

Heated tool butt welding

Polystone® CubX®

Welding parameters on the basis of DVS 2207-1 & 11

- Sheet format size: 2000 x 1500 x 57 mm

Quality	Temperature of the heating element [°C]	Equalizing [mm]	Preheating time with 0.01N/mm ² (1.4 psi) [sec]	Changeover time [sec]	Time to build up the pressure [sec]	Cooling time* [min]
Polystone® P CubX®	210	1,0	90**	Max. 6	11	20***
Polystone® G CubX®	220	1,0	120**	Max. 6	8	20***

*Recommended pressure (P CubX) : 12 mm * Length of the welding area [mm] * 0,1 N/mm²

*Recommended pressure (G CubX) : 12 mm * Length of the welding area [mm] * 0,15 N/mm²

**Experience value: Should be elongated if necessary

***A reduction in the cooling time of up to 50 % is the permitted under the circumstances