



Add: East of City Avenue, Economic Development Zone,
Zhangjiagang City, Jiangsu, China.

Tel: +86-512-58682198 / 58915912

Fax: 0512-58682126

Web: www.beierpm.com

E-mail: info@beierpm.com



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PLASTIC EXTRUSION

www.beierpm.com



COMPANY BRIEF

THE GLOBAL PLASTIC MACHINE BRAND MAKING BALANCE BETWEEN LIFE QUALITY AND SUSTAINABILITY OF THE EARTH

Jiangsu Beier Machinery is an integrated equipment supplier that accelerates plastic extrusion to recycling technology towards green recycling. As a company who is committed to sustainability, Jiangsu Beier Machinery integrates the three business units of plastic extrusion, compounding, and recycling systems to provide the global market with a substantial solution that balances the quality of life with the sustainability of the earth.

Since 1998, Beier's highly efficient and energy-saving European-style PE/PP/P-PR/PVC pipe, sheet and profile production lines, PVC blending and dosing systems and plastic solid waste recycling lines have served more than 125 countries and regions worldwide, creating value for more than 600 plastics companies with stable and sustainable production benefits and forming partnerships to develop a circular economy in various industries, including public works construction, construction markets and plastic recycling.

Innovation is one of Beier's core values that guides Beier's continuous evolution and growth, building its reputation through further technological upgrades, product service, customer satisfaction, and giving back to the community. Importantly, it is used to achieve the brand's mission, "Innovation for sustainability, pride in customer success". We believe - "There is power in really doing it."



DEVELOPMENT OF PLASTIC MACHINERY BUSINESS GROUP TO IMPROVE THE QUALITY OF HUMAN LIFE

Beier is conveniently located in Zhangjiagang National Economic and Technological Development District, Jiangsu Province, and is a national high-tech enterprise, a national torch plan enterprise, a provincial famous trademark, a provincial export base enterprise for plastic machinery products, and a provincial contract-abiding and credible enterprise.

For Beier and its global business partners, they will benefit from the Beier Machinery's vision to improve the quality of human life. In addition to plastic extrusion, compounding and recycling solutions, they will also have the professional resources and services of Bestar Blow Molding Machinery and Macquarie Import and Export Co., Ltd.

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PROPOSING A PLASTIC RECYCLING STRATEGY IN ACCORDANCE WITH PROTECTING THE COEXISTENCE OF HUMAN BEINGS AND ALL THINGS

Beier has built R&D platforms such as the Engineering Technology Research Center for Waste Plastics Utilization Machinery, Postdoctoral Workstation, Thousand Talents Program Workstation, etc. It has more than 80 national patents and has been awarded as a demonstration unit for the introduction of overseas intelligence. Beier Machinery gathers high-end professional and technical talents from Europe and China to gather the essence of industrial technology to meet the needs of customers in different market segments.

Beier Machinery always thinks about how to make production more efficient and environmentally friendly, so as to form the core competitiveness of sustainable development, contribute to the global cause of energy saving and emission reduction and green economic development, and strive to create a happier and better life.



30+
Are innovation
patents

50+
Patents for
utility model

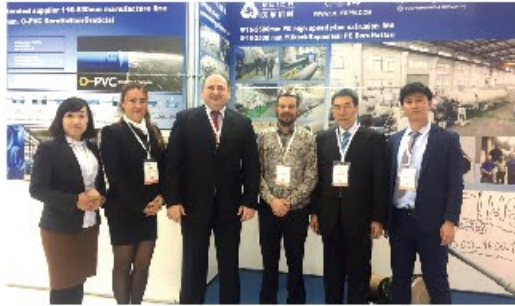
30+
Authorized
patents

CERTIFICATE AND HONOR

since 2003, above platforms was born 80 national patents, 30 of it are innovation patents. 50 patents for utility model, 30 authorized patents and provincial high & new technology accomplishment. award as high & new technology enterprise by office of science and technology of provincial government. for the purpose of supply well cost/performance industry solution to our clients, BEIER Group recruited a European engineer team which members are specialized in top plastic machinery engineering. they work together with our R&D team to improve quality and design of the product to narrow the gap toward the top European machines.

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OUR CLIENT



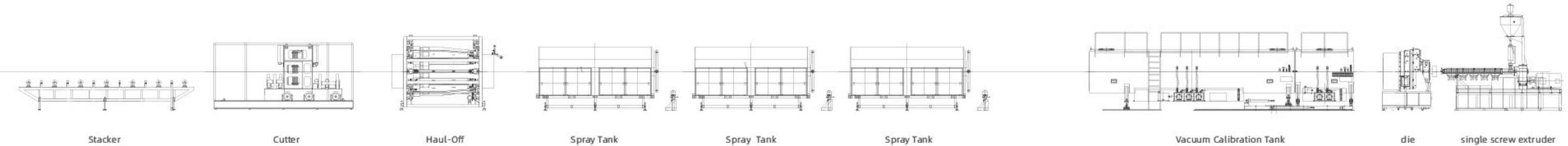
16-2500MM **PE HIGH SPEED** **HIGH EFFICIENCY** **EXTRUSION SOLUTION**

polyethylene is now in widespread use in many industries particularly industrial piping systems, including underground gas and water pipelines, where it is the dominant material.



16-2500MM
PE HIGH SPEED HIGH EFFICIENCY
EXTRUSION SOLUTION

- ⊙ The optimum spiral bush highly improves the output of extruder
- ⊙ Accurate temperature control system ensures material melting performance
- ⊙ Unique screw design achieves better plasticizing and high quality products
- ⊙ Precisely designed gearbox with a high torsion guarantees stable running
- ⊙ H sharp frame to decrease vibrating of extruder
- ⊙ Advanced PLC operation system realizes synchronization and high quality products
- ⊙ Adopt automatic water temperature & level control and special independent filters on both vacuum and cooling tanks
- ⊙ Offer stable haul-off unit with 2-12 caterpillars
- ⊙ Provide saw & chip free cutting options
- ⊙ Low energy consumption, excellent performance, and easy maintenance



Main Technical Parameter

Model	Pipe range (mm)	Extruder model	Extruder motor power(kw)	Max. Output (kg/h)
BRD-63	Φ20-63	BRD60/38	90	450
BRD-110	Φ20-110	BRD60/38	110	500
BRD-160	Φ40-160	BRD60/38	110	500
BRD-250	Φ50-250	BRD75/38	160	680
BRD-450	Φ160-450	BRD90/38	250	1000
BRD-630	Φ280-630	BRD90/38	280	1100
BRD-800	Φ315-800	BRD120/38	315	1300
BRD-1200	Φ500-1200	BRD120/38	355	1400
BRD-1600	Φ1000-1600	BRD90/38&BRD90/38	250+250	2000
BRD-2000	Φ1000-2000	BRD90/38&BRD90/38	280+280	2200

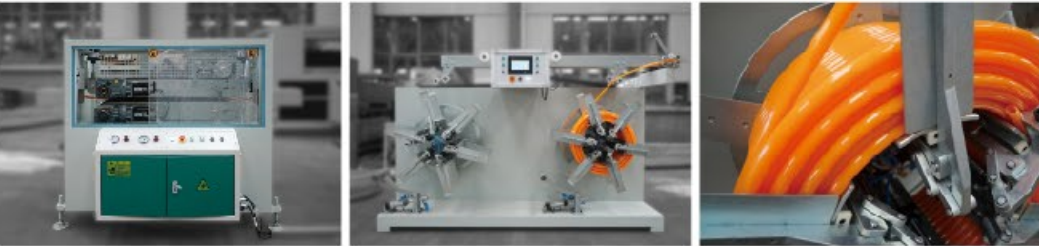
Φ16-63MM PP PE PE-RT PPR HIGH SPEED HIGH EFFICIENCY EXTRUSION SOLUTION

PP-R Pipe Application

- ⊙ Underfloor heating
- ⊙ Central heating installations in houses and industries
- ⊙ Industrial transportations chemical fluids and gasses
- ⊙ Conveyance of potable water
- ⊙ Special applications undersea networks, networks with a high risk of electrochemical corrosion etc
- ⊙ Hot and cold water transportation



Φ16-63MM
PP PE PE-RT PPR
HIGH SPEED HIGH EFFICIENCY
EXTRUSION SOLUTION

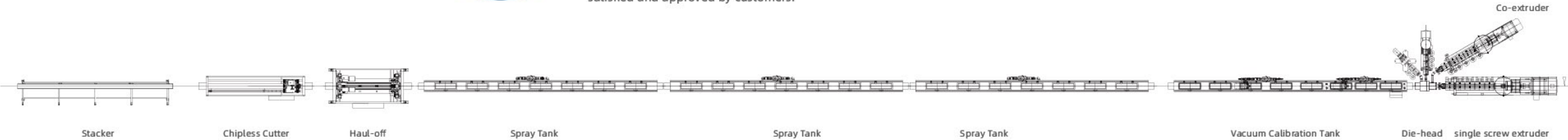


- Internal layer PP-R:30%
The internal layer made from high grade polypropylene granulate features the colour coding of the pipe and is used to guarantee the renowned sate processing as well as to protect the middle layers.
- Second layer Glass fiber compounding:30%
The PPR glass fiber compound is the result of detailed research carried out at the Beier Polymer-Engineering division and is a new development in this field. the perfect interaction between the corresponding glass fibres and the PP-R provides outstanding properties in terms of linear expansion,deflection and low-temperature impaction strengh.
- Intermediate layer PP-R.30%
Improved long-term stress behavior with longer periods of operation.especially at higher temperatures.
- External layer PP-R CT:10%



MULTI-LAYER PP-R
PIPE PRODUCTION LINE

Hot PP-R 4 layer pipe production line,which has been successfully running in Germany and Middle East markets,widely satisfied and approved by customers.



Main Technical Parameter

Pipe range	Extruder model	Motor power	Max. Output (kg/h)
20-63	BRD50/38	55	220-250
	BRD50/38	55	
20-160	BRD60/38	90	450-500
	BRD50/38	55	

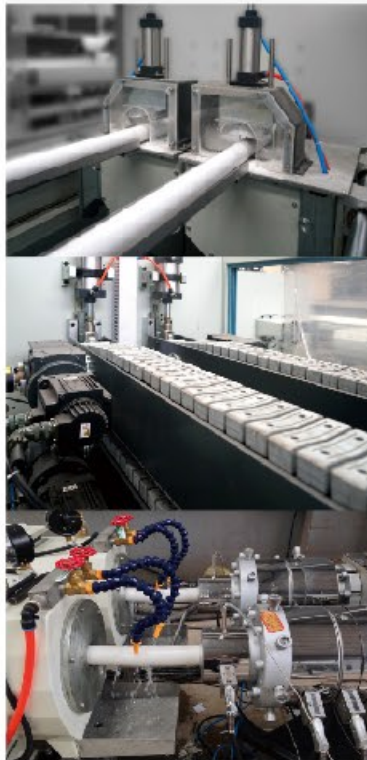
Φ16-1000MM PVC PIPE EXTRUSION SOLUTIONS

PVC Pipe Application

- ⊙ Conveyance of water, under pressure
- ⊙ Sewerage piping systems
- ⊙ Drainage piping systems
- ⊙ Electrical, telecommunications engineering pipeline



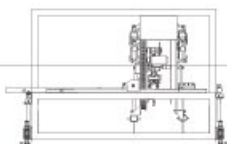
Φ16-1000MM PVC PIPE EXTRUSION SOLUTIONS



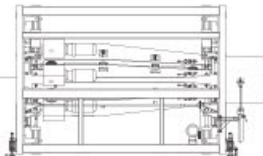
Φ16-1000 series PVC pipe extrusion line is mainly used in manufacturing the pipe for agricultural and constructional plumbing, cable laying etc. This line is composed by conical twin-screw extruder, mould, vacuum calibration tank, haul-off, cutter and staker etc. The extruder and haul-off adopt imported AC frequency control device, vacuum pump and haul-off motors adopt high-quality brand.



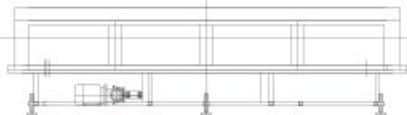
Belling Machine



Cutter



Haul Off

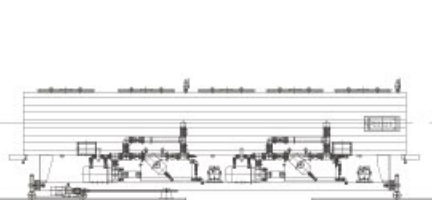


Spray Tank

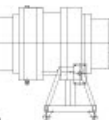


The haul-off methods are two-claw, three-claw, four-claw, six-claw, eight-claw etc. you may choose saw cutting type or planetary cutting type. It is additionally attached with the length counter and intensifying device. The equipment is with the reliable performance and high production efficiency.

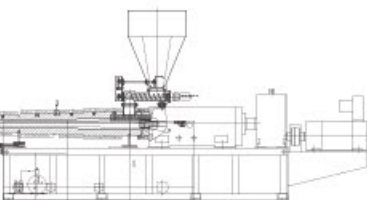
Our company can also manufacture special pipe production lines, eg. Spiral silencing pipe and core foaming pipe according to your requirements.



Vacuum Calibration Tank



die



Conical Twin Screw Extruder

Main Technical Parameter

Pipe range(mm)	Extruder model	Extruder motor power(KW)	Capacity(kg/h)
Φ16-63 Dual pipe	SJZ65/132	37	280-350
Φ50-110 Dual pipe	SJZ80/156	55	400-550
Φ50-160	SJZ65/132	37	280-350
Φ75-250	SJZ65/132	37	280-350
Φ110-315	SJZ80/156	55	400-550
Φ160-450	SJZ80/156	55	400-550
	BRP93/28	67	550-600
Φ315-630	SJZ92/188	110	750-850
	BRP107/26	90	750-850
Φ710-1000	BRP135/28	160	1100-1200

O-PVC INTEGRATED SUPPLIER 110-630MM MANUFACTURE LINE

O-PVC Pipe Application

- ◎ Supplying & Infrastructure nets
- ◎ Drain pipe
- ◎ Instruction
- ◎ Irrigation



O-PVC INTEGRATED SUPPLIER 110-630MM MANUFACTURE LINE

BEIER MACHINERY COOPERATED WITH
JANGSU UNIVERSITY OF SCIENCE AND
TECHNOLOGY & PRESTIGIOUS RESEARCH TEAM IN O-PVC FROM HEBEI



COST EFFICIENCY

Half thickness of PVC-U pipe. Raw material cost effective.
4 Times impact resistance to external loads



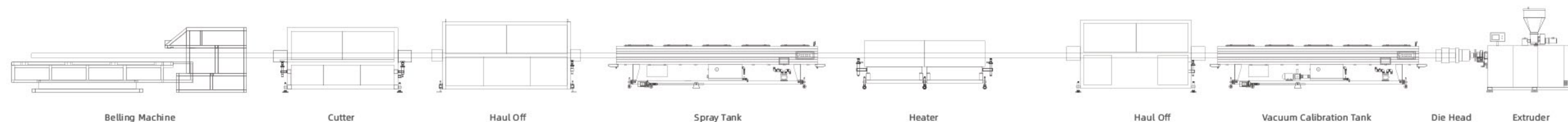
ENERGY EFFICIENT

Smooth inner wall. Higher water conveyance.
Increased hydraulic capacity
Between 15-40% more hydraulic capacity than PVC-U, HDPE

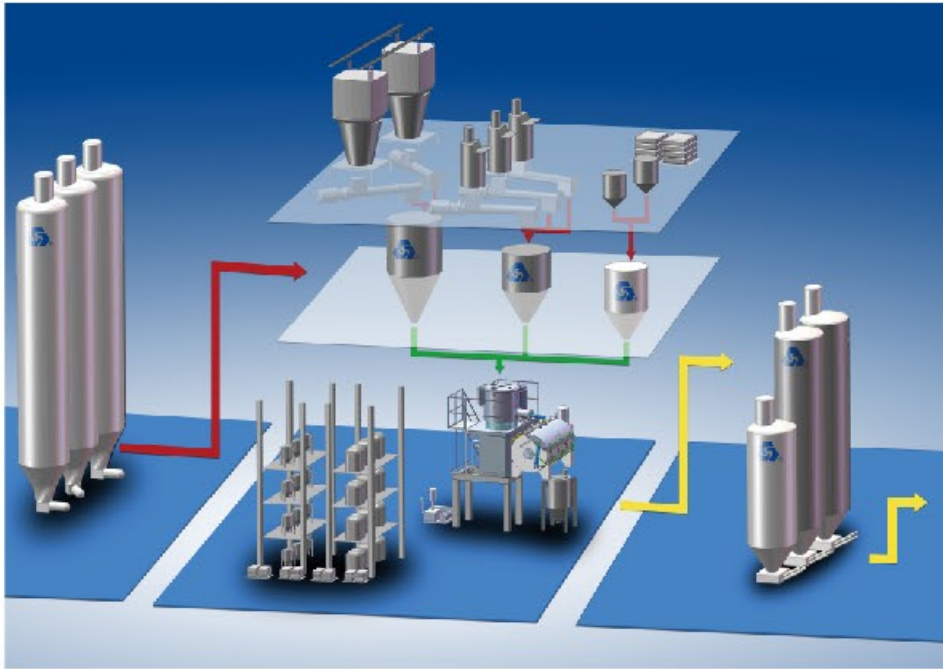
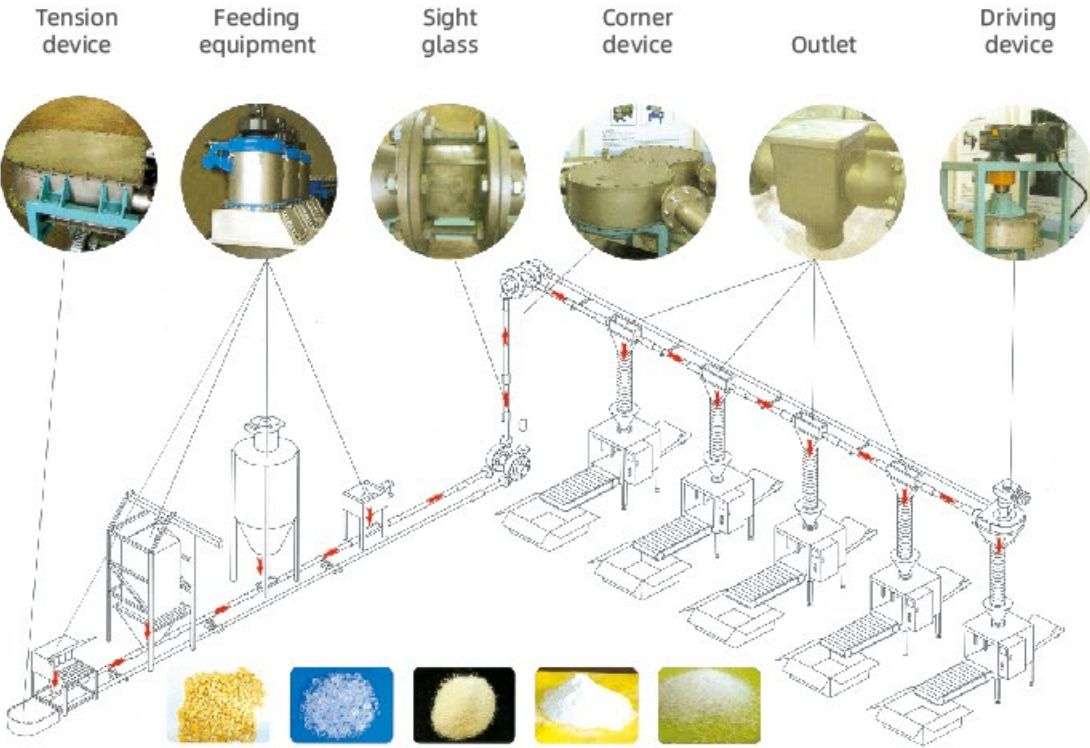


OPTIMAL ENVIRONMENTAL PERFORMANCE

Optimal environmental performance
Energy efficient



COMPOUNDING SYSTEM & MIXING UNIT



SHR SERIES HIGH-SPEED MIXER

SHR series mixers are mainly used for mixing, coloring, drying and etc, in plastics, rubber, food-stuff, daily chemical industry and so on.

SHR series mixers adopt advanced design and can be operated easily, safely and reliably. They have small size, light weight, high efficiency, low energy consumption and low noise.



Main Technical Parameter

Model	Capacity(L)	Effective capacity	Motor (KW)	Main Shaft Speed(rpm)	Heating method	Discharge method	Output(kg/h)
SHR-5A	5	3	1.1	1400	Self-friction	Hand	8
SHR-10A	10	7	3	2000			16
SHR-50A	50	35	7/11	750/1500	Electric	Pneumatic	82
SHR-100A	100	75	14/22	650/1300			165
SHR-200A	200	150	30/42	475/950			330
SHR-300A	300	225	40/55	475/950			495
SHR-500A	500	375	47/67	430/860			825
SHR-800A	800	600	83/110	370/740	Self-friction	Pneumatic	1320
SHR-200C	200	150	30/42	650/1300			330
SHR-300C	300	225	47/67	475/950			495
SHR-500C	500	375	83/110	500/1000			825

BRL-WN SERIES
HORIZONTAL MIXING UNIT

BRL-WH	Heat/cool	Heat/cool	Heat/cool	Heat/cool
Total volume(L)	500/1600	800/2500	1000/3000	800*2/4500
Effective capacity(L)	330/1000	600/1500	700/2100	1200/3000
Stirring speed(rpm)	430/860/70	370/740/60	300/600/50	350/700/50
Mixing time	8-15	8-15	8-15	8-15
Motor power(kw)	55/75/15	83/110/22	110/160/30	83/110*2/45
Weight(kg)	4200	5500	6500	8000
Output(kg/h)	825	1320	1650	2640



It is used in mixing, stirring, drying, coloring of plastics, rubberchemicals for daily use. It is an ideal advance equipment of producing plastic board, pipe, profile and degradation plastics.



We digest and absorb foreign advanced technology in making mixer, which adopts the vacuum mixing principle. The electric meters all adopt imported famous brands and adopt PLC controlling, which has character of high automation, quick mixing, the blade is precisely cast of stainless steel and treated by dynamic and static balancing. Especially, the blades of cooling machine adopt the advanced spiral stirring structure, which avoid dead angle, and with the feature of quick cooling, thoroughly discharging; high efficient of mixing.



BRL-LN SERIES
VERTICAL MIXING UNIT

BRL-LN series mixer units are widely used in mixing, drying, coloring for all kinds of resin such as PVC, PP, PE. They can also be applied in dryness of ABS, polycarbonate, and mixing hydroxybenzene, Alde Hyde resin.

This unit is composed of one hot mixing pot and one cooling pot, the materials from hot mixer will be filled into the cooling mixer automatically, so it and eliminate humidity, and protect from agglomeration.

Main Technical Parameter

BRL-LN	Heat/cool	Heat/cool	Heat/cool	Heat/cool
Total volume(L)	100/200	200/500	300/600	500/1250
Effective capacity(L)	65/130	150/320	225/380	330/750
Stirring speed(rpm)	650/1300/200	475/950/130	475/950/100	430/860/70
Mixing time	8-12	8-12	8-12	8-12
Motor power(kw)	14/22/7.5	30/42/7.5	40/55/11	55/75/15
Output(kg/h)	165	330	495	825

PLASTIC PROFILE & BOARD EXTRUSION



WPC PROFILE & BOARD APPLICATION

For building materials, home decoration, industrial products, such as outside decking, floor, wall panel, railings, and etc.

PVC PROFILE APPLICATION

Mostly used in Building & Construction Industry, for example door panel and frame, window frame, edge banding etc.



Our company successfully developed PVC wood-plastic foamed plate production line. The product of wood-plastic foamed plate collects advantages of wood and plastic. It not only has natural wood face, but also conquers nature wood shortage. It has good processing ability which is similar to wood; It can be process by saw, ingot, and dig, just use wood tools. The force is much better than normal wood. It has physical characteristics, such as resistant to compression, resistance to impact and others, which are similar to hard wood, and its durable function is clearly better than normal wood, wood-plastic material and the products can be resistance strong acid and alkali, water proof, corrosion resistance, besides, germ cannot breed on it. It is not motheaten, it can be aging resistance, static electricity resistance, flame retardant.



WIDE DOOR BOARD EXTRUSION

Main Technical Parameter

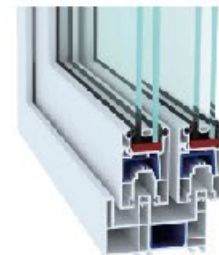
Specification	Width mm	Thickness mm
A	≤1220	20
B	≤1220	25
C	≤1220	30



The product can be used in making building template, toy board, tray, package box, sleeper, outdoor floor, railings, garden chair and other outdoor facilities, indicating plate, circulating box, roof beam etc.

- ◎ Particular designed conical twin screw for PVC powder raw materials
- ◎ Adapted to different moulds for different Pvc profiles
- ◎ With special designed vacuum calibration platform, haul-off and cutter, stacker.
- ◎ Adopt with full aspects efficient water mist cooling on profile.

PVC PROFILE EXTRUSION LINE



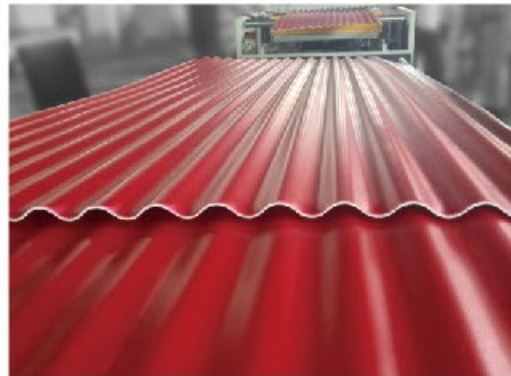
Fetching in Europe and America advanced technology and uniting with domestic condition, our company develop this production line. It possesses the features such as novel style, reasonable structure and friendly operation. The main extruder in this line, manufactured by our company, matches with auxiliary machines and die head.

This production can realize full automatic control from feeding to staking. Meanwhile each machine can be regulated manually. It possesses the advantages such as high elasticizing capacity, low energy consumption, high productivity performance cost value and long life. It's the best selecting equipment to produce all kinds of plastic profile.

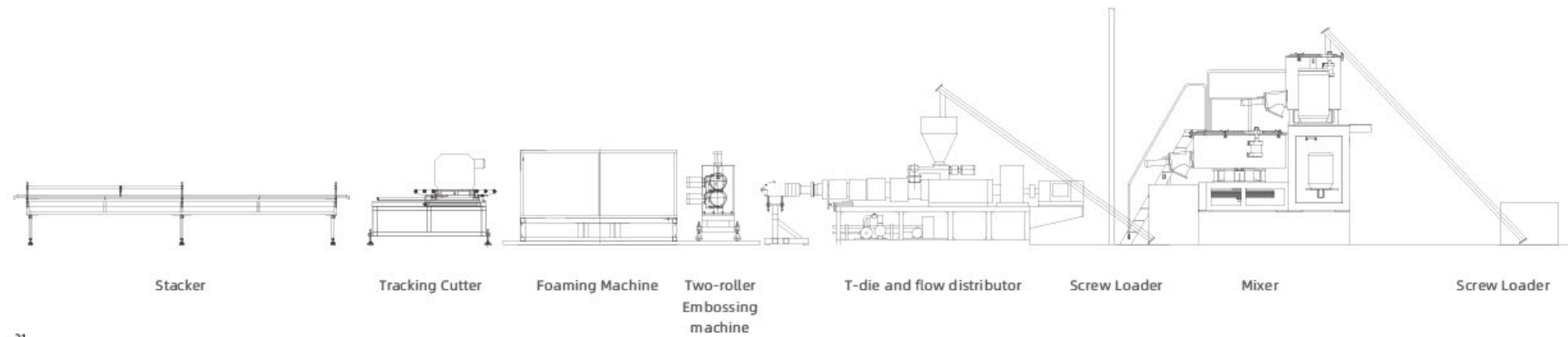
WOOD-PLASTIC PROFILE EXTRUSION LINE



- Optional to adopt conical twin screw extruder and parallel twin screw extruder
- Supply formula guide and staple raw material purchase
- Professional analyzing and design by considering production cost and tile's performance
- Single layer or A+B/A+B+C/A+B+A layers available



PVC+ASA/PMMA ROOF TILE PRODUCTION LINE



Main Technical Parameter

Layer structure of roofing tile	Single layer tile		Double layer tile		Three layer tile(inner foaming)
Extruder configuration	SJZ80/156	SJZ92/188	SJZ80/156+SJ50	SJZ92/188+SJ50	SJZ51/105+SJZ65/132+SJZ51/105
Width of tile	710-1220mm	710-1220mm	710-1220mm	710-1220mm	710-1220mm
Thickness of tile	0.8-3.0mm	0.8-3.0mm	2.5-3.0mm	2.5-3.0mm	2.5-3.0mm
Extrusion capacity	450-550kg/h	600-700kg/h	450-550kg/h	600-700kg/h	400-500kg/h

- ⦿ This production line is mainly used to produce PVC glaze title which width is 720,930,1100mm, thickness is 2mm,2.5mm 3mm.
- ⦿ PVC, ASA or PMMA compound roof tile production line consists of conical double screw extruder SJZ80/156, single screw co-extruder, extruding tool, forming machines for main tile and ridge tiles, haul-off, cutter, stacker;

- ⦿ Supply formula guide service and staple raw material purchase
- ⦿ professional analyzing and design by considering production cost and tile's performance.

PVC+ASA/PMMA GLAZE ROOF TILE PRODUCTION LINE



SHEET EXTRUSION SOLUTION APET PETG CPET SHEET EXTRUSION LINE

Main Technical Parameter

Model	APET Single Layer	APET/PETG Multi Layer
Extruder Specification	Φ120/33	Φ120/33, Φ65/33
Products Width	500-1500mm	500-1200mm
Products Thickness	0.20-1.5mm	0.20-1.5mm
Capacity(Max)	450kg/h	500kg/h
Main Motor Power	132kw	132kw/45kw
Design Production Speed	20m/min	25m/min



Products Application:

It has the features of good processing capacity, transparency, innocuity, no smell and no pollution, easy in recycling.

Vacuum Forming:

Food packing, toy box, stationery cases, tools and hardware packing.

Obstruct Application:

Electron components packing.

Normal Application:

Fold forming, under collar, decorate material, file folder, paper file, documents cover, credit cards.

Special Application:

Medical equipment, medicine packing, industrial antiseptis, plate for microwave oven(CPET).

APET,PETG,CPET Single-layer or Multi-layer Sheet Extrusion Machine

is one of the most advanced technology machinery in China with the matured technology and the stable production ability. This machine is about 30% better when comparing with the same equipment made in the domestic market. And this machine can also be used in the PS,PP,ABS sheet production, besides this company has developed the CEPT sheet production line, APET thick board production line, and the technology of these machines is much better than the technology used in the domestic market.

Dryer-free PET Double Venting Sheet Line

(free of crystallization drying system),it's the high quality PET sheet production line, designed with the simple operation system, low power cost which greatly reduces the cost of production.

PC PMMA PS MS SHEET PRODUCTION LINE

Main Technical Parameter

Model	BR120/38-1220
Material	PC, PMMA, PS
Products Width	1220mm
Products Thickness	1.5-4mm
Extruder Specification	120/38
Capacity(Max)	350-400kg/h

Application of PMMA Board(Acrylic board)

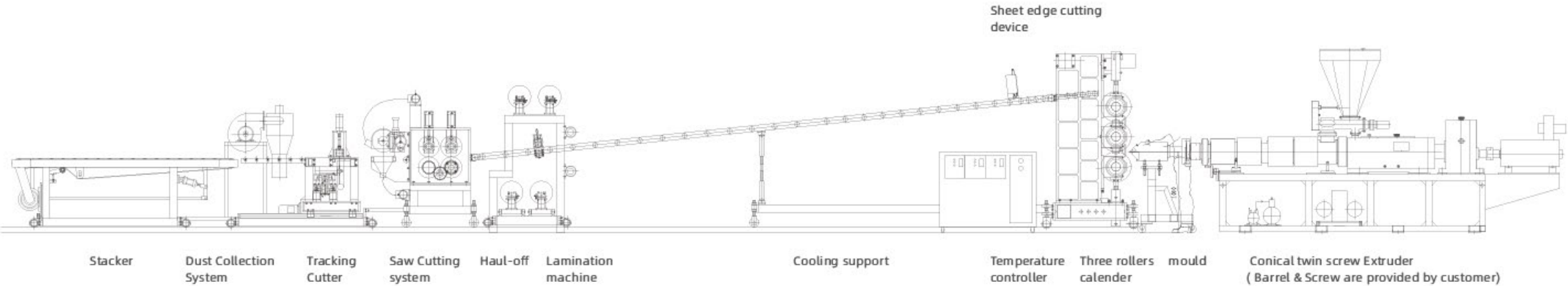
Used in the instrument widely, the part of the instrument, lamp and lanterns, decoration, construction material, the plane, auto fittings, medical equipments, arts, and crafts product, the insulating material of the electric apparatus, the sample, the sign and various light industry, culture and education, and daily life articles, etc.

PS Electricity Conductive Board

Mainly used for packing of semi-conductive electric components, computer products which requires no dust, not static electricity, no radio frequency, and it can be used for vacuum packing the food, medicines, hardwares, electronic products, toys and other products.

Applicable Scope Of PC Endurance Board

Garden ,the recreation place, decoration and the corridor pavilion; Internal and external ornaments in the commercial building, curtain wall of the modern urban building; transparent container of aviation, the windscreen before the motorcycle, the plane, the train, the steamer, the submarine, army and police's shield, the telephone booth, advertising signpost, the advertisement of the lamp houses, the expressway and overhead way of the city partition protective screen.



PP PE PS ABS SHEET EXTRUSION LINE

- ⦿ The screw was designed by special mixed material and high plastify, so that flux plastic, coloury, high output.
- ⦿ T-die was designed by special double throttle, it make sure sheet thickness more nicety.
- ⦿ Temperature control ± 1 , it will exactly control plastify process, sheet thickness.
- ⦿ Forming roller platform adopts vertical or 45 degree inclined collocation, which can lift up and down, it supplies more options in operations in operation for producing thick board thin board, and enhance quality of board.
- ⦿ Forming roller loop cooling system, matching with mould temperature controller to control temperature, which ensures even thickness of board.
- ⦿ Shearer can precisely cut the board.
- ⦿ Winder device, which adopts high grade torque motor, matching with four-axis automatic tension controlling, which can adjust speed and winding tension to get even surface for thin board, also with slitting device can set width of product as you want, we fix automatic meter counter which can set the length of product.



PE 63 (HDS 5 MPa) (discontinued)				PN2.5			PN3.2			PN 4			PN 5			PN 6.3			PN 8			PN 10			PN 12.5			PN 16		
PE 80 (HDS 6.3 MPa) (discontinued)				PN3.2			PN4			PN 5			PN 6.3			PN 8			PN 10			PN 12.5			PN 16			PN 20		
PE 100 (HDS 8 MPa)				PN4			PN5			PN 6.3			PN 8			PN 10			PN 12.5			PN 16			PN 16			PN 25		
Standard Diameter Ratio				SDR41			SDR33			SDR 26			SDR 21			SDR 17			SDR 13.6			SDR 11			SDR 9			SDR 7.4		
OD mm	Mean Outside Diameter		Ovality	Wall Thick- ness	Pipe ID & Mass		Wall Thick- ness	Pipe ID & Mass		Wall Thick- ness	Pipe ID & Mass		Wall Thick- ness	Pipe ID & Mass		Wall Thick- ness	Pipe ID & Mass		Wall Thick- ness	Pipe ID & Mass		Wall Thick- ness	Pipe ID & Mass		Wall Thick- ness	Pipe ID & Mass		Wall Thick- ness	Pipe ID & Mass	
	Min	Max	Max	Min	ID	kg/m	Min	ID	kg/m	Min	ID	kg/m	Min	ID	kg/m	Min	ID	kg/m	Min	ID	kg/m	Min	ID	kg/m	Min	ID	kg/m	Min	ID	kg/m
16	16	16,30	1,20																	1,60	12,64	0,07	2,00	11,80	0,09	2,30	11,17	0,10		
20	20	20,30	1,20													1,60	16,64	0,09	2,00	15,80	0,11	2,30	15,17	0,13	3,00	13,70	0,16			
25	25	25,30	1,20											1,60	21,64	0,12	2,00	20,80	0,14	2,30	20,17	0,16	3,00	18,70	0,21	3,50	17,65	0,24		
32	32	32,30	1,30							1,60	28,64	0,15	1,70	28,43	0,16	2,00	27,80	0,19	2,40	26,96	0,22	3,00	25,70	0,27	3,60	24,44	0,32	4,40	22,76	0,38
40	40	40,40	1,40							1,60	36,64	0,19	2,00	35,80	0,24	2,40	34,96	0,28	3,00	33,70	0,35	3,70	32,23	0,42	4,50	30,55	0,50	5,50	28,45	0,59
50	50	50,40	1,40	1,60	46,64	0,24	1,60	46,64	0,24	2,00	45,80	0,30	2,40	44,96	0,36	3,00	43,70	0,44	3,70	42,23	0,54	4,60	40,34	0,65	5,60	38,24	0,78	6,90	35,51	0,93
63	63	63,40	1,50	1,60	59,64	0,31	1,90	59,01	0,37	2,50	57,75	0,48	3,00	56,70	0,57	3,80	55,02	0,71	4,70	53,13	0,86	5,80	50,82	1,04	7,10	48,09	1,24	8,60	44,94	1,46
75	75	75,50	1,60	1,80	71,22	0,41	2,30	70,17	0,53	2,90	68,91	0,66	3,60	67,44	0,81	4,50	65,55	1,00	5,60	63,24	1,22	6,80	60,72	1,45	8,40	57,36	1,75	10,30	53,37	2,08
90	90	90,60	1,80	2,20	85,38	0,61	2,70	84,33	0,74	3,50	82,65	0,95	4,30	80,97	1,16	5,40	78,66	1,43	6,70	75,93	1,75	8,20	72,78	2,10	10,10	68,79	2,53	12,30	64,17	2,99
110	110	110,70	2,20	2,70	104,33	0,91	3,30	103,07	1,11	4,20	101,18	1,40	5,30	98,87	1,74	6,60	96,14	2,14	8,10	92,99	2,59	10,00	89,00	3,13	12,30	84,17	3,76	15,10	78,29	4,48
125	125	125,80	2,50	3,00	118,70	1,15	3,80	117,02	1,45	4,80	114,92	1,81	6,00	112,40	2,24	7,40	109,46	2,73	9,20	105,68	3,34	11,40	101,06	4,06	14,00	95,60	4,86	17,10	89,09	5,77
140	140	140,90	2,80	3,40	132,86	1,46	4,20	131,18	1,79	5,40	128,66	2,29	6,70	125,93	2,81	8,30	122,57	3,43	10,30	118,37	4,19	12,70	113,33	5,07	15,70	107,03	6,11	19,20	99,68	7,25
160	160	161,00	3,20	3,90	151,81	3,80	4,80	149,92	2,34	6,20	146,98	3,76	7,70	143,83	3,68	9,50	140,05	4,49	11,80	135,22	5,49	14,60	129,34	6,65	17,90	122,41	7,96	21,90	114,01	9,45
180	180	181,10	3,60	4,40	170,76	3,80	5,50	168,45	3,02	6,90	165,51	4,66	8,60	161,94	4,63	10,70	157,53	5,69	13,30	152,07	6,96	16,40	145,56	8,41	20,10	137,79	10,06	24,60	128,34	11,95
200	200	201,20	4,00	4,90	189,71	3,80	6,10	187,19	3,72	7,70	183,83	5,85	9,60	179,84	5,74	11,90	175,01	7,03	14,70	169,13	8,55	18,20	161,78	10,37	22,40	152,96	12,45	27,40	142,46	14,78
225	225	226,40	4,50	5,50	213,45	3,80	6,80	210,72	4,67	8,60	206,94	5,85	10,80	202,32	7,27	13,40	196,86	8,90	16,60	190,14	10,85	20,50	181,95	13,14	25,20	172,08	15,76	30,80	160,32	18,69
250	250	251,50	5,00	6,10	237,19	4,68	7,60	234,04	5,79	9,60	229,84	7,26	11,90	225,01	8,90	14,80	218,92	10,93	18,40	211,36	13,37	22,70	202,33	16,17	27,90	191,41	19,40	34,20	178,18	23,07
280	280	281,70	9,80	6,80	265,72	5,85	8,50	262,15	7,26	10,70	257,53	9,06	13,40	251,86	11,23	16,60	245,14	13,73	20,60	236,74	16,77	25,40	226,66	20,27	31,30	214,27	24,37	38,30	199,57	28,93
315	315	316,90	11,10	7,70	298,83	7,44	9,70	294,63	9,31	12,10	289,59	11,52	15,00	283,50	14,14	18,70	275,73	17,40	23,20	266,28	21,24	28,60	254,94	25,67	35,20	241,08	30,83	43,10	224,49	36,62
355	355	357,20	12,50	8,70	336,73	9,48	10,90	332,11	11,80	13,60	326,44	14,60	16,90	319,51	17,96	21,10	310,69	22,12	26,10	300,19	26,94	32,20	287,38	32,58	39,70	271,63	39,18	48,50	253,15	46,46
400	400	402,40	14,00	9,80	379,42	12,03	12,30	374,17	15,00	15,30	367,87	18,51	19,10	359,89	22,86	23,70	350,23	28,01	29,40	338,26	34,19	36,30	323,77	41,38	44,70	306,13	49,72	54,70	285,13	59,03
450	450	452,70	15,60	11,00	426,90	15,19	13,80	421,02	18,93	17,20	413,88	23,40	21,50	404,85	28,95	26,70	393,93	35,49	33,10	380,49	43,30	40,90	364,11	52,45	50,30	344,37	62,94	61,50	320,85	74,67
500	500	503,00	17,50	12,30	474,17	18,87	15,30	467,87	23,32	19,10	459,89	28,88	23,90	449,81	35,76	29,70	437,63	43,86	36,80	422,72	53,48	45,40	404,66	64,69	55,80	382,82	77,59			
560	560	563,40	19,60	13,70	531,23	23,55	17,20	523,88	29,36	21,40	515,06	36,24	26,70	503,93	44,74	33,20	490,28	54,92	41,20	473,48	67,07	50,80	453,32	81,08	62,50	428,75	97,34			
630	630	633,80	22,10	15,40	597,66	29,78	19,30	589,47	37,07	24,10	579,39	45,91	30,00	567,00	56,56	37,40	551,46	69,60	46,30	532,77	84,80	57,20	509,88	102,70	70,30	482,37	123,17			
710	710	716,40	See Note	17,40	673,46	37,92	21,80	664,22	47,19	27,20	652,88	58,39	33,90	638,81	72,02	42,10	621,59	88,30	52,20	600,38	107,74	64,50	574,55	130,50	79,30	543,47	156,57			
800	800	807,20	See Note	19,60	758,84	48,12	24,50	748,55	59,76	30,60	735,74	74,02	38,10	719,99	91,22	47,40	700,46	112,03	58,80	676,52	136,75	72,60	647,54	165,53	89,30	612,47	198,68			
900	900	908,10	See Note	22,00	853,80	60,77	27,60	842,04	75,73	34,40	827,76	93,62	42,90	809,91	115,54	53,30	788,07	141,72	66,20	760,98	173,19	81,70	728,43	209,56						
1000	1000	1009,00	See Note	24,50	948,55	75,20	30,60	935,74	93,30	38,20	919,78	115,51	47,70	899,83	142,74	59,30	875,47	175,18	72,50	847,75	211,01	90,20	810,58	257,24						

Note:For coiled pipe and for straight lengths with diameters≥710,the maximum out-of-roundness shall be agreed between manufacturer and purchaser.

Non-SANS specification

SANS specification

Standard Diameter Ratio	PN 6			PN 10		
	SDR 17.6			SDR 33		
OD mm	Wall Thickness	Pipe ID & Mass		Wall Thickness	Pipe ID & Mass	
	Min	ID	kg/m	Min	ID	kg/m
16	2,30	27,17	0,21	2,30	11,17	0,10
20	2,30	35,17	0,27	2,30	15,17	0,13
25	2,90	43,91	0,43	2,30	20,17	0,16
32	3,60	55,44	0,67	3,00	25,70	0,27
40	4,30	65,97	0,95	3,70	32,23	0,42
50	5,20	79,08	1,38	4,60	40,34	0,65
63	6,30	96,77	2,04	5,80	50,82	1,03
75	7,10	110,09	2,62	6,80	60,72	1,45
90	8,00	123,20	3,30	8,20	72,82	2,09
110	9,10	140,89	4,29	10,00	89,00	3,12
125	10,30	158,37	5,46	11,40	101,06,	4,04
140	11,40	176,06	6,72	12,70	113,33,	5,04
160	12,80	198,12	8,49	14,60	129,34	6,62
180	14,20	220,18	10,46	16,40	145,56	8,37
200	15,90	246,61	13,12	18,20	161,78	10,32
225	17,90	277,41	16,62	20,50	181,95	13,07
250	20,20	312,58	21,13	22,70	202,33	16,09
280	22,80	352,12	26,87	25,40	226,66	20,16
315	25,60	396,24	33,94	28,60	254,94	25,54
355	28,40	440,36	41,85	32,20	287,38	32,41
400	31,90	493,01	52,63	36,40	323,56	41,27
450	35,80	554,82	66,46	40,90	364,11	52,17
500				45,40	404,66	64,35
560				50,90	453,11	80,80
630				57,30	509,67	102,32