

Indian Standard

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

PART 3 SPECIFIC REQUIREMENTS FOR 90° ELBOWS

(First Revision)

1. **Scope** — This standard (Part 3) lays down the requirements for manufacture, dimension, tolerances and marking for 90° elbows made of injection moulded PVC 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 shown in Fig. 1.

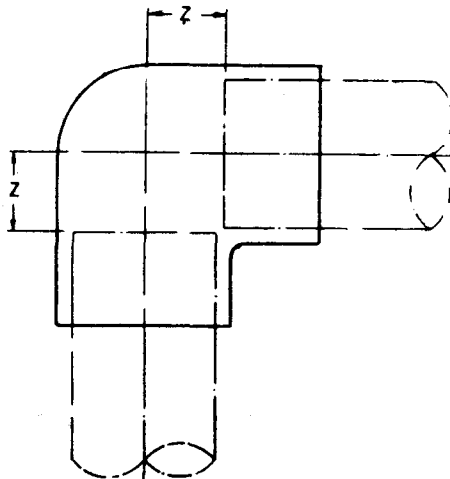


FIG. 1 99° ELBOW

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

2.2.2.1 There are several methods for providing the laying length. One such method is illustrated in Fig. 2.

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

3.1 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.

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

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TABLE 1 DIMENSIONS FOR LAYING LENGTH OF 90° ELBOWS

(Clause 2.2.2 and Fig. 1)

Size mm	90° Elbow Laying Length, Z mm
16	9 ± 1
20	11 ± 1
25	13.5 + 1.2 - 1
32	17 + 1.6 - 1
40	21 + 2 - 1
50	26 + 2.5 - 1
63	32.5 + 3.2 - 1
75	38.5 + 4 - 1
90	46 + 5 - 1
110	56 + 6 - 1
125	63.5 + 6 - 1
140	71 + 7 - 1
160	81 + 8 - 1
180	91 + 9 - 1
200	101 + 9 - 1
225	114 + 10 - 1
250	126 + 11 - 1
280	141 + 12 - 1
315	158.5 + 13 - 1

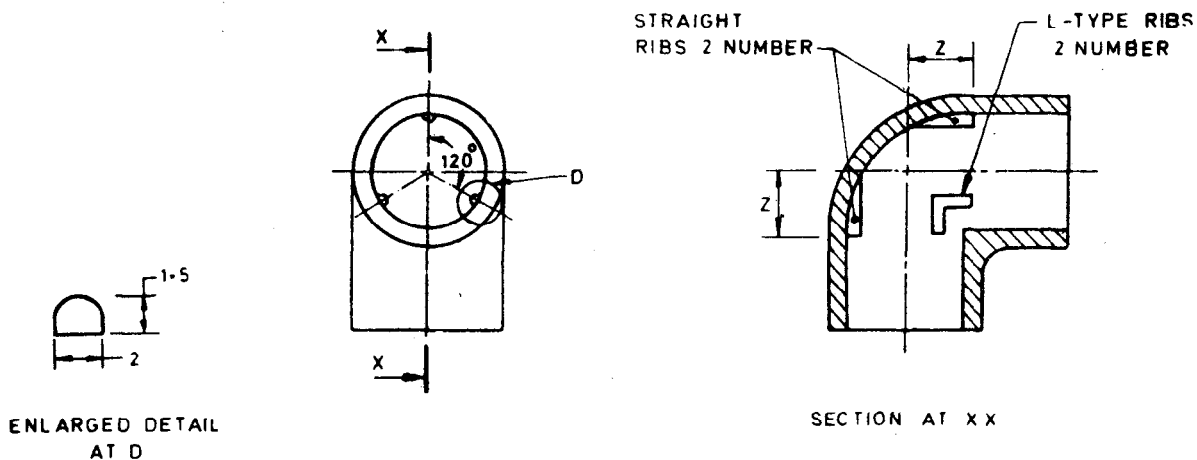


FIG. 2 METHOD OF PROVIDING LAYING LENGTH THROUGH PROVISION OF RIBS

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 2 Specific requirements for 45° 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.