120	•			•		1		
	312538	250	412,00	14,380	•			•		1		
	312542	315	517,00	27,608	•			•		1		
	312544	355	520,00	29,974	•			•		1		
11	12531	160	95,00	1,380	•	•		•		1		
	12535	200	274,00	5,735	•			•		1		
	12539	250	412,00	13,000	•			•		1		
	12543	315	517,00	27,300	•			•		1		
	12545	355	520,00	26,650	•			•		1		
	12547 <sup>1)</sup>	400	548,00	47,852	•			•		1		
	12549 <sup>1)</sup>	450	580,00	62,848	•			•		1		
1) mechanically stabilized through a fibre mix integrated in the middle layer of the fusiolen® PP-R												
11	2012535	200	274,00	6,865		•		•		1		
	2012539	250	412,00	16,000		•		•		1		
	2012543	315	517,00	27,100		•		•		1		
	2012545	355	520,00	42,000		•		•		1		
	2012547	400	548,00			•		•		1		
	2012549	450	580,00			•		•		1		
17,6	2512530	160	249,00	1,730		•		•		1		
	2512534	200	274,00			•		•		1		
	2512538	250	412,00	9,400		•		•		1		
	2512542	315	498,00	18,000		•		•		1		
	2512544	355	520,00			•		•		1		
	2512546	400	548,00	30,800		•		•		1		
	2512548	450	580,00			•		•		1		
	2512550	500	665,00			•		•		1		
	2512552	560	698,00			•		•		1		
	2512554	630	741,00			•		•		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



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	13106	16	9,00	22,00	24,50	0,015	•			10	1500	
	13108	20	11,00	25,50	29,50	0,022	•	•	•	10	800	
	13110	25	15,00	31,00	34,00	0,033	•	•	•	10	500	
	13112	32	17,00	35,00	43,00	0,054	•	•	•	5	300	
	13114	40	20,00	40,50	52,00	0,099	•	•	•	5	200	
	13116	50	26,00	49,50	68,00	0,175	•	•	•	5	100	
	13118	63	32,50	60,00	84,00	0,371	•	•	•	1	50	
	13120	75	38,50	68,50	100,00	0,540	•	•	•	1	30	
	13122	90	46,00	79,00	120,00	0,924	•	•	•	1	25	
	13124	110	56,00	93,00	147,00	1,611	•	•	•	1	14	
13126	125	76,50	116,50	167,00	2,655	•	•	•	1	8		

## T-PIECE BUTT WELDING

Systems: **aquatherm green pipe, aquatherm blue pipe**

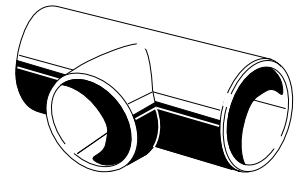
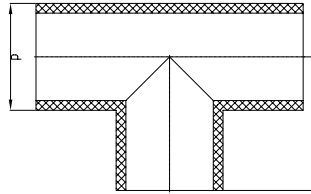
Material: Fusiolen® PP-R & PP-RP

Standard: DIN 16962, DIN EN ISO 15874

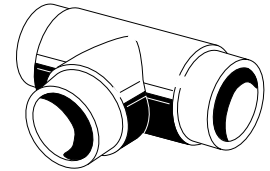
Notice: There is a gradual conversion of the XXL-fittings made of pipe segments to an injection molded design. The table shows which articles are already available in new design at the time of printing this catalogue. In the aquatherm technews we will inform you of further changes.

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.

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Fitting made of pipe segments



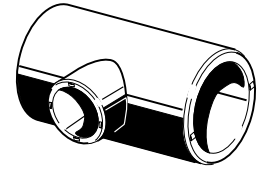
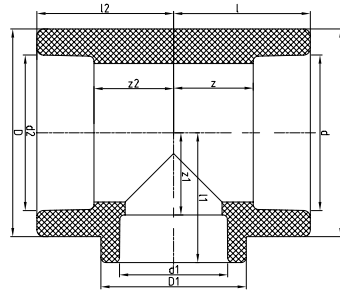
Injection molded fitting

SDR	Art.-No.	Dimension d [mm]	z	Weight [kg]	System		NEW		PU	Box unit	Price € m/pc
							Pipe segments	Injection molded*			
7,4	butt welding										
	<b>13130</b>	<b>160</b>	145,00	3,575	•			•	1	5	
	<b>13134</b>	<b>200</b>	250,00	9,825	•			•	1	2	
	<b>13138</b>	<b>250</b>	375,00	22,000	•			•	1	8	
9	<b>NEW 313130</b>	<b>160</b>	230,00	4,333	•			•	1		
	<b>313134</b>	<b>200</b>	250,00	7,236	•			•	1		
	<b>313138</b>	<b>250</b>	375,00	17,400	•			•	1		
	<b>313142</b>	<b>315</b>	460,00	33,810	•			•	1		
	<b>313144</b>	<b>355</b>	480,00	44,306	•			•	1		
11	<b>NEW 13131</b>	<b>160</b>	145,00	2,791	•	•		•	1	5	
	<b>13135</b>	<b>200</b>	250,00	6,865	•			•	1	2	
	<b>13139</b>	<b>250</b>	375,00	16,000	•			•	1	8	
	<b>13143</b>	<b>315</b>	460,00	20,450	•			•	1		
	<b>13145</b>	<b>355</b>	480,00		•			•	1		
	<b>13147<sup>1)</sup></b>	<b>400</b>	500,00	47,852	•			•	1		
	<b>13149<sup>1)</sup></b>	<b>450</b>	525,00	62,848	•			•	1		
1) mechanically stabilized through a fibre mix integrated in the middle layer of the fusiolen® PP-R											
11	<b>2013135</b>	<b>200</b>	250,00	6,865		•		•	1		
	<b>2013139</b>	<b>250</b>	375,00	16,000		•		•	1		
	<b>2013143</b>	<b>315</b>	460,00	20,450		•		•	1		
	<b>2013145</b>	<b>355</b>	480,00	42,000		•		•	1		
	<b>2013147</b>	<b>400</b>	500,00			•		•	1		
	<b>2013149</b>	<b>450</b>	525,00			•		•	1		
17,6	<b>NEW 2513130</b>	<b>160</b>	145,00	2,716		•		•	1		
	<b>2513134</b>	<b>200</b>	250,00			•		•	1		
	<b>2513138</b>	<b>250</b>	375,00	11,500		•		•	1		
	<b>2513142</b>	<b>315</b>	460,00	22,000		•		•	1		
	<b>2513144</b>	<b>355</b>	480,00	27,500		•		•	1		
	<b>2513146</b>	<b>400</b>	500,00			•		•	1		
	<b>2513148</b>	<b>450</b>	525,00			•		•	1		
	<b>2513150</b>	<b>500</b>	600,00			•		•	1		
	<b>2513152</b>	<b>560</b>	630,00			•		•	1		
	<b>2513154</b>	<b>630</b>	665,00			•		•	1		

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

# RED.- T-PIECE, SOCKET WELDING

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



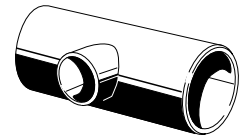
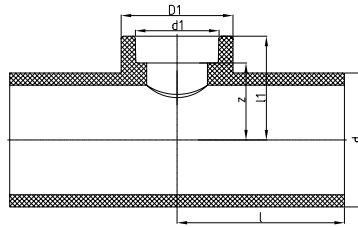
SDR	Art.-No.	d	d1	d2	l	l1	l2	z	z1	z2	D	D1	Weight [kg]	System	PU	Box unit	Price € m/pc		
socket welding																			
6 7,4 9 11 17,6	13506	20	16	16	25,50	25,50	25,50	11,00	12,00	12,50	29,50	29,50	0,025	•		10	1000		
	13508	20	16	20	25,50	25,50	25,50	11,00	12,00	11,00	29,50	29,50	0,024	•		10	1000		
	13510	20	20	16	25,50	25,50	25,50	11,00	11,00	12,50	29,50	29,50	0,023	•		10	1000		
	13511	20	25	20	31,00	30,50	31,00	16,50	14,50	16,50	34,00	34,00	0,040	•	•	•	10	500	
	13512	25	16	16	31,00	30,50	31,00	15,00	17,50	18,00	34,00	34,00	0,043	•			10	500	
	13514	25	16	20	31,00	30,50	31,00	15,00	17,50	16,50	34,00	34,00	0,041	•			10	500	
	13516	25	16	25	31,00	30,50	31,00	15,00	17,50	15,00	34,00	34,00	0,038	•			10	500	
	13520	25	20	20	31,00	30,50	31,00	15,00	16,00	16,50	34,00	34,00	0,039	•	•	•	10	500	
	13522	25	20	25	31,00	30,50	31,00	15,00	16,00	15,00	34,00	34,00	0,036	•	•	•	10	500	
	13528	32	16	32	35,00	31,00	35,00	17,00	18,00	17,00	43,00	29,50	0,053	•	•	•	5	300	
	13532	32	20	20	36,50	37,00	36,50	18,75	22,50	22,25	43,00	43,00	0,075	•	•	•	5	300	
	13534	32	20	32	35,00	31,00	35,00	17,00	16,50	17,00	43,00	29,50	0,049	•	•	•	5	300	
	13538	32	25	25	35,00	34,50	35,00	17,00	18,50	15,00	43,00	43,00	0,069	•	•	•	5		
	13540	32	25	32	35,00	34,50	35,00	17,00	18,50	17,00	43,00	43,00	0,050	•	•	•	5	300	
	13542	40	20	40	41,50	36,00	41,50	21,00	21,50	21,00	52,00	34,00	0,091	•	•	•	5	200	
	13544	40	25	40	41,50	36,00	41,50	21,00	20,00	21,00	52,00	34,00	0,090	•	•	•	5	200	
	13546	40	32	40	42,00	40,50	42,00	21,50	22,50	21,50	52,00	52,00	0,092	•	•	•	5	200	
	13547	50	20	50	49,50	40,50	49,50	26,00	26,00	26,00	68,00	29,50	0,161	•	•	•	5	100	
	13548	50	25	50	49,50	44,50	49,50	26,00	28,50	26,00	68,00	43,00	0,158	•	•	•	5	100	
	13550	50	32	50	49,50	44,50	49,50	26,00	26,50	26,00	68,00	43,00	0,159	•	•	•	5	100	
	13551	50	40	50	49,50	49,50	49,50	26,00	29,00	26,00	68,00	68,00	0,161	•	•	•	5	100	
	13552	63	20	63	60,00	48,50	60,00	32,50	34,00	32,50	84,00	34,00	0,334	•	•	•	1	50	
	13554	63	25	63	60,00	48,50	60,00	32,50	32,50	32,50	84,00	34,00	0,329	•	•	•	1	50	
	13556	63	32	63	60,00	53,50	60,00	32,50	35,50	32,50	84,00	52,00	0,342	•	•	•	1	50	
	13558	63	40	63	60,00	53,50	60,00	32,50	33,00	32,50	84,00	52,00	0,333	•	•	•	1	50	
	13560	63	50	63	60,00	60,00	60,00	32,50	36,50	32,50	84,00	84,00	0,402	•	•	•	1	50	
	13561	75	20	75	68,50	54,50	68,50	38,50	40,00	38,50	100,00	34,00	0,501	•	•	•	1	35	
	13562	75	25	75	68,50	54,50	68,50	38,50	38,50	38,50	100,00	34,00	0,497	•	•	•	1	35	
	13564	75	32	75	68,50	59,00	68,50	38,50	41,00	38,50	100,00	52,00	0,506	•	•	•	1	35	
	13566	75	40	75	68,50	59,00	68,50	38,50	38,50	38,50	100,00	52,00	0,496	•	•	•	1	35	
	13568	75	50	75	68,50	66,00	68,50	38,50	42,50	38,50	100,00	84,00	0,553	•	•	•	1	35	
	13570	75	63	75	68,50	66,00	68,50	38,50	38,50	38,50	100,00	84,00	0,518	•	•	•	1	35	
	13576 <sup>1)</sup>	90	32	90	79,00	65,00	79,00	46,00	47,00	46,00	120,00	52,00	0,882	•	•	•	1	25	
	13578 <sup>1)</sup>	90	40	90	79,00	65,00	79,00	46,00	44,50	46,00	120,00	52,00	0,870	•	•	•	1	25	
	13580 <sup>1)</sup>	90	50	90	79,00	75,00	79,00	46,00	51,50	46,00	120,00	84,00	0,908	•	•	•	1	25	
	13582 <sup>1)</sup>	90	63	90	79,00	75,00	79,00	46,00	47,50	46,00	120,00	84,00	0,874	•	•	•	1	25	
13584 <sup>1)</sup>	90	75	90	79,00	81,00	79,00	46,00	51,00	46,00	120,00	120,00	0,993	•	•	•	1	25		
13586 <sup>1)</sup>	110	63	110	93,00	87,50	93,00	56,00	60,00	56,00	147,00	100,00	1,567	•	•	•	1	15		
13588 <sup>1)</sup>	110	75	110	93,00	87,50	93,00	56,00	57,50	56,00	147,00	100,00	1,501	•	•	•	1	15		
13590 <sup>1)</sup>	110	90	110	93,00	89,00	93,00	56,00	56,00	56,00	147,00	120,00	1,534	•	•	•	1	15		
13592 <sup>1)</sup>	125	75	125	116,50	106,50	116,50	76,50	76,50	76,50	167,00	100,00	2,421	•	•	•	1	8		
13594 <sup>1)</sup>	125	90	125	116,50	109,50	116,50	76,50	76,50	76,50	167,00	120,00	2,519	•	•	•	1	8		
13596 <sup>1)</sup>	125	110	125	116,50	113,50	116,50	76,50	76,50	76,50	167,00	147,00	2,563	•	•	•	1	8		

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



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

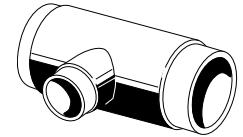
Systems: **aquatherm green pipe, aquatherm blue pipe**  
 Material: Fusiolen® PP-R & PP-RP  
 Standard: DIN 16962, DIN EN ISO 15874  
 Branch: socket welding



Fitting made of pipe segments

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.

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.



Injection molded fitting

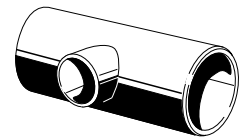
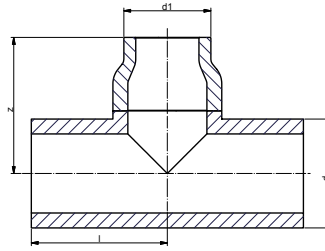
**Please note!** Electrofusion sockets can not be processed directly with injection molded fittings. When using electrofusion sockets either segment welded special fittings must be used or pipe pieces must be welded to the injection molded fittings.

SDR	Art.-No.	d	d1	l	l1	z	D	Weight [kg]	System	Pipe segments	Injection molded*	PU	Box unit	Price € m/pc
<b>NEW</b>														
branch: socket welding														
7,4	13600	160	75	230,00	122,00	92,00	100,00	4,414	•		•	1	4	
	13602	160	90	230,00	125,00	92,00	120,00	4,515	•		•	1	4	
	13608	200	75	250,00	142,00	112,00	100,00	7,110	•		•	1	1	
	13610	200	90	250,00	145,00	112,00	120,00	7,540	•		•	1	1	
	13612	200	110	250,00	149,00	112,00	147,00	7,325	•		•	1	1	
	13614	200	125	250,00	155,00	115,00	167,00	7,645	•		•	1	1	
	13624	250	75	375,00	167,00	137,00	100,00	16,600	•		•	1	10	
	13626	250	90	375,00	170,00	137,00	120,00	16,800	•		•	1	10	
	13628	250	110	375,00	174,00	137,00	147,00	16,800	•		•	1	10	
13630	250	125	375,00	180,00	140,00	167,00	17,000	•		•	1	10		
9	313600	160	75	230,00	122,00	92,00	100,00	3,48	•		•	1		
	313602	160	90	230,00	125,00	92,00	120,00	3,57	•		•	1		
	313608	200	75	250,00	142,00	112,00	100,00	5,81	•		•	1		
	313610	200	90	250,00	145,00	112,00	120,00	5,89	•		•	1		
	313612	200	110	250,00	149,00	112,00	147,00	6,20	•		•	1		
	313614	200	125	250,00	155,00	115,00	167,00	6,35	•		•	1		
	313624	250	75	375,00	167,00	137,00	100,00	14,72	•		•	1		
	313626	250	90	375,00	170,00	137,00	120,00	14,84	•		•	1		
	313628	250	110								•	1		
	313630	250	125	375,00	180,00	140,00	167,00	15,33	•		•	1		
313904	315	125							•		1			
313916	355	125	480,00		193,00		45,950	•		•	1	1		
11	13601	160	75	230,00	122,00	92,00	100,00	3,140	•	•	•	1	4	
	13603	160	90	230,00	125,00	92,00	120,00	3,176	•	•	•	1	4	
	13609	200	75	250,00	142,00	112,00	100,00	5,284	•		•	1	1	
	13611	200	90	250,00	145,00	112,00	120,00	5,168	•		•	1	1	
	13613	200	110	250,00	149,00	112,00	147,00	5,648	•		•	1	1	
	13615	200	125	250,00	155,00	115,00	167,00	5,786	•		•	1	1	
	13625	250	75	375,00	167,00	137,00	100,00	12,000	•		•	1	10	
	13627	250	90	375,00	170,00	137,00	120,00	12,000	•		•	1	10	
	13629	250	110	375,00	174,00	137,00	147,00	13,000	•		•	1	10	
	13631	250	125	375,00	180,00	140,00	167,00	12,000	•		•	1	10	
	13651	315	125	460,00	213,00	173,00	167,00	25,150	•		•	1		
	13663	355	125	480,00	233,00	193,00	167,00		•		•	1		
	13676	400	125	500,00	255,00	215,00	167,00		•		•	1		
13690	450	125	525,00	280,00	240,00	167,00		•		•	1			

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

## RED.- T-PIECE, BUTT WELDING

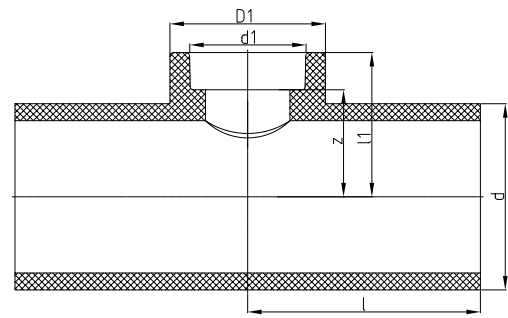
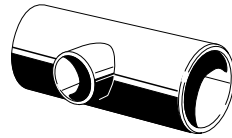
Systems: **aqualtherm green pipe**  
 Material: Fusiolen® PP-R & PP-RP  
 Standard: DIN 16962, DIN EN ISO 15874  
 Branch: butt welding



SDR	Art.-No.	d	d1	l	z	Weight [kg]	System	PU	Box unit	Price € m/pc
branch: butt welding										
7,4	13618	200	160	250,00	250,00	28,000	•	1	4	
	13634	250	160	375,00	682,00	27,000	•	1	4	
	13640	250	200	375,00	375,00		•	1	4	
9	313618	200	160	250,00	250,00	6,42	•	1		
	313634	250	160	375,00	682,00	22,070	•	1	1	
	313640	250	200	375,00	548,00	17,470	•	1	1	
	313906	315	160	460,00	238,00	29,310	•	1	1	
	313908	315	200	460,00	460,00	35,900	•	1	1	
	313910	315	250	460,00	460,00	36,400	•	1	1	
	313918	355	160	480,00	258,00	46,500	•	1	1	
	313920	355	200	480,00	268,00	38,950	•	1	1	
	313922	355	250	480,00	480,00	22,070	•	1	1	
313924	355	315	480,00	480,00	17,470	•	1	1		
11	13619	200	160	250,00	250,00		•	1		
	13635	250	160	375,00	375,00	19,500	•	1	4	
	13641	250	200	375,00	375,00	18,500	•	1	4	
	13653	315	160	460,00	238,00	24,850	•	1		
	13655	315	200	460,00	460,00	29,400	•	1		
	13657	315	250	460,00	460,00	30,250	•	1		
	13665	355	160	480,00	258,00		•	1		
	13667	355	200	480,00	268,00		•	1		
	13669	355	250	480,00	480,00		•	1		
	13671	355	315	480,00	480,00		•	1		
	13678	400	160	500,00	354,00		•	1		
	13680	400	200	500,00	318,00		•	1		
	13682	400	250	500,00	280,00		•	1		
	13684	400	315	500,00	500,00		•	1		
	13685	400	355	500,00	500,00		•	1		
	13692	450	160	525,00	379,00		•	1		
	13694	450	200	525,00	343,00		•	1		
13696	450	250	525,00	305,00		•	1			
13698	450	315	525,00	315,00		•	1			
13699	450	355	525,00	525,00		•	1			
13700	450	400	525,00	525,00		•	1			

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

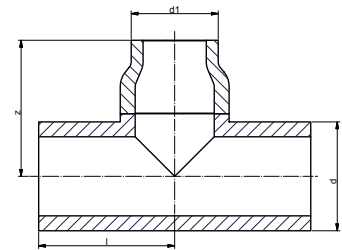
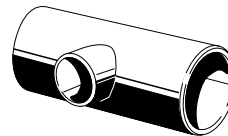
Systems: **aquatherm blue pipe**  
 Material: Fusiolen® PP-R  
 Standard: DIN 16962, DIN EN ISO 15874  
 Colour: blue/green  
 Branch: socket welding



SDR	Art.-No.	d	d1	l	l1	z	D	Weight [kg]	System	PU	Box unit	Price € m/pc
branch: socket welding												
11	2013609	200	75	250,00	142,00	112,00	100,00		•	1		
	2013611	200	90	250,00	145,00	112,00	120,00		•	1		
	2013613	200	110	250,00	149,00	112,00	147,00		•	1		
	2013615	200	125	250,00	155,00	115,00	167,00		•	1		
	2013625	250	75	375,00	167,00	137,00	100,00		•	1		
	2013627	250	90	375,00	170,00	137,00	120,00		•	1		
	2013629	250	110	375,00	174,00	137,00	147,00		•	1		
	2013631	250	125	375,00	180,00	140,00	167,00		•	1		
	2013651	315	125	460,00	213,00	173,00	167,00	25,000	•	1		
	2013663	355	125	480,00	233,00	193,00	167,00		•	1		
	2013676	400	125	500,00	255,00	215,00	167,00		•	1		
2013690	450	125	525,00	280,00	240,00	167,00		•	1			

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

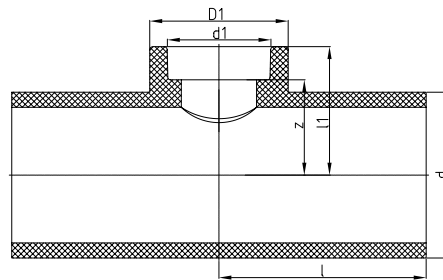
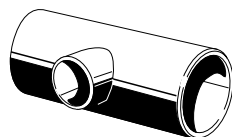
Systems: **aquatherm blue pipe**  
 Material: Fusiolen® PP-R  
 Standard: DIN 16962, DIN EN ISO 15874  
 Colour: blue/green  
 Branch: butt welding



SDR	Art.-No.	d	d1	l	z	Weight [kg]	System	PU	Box unit	Price € m/pc
branch: butt welding										
11	2013619	200	160	250,00	250,00		•	1		
	2013635	250	160	375,00	682,00		•	1		
	2013641	250	200	375,00	548,00		•	1		
	2013653	315	160	460,00	238,00	25,000	•	1		
	2013655	315	200	460,00	460,00		•	1		
	2013657	315	250	460,00	460,00		•	1		
	2013665	355	160	480,00	258,00		•	1		
	2013667	355	200	480,00	268,00	30,200	•	1		
	2013669	355	250	480,00	480,00	40,000	•	1		
	2013671	355	315	480,00	480,00	40,000	•	1		
	2013678	400	160	500,00	354,00		•	1		
	2013680	400	200	500,00	318,00		•	1		
	2013682	400	250	500,00	280,00	46,000	•	1		
	2013684	400	315	500,00	500,00		•	1		
	2013685	400	355	500,00	500,00		•	1		
	2013692	450	160	525,00	379,00		•	1		
	2013694	450	200	525,00	343,00		•	1		
	2013696	450	250	525,00	305,00		•	1		
	2013698	450	315	525,00	315,00		•	1		
2013699	450	355	525,00	525,00		•	1			
2013700	450	400	525,00	525,00		•	1			

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

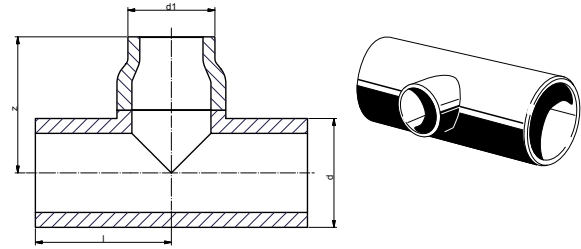
Systems: **aquatherm blue pipe**  
 Material: Fusiolen® PP-R  
 Standard: DIN 16962, DIN EN ISO 15874  
 Colour: blue  
 Branch: socket welding



SDR	Art.-No.	d	d1	l	l1	z	D	Weight [kg]	System	PU	Box unit	Price € m/pc
17,6	branch: socket welding											
	2513600	160	75	230,00	122,00	92,00	100,00		•	1		
	2513602	160	90	230,00	125,00	92,00	120,00		•	1		
	2513608	200	75	250,00	142,00	112,00	100,00		•	1		
	2513610	200	90	250,00	145,00	112,00	120,00		•	1		
	2513612	200	110	250,00	149,00	112,00	147,00		•	1		
	2513614	200	125	250,00	155,00	115,00	167,00		•	1		
	2513624	250	75	375,00	167,00	137,00	100,00		•	1		
	2513626	250	90	375,00	170,00	137,00	120,00		•	1		
	2513628	250	110	375,00	174,00	137,00	147,00		•	1		
	2513630	250	125	375,00	180,00	140,00	167,00		•	1		
	2513651	315	125	460,00	213,00	173,00	167,00		•	1		
	2513663	355	125	480,00	233,00	193,00	167,00	21,500	•	1		
	2513676	400	125	500,00	255,00	215,00	167,00		•	1		
	2513690	450	125	525,00	280,00	240,00	167,00		•	1		
2513804	500	125	600,00	305,00	265,00	167,00		•	1			
2513821	560	125	630,00	335,00	295,00	167,00		•	1			
2513839	630	125	665,00	370,00	330,00	167,00		•	1			

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

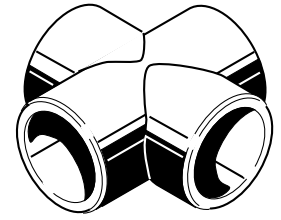
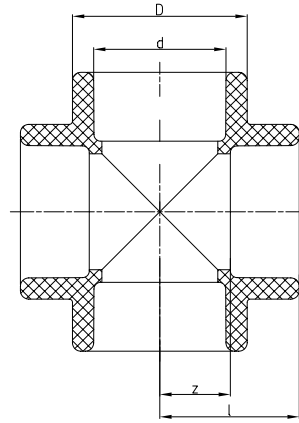
Systems: **aquatherm blue pipe**  
 Standard: DIN 16962, DIN EN ISO 15874  
 Colour: blue  
 Branch: butt welding



SDR	Art.-No.	d	d1	l	z	Weight [kg]	System	PU	Box unit	Price € m/pc
	butt welding									
	2513618	200	160	250,00	250,00		•	1		
	2513634	250	160	375,00	375,00		•	1		
	2513640	250	200	375,00	375,00		•	1		
	2513653	315	160	460,00	238,00		•	1		
	2513655	315	200	460,00	460,00		•	1		
	2513657	315	250	460,00	460,00		•	1		
	2513665	355	160	480,00	258,00	21,500	•	1		
	2513667	355	200	480,00	268,00		•	1		
	2513669	355	250	480,00	480,00		•	1		
	2513671	355	315	480,00	480,00		•	1		
	2513678	400	160	500,00	354,00		•	1		
	2513680	400	200	500,00	318,00		•	1		
	2513682	400	250	500,00	280,00	29,000	•	1		
	2513684	400	315	500,00	500,00	35,800	•	1		
	2513685	400	355	500,00	500,00		•	1		
	2513692	450	160	525,00	379,00		•	1		
	2513694	450	200	525,00	343,00		•	1		
	2513696	450	250	525,00	305,00		•	1		
	2513698	450	315	525,00	315,00		•	1		
	2513699	450	355	525,00	525,00		•	1		
	2513700	450	400	525,00	525,00		•	1		
17,6	2513806	500	160	600,00	404,00		•	1		
	2513808	500	200	600,00	368,00		•	1		
	2513810	500	250	600,00	330,00		•	1		
	2513812	500	315	600,00	340,00		•	1		
	2513813	500	355	600,00	600,00		•	1		
	2513814	500	400	600,00	600,00		•	1		
	2513815	500	450	600,00	600,00		•	1		
	2513823	560	160	630,00	434,00		•	1		
	2513825	560	200	630,00	398,00		•	1		
	2513827	560	250	630,00	360,00		•	1		
	2513829	560	315	630,00	370,00		•	1		
	2513830	560	355				•	1		
	2513831	560	400	630,00	630,00		•	1		
	2513832	560	450	630,00	630,00		•	1		
	2513833	560	500	630,00	630,00		•	1		
	2513841	630	160	665,00	474,00		•	1		
	2513843	630	200	665,00	438,00		•	1		
	2513845	630	250	665,00	400,00		•	1		
	2513847	630	315	665,00	405,00		•	1		
	2513848	630	355				•	1		
	2513849	630	400	665,00	665,00		•	1		
	2513850	630	450	665,00	665,00		•	1		
	2513851	630	500	665,00	665,00		•	1		
	2513852	630	560	665,00	665,00		•	1		

## CROSS

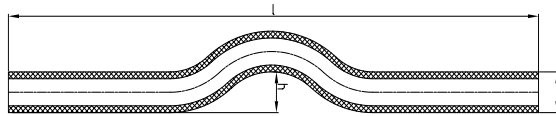
Systems: **aquatherm green pipe**,  
**aquatherm blue pipe**, **aquatherm lilac pipe**  
 Material: Fusiolen® PP-R  
 Standard: DIN 16962, DIN EN ISO 15874  
 Colour: green



SDR	Art.-No.	Dimension d [mm]	z	l	D	Weight [kg]	System	PU	Box unit	Price € m/pc
socket welding										
6	<b>13708</b>	<b>20</b>	26,00	11,50	29,50	0,025	• • •	10	500	
7,4	<b>13710</b>	<b>25</b>	29,50	13,50	34,00	0,035	• • •	10	500	
9	<b>13712</b>	<b>32</b>	35,00	17,00	43,00	0,064	• • •	5	250	
11	<b>13714</b>	<b>40</b>	41,50	21,00	52,00	0,099	• • •	5	150	

## 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	<b>16106</b>	<b>16</b>	17,00	352,00	0,038	•	10	600	
7,4	<b>16108</b>	<b>20</b>	22,00	352,00	0,060	• • •	10	400	
9	<b>16110</b>	<b>25</b>	25,00	352,00	0,091	• • •	10	250	
11	<b>16112</b>	<b>32</b>	32,00	352,00	0,154	• • •	5	120	

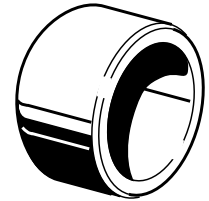
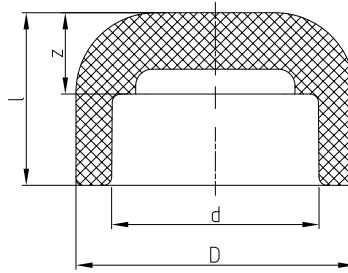
# END CAP

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



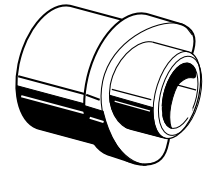
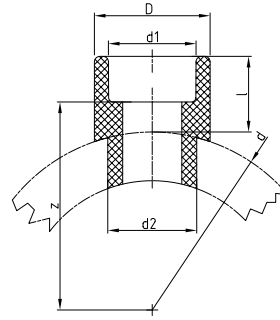
SDR	Art.-No.	Dimension d [mm]	l	z	D	Weight [kg]	System	PU	Box unit	Price € m/pc
socket welding										
6 7,4 9 11	14106	16	26,50	13,50	26	0,008	•		10	2000
	14108	20	24,00	9,50	29,5	0,009	•	•	10	2000
	14110	25	24,00	8,00	34	0,011	•	•	10	1500
	14112	32	31,50	13,50	43	0,019	•	•	5	1000
	14114	40	38,00	17,50	52	0,043	•	•	5	500
	14116	50	44,50	21,00	68	0,081	•	•	5	300
	14118	63	52,00	24,50	84	0,144	•	•	1	150
	14120	75	58,50	28,50	100	0,243	•	•	1	90
	14122	90	57,50	34,50	120	0,368	•	•	1	60
	14124	110	65,00	28,00	147	0,635	•	•	1	40
14126	125	70,00	30,00	167	0,862	•	•	1	30	
butt welding										
7,4	14130	160	70,00			0,914	•	•	1	30
	14134	200	80,00			1,378	•	•	1	24
	14138	250	90,00			2,530	•	•	1	10
9	314130	160	70,00			0,60	•		1	
	314134	200	80,00			1,10	•		1	
	314138	250	90,00			2,00	•		1	
	314142	315	270,00			5,80	•		1	
	314144	355	65,00			9,00	•		1	
11	14131	160	70,00			0,818	•	•	1	30
	14135	200	80,00			1,070	•	•	1	24
	14139	250	90,00			1,989	•	•	1	10
	14143	315	270,00			6,200	•	•	1	
	14145	355	65,00			9,500	•	•	1	
	14147	400	60,00				•	•	1	
	14149	450	70,00				•	•	1	
17,6	2514130	160				0,679		•	1	
	2514134	200				0,925		•	1	
	2514138	250				2,109		•	1	
	2514142	315				2,961		•	1	
	2514144	355				3,930		•	1	
	2514146	400	60,00			5,821		•	1	
	2514148	450	70,00			8,520		•	1	
	2514150	500	75,00			12,500		•	1	
	2514152	560	80,00			16,000		•	1	
2514154	630	90,00			23,500		•	1		

## WELD-IN SADDLE

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

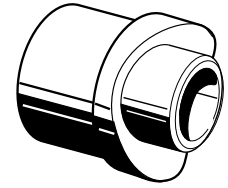
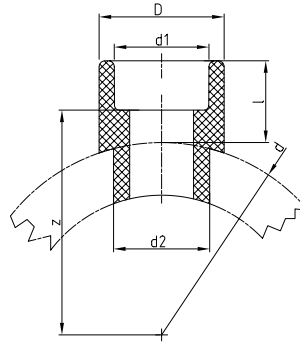


SDR	Art.-No.	d	d1	d2	l	z	D	Weight [kg]	System	PU	Box unit	Price € m/pc
socket welding												
6 7,4 9 11 17,6	15156*	40	20	25	27,00	32,50	29,50	0,016	•	•	•	5 1000
	15158*	40	25	25	28,50	32,50	34,00	0,017	•	•	•	5 1000
	15160	50	20	25	27,50	38,00	29,50	0,018	•	•	•	5 1000
	15162	50	25	25	28,50	37,50	34,00	0,019	•	•	•	5 1000
	15164	63	20	25	27,50	44,50	29,50	0,017	•	•	•	5 1000
	15166	63	25	25	28,50	44,00	34,00	0,019	•	•	•	5 750
	15168	63	32	32	30,00	43,50	43,00	0,028	•	•	•	5 750
	15170	75	20	25	27,50	50,50	29,50	0,018	•	•	•	5 1000
	15172	75	25	25	28,50	50,00	34,00	0,019	•	•	•	5 750
	15174	75	32	32	30,00	49,50	43,00	0,028	•	•	•	5 750
	15175	75	40	40	34,00	51,00	52,00	0,049	•	•	•	5 400
	15176	90	20	25	27,50	58,00	29,50	0,018	•	•	•	5 1000
	15178	90	25	25	28,50	57,50	34,00	0,019	•	•	•	5 1000
	15180	90	32	32	30,00	57,00	43,00	0,029	•	•	•	5 750
	15181	90	40	40	34,00	58,50	52,00	0,048	•	•	•	5 500
	15182	110	20	25	27,50	68,00	29,50	0,019	•	•	•	5 1000
	15184	110	25	25	28,50	68,50	34,00	0,020	•	•	•	5 1000
	15186	110	32	32	30,00	67,00	43,00	0,030	•	•	•	5 750
	15188	110	40	40	34,00	68,50	52,00	0,050	•	•	•	5 450
	15189	110	50	50	34,00	65,50	68,00	0,091	•	•	•	5 200
	15190	125	20	25	27,50	75,50	67,00	0,019	•	•	•	5 1000
	15192	125	25	25	28,50	75,00	34,00	0,020	•	•	•	5 1000
	15194	125	32	32	30,00	74,50	43,00	0,029	•	•	•	5 750
	15196	125	40	40	34,00	76,00	52,00	0,050	•	•	•	5 450
	15197	125	50	50	34,00	73,00	68,00	0,091	•	•	•	5 200
	15198	125	63	63	38,00	73,00	84,00	0,150	•	•	•	5 125
	15206	160	20	25	27,50	93,00	29,50	0,021	•	•	•	5 700
	15208	160	25	25	28,50	92,50	34,00	0,023	•	•	•	5 700
	15210	160	32	32	30,00	92,00	43,00	0,034	•	•	•	5 500
	15212	160	40	40	34,00	93,50	52,00	0,054	•	•	•	5 300
	15214	160	50	50	34,00	90,50	84,00	0,093	•	•	•	5 200
15216	160	63	63	38,00	90,50	84,00	0,155	•	•	•	5 120	
15218	160	75	75	42,00	92,00	100,00	0,227	•	•	•	5 80	
15220	160	90	90	45,00	92,00	120,00	0,364	•	•	•	5 40	
15228	200-250	20	25	27,50	113,00	29,50	0,020	•	•	•	5 100	
15229	200-250	25	25	28,50	112,50	34,00	0,021	•	•	•	5 100	
15230	200-250	32	32	30,00	112,00	43,00	0,031	•	•	•	5 50	
15231	200	40	40	34,00	113,50	52,00	0,049	•	•	•	5 200	
15232	200	50	50	34,00	110,50	68,00	0,087	•	•	•	5 200	
15233	200	63	63	37,50	110,00	84,00	0,147	•	•	•	5 120	
15234	200	75	75	42,00	112,00	100,00	0,220	•	•	•	5 100	
15235	200	90	90	45,00	112,00	120,00	0,342	•	•	•	5 5	
15236	200	110	110	49,00	112,00	147,00	0,577	•	•	•	5 2	
15237	200	125	125	55,00	115,00	167,00	0,869	•	•	•	5 20	
15251	250	40	40	34,00	138,50	52,00	0,053	•	•	•	5 150	
15252	250	50	50	34,00	135,50	68,00	0,090	•	•	•	5 100	
15253	250	63	63	37,50	135,00	84,00	0,152	•	•	•	5 140	
15254	250	75	75	42,00	137,00	100,00	0,222	•	•	•	5 5	
15255	250	90	90	45,00	137,00	120,00	0,348	•	•	•	5 5	
15256	250	110	110	49,00	137,00	147,00	0,054	•	•	•	5 20	
15257	250	125	125	55,00	140,00	167,00	0,820	•	•	•	5 20	



## WELD-IN SADDLES

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

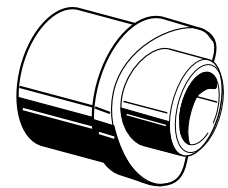
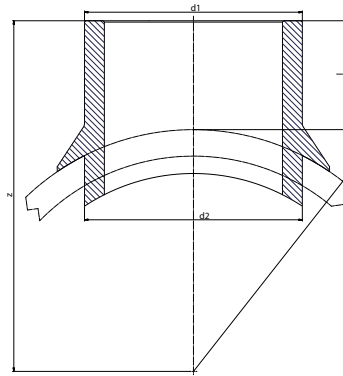


SDR	Art.-No.	d	d1	d2	l	z	D	Weight [kg]	System	PU	Box unit	Price € m/pc
socket welding												
6 7,4 9 11 17,6	15260	315-355	63	63	37,50	167,50	84,00	0,153	• •	1		
	15261	315-355	75	75	42,00	169,50	100,00	0,230	• •	1		
	15262	315	90	90	45,00	169,50	120,00	0,347	• •	1		
	15263	315	110	110	49,00	169,50	147,00	0,567	• •	1		
	15264	315	125	125	55,00	172,50	167,00	0,830	• •	1		
	15268	355	90	90	45,00	189,5	120,00	0,355	• •	1		
	15269	355	110	110	49,00	189,5	147,00	0,586	• •	1		
	15270	355	125	125	55,00	192,5	167,00	0,803	• •	1		
	15275	400-500	75	75	42,00	212,00	100,00	0,209	• •	1		
	15277	400-450	110	110	49,00	212,00	147,00	0,528	• •	1		
	15278	400	125	125	55,00	215,00	167,00	0,769	• •	1		
	15288	400-500	90	90	45,00	237,00	120,00	0,326	• •	1		
	15290	450-500	125	125	55,00	240,00	167,00	0,774	• •	1		
	15300	400-630	63	63	37,50	260,00	84,00	0,148	• •	1		
	15303	500-560	110	110	49,00	262,00	147,00	0,541	• •	1		
	15315	560-630	75	75	42,00	292,00	100,00	0,224	• •	1		
15316	560-630	90	90	45,00	292,00	120,00	0,340	• •	1			
15318	560-630	125	125	55,00	280,00	167,00	0,792	• •	1			
15331	630	110	110	49,00	327,00	147,00	0,563	• •	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 158 onwards.

## WELD-IN SADDLE BUTT WELDING

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

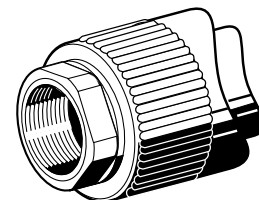
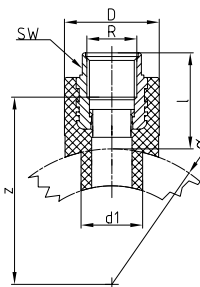


SDR	Art.-No.	d	d1	d2	l	z	Weight [kg]	System	PU	Box unit	Price € m/pc
butt welding											
9	315265	315	160	160	80,00	237,50	0,7	• •	1	1	
	315271	355	160	160	80,00	257,50	0,8	• •	1	1	
11	15265	315	160	160	160,00	80,00	0,868	• •	1	1	
	15271	355	160	160	160,00	80,00	0,845	• •	1	1	

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 158 onwards.

## WELD-IN SADDLE WITH FEMALE THREAD

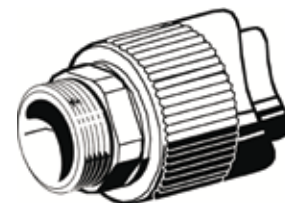
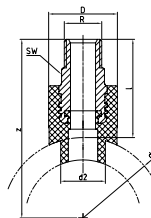
Systems: **aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe**  
 Material: Fusiolen® PP-R  
 Standard: DIN 16962, DIN EN ISO 15874  
 Colour: green  
 Notice: \*do not use with aquatherm blue pipe OT



SDR	Art.-No.	d	d1	l	z	D	R	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
socket welding													
6 7,4 9 11 17,6	<b>28214*</b>	<b>40</b>	<b>25</b>	39,00	43,00	38,50	1/2"	24,00	0,088	• • •	5	300	
	<b>28216</b>	<b>50</b>	<b>25</b>	39,00	48,00	38,50	1/2"	24,00	0,090	• • •	5	300	
	<b>28218</b>	<b>63</b>	<b>25</b>	39,00	54,50	38,50	1/2"	24,00	0,089	• • •	5	300	
	<b>28220</b>	<b>75</b>	<b>25</b>	39,00	53,50	38,50	1/2"	24,00	0,083	• • •	5	300	
	<b>28222</b>	<b>90</b>	<b>25</b>	39,00	68,00	38,50	1/2"	24,00	0,090	• • •	5	300	
	<b>28224</b>	<b>110</b>	<b>25</b>	39,00	78,00	38,50	1/2"	24,00	0,089	• • •	5	300	
	<b>28226</b>	<b>125</b>	<b>25</b>	39,00	85,50	38,50	1/2"	24,00	0,092	• • •	5	250	
	<b>28230</b>	<b>160</b>	<b>25</b>	39,00	103,00	38,50	1/2"	24,00	0,092	• • •	5	250	
	<b>28232</b>	<b>200</b>	<b>25</b>	39,00	38,00	38,50	1/2"	24,00	0,092	• • •	5	50	
	<b>28234</b>	<b>40</b>	<b>25</b>	39,00	43,00	43,50	3/4"	31,00	0,107	• • •	5	300	
	<b>28236</b>	<b>50</b>	<b>25</b>	39,00	49,50	43,50	3/4"	31,00	0,110	• • •	5	300	
	<b>28238</b>	<b>63</b>	<b>25</b>	39,00	55,50	43,50	3/4"	31,00	0,109	• • •	5	300	
	<b>28240</b>	<b>75</b>	<b>25</b>	39,00	63,00	43,50	3/4"	31,00	0,109	• • •	5	300	
	<b>28242</b>	<b>90</b>	<b>25</b>	39,00	73,00	43,50	3/4"	31,00	0,110	• • •	5	300	
	<b>28244</b>	<b>110</b>	<b>25</b>	39,00	80,50	43,50	3/4"	31,00	0,110	• • •	5	300	
	<b>28246</b>	<b>125</b>	<b>25</b>	39,00	96,00	43,50	3/4"	31,00	0,112	• • •	5	300	
	<b>28250</b>	<b>160</b>	<b>25</b>	39,00	58,50	43,50	3/4"	31,00	0,112	• • •	5	250	
	<b>28254</b>	<b>200</b>	<b>25</b>	39,00	66,00	43,50	3/4"	31,00	0,112	• • •	5	250	
	<b>28260</b>	<b>75</b>	<b>32</b>	43,00	76,00	60,00	1"	39,00	0,222	• • •	5	125	
	<b>28262</b>	<b>90</b>	<b>32</b>	43,00	83,50	60,00	1"	39,00	0,221	• • •	5	125	
<b>28264</b>	<b>110</b>	<b>32</b>	43,00	101,00	60,00	1"	39,00	0,224	• • •	5	125		
<b>28266</b>	<b>125</b>	<b>32</b>	43,00	123,00	60,00	1"	39,00	0,022	• • •	5	125		
<b>28270</b>	<b>160</b>	<b>32</b>	43,00	118,00	60,00	1"	39,00	0,226	• • •	5	125		
<b>28274</b>	<b>200</b>	<b>32</b>	43,00	121,00	60,00	1"	39,00	0,244	• • •	5	25		

## WELD-IN SADDLE WITH MALE THREAD

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	d2	l	z	D	R	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
socket welding													
6 7,4 9 11 17,6	<b>28314*</b>	<b>40</b>	<b>25</b>	55,00	75,00	38,50	R1/2	21,00	0,088	• • •	5	300	
	<b>28316</b>	<b>50</b>	<b>25</b>	55,00	80,00	38,50	R1/2	21,00	0,090	• • •	5	300	
	<b>28318</b>	<b>63</b>	<b>25</b>	55,00	86,50	38,50	R1/2	21,00	0,089	• • •	5	300	
	<b>28320</b>	<b>75</b>	<b>25</b>	55,00	92,50	38,50	R1/2	21,00	0,097	• • •	5	300	
	<b>28322</b>	<b>90</b>	<b>25</b>	55,00	100,00	38,50	R1/2	21,00	0,090	• • •	5	300	
	<b>28324</b>	<b>110</b>	<b>25</b>	55,00	110,00	38,50	R1/2	21,00	0,089	• • •	5	300	
	<b>28326</b>	<b>125</b>	<b>25</b>	55,00	117,50	38,50	R1/2	21,00	0,092	• • •	5	300	
	<b>28330</b>	<b>160</b>	<b>25</b>	55,00	135,00	38,50	R1/2	21,00	0,092	• • •	5	300	
	<b>28334</b>	<b>40</b>	<b>25</b>	56,00	76,00	43,50	R3/4	24,00	0,107	• • •	5	250	
	<b>28336</b>	<b>50</b>	<b>25</b>	56,00	81,00	43,50	R3/4	24,00	0,110	• • •	5	250	
	<b>28338</b>	<b>63</b>	<b>25</b>	56,00	87,50	43,50	R3/4	24,00	0,109	• • •	5	250	
	<b>28340</b>	<b>75</b>	<b>25</b>	56,00	93,50	43,50	R3/4	24,00	0,109	• • •	5	250	
	<b>28342</b>	<b>90</b>	<b>25</b>	56,00	101,00	43,50	R3/4	24,00	0,110	• • •	5	250	
	<b>28344</b>	<b>110</b>	<b>25</b>	56,00	111,00	43,50	R3/4	24,00	0,110	• • •	5	250	
	<b>28346</b>	<b>125</b>	<b>25</b>	56,00	118,50	43,50	R3/4	24,00	0,112	• • •	5	250	
	<b>28350</b>	<b>160</b>	<b>25</b>	56,00	136,00	43,50	R3/4	24,00	0,112	• • •	5	250	

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 158 onwards.

## FLANGE ADAPTER SOCKET WELDING

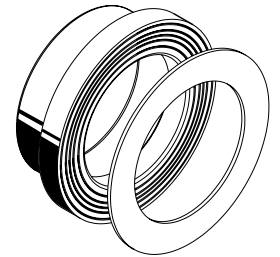
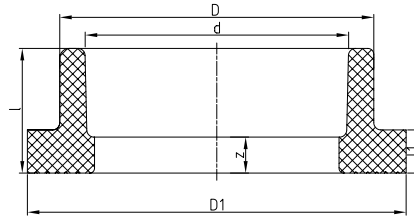
with gasket

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	z	D	D1	l1	z1	Weight [kg]	System	PU	Box unit	Price € m/pc
socket welding													
6 7,4 9 11	15512	32	35,00	17,00	41,00	68,00	11,00	3,00	0,053	• • •	1	1	
	15514	40	36,50	16,00	50,00	78,00	12,00	3,00	0,071	• • •	1	1	
	15516	50	40,50	17,00	61,00	88,00	13,00	3,00	0,095	• • •	1	1	
	15518	63	44,50	16,00	76,00	102,00	15,00	3,00	0,130	• • •	1	1	
	15520	75	47,00	17,00	90,00	122,00	17,00	3,00	0,191	• • •	1	1	
	15522	90	50,00	17,00	108,00	138,00	17,00	3,00	0,258	• • •	1	1	
	15524	110	55,50	18,50	131,00	158,00	18,50	3,00	0,329	• • •	1	1	
	15526*	125	202,00	202,00	125,00	158,00	13,50	3,00	1,330	• • •	1	1	
15527	125	63,00	23,00	165,00	188,00	20,00	3,00	0,724	• • •	1	1		

\*only applicable with fitting, with 110 mm flange adapter

## FLANGE ADAPTER BUTT WELDING

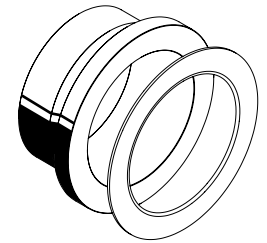
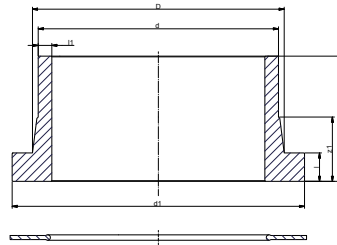
with gasket

Systems: **aquatherm green pipe**, **aquatherm blue pipe**

Material: Fusiolen® PP-R & PP-RP

Standard: DIN 16962, DIN EN ISO 15874

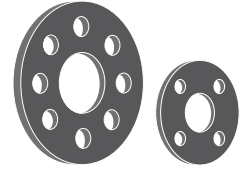
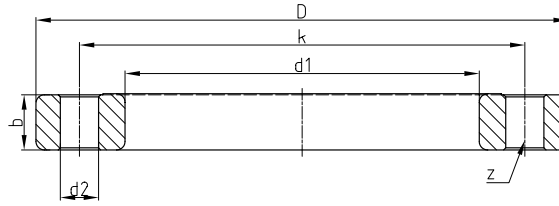
Colour: green



SDR	Art.-No.	Dimension d [mm]	l	z	D	D1	l1	z1	Weight [kg]	System	PU	Box unit	Price € m/pc
butt welding													
7,4	15530	160	25,00	93,00	175,00	212	21,90	3,00	1,163	• •	1	1	
	15534	200	32,00	130,00	232,00	268	27,40	6,00	2,292	• •	1	1	
	15538	250	35,00	130,00	285,00	320	34,20	6,00	3,298	• •	1	1	
9	315530	160	25,00	93,00	175,00	212	17,90	53,00	0,98	•	1	1	
	315534	200	32,00	130,00	232,00	268	22,40	72,00	2,00	•	1	1	
	315538	250	35,00	130,00	285,00	320	27,90	75,00	3,10	•	1	1	
	315542	315	35,00	170,00	337,00	370	35,20	90,00	5,50	•	1	1	
	315544	355	42,00	185,00	372,00	432	39,70	95,00	7,80	•	1	1	
11	15531	160	25,00	93,00	175,00	212	14,60	6,00	0,955	• •	1	1	
	15535	200	32,00	130,00	232,00	268	18,20	6,00	1,957	• •	1	1	
	15539	250	35,00	130,00	285,00	320	22,70	6,00	2,717	• •	1	1	
	15543	315	35,00	170,00	333,00	370	28,60	6,00	5,650	• •	1	1	
	15545	355	42,00	185,00	370,00	432	32,20	6,00	9,000	• •	1	1	
	15547	400	33,00	199,00	425,00	484	22,70	6,00		• •	1	1	
	15549	450	46,00	140,00	425,00	586	25,70	7,00		• •	1	1	
17,6	2515530	160	25,00	93,00	175,00	212	9,10	3,00	0,821	•	1	11	
	2515534	200	32,00	130,00	232,00	268	11,40	6,00		•	1	11	
	2515538	250	35,00	130,00	285,00	320	14,20	6,00	2,736	•	1	11	
	2515542	315	35,00	170,00	333,00	370	17,90	6,00	4,500	•	1	11	
	2515544	355	42,00	185,00	370,00	432	20,10	6,00	6,500	•	1	11	
	2515546	400	33,00	199,00	425,00	484	22,70	6,00	8,500	•	1	11	
	2515548	450	46,00	140,00	512,00	586	25,70	7,00	12,000	•	1	11	
	2515550	500	47,00	141,00	525,00	585	28,40	7,00	9,800	•	1	11	
	2515552	560	50,00	141,00	612,00	685	31,70	7,00	13,800	•	1	11	
2515554	630	50,00	142,00	640,00	688	35,70	7,00	12,600	•	1	11		

## PLASTIC COATED STEEL FLANGE

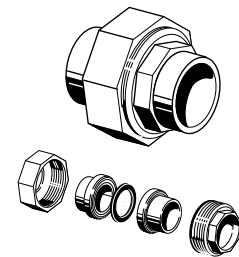
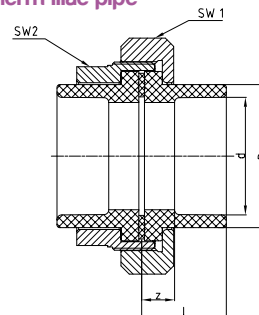
Systems: **aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe**  
 Material: PP/steel  
 Colour: grey



SDR	Art.-No.	Dimension	fits to Art.-No.	d1	D	K	d2	b	z	Weight [kg]	System	PU	Box unit	Price € m/pc	
socket welding															
6 7,4 9 11 17,6	15712	32	15512	42	116,00	85,00	14	15,50	4,00	0,466	• • •	1	1		
	15714	40	15514	51	141,00	100,00	18	17,50	4,00	0,681	• • •	1	1		
	15716	50	15516	62	151,00	110,00	18	17,50	4,00	0,767	• • •	1	1		
	15718	63	15518	78	166,00	125,00	18	19,00	4,00	0,885	• • •	1	1		
	15720	75	15520	92	186,00	145,00	18	19,00	4,00	1,154	• • •	1	1		
	15722	90	15522	110	201,00	160,00	18	21,00	8,00	1,404	• • •	1	1		
	15724	110	15524/26	133	221,00	180,00	18	22,00	8,00	1,461	• • •	1	1		
	15726	125	15527	167	251,00	210,00	18	26,00	8,00	2,096	• • •	1	1		
	15730	160	15530 15531 2515530	178	286,00	240,00	22	27,00	8,00	3,628	• •		1	1	
	15734	200	15534 15535 2515534	235	341,00	295,00	22	28,00	8,00	4,643	• •		1	1	
	15738	250	15538 15539 2515538	288	406,00	350,00	22	31,00	12,00	7,216	• •		1	1	
	15742	315	15543 2515542	340	460,00	400,00	22	34,50	12,00	9,500	• •		1	1	
	15744	355	15545 2515544	380	520,00	460,00	22	39,00	16,00	15,300	• •		1	1	
	15746	400	2515546	430	565,00	515,00	26	34,00	16,00	50,558	• •		1	1	
	15748	450	2515548	517	670,00	620,00	26	42,00	20,00	65,789	• •		1	1	
15750	500	2515550	533	670,00	620,00	26	38,00	20,00	60,783	• •		1	1		
15752	560	2515552	618	785,00	725,00	30	50,00	20,00	95,096	• •		1	1		
15754	630	2515554	645	785,00	725,00	30	40,00	20,00	82,112	• •		1	1		

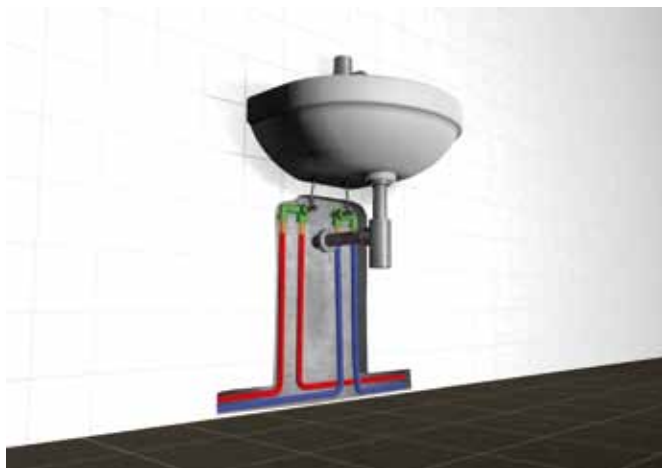
## COUPLING SCREW JOINT

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

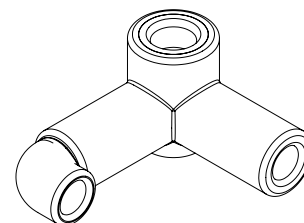


SDR	Art.-No.	Dimension d [mm]	l	z	D	SW1	SW2	Weight [kg]	System	PU	Box unit	Price € m/pc
socket welding												
6 7,4 9 11	15812	32	36,50	18,50	41,00	64,00	50,00	0,479	• • •	1		
	15814	40	38,00	17,50	50,00	80,00	60,00	0,841	• • •	1		
	15816	50	41,00	17,50	61,00	86,00	70,00	0,821	• • •	1		
	15818	63	45,00	17,50	76,00	108,00	90,00	1,498	• • •	1		
	15820	75	47,50	17,50	90,00	128,00	104,00	1,998	• • •	1		

**NEW PRINCIPLE OF FLOW-THROUGH BACK PLATE ELBOW**

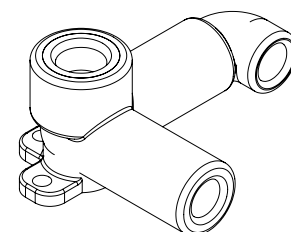


**NEW aquatherm green pipe FLOW-THROUGH BACK PLATE ELBOW LEFT**



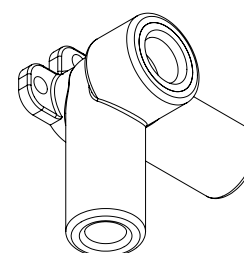
SDR	Art.-No.	d	R	l	z	D	l1	z1	D1	L	c	Weight [kg]	System	PU	Box unit	Price € m/pc
	<b>20176</b>	<b>16</b>	<b>1/2"</b>											1		
	<b>20178</b>	<b>20</b>	<b>1/2"</b>											1		

**NEW aquatherm green pipe FLOW-THROUGH BACK PLATE ELBOW RIGHT**



SDR	Art.-No.	d	R	l	z	D	l1	z1	D1	L	c	Weight [kg]	System	PU	Box unit	Price € m/pc
	<b>20186</b>	<b>16</b>	<b>1/2"</b>											1		
	<b>20188</b>	<b>20</b>	<b>1/2"</b>											1		

**NEW aquatherm green pipe FLOW-THROUGH BACK PLATE ELBOW LEFT/RIGHT**



SDR	Art.-No.	d	R	l	z	D	l1	z1	D1	L	c	Weight [kg]	System	PU	Box unit	Price € m/pc
	<b>20166</b>	<b>16</b>	<b>1/2"</b>											1		
	<b>20168</b>	<b>20</b>	<b>1/2"</b>											1		

**NOTICE:**

For the production of the aquatherm green pipe flow-through back plate elbow Art.-No. 20176,20178 20186, 20188 the aquatherm green pipe elbows male/female 12306 (16mm) or 12308 (20mm) have to be used.

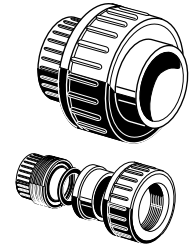
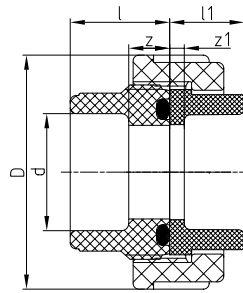
## COUPLING SCREW JOINT

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	<b>15838</b>	<b>20</b>	26,00	12,00	20,00	5,50	46,00	0,036	• • •	10	300	
	<b>15840</b>	<b>25</b>	28,00	12,00	21,00	5,00	56,00	0,058	• • •	10	250	
	<b>15842</b>	<b>32</b>	32,00	12,00	23,00	5,00	66,00	0,089	• • •	5	200	
	<b>15844</b>	<b>40</b>	38,00	14,00	25,50	5,00	79,00	0,136	• • •	5	150	
	<b>15846</b>	<b>50</b>	45,00	16,00	28,50	5,00	87,00	0,170	• • •	5	100	
	<b>15848</b>	<b>63</b>	55,50	20,00	32,50	5,00	107,00	0,240	• • •	1	60	
	<b>15850</b>	<b>75</b>	50,00	20,00	36,00	6,00	128,00	0,451	• • •	1	1	

## ELECTROFUSION SOCKET

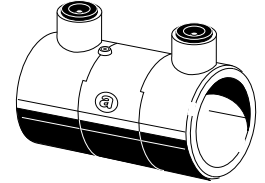
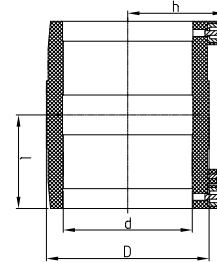
Systems: **aquatherm green pipe,**  
**aquatherm blue pipe, aquatherm lilac pipe**

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	l1	D	Weight [kg]	System	PU	Box unit	Price € m/pc
Electro-socket welding										
6 7,4 9 11 17,6	<b>17208</b>	<b>20</b>	35,00	36,00	31,50	0,049	• • •	1	500	
	<b>17210</b>	<b>25</b>	39,00	38,50	36,50	0,057	• • •	1	350	
	<b>17212</b>	<b>32</b>	40,00	42,50	45,00	0,077	• • •	1	300	
	<b>17214</b>	<b>40</b>	46,00	47,00	54,00	0,103	• • •	1	200	
	<b>17216</b>	<b>50</b>	51,50	52,00	65,00	0,142	• • •	1	130	
	<b>17218</b>	<b>63</b>	59,00	58,00	81,50	0,239	• • •	1	75	
	<b>17220</b>	<b>75</b>	65,00	64,50	96,00	0,347	• • •	1	45	
	<b>17222</b>	<b>90</b>	72,50	72,00	113,50	0,501	• • •	1	30	
	<b>17224</b>	<b>110</b>	80,00	82,50	139,00	0,821	• • •	1	22	
	<b>17226</b>	<b>125</b>	86,00	90,00	156,00	1,097	• • •	1	16	
	<b>17230*</b>	<b>160</b>	93,00	109,50	197,00	1,754	• • •	1	10	
<b>17234*</b>	<b>200</b>	105,00	134,00	243,00	3,625	• • •	1			
<b>17238*</b>	<b>250</b>	125,00	170,00	315,00	7,142	• • •	1			

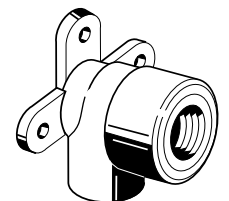
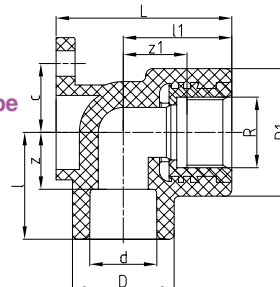
## BACK PLATE ELBOW

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

Material: Fusiolen® PP-R, brass

Standard: DIN 16962, DIN EN ISO 15874

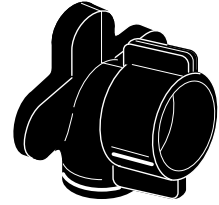
Colour: green



SDR	Art.-No.	d	R	l	z	D	l1	z1	D1	L	c	Weight [kg]	System	PU	Box unit	Price € m/pc
socket welding																
6 7,4 11	<b>20106</b>	<b>16</b>	<b>1/2"</b>	31,00	18,00	29,50	31,50	15,50	37,00	51,00	20,00	0,080	• • •	10	200	
	<b>20108</b>	<b>20</b>	<b>1/2"</b>	31,00	16,50	29,50	31,50	15,50	37,00	51,00	20,00	0,079	• • •	10	200	
	<b>20110</b>	<b>20</b>	<b>3/4"</b>	37,00	22,50	34,00	37,00	24,00	44,00	54,00	25,00	0,102	• • •	10	150	
	<b>20112</b>	<b>25</b>	<b>3/4"</b>	37,00	21,00	34,00	37,00	24,00	44,00	54,00	25,00	0,105	• • •	10	150	
	<b>20113</b>	<b>25</b>	<b>1/2"</b>	33,50	17,50	34,00	31,00	15,00	37,00	53,00	20,00	0,081	• • •	10	200	

## SOUND ISOLATION COVER

for **aquatherm green pipe** back plate elbow 1/2"



Art.- No.	Dimension	PU	Box unit	Price € m/St
<b>20120</b>	Thickness approx. 5 mm	1	60	

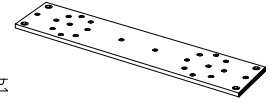
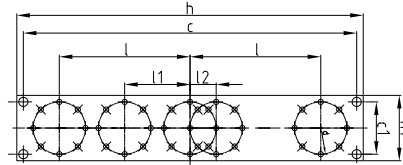
## MOUNTING PLATE

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
<b>60010</b>	40	100,00	50,00	20,00	255,00	40,00	265,00	50,00	0,221	• • •	1	1	

not suitable for connection with sound insulation plate (Art.-No. 79080).  
We recommend mounting rail Art.-No. 79090.

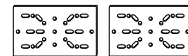
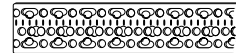
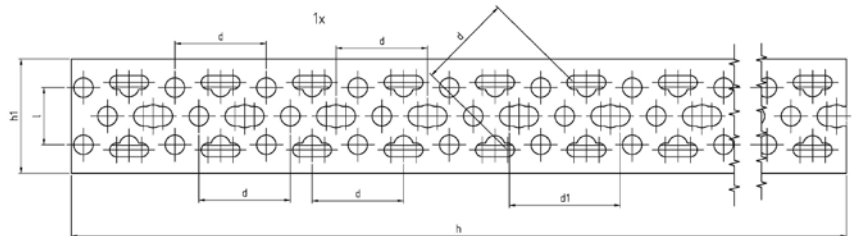
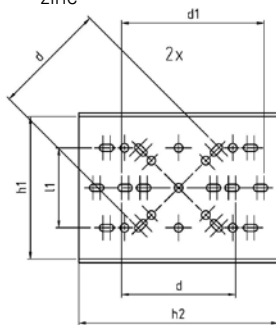
## MOUNTING PLATE

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
<b>79090</b>	40	50	25,00	28,00	560,00	50,00	70,00	0,546	• • •	2	4	

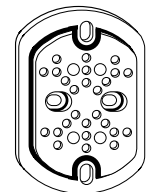
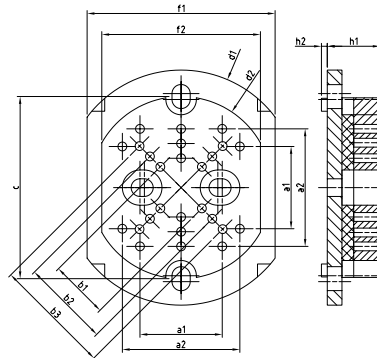
## SOUND ISOLATION PLATE

for **aquatherm green pipe** and **aquatherm grey pipe** back plate elbow

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

Material: PP

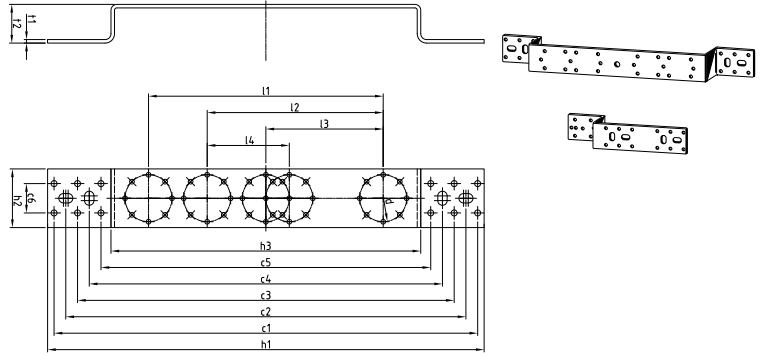
Colour: white



Art.-No.	a1	a2	b1	b2	b3	c	d1	d2	f1	f2	h1	h2	Weight [kg]	System	PU	Box unit	Price € m/pc
<b>79080</b>	28,00	40,00	20,00	30,00	40,00	62,00	80	62	64,00	54,00	18,00	2,00	0,058	• • •	2		

## MOUNTING RAIL (DOUBLE AND SINGLE)

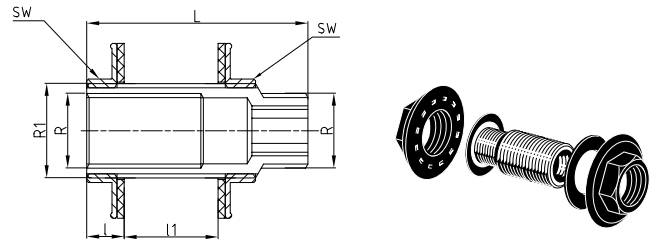
Systems: **aquatherm green pipe** **aquatherm blue pipe**,  
**aquatherm lilac pipe**  
Material: iron, galvanized  
Colour: zinc



Art.-No.	d	l1	l2	l3	l4	c1	c2	c3	c4	c5	c6	h1	h2	h3	t1	t2	Weight [kg]	System	PU	Box unit	Price € m/pc
<b>79095</b>	40	200,00	150,00	100,00	70,00	361,00	341,00	321,00	301,00	281,00	25,00	372,00	50,00	264,00	3,00	33,00	0,412	• • •	2	4	
<b>79096</b>																	0,235	• • •	2	4	

## DRY CONSTRUCTION WALL FITTING

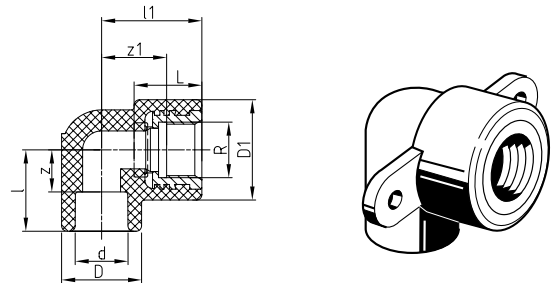
Systems: **aquatherm green pipe** **aquatherm blue pipe**,  
**aquatherm lilac pipe**  
Material: brass



Art.-No.	R	R1	l	l1	L	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
<b>20114</b>	1/2"	3/4"	10,50	26,00	62,00	30,00	0,213	• • •	10	300	

## BACK PLATE ELBOW FOR DRY CONSTRUCTION

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

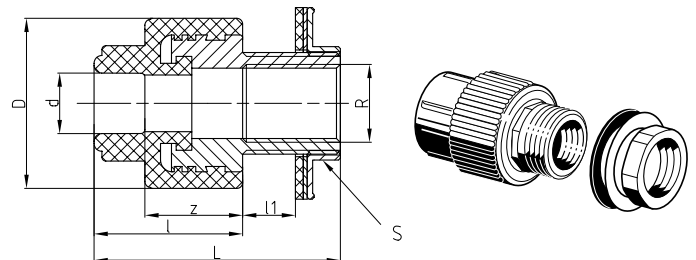


SDR	Art.-No.	d	R	l	z	D	l1	z1	D1	L	c	Weight [kg]	System	PU	Box unit	Price € m/pc
6	socket welding															
7,4	<b>20156</b>	16	1/2"	30,00	17,00	29,50	37,00	24,00	37,00	25,00	59,00	0,079	• • •	10	250	
11	<b>20158</b>	20	1/2"	30,00	15,50	29,50	37,00	24,00	37,00	25,00	59,00	0,079	• • •	10	200	

## 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
6	socket welding													
7,4	<b>20204</b>	20	1/2"	40,00	25,50	43,50	13,50	65,00	29,00	0,204	• • •	10	1	

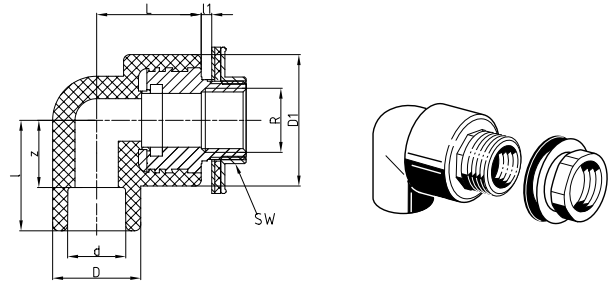
e.g. for connection of a cistern or application with mounting plate (Art.-No. 60110-60115)



## 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

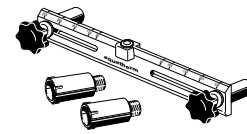


SDR	Art.-No.	d	R	l	z	D	l1	L	D1	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
socket welding															
6 7,4 11	<b>20206</b>	<b>16</b>	<b>1/2"</b>	37,00	24,00	29,50	3,50	35,00	44,00	29,00	0,201	• • •	10		
	<b>20208</b>	<b>20</b>	<b>1/2"</b>	37,00	22,50	29,50	3,50	35,00	44,00	29,00	0,154	• • •	10		
	<b>20209</b>	<b>25</b>	<b>1/2"</b>	37,00	21,00	34,00	3,50	37,00	44,00	29,00	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

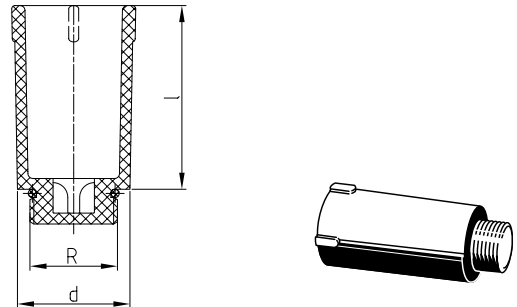


Art.-No.	a	b	h1	l1	l2	d	l	R	Weight [kg]	System	PU	Box unit	Price € m/pc
<b>50700</b>	280,00	36,00	8,00	80,00	250,00	28	55,50	1/2"	0,252	• • •	1		

## 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

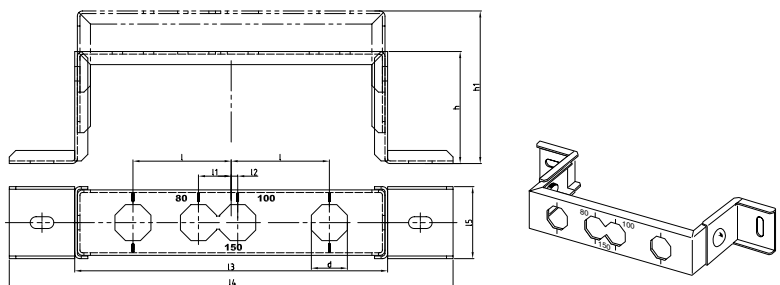


Art.-No.	d	R	l	Weight [kg]	System	PU	Box unit	Price € m/pc
<b>50708</b>	28	1/2"	55,50	0,022	• • •	10		
<b>50710</b>	34	3/4"	55,50	0,027	• • •	10		

## 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
<b>60110</b>	27,50	75,00	25,00	5,00	92,50	122,50	239,00	339,00	55,00	0,630	• • •	1	1	

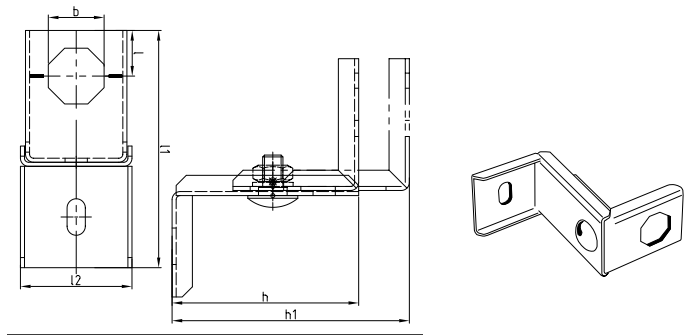
## MOUNTING UNIT

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
<b>60115</b>	27,50	118,00	22,50	55,00	92,50	122,50	0,278	• • •	1	1	

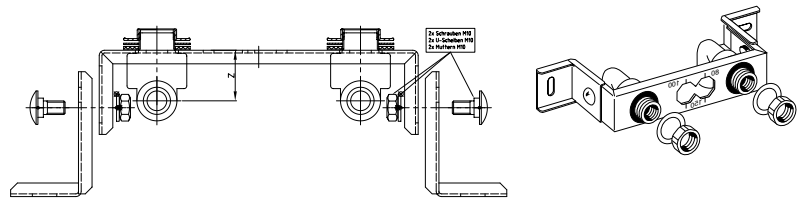
## MOUNTING UNIT

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	b	l3	l4	l5	Weight [kg]	System	PU	Box unit	Price € m/pc
<b>60150</b>	27,50	75,00	25,00	5,00	92,50	122,50	239,00	339,00	55,00	0,942	• • •	1	1	1	

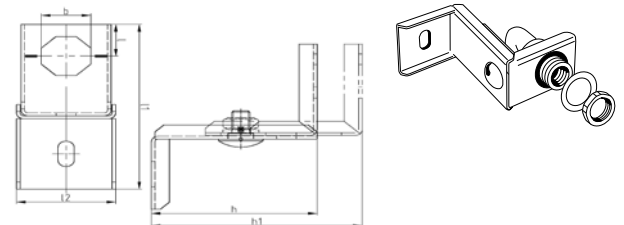
## MOUNTING UNIT

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
<b>60155</b>	27,5	22,5	118	55	92,5	122,5	0,278	• • •	1	1	

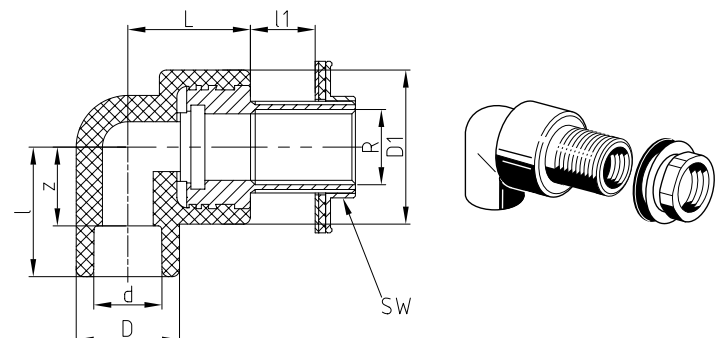
## TRANSITION ELBOW

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	<b>20210</b>	20	1/2"	37,00	22,50	29,50	35,00	18,50	44,00	29,00	0,223	• • •	10		
7,4															
11															

with 30 mm thread, counternut, gasket and tension washer

## TRANSITION PIECE WITH FEMALE THREAD

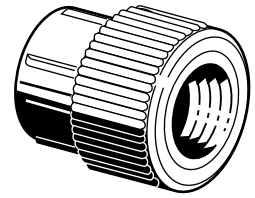
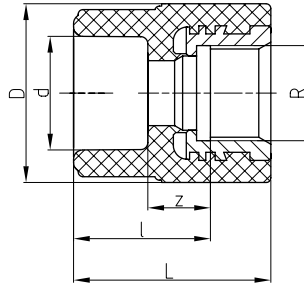
round

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

Material: Fusiolen® PP-R, brass

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	<b>21006</b>	<b>16</b>	<b>1/2"</b>	28,00	15,00	38,50	41,00	0,066	• • •	10	400	
	<b>21008</b>	<b>20</b>	<b>1/2"</b>	27,50	13,00	37,50	40,50	0,064	• • •	10	400	
	<b>21010</b>	<b>20</b>	<b>3/4"</b>	27,50	13,00	43,50	40,50	0,089	• • •	10	300	
	<b>21011</b>	<b>25</b>	<b>1/2"</b>	29,00	13,00	37,50	42,00	0,065	• • •	10	400	
	<b>21012</b>	<b>25</b>	<b>3/4"</b>	27,50	11,50	43,50	40,50	0,087	• • •	10	300	
	<b>21013</b>	<b>32</b>	<b>3/4"</b>	30,50	12,50	43,50	43,50	0,092	• • •	5	200	

## TRANSITION PIECE WITH FEMALE THREAD

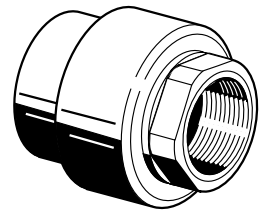
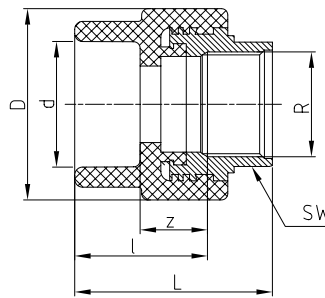
hex shaped threaded transition

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	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	<b>21106</b>	<b>16</b>	<b>1/2"</b>	34,50	21,50	38,50	50,50	24,00	0,089	• • •	10	400	
	<b>21108</b>	<b>20</b>	<b>1/2"</b>	34,50	20,00	37,50	50,50	24,00	0,088	• • •	10	400	
	<b>21110</b>	<b>20</b>	<b>3/4"</b>	29,00	14,50	43,50	50,00	31,00	0,112	• • •	10	300	
	<b>21111</b>	<b>25</b>	<b>1/2"</b>	36,00	20,00	37,50	52,00	24,00	0,089	• • •	10	300	
	<b>21112</b>	<b>25</b>	<b>3/4"</b>	29,00	13,00	43,50	50,00	31,00	0,109	• • •	10	300	
	<b>21113</b>	<b>32</b>	<b>3/4"</b>	32,00	14,00	43,50	53,00	31,00	0,114	• • •	5	150	
	<b>21114</b>	<b>32</b>	<b>1"</b>	37,50	19,50	60,00	59,50	39,00	0,239	• • •	5	125	
	<b>21115</b>	<b>40</b>	<b>1"</b>	40,00	19,50	60,00	62,00	39,00	0,245	• • •	5	125	
	<b>21116</b>	<b>40</b>	<b>1 1/4"</b>	40,00	19,50	74,00	63,00	50,00	0,385	• • •	5	80	
	<b>21117</b>	<b>50</b>	<b>1 1/4"</b>	43,00	19,50	74,00	66,00	50,00	0,404	• • •	5	75	
	<b>21118</b>	<b>50</b>	<b>1 1/2"</b>	45,00	21,50	85,50	67,00	55,00	0,424	• • •	5	60	
	<b>21119</b>	<b>63</b>	<b>1 1/2"</b>	51,50	24,00	84,00	73,50	55,00	0,440	• • •	1	50	
	<b>21120</b>	<b>63</b>	<b>2"</b>	50,00	22,50	101,00	76,00	67,00	0,589	• • •	1	35	
<b>21122</b>	<b>75</b>	<b>2"</b>	51,00	21,00	100,00	77,00	67,00	0,613	• • •	1	25		

## TRANSITION PIECE WITH MALE THREAD

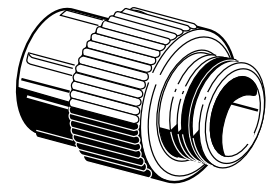
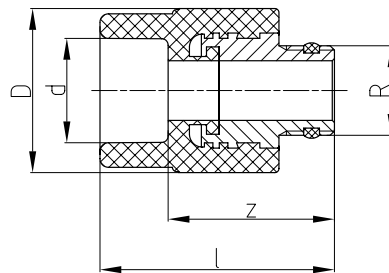
round, self sealing

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	D	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 11	<b>21258</b>	<b>20</b>	<b>1/2"</b>	52,50	38,00	38,50	0,090	• • •	10		
	<b>21261</b>	<b>25</b>	<b>1/2"</b>	54,00	38,00	38,50	0,091	• • •	10		
	<b>21262</b>	<b>25</b>	<b>3/4"</b>	53,50	37,50	38,50	0,098	• • •	10		

### TRANSITION PIECE WITH MALE THREAD

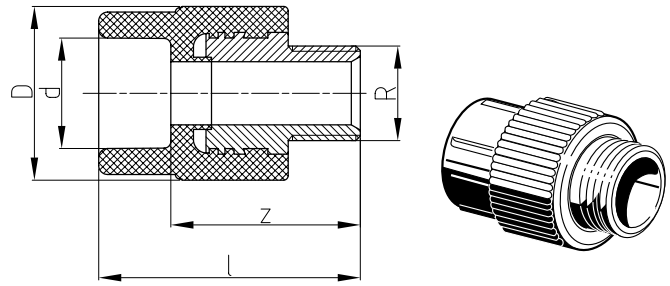
round

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	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	<b>21206</b>	<b>16</b>	<b>1/2"</b>	56,50	43,50	38,50	0,097	•	10	400	
	<b>21208</b>	<b>20</b>	<b>1/2"</b>	56,50	42,00	38,50	0,097	• • •	10	400	
	<b>21210</b>	<b>20</b>	<b>3/4"</b>	57,50	43,00	38,50	0,109	• • •	10	300	
	<b>21211</b>	<b>25</b>	<b>1/2"</b>	58,00	42,00	38,50	0,098	• • •	10	300	
	<b>21212</b>	<b>25</b>	<b>3/4"</b>	57,50	41,50	38,50	0,107	• • •	10	350	
	<b>21213</b>	<b>32</b>	<b>3/4"</b>	59,50	41,50	43,00	0,115	• • •	5	250	

### TRANSITION PIECE WITH MALE THREAD

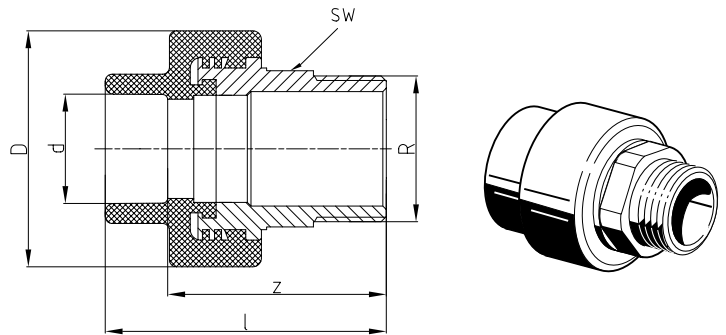
with hex shaped threaded transition

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

Material: Fusiolen® PP-R, brass

Standard: DIN 16962, DIN EN ISO 15874

Colour: green



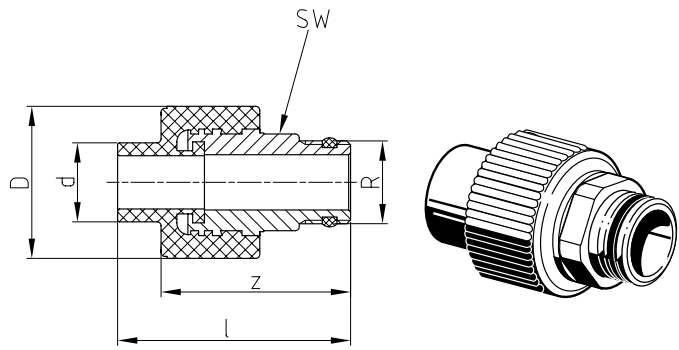
SDR	Art.-No.	d	R	l	z	D	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	<b>21306</b>	<b>16</b>	<b>1/2"</b>	66,50	53,50	38,50	0,119	•	10	300	
	<b>21308</b>	<b>20</b>	<b>1/2"</b>	66,50	52,00	38,50	0,104	• • •	10	300	
	<b>21310</b>	<b>20</b>	<b>3/4"</b>	67,50	53,00	38,50	0,129	• • •	10	300	
	<b>21312</b>	<b>25</b>	<b>3/4"</b>	67,50	51,50	38,50	0,103	• • •	10	300	
	<b>21314</b>	<b>32</b>	<b>1"</b>	78,50	60,50	53,00	0,216	• • •	5	125	
	<b>21316</b>	<b>32</b>	<b>1 1/4"</b>	81,00	63,00	68,00	0,320	• • •	5	100	
	<b>21317</b>	<b>40</b>	<b>1"</b>	81,00	60,50	52,00	0,222	• • •	5	100	
	<b>21318</b>	<b>40</b>	<b>1 1/4"</b>	84,50	64,00	68,00	0,326	• • •	5	80	
	<b>21319</b>	<b>50</b>	<b>1 1/4"</b>	85,50	62,00	68,00	0,352	• • •	5	75	
	<b>21320</b>	<b>50</b>	<b>1 1/2"</b>	88,50	65,00	74,00	0,429	• • •	5	60	
	<b>21321</b>	<b>63</b>	<b>1 1/2"</b>	94,50	67,00	72,50	0,466	• • •	1	40	
	<b>21322</b>	<b>63</b>	<b>2"</b>	102,50	75,00	84,00	0,679	• • •	1	40	
	<b>21323</b>	<b>75</b>	<b>2"</b>	102,00	72,00	84,00	0,729	• • •	1	25	
	<b>21324</b>	<b>75</b>	<b>2 1/2"</b>	105,00	75,00	100,00	0,972	• • •	1	25	
	<b>21325</b>	<b>90</b>	<b>3"</b>	121,00	88,00	120,00	1,315	• • •	1	20	
<b>21327</b>	<b>110</b>	<b>4"</b>	148,00	111,00	147,00	2,699	• • •	1	8		

**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. aquatherm green pipe stainless steel price list Order-. No.: E53180 on request!!

### 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

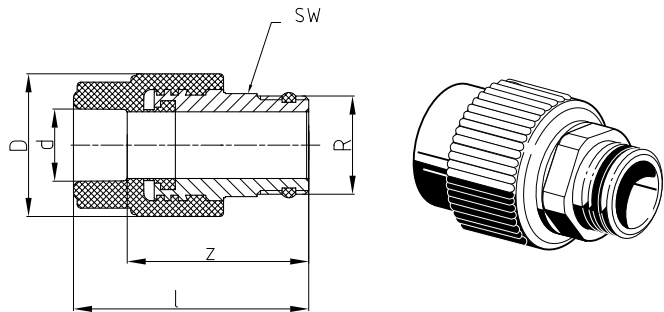


SDR	Art.-No.	d	R	l	z	D	Weight [kg]	System	PU	Box unit	Price € m/pc
6											
7,4	<b>21355</b>	<b>20</b>	<b>1/2"</b>	59,00	48,00	38,50	0,107	• • •	10		
11											

### TRANSITION PIECE WITH MALE THREAD

self-sealing, with hex shaped threaded transition female/male

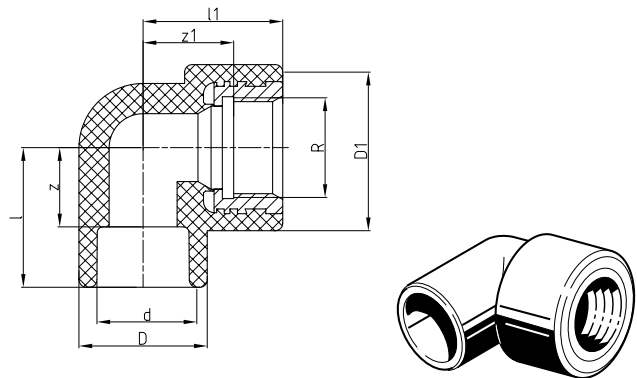
Systems: **aquatherm green pipe**, **aquatherm blue pipe**,  
**aquatherm lilac pipe**  
Material: Fusiolen® PP-R, brass  
Standard: DIN 16962, DIN EN ISO 15874  
Colour: green



SDR	Art.-No.	d	R	l	z	D	Weight [kg]	System	PU	Box unit	Price € m/pc
6											
7,4	<b>21356</b>	<b>16</b>	<b>1/2"</b>	63,50	50,50	38,50	0,112	•	10		
11	<b>21358</b>	<b>20</b>	<b>1/2"</b>	63,50	49,00	38,50	0,111	• • •	10		

### 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

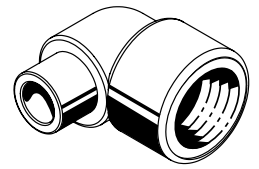
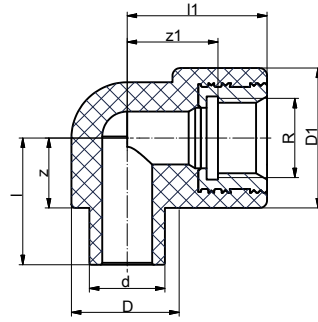


SDR	Art.-No.	d	R	l	z	D	l1	z1	D1	Weight [kg]	System	PU	Box unit	Price € m/pc
6														
7,4	<b>23006</b>	<b>16</b>	<b>1/2"</b>	31,50	18,50	29,50	37,00	24,00	37,00	0,072	•	10	300	
9	<b>23008</b>	<b>20</b>	<b>3/4"</b>	37,00	22,50	34,00	37,00	24,00	44,00	0,102	• • •	10	250	
11	<b>23010</b>	<b>20</b>	<b>1/2"</b>	31,50	17,00	29,50	31,50	18,50	37,00	0,074	• • •	10	300	
	<b>23012</b>	<b>25</b>	<b>3/4"</b>	37,00	21,00	34,00	37,00	24,00	44,00	0,100	• • •	10	200	
	<b>23014</b>	<b>25</b>	<b>1/2"</b>	34,00	18,00	34,00	37,00	24,00	37,00	0,074	• • •	10	250	
	<b>23016</b>	<b>32</b>	<b>3/4"</b>	27,50	9,50	43,00	51,00	38,00	44,00	0,104	• • •	5	150	
	<b>23018</b>	<b>32</b>	<b>1"</b>	34,00	16,00	43,00	66,50	44,50	60,50	0,251	• • •	5	100	

**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. aquatherm green pipe stainless steel price list Order-. No.: E53180 on request!!

## TRANSITION ELBOW WITH FEMALE THREAD

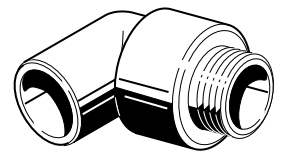
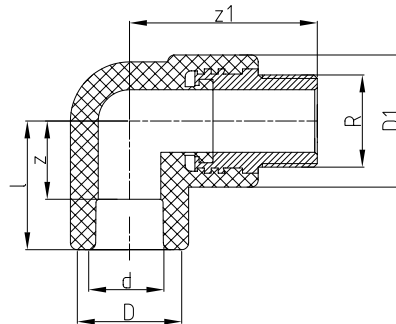
Systems: **aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe**  
 Material: Fusiolen® PP-R, brass  
 Standard: DIN 16962, DIN EN ISO 15874  
 Colour: green



SDR	Art.-No.	d	R	l	z	D	l1	z1	D1	Weight [kg]	System	PU	Box unit	Price € m/pc
6														
7,4														
11	<b>23208</b>	<b>20</b>	<b>1/2"</b>	33,50	18,50	29,50	37,00	24,00	37,00	0,076	• • •	10	300	

## TRANSITION ELBOW WITH MALE THREAD

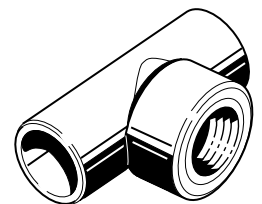
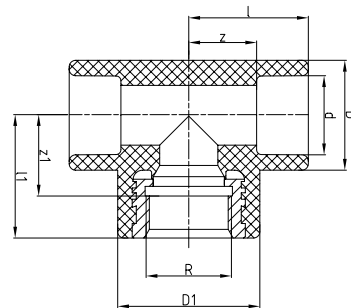
Systems: **aquatherm green pipe, aquatherm blue pipe, aquatherm lilac pipe**  
 Material: Fusiolen® PP-R, brass  
 Standard: DIN 16962, DIN EN ISO 15874  
 Colour: green



SDR	Art.-No.	d	R	l	z	D	z1	D1	Weight [kg]	System	PU	Box unit	Price € m/pc
6	<b>23504</b>	<b>16</b>	<b>1/2"</b>	31,50	18,50	29,50	53,00	37,00	0,109	• • •	10	400	
7,4	<b>23506</b>	<b>20</b>	<b>1/2"</b>	31,50	17,00	29,50	53,00	37,00	0,108	• • •	10	300	
9	<b>23508</b>	<b>20</b>	<b>3/4"</b>	37,00	22,50	34,00	54,00	38,00	0,128	• • •	10	200	
11	<b>23510</b>	<b>25</b>	<b>3/4"</b>	37,00	21,00	34,00	54,00	38,00	0,105	• • •	10	250	
	<b>23512</b>	<b>32</b>	<b>3/4"</b>	27,50	9,50	43,00	68,00	38,00	0,112	• • •	5	150	
	<b>23514</b>	<b>32</b>	<b>1"</b>	31,00	13,00	43,00	85,50	52,00	0,233	• • •	5	100	

## THREADED BRANCH TEE 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	l1	z1	D1	Weight [kg]	System	PU	Box unit	Price € m/pc
6	<b>25004</b>	<b>16</b>	<b>1/2"</b>	31,50	18,50	29,50	37,00	24,00	37,00	0,089	• • •	10	250	
7,4	<b>25006</b>	<b>20</b>	<b>1/2"</b>	31,50	17,00	29,50	37,00	24,00	37,00	0,086	• • •	10	250	
9	<b>25008</b>	<b>20</b>	<b>3/4"</b>	37,00	22,50	34,00	38,00	25,00	44,00	0,121	• • •	10	170	
11	<b>25010</b>	<b>25</b>	<b>1/2"</b>	34,00	18,00	34,00	38,00	25,00	37,00	0,091	• • •	10	200	
	<b>25012</b>	<b>25</b>	<b>3/4"</b>	37,00	21,00	34,00	38,00	25,00	44,00	0,109	• • •	10	150	
	<b>25013</b>	<b>32</b>	<b>1/2"</b>	35,00	17,00	37,00	37,00	24,00	37,00	0,103	• • •	5		
	<b>25014</b>	<b>32</b>	<b>3/4"</b>	27,50	9,50	43,00	51,00	38,00	44,00	0,111	• • •	5	100	
	<b>25016</b>	<b>32</b>	<b>1"</b>	31,00	13,50	43,00	67,00	49,00	60,00	0,254	• • •	5	80	
	<b>25018</b>	<b>40</b>	<b>1/2"</b>	42,50	22,00	52,00	39,00	26,00	37,00	0,180	• • •	5		
	<b>25019</b>	<b>40</b>	<b>3/4"</b>								• • •	5		
	<b>25020</b>	<b>40</b>	<b>1"</b>	41,50	21,00	52,00	56,00	34,00	60,00	0,329	• • •	5		
	<b>25022</b>	<b>50</b>	<b>1"</b>	49,50	26,00	68,00	63,50	43,50	68,00	0,385	• • •	5	40	

**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. aquatherm green pipe stainless steel price list Order-. No.: E53180 on request!!

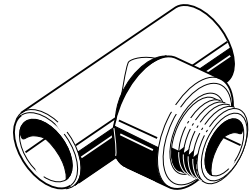
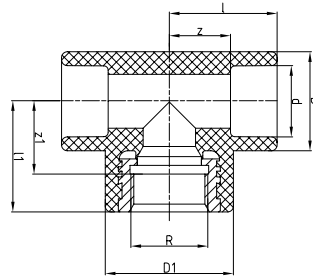
## THREADED BRANCH TEE WITH MALE THREAD

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	z1	D1	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 11	<b>25506</b>	<b>20</b>	<b>1/2"</b>	31,50	17,00	29,50	53,00	37,00	0,102	• • •	10	200	

## TRANSITION COUPLING WITH MALE THREAD

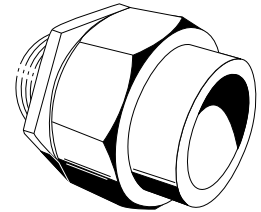
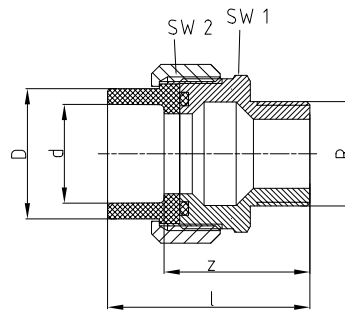
with union nut and welding socket

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	D	SW1	SW2	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	<b>26608</b>	<b>20</b>	<b>1/2"</b>	54,50	40,00	27,50	36,00	36,00	0,145	• • •	1		
	<b>26610</b>	<b>25</b>	<b>3/4"</b>	59,50	43,50	36,00	46,00	46,00	0,243	• • •	1		
	<b>26612</b>	<b>32</b>	<b>1"</b>	64,50	46,50	41,50	52,00	50,00	0,336	• • •	1		
	<b>26614</b>	<b>40</b>	<b>1 1/4"</b>	70,00	49,50	53,00	64,00	65,00	0,632	• • •	1		
	<b>26616</b>	<b>50</b>	<b>1 1/2"</b>	86,50	63,00	59,00	72,00	57,00	0,624	• • •	1		
	<b>26618</b>	<b>63</b>	<b>2"</b>	95,50	68,00	74,00	89,00	66,00	1,212	• • •	1		

## TRANSITION COUPLING WITH FEMALE THREAD

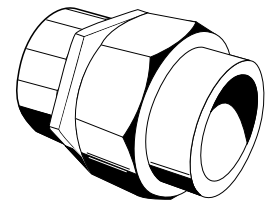
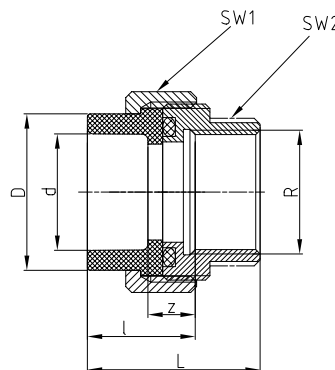
with union nut and welding socket

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	l	z	D	L	SW1	SW2	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	<b>26638</b>	<b>20</b>	<b>1/2"</b>	30,00	15,50	27,50	45,00	36,00	25,00	0,083	• • •	1		
	<b>26640</b>	<b>25</b>	<b>3/4"</b>	32,00	16,00	36,00	49,00	45,00	32,00	0,193	• • •	1		
	<b>26642</b>	<b>32</b>	<b>1"</b>	37,00	19,00	41,50	54,00	52,00	40,00	0,291	• • •	1		
	<b>26644</b>	<b>40</b>	<b>1 1/4"</b>	36,50	16,00	53,00	58,50	64,00	47,00	0,423	• • •	1		
	<b>26646</b>	<b>50</b>	<b>1 1/2"</b>	45,50	22,00	59,00	64,50	72,00	57,00	0,610	• • •	1		
	<b>26648</b>	<b>63</b>	<b>2"</b>	50,50	23,00	74,00	74,50	89,00	68,00	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. aquatherm green pipe stainless steel price list Order-. No.: E53180 on request!!

## LOOSE NUT ADAPTER

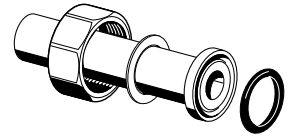
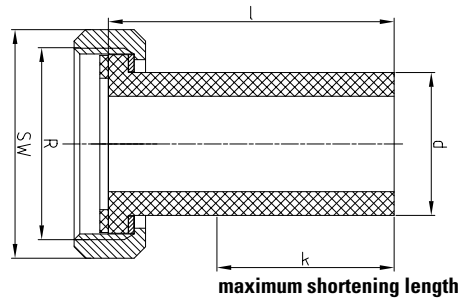
length: 100 mm, with gasket

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	k	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	26708	20	1"	100,00	65,00	36,00	0,079	• • •	1	150	
	26710	25	1 1/4"	100,00	62,00	46,00	0,104	• • •	1	125	
	26712	32	1 1/2"	100,00	58,00	52,00	0,175	• • •	1	100	
	26714	40	2"	100,00	53,00	64,00	0,258	• • •	1	75	
	26716	50	2 1/4"	100,00	49,00	72,00	0,344	• • •	1	60	
	26718	63	2 3/4"	100,00	43,00	89,00	0,583	• • •	1	40	
	26720	75	3 1/2"	100,00	34,00	110,00	0,918	• • •	1	30	
	26722	90	4"	100,00	26,00	120,00	1,238	• • •	1	20	

## WATER METER NUT ADAPTER

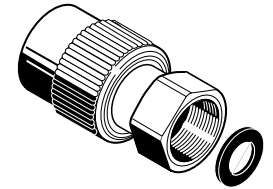
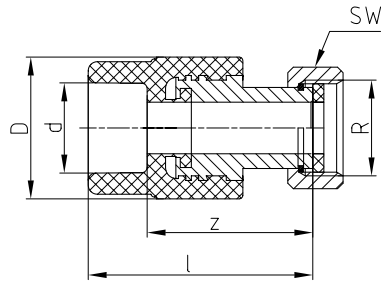
with gasket

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	Nut R	l	z	D	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	26808	20	3/4"	59,50	45,00	38,50	30,00	0,153	• • •	1		
	26810	25	3/4"	61,00	45,00	38,50	30,00	0,155	• • •	1		
	26812	32	3/4"	62,00	44,00	43,50	30,00	0,162	• • •	1		

## NUT ADAPTER

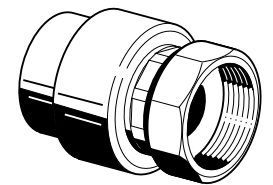
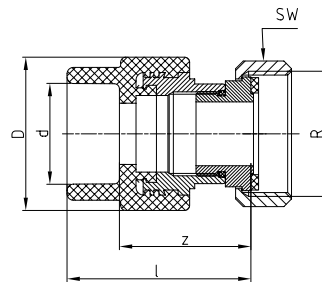
ISO-standard

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	z	D	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	27010	20	1"	58,50	36,00	38,50	36,00	0,182	• • •	10		
	27011	25	1"	60,00	44,00	38,50	36,00	0,186	• • •	10		
	27012	25	1 1/4"	60,00	44,00	43,50	46,00	0,274	• • •	10		
	27013	32	1 1/4"	63,00	45,00	43,50	46,00	0,279	• • •	5		
	27014	32	1 1/2"	69,50	51,50	60,00	52,00	0,446	• • •	5		
	27015	40	1 1/2"	72,00	51,50	60,00	52,00	0,421	• • •	5		
	27016	40	2"	74,00	53,50	74,00	64,00	0,719	• • •	5		
	27017	50	2"	77,00	53,50	74,00	64,00	0,736	• • •	5		
	27018	50	2 1/4"	77,00	54,50	84,00	72,00	0,831	• • •	5		
	27019	63	2 1/4"	83,50	56,00	84,00	72,00	0,889	• • •	1		
	27020	63	2 3/4"	84,00	56,50	101,00	89,00	1,306	• • •	1		
	27021	75	2 3/4"	85,00	55,00	100,00	89,00	1,275	• • •	1		
	27022	75	3 1/2"	91,00	61,00	100,00	110,00	1,818	• • •	1		



## COUNTERPART

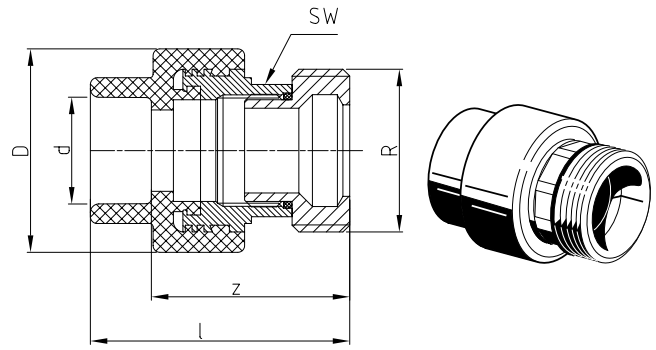
with welding socket and male thread for ISO-standard adapter

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	24,00	0,151	• • •	10	300	
	27311	25	1"	63,00	47,00	38,50	24,00	0,153	• • •	10	300	
	27312	25	1 1/4"	63,00	47,00	43,50	31,00	0,221	• • •	10	250	
	27313	32	1 1/4"	66,00	48,00	43,50	31,00	0,226	• • •	5	175	
	27314	32	1 1/2"	76,50	58,50	60,00	39,00	0,408	• • •	5	125	
	27315	40	1 1/2"	79,00	58,50	60,00	39,00	0,414	• • •	5	125	
	27316	40	2"	81,00	60,50	74,00	50,00	0,650	• • •	5	70	
	27317	50	2"	84,00	60,50	74,00	50,00	0,634	• • •	5	70	
	27318	50	2 1/4"	83,00	59,50	84,00	55,00	0,750	• • •	5	50	
	27319	63	2 1/4"	89,50	62,00	84,00	55,00	0,728	• • •	1	45	
	27320	63	2 3/4"	94,00	66,50	101,00	67,00	1,093	• • •	1	30	
	27321	75	2 3/4"	95,00	65,00	100,00	67,00	1,117	• • •	1	30	
27322	75	3 1/2"	100,00	70,00	100,00	67,00	1,436	• • •	1	30		

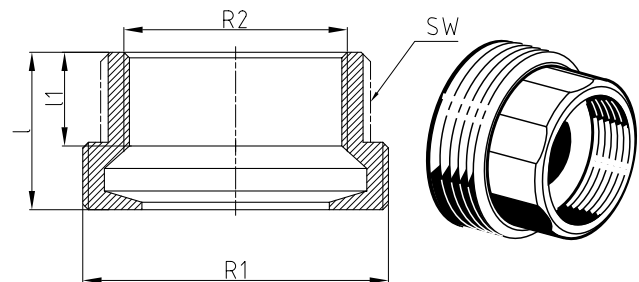
## BRASS COUNTERPART

with female thread, for ISO-standard adapter / loose nut adapter

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

Material: Fusiolen® PP-R, brass

Colour: green



SDR	Art.-No.	Male thread R1	Female thread R2	l	l1	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	27510	1"	1/2"	25,00	15,00	25,00	0,063	• • •	10	400	
	27512	1 1/4"	3/4"	28,00	18,00	32,00	0,119	• • •	10	200	
	27514	1 1/2"	1"	31,00	17,00	40,00	0,175	• • •	5	125	
	27516	2"	1 1/4"	33,00	22,00	47,00	0,263	• • •	5	75	
	27518	2 1/4"	1 1/2"	36,00	19,00	57,00	0,333	• • •	5	60	
	27520	2 3/4"	2"	42,00	24,00	68,00	0,517	• • •	1	35	
	27522	3 1/2"	2 1/2"	46,00	27,00	84,00	0,801	• • •	1	25	
	27524	4"	3"	46,00	27,00	97,00	0,943	• • •	1	25	

**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. aquatherm green pipe stainless steel price list Order-. No.: E53180 on request!!

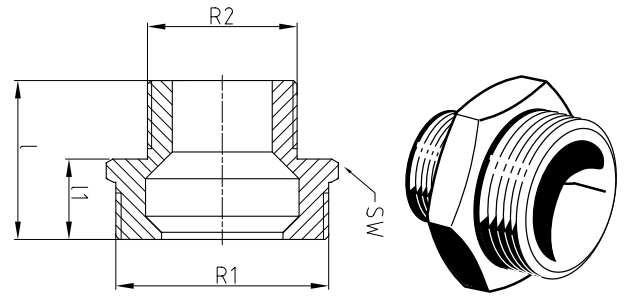
## BRASS COUNTERPART

with male thread, for ISO-standard adapter / loose nut adapter

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

Material: brass

Colour: green



SDR	Art.-No.	Thread R1	Thread R2	l	l1	SW	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	<b>27710</b>	<b>1"</b>	<b>1/2"</b>	34,50	18,50	36,00	0,109	• • •	10	250	
	<b>27712</b>	<b>1 1/4"</b>	<b>3/4"</b>	38,50	21,00	46,00	0,188	• • •	10	140	
	<b>27714</b>	<b>1 1/2"</b>	<b>1"</b>	41,50	22,50	50,00	0,211	• • •	5	100	
	<b>27716</b>	<b>2"</b>	<b>1 1/4"</b>	44,50	22,50	65,00	3,630	• • •	5	60	
	<b>27718</b>	<b>2 1/4"</b>	<b>1 1/2"</b>	58,00	36,00	57,00	0,472	• • •	5	50	
	<b>27720</b>	<b>2 3/4"</b>	<b>2"</b>	63,00	38,00	66,00	0,803	• • •	1	25	
	<b>27722</b>	<b>3 1/2"</b>	<b>2 1/2"</b>	70,00	42,00	82,00	1,189	• • •	1	15	
<b>27724</b>	<b>4"</b>	<b>3"</b>	74,00	42,00	97,00	1,398	• • •	1	10		

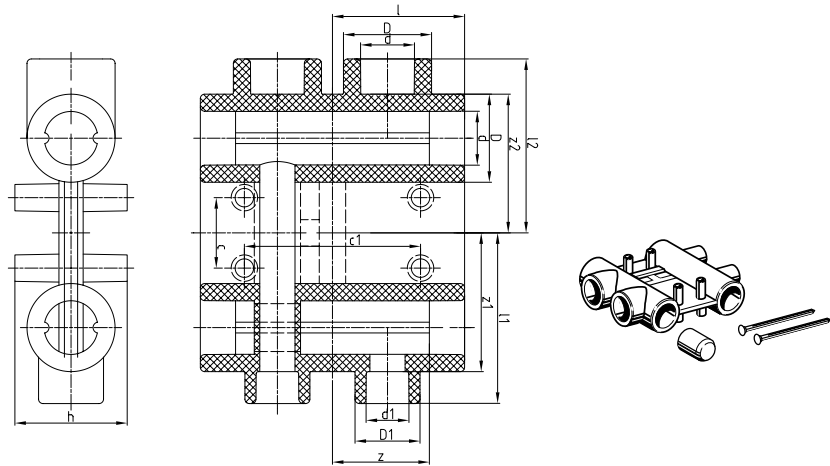
## DISTRIBUTION BLOCK PLUMBING

including 1 plug and 2 fastenings

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

Material: Fusiolen® PP-R

Colour: green

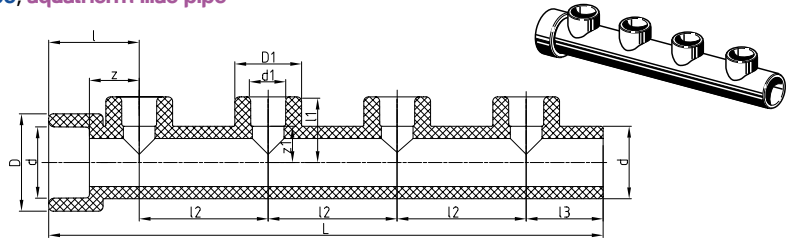


SDR	Art.-No.	d	l	z	D	d1	l1	z1	D1	l2	z2	c	c1	c2	l3	h	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 11	<b>30115</b>	<b>25</b>	60,00	44,00	40,00	20	77,50	63,00	29,50	79,00	63,00	32,00	80,00	100,00	36,00	51,00	0,273	• • •	1		

## 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

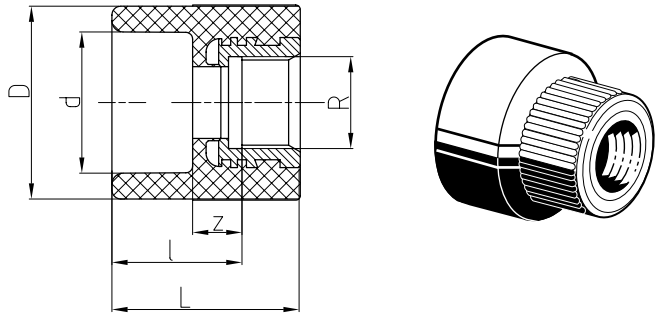


SDR	Art.-No.	d	d1	l	z	D	l1	z1	D1	l2	l3	L	Weight [kg]	System	PU	Box unit	Price € m/pc	
6	30602	32	16	40,00	22,00	43,00	29,00	16,00	29,50	57,00	36,00	245,00	0,141	•		1		
7,4																		
9	30604	32	20	40,00	22,00	43,00	29,00	14,50	29,50	57,00	36,00	245,00	0,134	•	•	•	1	
11																		

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	30804	32	1/2"	30,00	12,00	43,00	43,00	0,077	•	•	•	2
7,4												
9												
11												

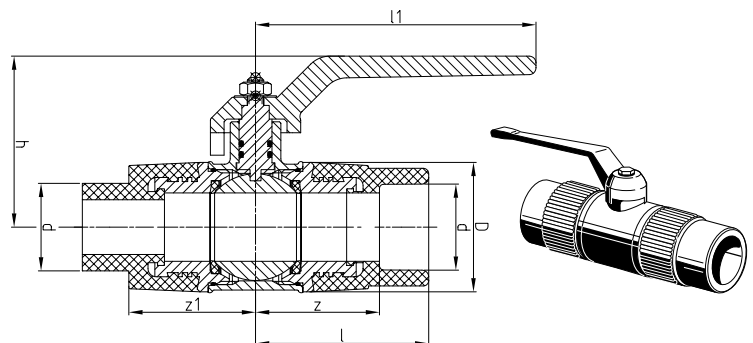
\* transition piece as manifold endpiece with female thread

**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. aquatherm green pipe stainless steel price list Order-. No.: E53180 on request!!

## BALL VALVE FOR MANIFOLD

female/male

Systems: **aquatherm green pipe**, **aquatherm blue pipe**, **aquatherm lilac pipe**  
 Material: Fusiolen® PP-R, brass  
 Colour: green

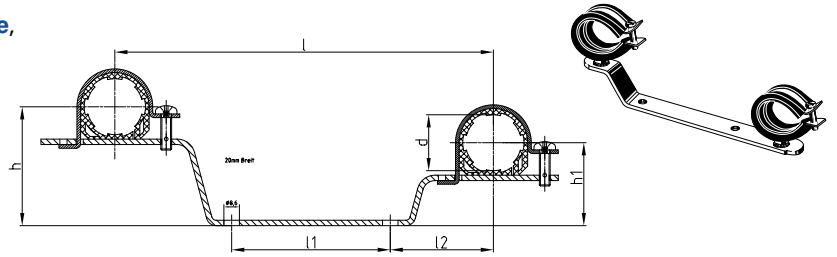


SDR	Art.-No.	d	l	z	D	z1	h	l1	Weight [kg]	System	PU	Box unit	Price € m/pc
6	78000	32	63,00	45,00	47,50	46,50	78,00	108,00	0,575	•	•	•	2
7,4													
9													
11													

## 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
<b>60210</b>	<b>32</b>	210,00	80,00	57,00	66,00	46,00	0,226	• • •	2		

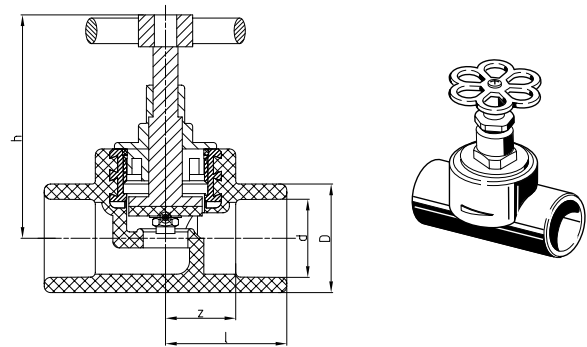
## GLOBE VALVE

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	<b>40808</b>	<b>20</b>	35,00	20,50	29,50	70,00	0,165	• • •	1	100	
7,4	<b>40810</b>	<b>25</b>	38,00	22,00	34,00	70,00	0,172	• • •	1	100	
9	<b>40812</b>	<b>32</b>	49,00	31,00	43,00	86,50	0,314	• • •	1	60	
11	<b>40814</b>	<b>40</b>	60,00	39,50	52,00	100,50	0,585	• • •	1	35	

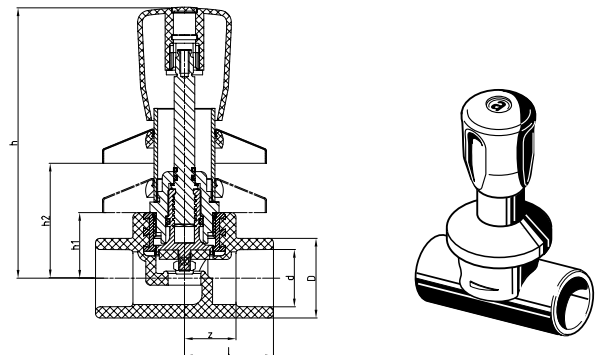
## CONCEALED VALVE

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	<b>40858</b>	<b>20</b>	35,00	20,50	29,50	116,00	28,00	59,00	0,319	• • •	1	40	
7,4	<b>40860</b>	<b>25</b>	38,00	22,00	34,00	116,00	28,00	59,00	0,330	• • •	1	40	
9	<b>40862</b>	<b>32</b>	49,00	31,00	43,00	121,00	34,00	59,00	0,416	• • •	1	30	

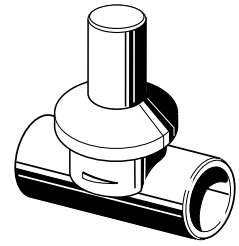
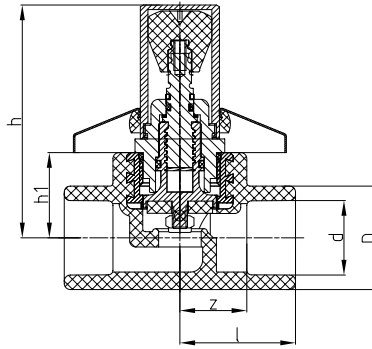
## CONCEALED VALVE

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												
7,4	<b>40868</b>	<b>20</b>	35,00	20,50	29,50	71,50	28,00	0,258	• • •	1	50	
9	<b>40870</b>	<b>25</b>	38,00	22,00	34,00	71,50	28,00	0,288	• • •	1	50	
11	<b>40872</b>	<b>32</b>	49,00	31,00	43,00	82,50	34,00	0,376	• • •	1	30	

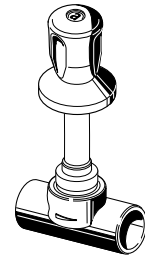
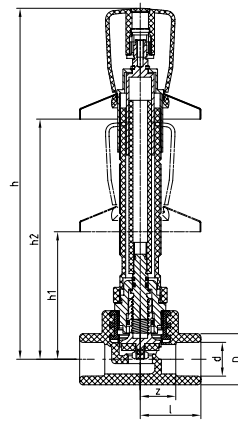
## CONCEALED VALVE

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													
7,4	<b>40878</b>	<b>20</b>	35,00	20,50	29,50	213,00	59,00	147,00	0,357	• • •	1	40	
9	<b>40880</b>	<b>25</b>	38,00	22,00	34,00	213,00	59,00	147,00	0,369	• • •	1	40	
11	<b>40882</b>	<b>32</b>	49,00	31,00	43,00	219,00	65,00	153,00	0,455	• • •	1	20	

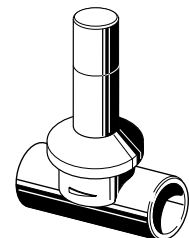
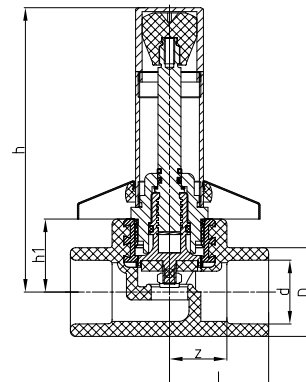
## CONCEALED VALVE

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												
7,4	<b>40888</b>	<b>20</b>	35,00	20,50	29,50	109,00	28,00	0,342	• • •	1	50	
9	<b>40890</b>	<b>25</b>	38,00	22,00	34,00	109,00	28,00	0,350	• • •	1	50	
11	<b>40892</b>	<b>32</b>	49,00	31,00	43,00	115,00	34,00	0,432	• • •	1	40	

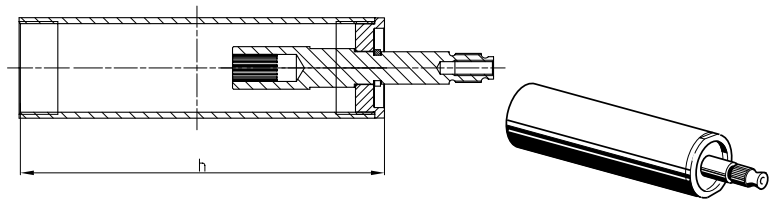
## EXTENSION FOR CONCEALED VALVE

chromium-plated for Art.-No. 40858-40862

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

Material: brass

Colour: chrom



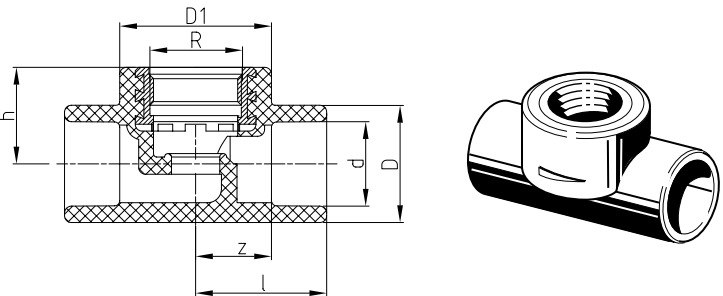
Art.-No.	h	Weight [kg]	System	PU	Box unit	Price € m/pc
40900	92,00	0,148	• • •	1	300	
40902	132,00	0,209	• • •	1	200	

## 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	150	
	40910	25	3/4"	38,00	22,00	34,00	28,00	44,00	0,101	• • •	1	150	
	40912	32	1"	49,00	31,00	43,00	34,00	52,00	0,146	• • •	1	100	
	40914	40	1 1/4"	60,00	39,50	52,00	41,00		0,313	• • •	1	50	

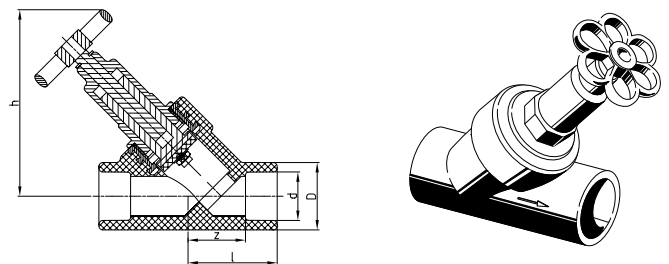
## INCLINED VALVE

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	100	
	41110	25	45,00	29,00	34,00	95,50	0,283	• • •	1	80	
	41112	32	56,00	38,00	43,00	111,50	0,421	• • •	1	50	
	41114	40	65,00	44,50	52,00	135,00	0,834	• • •	1	25	

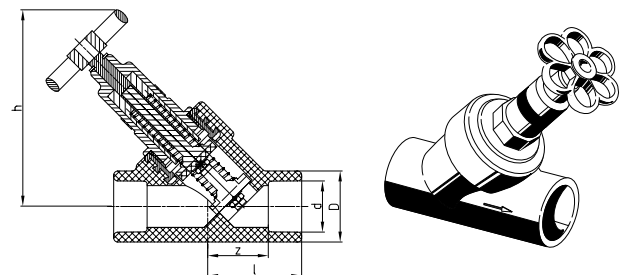
## NON-RETURN VALVE

without drain

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

Material: Fusiolen® PP-R, brass

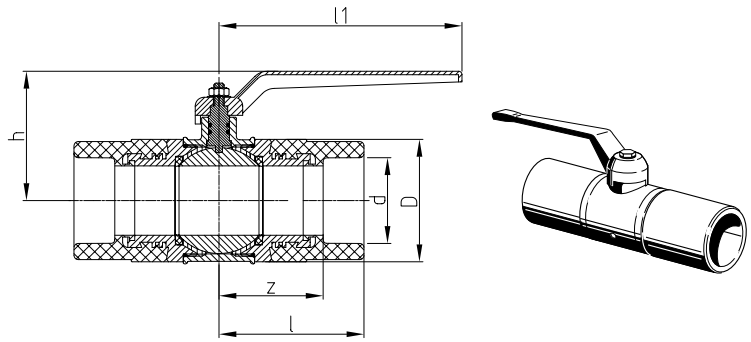
Colour: green



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	80	
	41210	25	45,00	29,00	34,00	95,50	0,292	• • •	1	80	
	41212	32	56,00	38,00	43,00	111,50	0,432	• • •	1	50	
	41214	40	65,00	44,50	52,00	135,00	0,840	• • •	1	25	

## BALL VALVE PP/BRASS

Systems: **aquatherm green pipe**, **aquatherm blue pipe**,  
**aquatherm lilac pipe**  
Material: Fusiolen® PP-R, brass  
Colour: green

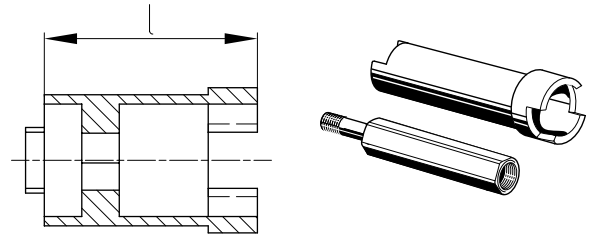


SDR	Art.-No.	d	l	z	D	h	l1	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	<b>41308</b>	<b>20</b>	55,00	40,50	32,00	66,00	85,00	0,280	• • •	1	100	
	<b>41310</b>	<b>25</b>	55,00	39,00	41,00	73,00	85,00	0,375	• • •	1	100	
	<b>41312</b>	<b>32</b>	63,50	45,50	47,00	82,00	108,00	0,592	• • •	1	60	
	<b>41314</b>	<b>40</b>	72,50	52,00	58,00	93,00	108,00	1,034	• • •	1	40	
	<b>41316</b>	<b>50</b>	83,50	60,00	70,50	114,00	140,00	1,339	• • •	1	25	
	<b>41318</b>	<b>63</b>	102,50	75,00	87,00	132,00	140,00	2,552	• • •	1	15	

## 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

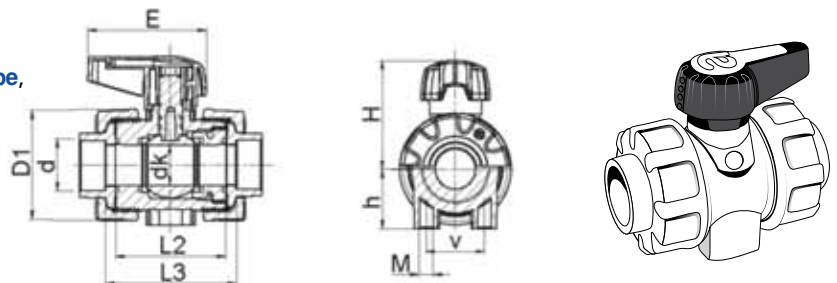


Art.-No.	l	for Art.-No.	Weight [kg]	System	PU	Box unit	Price € m/pc
<b>41378</b>	<b>35,00</b>	<b>41308 / 41310</b>	0,120	• • •	1		
<b>41382</b>	<b>35,00</b>	<b>41312 / 41314</b>	0,120	• • •	1		
<b>41386</b>	<b>46,00</b>	<b>41316 / 41318</b>	0,273	• • •	1		

## 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	dk	D1	E	h	H	L2	L3	DN	Weight [kg]	System	PU	Box unit	Price € m/pc
6 7,4 9 11	<b>41488</b>	<b>20</b>	13,5	50,30	66	27,00	48	56,50	68,00	15	0,118	• • •	1	200	
	<b>41490</b>	<b>25</b>	18,5	59,00	81	30,00	56,5	65,50	78,50	20	0,188	• • •	1	120	
	<b>41492</b>	<b>32</b>	23,9	70,30	81,5	40,00	64,5	72,00	84,50	25	0,277	• • •	1	80	
	<b>41494</b>	<b>40</b>	31,0	85,90	91,5	46,00	83,3	85,00	100,00	32	0,434	• • •	1	55	
	<b>41496</b>	<b>50</b>	38,5	99,50	91,5	55,00	89,4	89,00	107,00	40	0,549	• • •	1	45	
	<b>41498</b>	<b>63</b>	50,0	125,50	141,5	70,00	115	101,00	118,00	50	0,922	• • •	1	25	

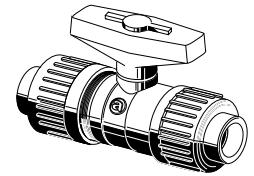
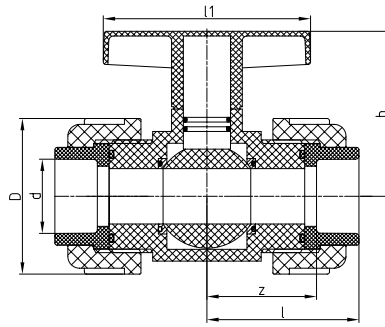
## PP-BALL VALVE

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	<b>41400</b>	<b>75</b>	138,00	108,00	129,00	137,00	186,00		65	2,615	• • •	1	10	
7,4														
9														
11														

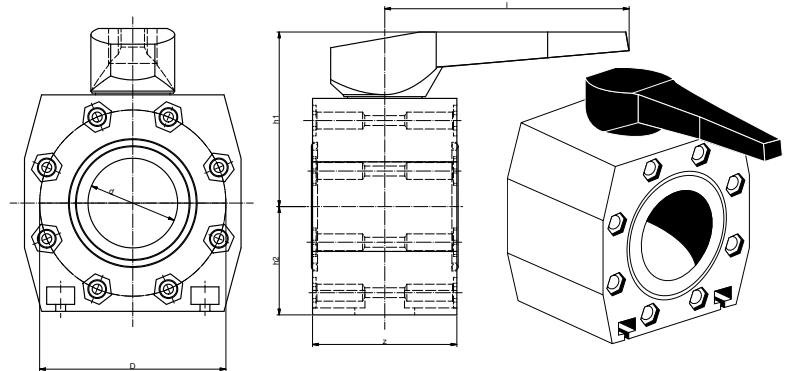
## PP-BALL VALVE

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	DN	Weight [kg]	System	PU	Box unit	Price € m/pc
6	<b>41601</b>	<b>75</b>									• • •	1		
7,4	<b>41602</b>	<b>90</b>	77	210,00	124,00	160,00	150,00	93,00	80	4,171	• • •	1		
9	<b>41604</b>	<b>110</b>	94	260,00	145,00	180,00	165,00	103,00	100	5,612	• • •	1		
11	<b>41607</b>	<b>160</b>	135	310,00	205,00	240,00	210,00	136,50	150	5,615	• • •	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 M16x60mm for Art.-No. 41602/41604

Hexagon screw M20x80mm for Art.-No. 41607

corresponding flat washer M16

NOTICE: These are not included in delivery.

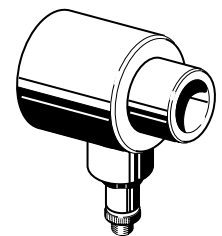
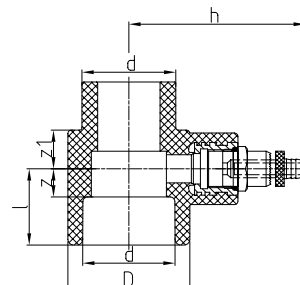
## DRAINING BRANCH

to weld in aquatherm green pipe valves

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

Material: Fusiolen® PP-R, brass

Colour: green



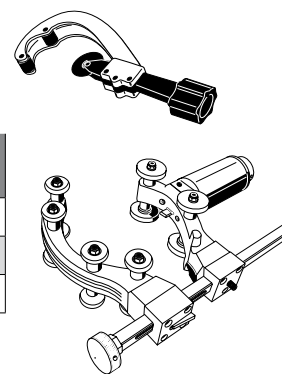
SDR	Art.-No.	d	z	l	D	z1	h	Weight [kg]	System	PU	Box unit	Price € m/pc
6	<b>41408</b>	<b>20</b>	11,50	26,00	34,00	16,50	67,00	0,098	• • •	1	200	
	<b>41410</b>	<b>25</b>	10,00	26,00	34,00	16,50	67,00	0,096	• • •	1	200	
	<b>41412</b>	<b>32</b>	14,00	32,00	43,00	17,00	70,50	0,118	• • •	1	150	
	<b>41414</b>	<b>40</b>	12,00	32,50	52,00	16,50	76,50	0,140	• • •	1	100	
	<b>41416</b>	<b>50</b>	15,50	39,00	68,00	17,00	83,75	0,202	• • •	1	40	
	<b>41418</b>	<b>63</b>	16,50	44,00	84,00	16,50	93,00	0,288	• • •	1	25	



**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.

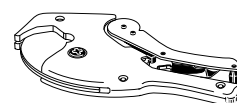
### PIPE CUTTER

Art.-No.	for pipe dimensions	PU	Box unit	Price € m/pc
<b>50102</b>	ø 16 - 40 mm	1		
<b>50105</b>	ø 50 - 125 mm	1		
<b>50106</b>	ø 110 - 160 mm	1		



### PIPE CUTTER

Art.-No.	for pipe dimensions	PU	Box unit	Price € m/pc
<b>50104</b>	ø 16 - 40 mm	1		



### ORBITAL CIRCULAR SAW

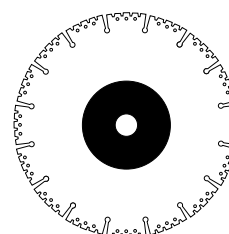
Art.-No.	for pipe dimensions	PU	Box unit	Price € m/pc
<b>50108</b>	ø 160 - 355 mm	1		

This orbital circular saw can be ordered directly from Rothenberger with Art.-No. 5.5620 ([www.rothenberger.com](http://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	Bohrung	PU	Box unit	Price € m/pc
<b>50107</b>	ø 125 mm	22,2 mm	1		
<b>50109</b>	ø 230 mm	22,2 mm	1		

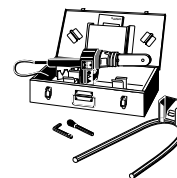
Application: for each angle grinder  
Design: diamant galvanized cutting disc



### MANUAL WELDING DEVICE (500 W)

Art.-No.	for pipe dimensions	PU	Box unit	Price € m/pc
<b>50336</b>	ø 16 - 32 mm	1		

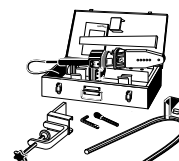
for one tool  
with base and case for tools



### MANUAL WELDING DEVICE (800 W)

Art.-No.	for pipe dimensions	PU	Box unit	Price € m/pc
<b>50337</b>	ø 16 - 63 mm	1		

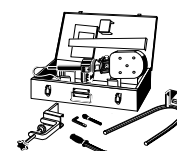
for two tools  
with base and case for tools



### MANUAL WELDING DEVICE (1400 W)

Art.-No.	for pipe dimensions	PU	Box unit	Price € m/pc
<b>50341</b>	ø 50 - 125 mm	1		

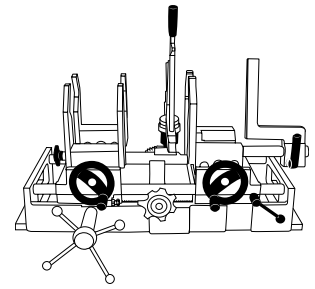
with base and case for tools, including handle



### WELDING MACHINE (1400 W)

Art.-No.	for pipe dimensions	PU	Box unit	Price € m/pc
50148	ø 50 - 125 mm - 230 V	1		

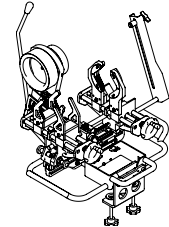
including welding tools 50-125 mm, roll stand and wooden transport case



### WELDING MACHINE (1400 W) LIGHT

Art.-No.	for pipe dimensions	PU	Box unit	Price € m/pc
50145	ø 63 - 125 mm	1		

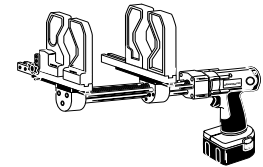
including manual welding device (1400 W) and wooden transport case



### ELECTRIC WELDING JIG

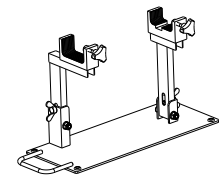
Art.-No.	for pipe dimensions	PU	Box unit	Price € m/pc
50159	ø 63 - 125 mm	1		

including standby accumulator, charging station and metal case



### BASE FOR ART.-NO. 50159

Art.-No.	Dimension	PU	Box unit	Price € m/pc
50151		1		

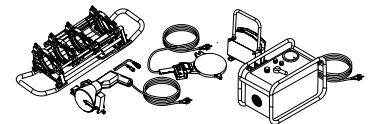


### BUTT WELDING MACHINES ROTHENBERGER

Art.-No.	for pipe dimensions	PU	Box unit	Price € m/pc
50163	ø 160 - 250 mm	1		
50178	ø 160 - 355 mm	1		

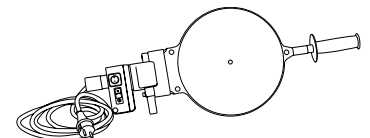
including wooden transport box.

The butt welding machine can be obtained directly from Rothenberger ([www.rothenberger.com](http://www.rothenberger.com))



### 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 - 160 mm	1		

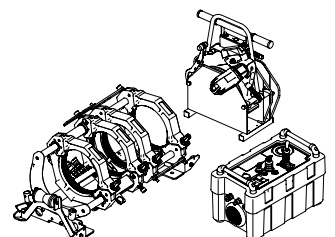


### BUTT WELDING MACHINES RITMO

Art.-No.	for pipe dimensions	PU	Box unit	Price € m/pc
50165	ø 160 - 250 mm	1		
50166	ø 160 - 315 mm	1		
50177	ø 160 - 355 mm	1		
50169	ø 400 - 630 mm	1		

including wooden transport box.

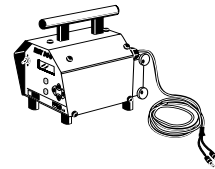
The butt welding machine can be obtained directly from Ritmo ([www.ritmo.it](http://www.ritmo.it))



## ELECTROFUSION DEVICE

Art.-No.	for pipe dimensions	PU	Box unit	Price € m/pc
<b>50175</b>	ø 20 - 250 mm	1		

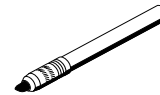
For processing with electro-fusion-sockets Art.-No. 17234-17238.  
Special calibration-tools - obtainable on request - are required



## TEMPERATURE PENCIL

Art.-No.	Dimension	PU	Box unit	Price € m/pc
<b>50190</b>		1		

to check the correct welding temperature



## SURFACE THERMOMETER

Art.-No.	Dimension	PU	Box unit	Price € m/pc
<b>50188</b>		1		

to check the correct welding temperature



## TEMPERATURE PREDECTIVE GLOVE

for tool change

Art.-No.	Dimension	PU	Box unit	Price € m/pc
<b>50195</b>		2		



## CLEANING WIPES

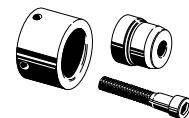
Art.-No.	Dimension	PU	Box unit	Price € m/pc
<b>50193</b>	Box with 100 towels	1		

for electrofusion sockets



## WELDING TOOLS

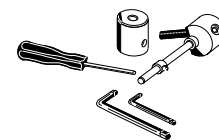
Art.-No.	Dimension	PU	Box unit	Price € m/pc
<b>50206</b>	16 mm	1		
<b>50208</b>	20 mm	1		
<b>50210</b>	25 mm	1		
<b>50212</b>	32 mm	1		
<b>50214</b>	40 mm	1		
<b>50216</b>	50 mm	1		
<b>50218</b>	63 mm	1		
<b>50220</b>	75 mm	1		
<b>50222</b>	90 mm	1		
<b>50224</b>	110 mm	1		
<b>50226</b>	125 mm	1		



## REPAIR SET

Art.-No.	Dimension	PU	Box unit	Price € m/pc
50307	7 mm	1		
50311	11 mm	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	7/11 mm	10		



## **NEW** aquatherm UNIVERSAL PEELING TOOLS

for aquatherm green pipe MF UV, aquatherm green pipe MF RP UV, aquatherm blue pipe MF UV, aquatherm green pipe MS and aquatherm blue pipe MF OT

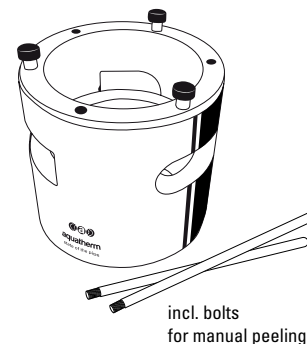
Required for the **socket welding**

(in combination with socket welding fittings from page 112 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	75 mm	1		
50486	90 mm	1		
50487	110 mm	1		
50488	125 mm	1		



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 faser, **MS** = multilayer stabi, **OT** = oxygen tight, **UV** = ultraviolet protected, **TI** = thermal insulation, **RP** = raised pressure

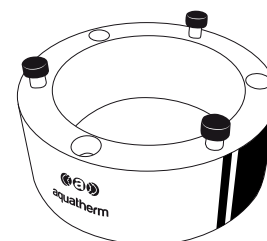
## **NEW** aquatherm EXTENSION FOR UNIVERSAL PEELING TOOL

Required for the **electrofusion socket welding** (aquatherm electrofusion sockets on page 134)



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)

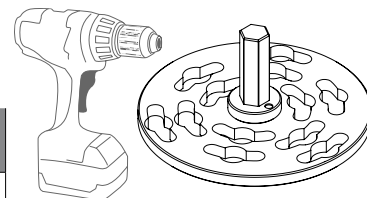
Art.-No.	Dimension	PU	Box unit	Price € m/pc
50489	for peeling tool 20 mm art.-no. 50479	1		
50490	for peeling tool 25 mm art.-no. 50480	1		
50491	for peeling tool 32 mm art.-no. 50481	1		
50492	for peeling tool 40 mm art.-no. 50482	1		
50493	for peeling tool 50 mm art.-no. 50483	1		
50494	for peeling 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		



## NEW 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	3	
50500	for universal peeling tool 50485 – 50488	1	3	



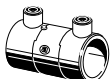
Delivery without drilling machine!

## aquatherm PEELING TOOLS FOR ELECTROFUSION SOCKET WELDING (Art.-No.17208-17238)

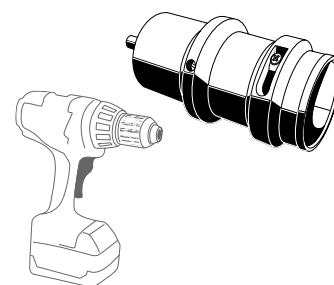
for aquatherm green pipe S, aquatherm green pipe MF, aquatherm green pipe MF RP, aquatherm green pipe MFTI, aquatherm blue pipe S, aquatherm blue pipe MF and aquatherm blue pipe MFTI

Required to remove the **oxid coating**

(aquatherm electrofusion sockets on page 134)



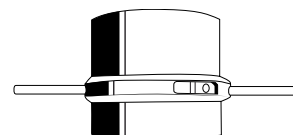
Art.-No.	Dimension	PU	Box unit	Price € m/pc
<b>In combination with a drilling machine</b>				
50558	20 mm	1		
50560	25 mm	1		
50562	32 mm	1		
50564	40 mm	1		
50566	50 mm	1		
50568	63 mm	1		
50570	75 mm	1		
50572	90 mm	1		



Art.-No. 50558-50572

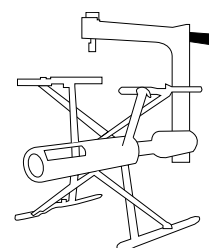
In combination with a drilling machine (not included!)

<b>For manual peeling</b>				
50574	110 mm	1		
50576	125 mm	1		
50580	160 mm	1		



Art.-No. 50574-50580

<b>For manual peeling</b>				
50592	200 + 250 mm	1		



Art.-No. 50592

Not suitable for aquatherm green pipe UV, aquatherm blue pipe UV, aquatherm blue pipe OT and aquatherm green pipe MS

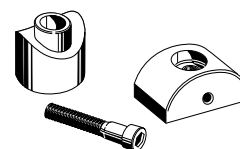
S = single, MF = multilayer faser, MS = multilayer stabi, OT = oxygen tight, UV = ultraviolet protected, TI = thermal insulation, RP = raised pressure

Spare parts such as blades can be requested under [service@aquatherm.de](mailto:service@aquatherm.de)!

## SADDLE WELDING TOOLS

for welding saddles

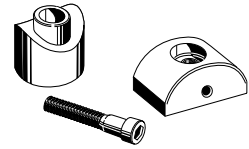
Art.-No.	Dimension	PU	Box unit	Price € m/pc
50614	40 x 20/25 mm	1		
50616	50 x 20/25 mm	1		
50619	63 x 20/25 mm	1		
50620	63 x 32 mm	1		
50623	75 x 20/25 mm	1		
50624	75 x 32 mm	1		
50625	75 x 40 mm	1		
50627	90 x 20/25 mm	1		
50628	90 x 32 mm	1		
50629	90 x 40 mm	1		
50631	110 x 20/25 mm	1		
50632	110 x 32 mm	1		
50634	110 x 40 mm	1		
50635	110 x 50 mm	1		
50636	125 x 20/25 mm	1		
50638	125 x 32 mm	1		
50640	125 x 40 mm	1		
50642	125 x 50 mm	1		
50644	125 x 63 mm	1		
50648	160 x 20/25 mm	1		
50650	160 x 32 mm	1		
50652	160 x 40 mm	1		
50654	160 x 50 mm	1		
50656	160 x 63 mm	1		
50657	160 x 75 mm	1		
50658	160 x 90 mm	1		
50660	200 x 20/25 mm	1		
50662	200 x 32 mm	1		
50664	200 x 40 mm	1		
50666	200 x 50 mm	1		
50667	200 x 75 mm	1		
50668	200 x 63 mm	1		
50669	200 x 90 mm	1		
50670	200 x 110 mm	1		
50671	200 x 125 mm	1		
50672	250 x 20/25 mm	1		
50674	250 x 32 mm	1		
50676	250 x 40 mm	1		
50678	250 x 50 mm	1		
50680	250 x 63 mm	1		
50682	250 x 75 mm	1		



## SADDLE WELDING TOOLS

for welding saddles

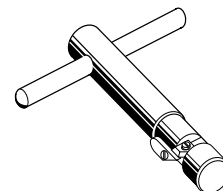
Art.-No.	Dimension	PU	Box unit	Price € m/pc
50684	250 x 90 mm	1		
50686	250 x 110 mm	1		
50688	250 x 125 mm	1		
50690	315 x 63 mm	1		
50692	315 x 75 mm	1		
50694	315 x 90 mm	1		
50696	315 x 110 mm	1		
50698	315 x 125 mm	1		
50699	315 x 160 mm	1		
50712	355 x 63 mm	1		
50714	355 x 75 mm	1		
50716	355 x 90 mm	1		
50718	355 x 110 mm	1		
50720	355 x 125 mm	1		
50722	355 x 160 mm	1		
50726	400-630 x 63 mm	1		
50728	400-500 x 75 mm	1		
50730	560-630 x 75 mm	1		
50732	400-500 x 90 mm	1		
50734	560-630 x 90 mm	1		
50736	400-450 x 110 mm	1		
50738	500-560 x 110 mm	1		
50740	630 x 110 mm	1		
50742	400 x 125 mm	1		
50744	450-500 x 125 mm	1		
50746	560-630 x 125 mm	1		



## CHAMFERING DEVICES

Art.-No.	Dimension	PU	Box unit	Price € m/pc
50910	20 & 25 mm	1		
50912	32 mm	1		
50914	40 mm	1		

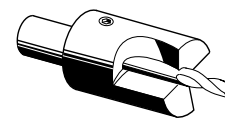
for removal of the aluminium swarfs at the drill hole only with stabi-composite pipes - to prepare the saddle welding



Only for stabi-composite pipes!

## DRILLS for installation of weld-in saddles

Art.-No.	Dimension	PU	Box unit	Price € m/pc
50940	20 & 25 mm (for pipes 40 - 160 mm)	1		
50941	20 & 25 mm (for pipes 63 - 250 mm)	1		
50942	32 mm	1		
50944	40 mm	1		
50946*	50 mm	1		
50948*	63 mm	1		
50950**/**	75 mm	1		
50952**/**	90 mm	1		
50954**/**	110 mm	1		
50956**/**	125 mm	1		
50958**/**	160 mm	1		



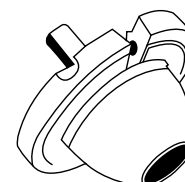
\* may only be used in fixed drilling machines!



\*\* tool holder MK4

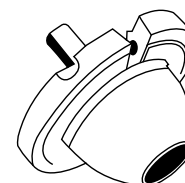
## SADDLE PEELING TOOLS FOR aquatherm blue pipe OT PIPES ø 50-125mm

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 aquatherm blue pipe OT PIPES ø 160-250mm

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	













Management  
System  
ISO 9001:2008  
ISO 14001:2004  
ISO 50001:2011  
[www.tuv.com](http://www.tuv.com)  
ID 0091005348

## **aquatherm GmbH**

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

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

[info@aquatherm.de](mailto:info@aquatherm.de) [www.aquatherm.de](http://www.aquatherm.de)