



FEATURE AND BENEFITS OF MASTER FIT PPR-C PIPES & FITTINGS

- Extremely Long Life at least 50 years
- No Scaling
- Food Grade Material
- Rust & Corrosion Free
- Rupture Free
- High Resistance to Acids and Chlorides
- Noise Free at High flow rates
- Low Electrical Conductivity
- High Pressure Light weight and Easy to install
- Homogenous Joints
- Environment Friendly with Recyclable ability
- Cost Effective pipeline network
- Excellent Weld ability
- Extensive Saving in Time and Labor

NOBLE ENTERPRISES

BRAND NAME

MASTER FIT

MANUFACTURER OF uPVC, PPRC, PE, CONDUIT PIPES, FITTINGS
& PE WATER STORAGE TANKS



JOINTING METHOD:

The Process of jointing **MASTER FIT** PPR-C pipes and fittings is simple and results in a permanent joint. It is carried out by using a simple welding machine that melts the internal surface of the fitting and the external surface of the pipe, so that the material of the pipe and the fitting will be fused together to form a leak-free joint.

DETAIL IS GIVEN BELOW:

- Prepare the welding machine by fitting it with the welding dies of the diameters to be welded.
- Connect the plug to the power supply socket and wait until the machine reaches the working temperature of approximately 260°C.
- Cut the pipe at right angle by using a sharp cutter.
- Clean the pipe from burrs, cutting and chips.
- Always mark the welding depths at the end of the pipe before heating.
- Push the end of the pipe and fitting into the welding machine Simultaneously.
- Remove the pipe and fitting from the welding machine are joined to one another immediately and without turning.
- Allow the joint to cool down as per specified cooling time before standing installation.

Joined Methods for PPRC Pipes



Socket Welding Time For Master Fit PPR-C Pipes & Fittings

The following table depicts the guidelines for heating of pipes & fittings for the purpose of welding according to DVS 2207-11

Pipe external Size	Welding Depth	Heating Time	Welding time	Cooling Time
mm	mm	Sec.	Sec.	Min.
20 mm	14.0	5	4	2
25 mm	15.0	7	4	2
32 mm	16.5	8	6	4
40 mm	18.0	12	6	4
50 mm	20.0	18	6	4
63 mm	24.5	24	8	6
75 mm	26.0	30	8	8
90 mm	29.0	40	8	8
110 mm	32.5	50	10	8

When the outdoor temperature is below 5 c , the heating time according to DVS 2207-11 should be increased by 50 %.

Master Fit Pipes SDR 6 PP-R 80 PN 20 Pipe Series 6 acc to DIN 8077-8078

Pipe external Size	Wall Thickness	Internal Diameter	Weight
mm	s (mm)	Di (mm)	Kg/m
20 mm	3.4	13.2	0.172
25 mm	4.2	16.6	0.260
32 mm	5.4	21.2	0.434
40 mm	6.7	26.6	0.671
50 mm	8.3	33.4	1.04
63 mm	10.5	42.0	4.65
75 mm	12.5	50.0	2.34
90 mm	15.0	60.0	3.36
110 mm	18.3	73.4	5.01