

Indian Standard

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

PART 7 SPECIFIC REQUIREMENTS FOR UNIONS

(First Revision)

1. Scope — This standard (Part 7) laid down the requirements for manufacture, dimensions, tolerances and marking for union 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 requirement (*first revision*).

2.2 Manufacture

2.2.1 A typical illustration of union is shown in Fig. 1.

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

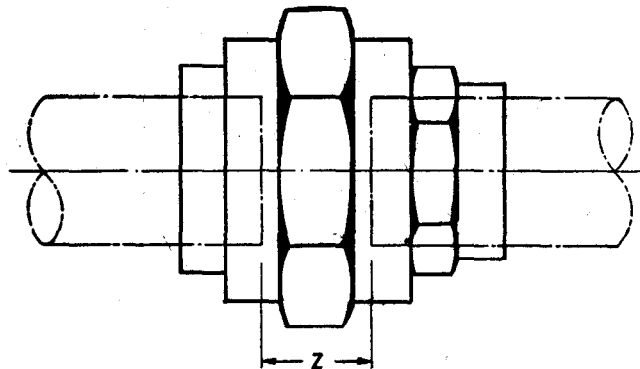


FIG. 1 UNION

TABLE 1 DIMENSIONS FOR LAYING LENGTH OF UNION

Size mm	Union Laying Length mm
16	13.5 ± 1
20	13.5 ± 1
25	$13.5 + 1.2$ - 1
32	$13.5 + 1.6$ - 1
40	$15 + 2$ - 1
50	$17 + 2.5$ - 1
63	$21 + 3.2$ - 1

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IS : 7834 (Part 7) - 1987

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

3. Marking — Each union 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.

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 5 Specific requirements for 45° tees
- Part 6 Specific requirements for sockets
- Part 8 Specific requirements for caps

This standard was first published in 1975. The present revision has been taken up to align the standard with revision of Part 1 of the standard.