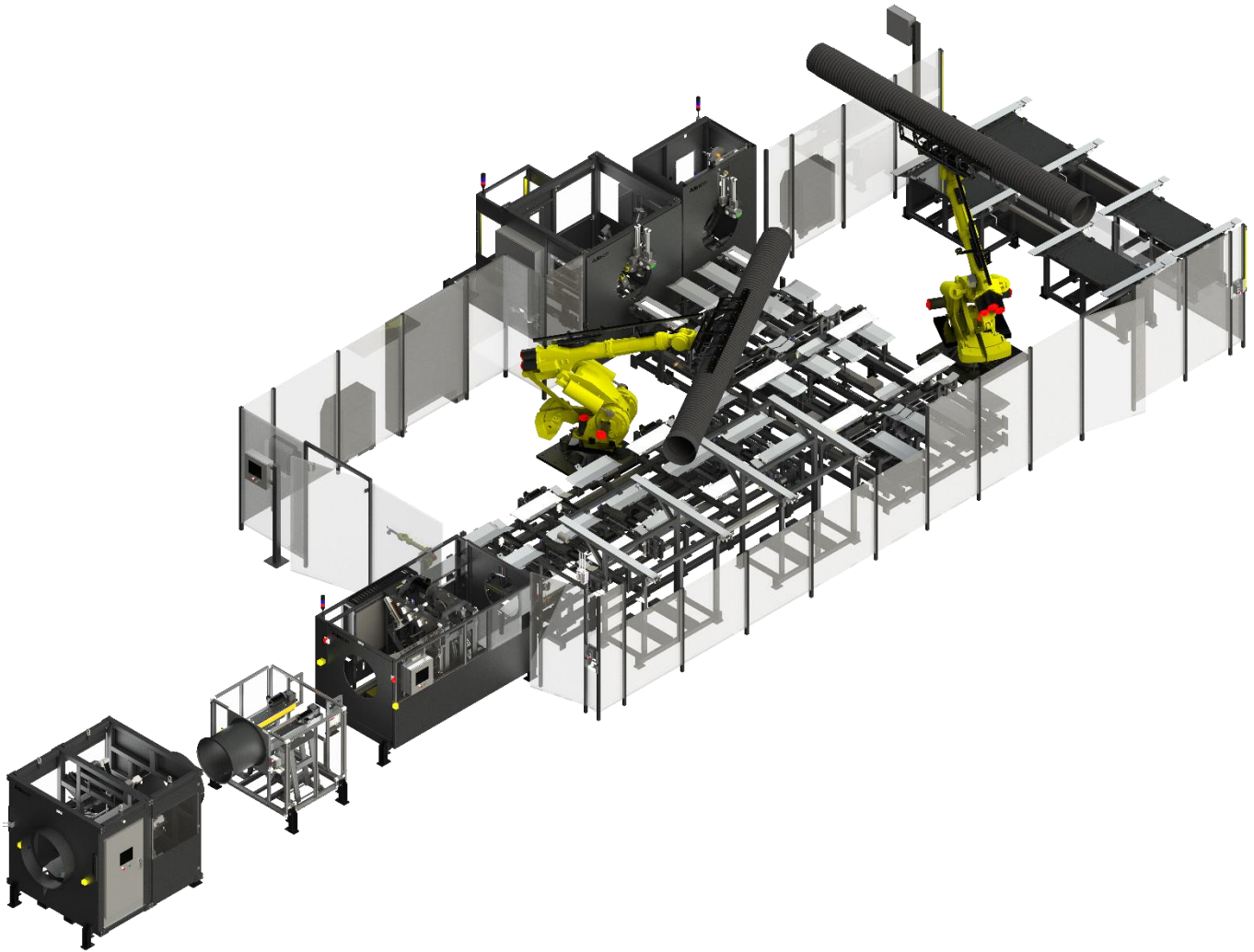


XFORM 418 SYSTEM



XFORM 418 SYSTEM

Pipe Size (ID)	Corr Speed with Bell (ft/min)	10' Cycle time (s)	20' Cycle time (s)	Corr Speed plain end (ft/min)	10' Cycle time (s)	20' Cycle time (s)
4"	44	13.6	27.3	49	12.2	24.5
6"	28	21.4	42.9	31	19.4	38.7
8"	18	33.3	66.7	20	30.0	60.0
10"	12	50.0	100.0	13	46.2	92.3
12"	10	60.0	120.0	11	54.5	109.1
15"	7	85.7	171.4	8	75.0	150.0
18"	5	120.0	240.0	6	100.0	200.0