

# V1600CNC Butt Fusion Machine

RIYANG V1600CNC automatic controlled hydraulic operated butt fusion welding machine is suitable for PE and PP pipes from 1000mm to 1600mm OD. It is featured:

- ◎ Consists of basic frame, hydraulic unit, planing tool, heating plate, basket
- ◎ Standard welding range 1600mm SDR 17 to 1000mm SDR 11 with optional clamp inserts
- ◎ According to ISO/DVS/POP003 SLP & DLP low pressure Standards
- ◎ Reductions included: 1600x1400, 1400x1200, 1200x1000
- ◎ Electro hydraulic pump with controls and accumulator are mounted on the main frame. Includes countdown timers for heating and cooling phases
- ◎ Aluminium PTFE coated heating plate with electronic temperature control.
- ◎ Welding can be carried out between clamps 3 & 4 for tees, bends and manifold work
- ◎ 2 years warranty
- ◎ Featured components:
  - Quick coupling connector originally comes from Stucchi brand, Italy
  - Pressure keeping valve originally comes from Keta brand, China (NO.1 in China)
  - Proportional valve originally comes from Hydraforce brand, USA
  - Oil seal kit originally comes from Germany and Japan
  - PLC kit originally comes from Siemens, Germany
  - Electricity parts come from Schneider, Germany
- Etc....
- ◎ Options: Hydraulically operated clamps, hydraulically locking, stub end holder, other size reductions, high pressure welding system.

## Specifications Chart

Model	V1600CNC	
Applicable material	PE, PP, PVDF	
Pipe size (OD)	1000mm, 1200mm, 1400mm, 1600mm	
Ambient temperature	-5~45℃	
Power supply	~380 V±10 %	
Frequency	50 Hz	
Total current	84A	
Total power	52.5KW	
Include: Heater plate	42 kW	
Milling cutter motor	7.5 kW IP54	
Hydraulic unit motor	3 kW IP54	
Insulation resistance	>1MΩ	
Max.working pressure	25 MPa	
Cylinder area	81.28 cm <sup>2</sup>	
Cylinder capacity	42 L	
Hydraulic oil	40~50 (viscosity mm <sup>2</sup> /s, 40℃)	
Noise level	<70 dB	
Max.temperature of heating plate	270℃	
Temperature deviation of heating plate	±7℃	
Basic frame	Dimension,mm	3540X2600X2300
	Weight,kg	5000
Milling cutter	Dimension,mm	2490X280X2500
	Weight,kg	1500
Heater	Dimension,mm	2600X90X2250
	Weight,kg	500
Support for milling cutter and heater	Dimension,mm	2340X1700X2000
	Weight,kg	800
Total weight (kg)		≈7800

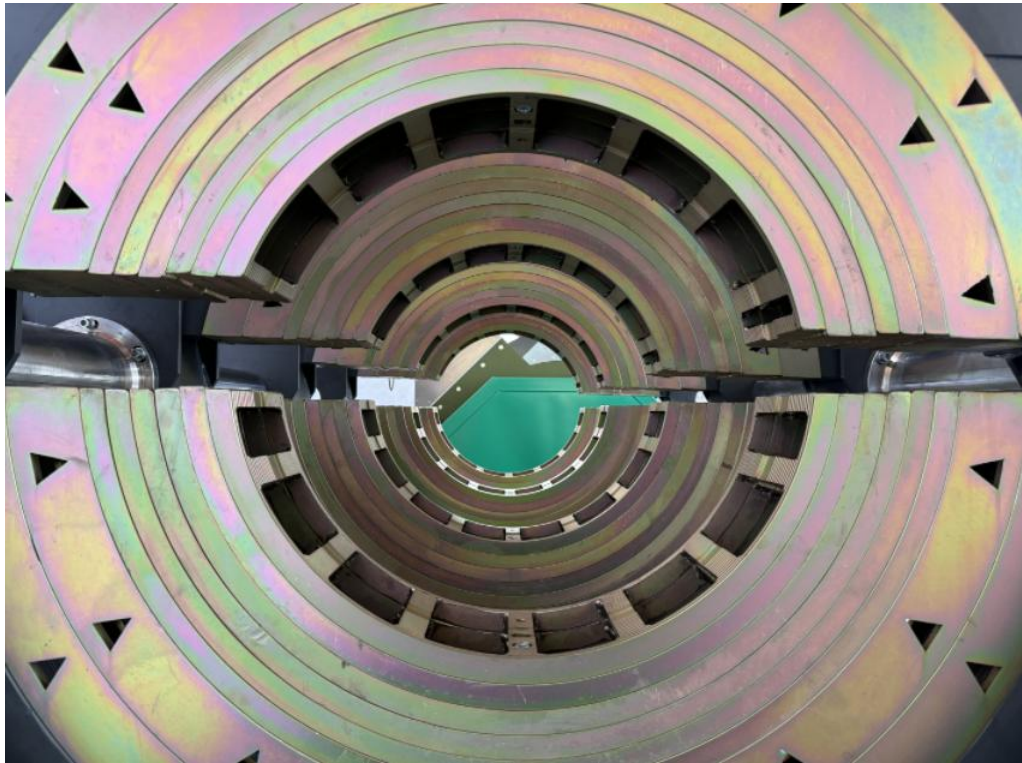
## Overview of RIYANG V1600CNC Butt Fusion Machine



(With hydraulic clamps and hydraulic locking)








(Galvanized Reducing Inserts )




(Control Panel)




**ADMIN**

EMERGENCY  
ACTIVATED!

PRESS [RESET] 2S  
FOR SERVO HOME



**RECOERD**



**WELDING**

ANGLE:	11.3°	BEADING PRESSURE:	27.9bar
DIAMETER:	500mm	SOAKING PRESSURE:	0.0bar
SDR:	21.0	SOAKING TIME:	238S
THICKNESS:	23.8mm	CHANGE OVER TIME:	12S
MATERIAL:	PE 80	WELDING PRESSURE:	27.9bar
BEAD SIZE:	2.5mm	COOLING TIME:	28.8MIN

STANDARD:	DVS2207PE
DATE:	2022-10-11
TIME:	15:23:25
AMBIENT PV:	0°C
WELDING SV:	2050°C
PLC COMMUNICATION:	<span style="color: red;">●</span>

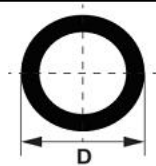
## WELDING

[PARAMETERS](#)[CALIBRATION](#)[MAIN](#)

## SELECT WELDING STANDARD

[ASTM F2620-2020](#)[DVS2007/1, PE](#)[CUSTOM](#)[DVS2007/11, PP](#)[DVS2207PE](#)[ISO21307, PE](#)[BACK](#)[NEXT](#)

## SELECT DIAMETER

[DVS2207PE](#)[30°](#)[630](#)[315](#)[355](#)[400](#)[450](#)[500](#)[560](#)[630](#)[BACK](#)[NEXT](#)

## SELECT SDR

DVS2207PE
30.00°
630
PE 80
11.0

6
---

7.4
-----

9
---

11
----

13.6
------

17
----

17.6
------

21
----

26
----

33
----

41
----

BACK
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NEXT
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## BEAD UP

BEAD SIZE:

4mm



P1:

0bar

91bar

T:

0°C

200°C

CONFIRM

## COOLING

RELEASE PRESSURE

COUNTDOWN

1S

NOTE:  
COULD TURN OFF THE HEAT

T5:

1S

4158S

P3:

0bar

91bar

T:

0°C

200°C

