

Indian Standard

SPECIFICATION FOR INJECTION MOULDED PVC SOCKET FITTINGS WITH SOLVENT CEMENT JOINTS FOR WATER SUPPLIES

PART 2 SPECIFIC REQUIREMENTS FOR 45° ELBOWS

(First Revision)

1. Scope — This standard (Part 2) lays down the requirements for manufacture, dimensions, tolerances and marking for 45° elbows made of injection moulded PVC for water supplies.

2. Requirements

2.1 General — The general requirements for material, manufacture, methods of test, sampling and inspection shall conform to IS : 7834 (Part 1)-1987 'Specification for injection moulded PVC socket fittings with solvent cement joints for water supplies: Part 1 General requirements (first revision)'.

2.2 Manufacture

2.2.1 A typical illustration of elbow is given in Fig. 1.

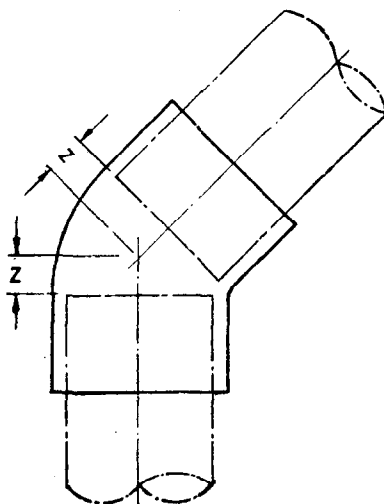


FIG. 1 45° Elbow

2.2.2 Laying Length — The laying length Z and the tolerance thereon shall comply with those given in Table 1.

2.2.3 The inside diameter of the socket and the socket length shall comply with those given in IS : 7834 (Part 1)-1987.

3. Marking — Each elbow fitting shall be marked with the following information:

- a) Manufacturer's name or identification mark, and
- b) Size of the fitting and the appropriate class (working pressure) to which the pressure rating of the fitting corresponds.

3.1 Standard Mark — Details available with the Bureau of Indian Standards.

TABLE 1 DIMENSIONS FOR LAYING LENGTHS OF 45° ELBOWS

(Clause 2.2.2; and Fig. 1)

Size mm	45° Elbow Laying Length, Z mm
16	4.5 ± 1
20	5 ± 1
25	6 + 1.2 - 1
32	7.5 + 1.6 - 1
40	9.5 + 2 - 1
50	11.5 + 2.5 - 1
63	14 + 3.2 - 1
75	16.5 + 4 - 1
90	19.5 + 5 - 1
110	23.5 + 6 - 1
125	27 + 6 - 1
140	30 + 7 - 1
160	34 + 8 - 1
180	38 + 8 - 1
200	43 + 9 - 1
225	48 + 10 - 1
250	53 + 11 - 1
280	60 + 12 - 1
315	67 + 13 - 1

EXPLANATORY NOTE

The requirements of injection moulded PVC socket fittings are covered in eight parts. The other parts are as follows:

- Part 1 General requirements
- Part 3 Specific requirements for 90° elbows
- Part 4 Specific requirements for 90° tees
- Part 5 Specific requirements for 45° tees
- Part 6 Specific requirements for sockets
- Part 7 Specific requirements for unions
- Part 8 Specific requirements for caps

This standard was first published in 1975 and covered sizes of fittings up to 160 mm. The present revision has been taken up to cover additional sizes of fittings up to 315 mm.