

Indian Standard

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

PART 5 SPECIFIC REQUIREMENTS FOR 45° TEES

(First Revision)

1. Scope — This standard (Part 5) lays down the requirements for manufacture, dimensions, tolerances and marking for 45° tees 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 45° tee is shown in Fig. 1.

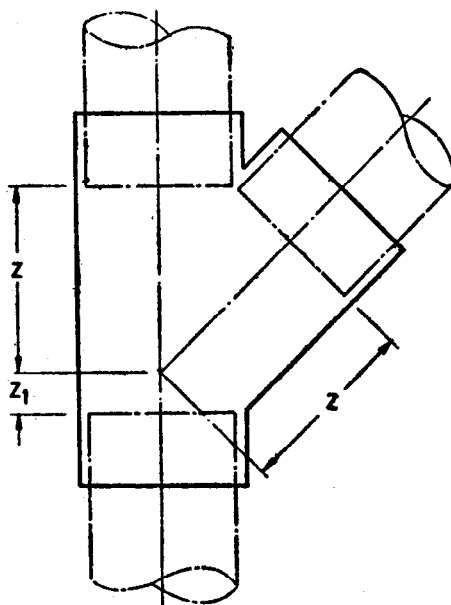


FIG. 1 45° TEE

2.2.2 Laying lengths — The laying lengths Z and Z_1 and the tolerance thereon shall comply with those given in Table 1 read with Fig. 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 tee 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 Marking — Details available with the Bureau of Indian Standards.

TABLE 1 DIMENSIONS FOR LAYING LENGTHS OF 45° TEES

(Clause 2.2.2 and Fig. 1)

Size mm	45° Tees Laying Length	
	Z mm	Z ₁ mm
16	—	—
20	27 ± 3	6 + 2 - 1
25	33 + 3	7 + 2 - 1
32	42 + 4 - 3	8 + 2 - 1
40	51 + 5 - 3	10 + 2 - 1
50	63 + 6 - 3	12 + 2 - 1
63	79 + 7 - 3	14 + 2 - 1
75	94 + 9 - 3	17 + 2 - 1
90	112 + 11 - 3	20 + 3 - 1
110	137 + 13 - 4	24 + 3 - 1
125	157 + 15 - 4	27 + 3 - 1
140	175 + 17 - 5	30 + 4 - 1
160	200 + 20 - 6	35 + 4 - 1

Note — Higher sizes of 45° elbow are not recommended by ISO also.

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 3 Specific requirements for 90° elbows
- Part 4 Specific requirements for 90° 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. Sizes up to 160 mm were covered. Higher sizes for 45° elbow are not recommended by ISO also. In the present revision, the dimensions for laying lengths for size 125 mm have been added.