



CD/K/110:2009
ICS 93.030; 91.140.80; 23.040.20; 23.040.45

EAST AFRICAN STANDARD

Plastics piping systems for non-pressure underground drainage and sewerage — Polypropylene (PP)

EAST AFRICAN COMMUNITY

Foreword

Development of the East African Standards has been necessitated by the need for harmonizing requirements governing quality of products and services in East Africa. It is envisaged that through harmonized standardization, trade barriers which are encountered when goods and services are exchanged within the Community will be removed.

In order to meet the above objectives, the EAC Partner States have enacted an East African Standardization, Quality Assurance, Metrology and Test Act, 2006 (EAC SQMT Act, 2006) to make provisions for ensuring standardization, quality assurance, metrology and testing of products produced or originating in a third country and traded in the Community in order to facilitate industrial development and trade as well as helping to protect the health and safety of society and the environment in the Community.

East African Standards are formulated in accordance with the procedures established by the East African Standards Committee. The East African Standards Committee is established under the provisions of Article 4 of the EAC SQMT Act, 2006. The Committee is composed of representatives of the National Standards Bodies in Partner States, together with the representatives from the private sectors and consumer organizations. Draft East African Standards are circulated to stakeholders through the National Standards Bodies in the Partner States. The comments received are discussed and incorporated before finalization of standards, in accordance with the procedures of the Community.

Article 15(1) of the EAC SQMT Act, 2006 provides that "Within six months of the declaration of an East African Standard, the Partner States shall adopt, without deviation from the approved text of the standard, the East African Standard as a national standard and withdraw any existing national standard with similar scope and purpose".

East African Standards are subject to review, to keep pace with technological advances. Users of the East African Standards are therefore expected to ensure that they always have the latest versions of the standards they are implementing.

© East African Community 2010 — All rights reserved*

East African Community

P O Box 1096

Arusha

Tanzania

Tel: 255 27 2504253/8

Fax: 255-27-2504481/2504255

E-Mail: eac@eachq.org

Web: www.each.int

* © 2010 EAC — All rights of exploitation in any form and by any means reserved worldwide for EAC Partner States' NSBs.

Introduction

In the preparation of this East African Standard, the following source was consulted extensively:

ISO 8773:2006, *Plastics piping systems for non-pressure underground drainage and sewerage — Polypropylene (PP)*

Assistance derived from this source and others inadvertently not mentioned is hereby acknowledged.

Draft for comments only — Not to be cited as East African Standard

**Plastics piping systems for non-pressure
underground drainage and sewerage —
Polypropylene (PP)**

*Systèmes de canalisations en plastique pour les branchements et les
collecteurs d'assainissement enterrés sans pression — Polypropylène
(PP)*



PDF disclaimer

This PDF file may contain embedded typefaces. In accordance with Adobe's licensing policy, this file may be printed or viewed but shall not be edited unless the typefaces which are embedded are licensed to and installed on the computer performing the editing. In downloading this file, parties accept therein the responsibility of not infringing Adobe's licensing policy. The ISO Central Secretariat accepts no liability in this area.

Adobe is a trademark of Adobe Systems Incorporated.

Details of the software products used to create this PDF file can be found in the General Info relative to the file; the PDF-creation parameters were optimized for printing. Every care has been taken to ensure that the file is suitable for use by ISO member bodies. In the unlikely event that a problem relating to it is found, please inform the Central Secretariat at the address given below.

© ISO 2006

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.org
Web www.iso.org

Published in Switzerland

Contents

Page

Foreword.....	iv
1 Scope	1
2 Normative references	1
3 Symbols and abbreviated terms	2
3.1 Symbols	2
3.2 Abbreviated terms	3
4 Material	3
4.1 Base material	3
4.2 Reprocessible and recyclable material	3
4.3 Melt mass-flow rate	3
4.4 Resistance to internal pressure of pipe material (long-term behaviour)	4
4.5 Resistance to internal pressure of fitting material (long-term behaviour)	4
4.6 Sealing ring retaining means	4
5 General characteristics	5
5.1 Appearance	5
5.2 Colour	5
6 Geometrical characteristics	5
6.1 General	5
6.2 Dimensions of pipes	5
6.3 Dimensions of fittings	8
6.4 Dimensions of sockets and spigots	9
6.5 Types of fittings	13
7 Mechanical characteristics	17
7.1 Mechanical characteristics of pipes	17
7.2 Additional mechanical characteristics	17
7.3 Mechanical characteristics of fittings	18
8 Physical characteristics	19
8.1 Physical characteristics of pipes	19
8.2 Physical characteristics of fittings	19
9 Performance requirements	20
10 Sealing rings	20
11 Marking	20
11.1 General	20
11.2 Minimum required marking of pipes	20
11.3 Minimum required marking of fittings	21
Bibliography	22

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 8773 was prepared by Technical Committee ISO/TC 138, *Plastics pipes, fittings and valves for the transport of fluids*, Subcommittee SC 1, *Plastics pipes and fittings for soil, waste and drainage (including land drainage)*.

This second edition cancels and replaces the first edition (ISO 8773:1991), which has been technically revised.

Plastics piping systems for non-pressure underground drainage and sewerage — Polypropylene (PP)

1 Scope

This International Standard specifies the requirements for polypropylene (PP) pipes, fittings and piping systems intended for use for non-pressure underground drainage and sewerage for the conveyance of soil and waste discharge of domestic and industrial origin, as well as surface water.

It covers buried pipework, as well as piping systems buried within the building structure.

In the case of industrial discharge, it is necessary that the chemical and temperature resistance be taken into account, but this will need to be done separately.

This International Standard is applicable to PP pipes with or without an integral socket and to jointing by means of push-fit joints with sealing rings or butt-fused joints.

NOTE 1 Fittings can be manufactured by injection-moulding or fabricated from pipes and/or mouldings.

This International Standard covers PP materials with normal E moduli and with higher E moduli, designated as HM (higher modulus), and gives a range of nominal sizes and pipe series, as well as recommendations concerning colours.

This International Standard also specifies the test parameters for the test methods referred to herein.

NOTE 2 PP materials with normal E moduli have an E modulus of between 1 250 MPa and 1 700 MPa. PP materials with higher E moduli (PP-HM materials) have an E modulus greater than or equal to 1 700 MPa.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 580:2005, *Plastics piping and ducting systems — Injection-moulded thermoplastics fittings — Methods for visually assessing the effects of heating*

ISO 1133:2005, *Plastics — Determination of the melt mass-flow rate (MFR) and the melt volume-flow rate (MVR) of thermoplastics*

ISO 1167-1, *Thermoplastics pipes, fittings and assemblies for the conveyance of fluids — Determination of the resistance to internal pressure — Part 1: General method*

ISO 1167-2, *Thermoplastics pipes, fittings and assemblies for the conveyance of fluids — Determination of the resistance to internal pressure — Part 2: Preparation of pipe test pieces*

ISO 2505:2005, *Thermoplastics pipes — Longitudinal reversion — Test method and parameters*

ISO 3126, *Plastics piping systems — Plastics components — Determination of dimensions*

ISO 3127, *Thermoplastics pipes — Determination of resistance to external blows — Round-the-clock method*

ISO 4065, *Thermoplastics pipes — Universal wall thickness table*

ISO 4435, *Plastics piping systems for non-pressure underground drainage and sewerage — Unplasticized poly(vinyl chloride) (PVC-U)*

ISO 9969, *Thermoplastics pipes — Determination of ring stiffness*

ISO 11173, *Thermoplastics pipes — Determination of resistance to external blows — Staircase method*

EN 1277:2003, *Plastics piping systems — Thermoplastics piping systems for buried non-pressure applications — Test method for leaktightness of elastomeric sealing ring type joints*

EN 1401-1, *Plastics piping systems for non-pressure underground drainage and sewerage — Unplasticized poly(vinyl chloride) (PVC-U) — Part 1: Specifications for pipes, fittings and the system*

EN 12061, *Plastics piping systems — Thermoplastics fittings — Test method for impact resistance*

EN 12256, *Plastics piping systems — Thermoplastics fittings — Test method for mechanical strength or flexibility of fabricated fittings*

3 Symbols and abbreviated terms

For the purposes of this document, the following symbols and abbreviated terms apply.

NOTE The symbols are illustrated in Figures 1 to 21.

3.1 Symbols

A	length of engagement
B	length of lead-in
C	depth of sealing zone
d_{em}	mean outside diameter
d_n	nominal outside diameter
d_{sm}	mean inside diameter of socket
d_3	internal diameter of groove
e	wall thickness
e_m	mean wall thickness
e_2	wall thickness of socket
e_3	wall thickness in groove area
f	groove width
H	length of chamfer

L	axial cover of saddle branch
L_1	length of spigot
l	effective length of pipe
M	length of plug spigot
R	radius of swept fittings
Z_d	design length (Z_d length)
α	nominal angle of fitting

3.2 Abbreviated terms

CT	close tolerance
DN	nominal size
DN/OD	nominal size, outside diameter-related
MFR	melt mass-flow rate
PP	polypropylene
PP-HM	polypropylene with high E modulus
S	pipe series S
SDR	standard dimension ratio
SN	nominal ring stiffness
TIR	true impact rate

4 Material

4.1 Base material

The base material shall be polypropylene (PP), to which are added those additives needed to facilitate the manufacture of components conforming to the requirements of this International Standard.

4.2 Reprocessable and recyclable material

In addition to virgin material, the use of reprocessable material obtained during the production and testing of products conforming to this International Standard is permitted. External reprocessable material and recyclable material shall not be used.

4.3 Melt mass-flow rate

Pipes and fittings shall be made from PP materials with an MFR of

$$\text{MFR (230/2,16)} \leq 1,5 \text{ g/10 min}$$

when tested in accordance with ISO 1133:2005, using conditions M (temperature: 230 °C; loading mass: 2,16 kg).

Materials for pipes and fittings for butt-fusion joints shall be designated by the following classes with regard to the MFR:

- Class A: MFR ≤ 0,3 g/10 min
- Class B: 0,3 g/10 min < MFR ≤ 0,6 g/10 min
- Class C: 0,6 g/10 min < MFR ≤ 0,9 g/10 min
- Class D: 0,9 g/10 min < MFR ≤ 1,5 g/10 min

Only pipes and fittings made from materials of the same or an adjacent MFR class may be fused together.

4.4 Resistance to internal pressure of pipe material (long-term behaviour)

When determined in accordance with the test method as specified in Table 1, using the indicated parameters, the pipe material shall have the characteristic conforming to the requirement given in Table 1.

The material shall be tested in the form of a pipe.

Table 1 — Material characteristics (long-term behaviour)

Characteristic	Requirement	Test parameters		Test methods
Resistance to internal pressure	No failure during the test period	End caps Test temperature Orientation Number of test pieces Circumferential (hoop) stress Conditioning period Type of test Test period	Type a or b 95 °C Free 3 2,5 MPa 1 h Water-in-water 1 000 h	ISO 1167-1 ISO 1167-2

4.5 Resistance to internal pressure of fitting material (long-term behaviour)

When determined in accordance with the test method as specified in Table 1, using the indicated parameters, the fitting material shall have characteristic conforming to the requirement given in Table 1.

The fitting material shall be tested, in its actual formulation, in the form of an extruded or injection-moulded pipe.

Fabricated fittings or parts of fabricated fittings shall be made from pipes conforming to this International Standard, except for requirements relating to wall thickness, and/or from mouldings of PP conforming to the material, mechanical and physical characteristics specified in this International Standard.

4.6 Sealing ring retaining means

Sealing rings may be retained using means made from polymers other than PP.

5 General characteristics

5.1 Appearance

When viewed without magnification, pipes and fittings shall meet the following requirements:

- the internal and external surfaces shall be smooth, clean and free from grooving, blistering, impurities, pores and any other surface irregularity likely to prevent conformity with this International Standard;
- pipe ends and fittings shall be cleanly cut and their ends shall be square to their axis.

5.2 Colour

The pipes and fittings shall be coloured through the whole wall.

The colour should preferably be orange-brown (approximately matching RAL 8023), black or dusty grey (approximately matching RAL 7037), see reference [1].

6 Geometrical characteristics

6.1 General

All dimensions shall be measured in accordance with ISO 3126.

The figures given in this International Standard are schematic sketches only, indicating the relevant dimensions. They do not necessarily represent manufactured components. The dimensions given shall be conformed with, however.

6.2 Dimensions of pipes

6.2.1 Outside diameter

The mean outside diameter, d_{em} , shall be in accordance with Table 2.

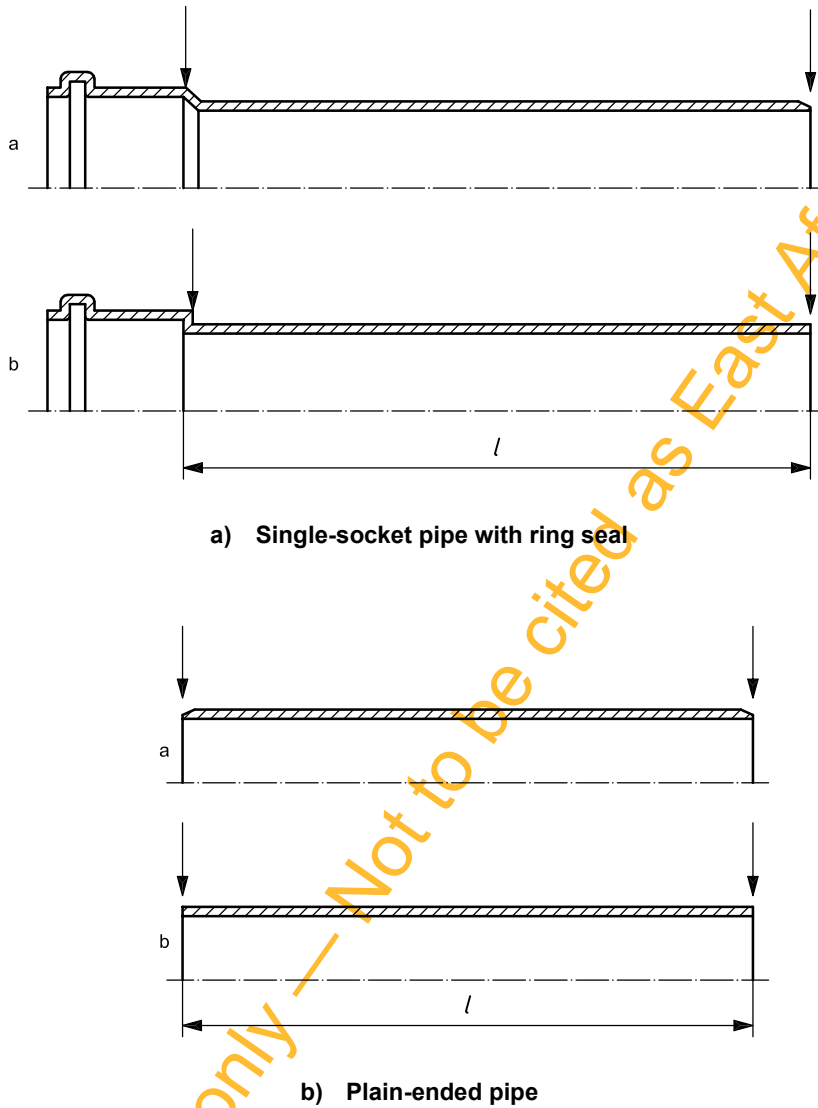
Table 2 — Mean outside diameters

Dimensions in millimetres

Nominal size DN/OD	Nominal outside diameter d_n	Mean outside diameter	
		$d_{em,min}$	$d_{em,max}$
110	110	110,0	110,4
125	125	125,0	125,4
160	160	160,0	160,5
200	200	200,0	200,6
250	250	250,0	250,8
315	315	315,0	316,0
355	355	355,0	358,2
400	400	400,0	403,6
450	450	450,0	454,1
500	500	500,0	504,5
630	630	630,0	635,6
800	800	800,0	807,2
1 000	1 000	1 000,0	1 009,0
1 200	1 200	1 200,0	1 210,0
1 400	1 400	1 400,0	1 410,0
1 600	1 600	1 600,0	1 610,0

6.2.2 Effective length of pipes

The effective length, l , of a pipe, shall be not less than that declared by the manufacturer when measured as shown in Figure 1.



Key

- l effective length of pipe
- a With chamfer.
- b Without chamfer.

Figure 1 — Effective length of pipes

6.2.3 Chamfering

If a chamfer is applied, the angle of chamfering shall be between 15° and 45° to the axis of the pipe (see Figure 1 or Figure 2, as applicable).

The remaining wall thickness of the end of the pipe shall be at least one-third of e_{min} .

6.2.4 Wall thicknesses

The wall thickness, e , shall be in accordance with Table 3, where a maximum wall thickness at any point of $1,25e_{\min}$ is permitted, provided that the mean wall thickness, e_m , is less than or equal to the specified $e_{m,\max}$.

Table 3 — Wall thicknesses

Dimensions in millimetres

Nominal size DN/OD	Nominal outside diameter d_n	Wall thickness							
		PP with normal E modulus						PP-HM	
		SN 2 ^a SDR 41 ^c		SN 4 SDR 33 ^c		SN 8 SDR 23,4 ^c		SN 8 SDR 27,6 ^c	
e_{\min} ^b	$e_{m,\max}$	e_{\min} ^b	$e_{m,\max}$	e_{\min} ^b	$e_{m,\max}$	e_{\min} ^b	$e_{m,\max}$		
110	110	—	—	3,4	4,0	4,7	5,4	4,0	4,6
125	125	—	—	3,9	4,5	5,4	6,2	4,6	5,3
160	160	3,9	4,5	4,9	5,6	6,9	7,8	5,8	6,6
200	200	4,9	5,6	6,2	7,1	8,6	9,7	7,3	8,3
250	250	6,2	7,1	7,7	8,7	10,7	12,0	9,1	10,3
315	315	7,7	8,7	9,7	10,9	13,5	15,1	11,4	12,8
355	355	8,7	9,8	10,9	12,3	15,2	17,0	12,9	14,4
400	400	9,8	11,0	12,3	13,8	17,1	19,1	14,5	16,2
450	450	11,0	12,3	13,8	15,4	19,2	21,4	16,3	18,2
500	500	12,3	13,8	15,3	17,1	21,4	23,8	18,1	20,3
630	630	15,4	17,2	19,3	21,5	26,9	29,8	22,8	25,3
800	800	19,6	21,8	24,5	27,2	34,2	37,9	29,0	32,1
1 000	1 000	24,5	27,2	30,6	33,9	42,7	47,9	36,2	40,0
1 200	1 200	29,4	32,6	36,7	40,6	51,2	56,6	43,4	47,8
1 400	1 400	34,3	38,0	42,9	47,4	59,8	66,0	50,6	55,8
1 600	1 600	39,2	43,4	49,0	54,1	68,3	75,4	57,9	62,8

NOTE For components conforming to this International Standard, the standard dimension ratio, SDR, and the values of the pipe series S specified in this table are calculated from the equation $SDR = 2S + 1$ and are related as follows:

SDR 41 corresponds to S 20;

SDR 33 corresponds to S 16;

SDR 27,6 corresponds to S 13,3;

SDR 23,4 corresponds to S 11,2.

^a SN 2 is applicable for buried installations outside the building structure only. Respect the verifications to be carried out for the structural design of the piping and the installation conditions.

^b The e_{\min} values are according to ISO 4065.

^c The standard dimension ratios (SDR) are defined in ISO 4065.

6.3 Dimensions of fittings

6.3.1 Outside diameter

The mean outside diameter, d_{em} , of the spigot shall conform to Table 2 or to Table 4, as applicable.

6.3.2 Outside diameter for spigots with close tolerances (Type CT)

For the purposes of this International Standard, in addition to the dimensions and tolerances given in Table 2 for spigot ends of fittings, tolerances that are in accordance with EN 1401-1 are permitted.

If these tolerances, classified as close tolerances (CT), are required, the mean outside diameter, d_{em} , of the pipe and spigot, as well as the tolerances, shall be in accordance with Table 4.

Table 4 — Mean outside diameters for spigots with close tolerances type CT

Dimensions in millimetres

Nominal size DN/OD	Nominal outside diameter d_n	Mean outside diameter	
		$d_{em,min}$	$d_{em,max}$
200	200	200,0	200,5
250	250	250,0	250,5
315	315	315,0	315,6
355	355	355,0	355,7
400	400	400,0	400,7
450	450	450,0	450,8
500	500	500,0	500,9
630	630	630,0	631,1

Spigot ends of fittings with mean outside diameters in accordance with this table may be used with pipes and fittings conforming to ISO 4435, provided that the socket(s) for these pipes and fittings are intended for use with elastomeric ring seal joints.

NOTE Spigot ends of fittings with mean outside diameters in accordance with this table are normally injection-moulded or machined.

6.3.3 Design length

The design length, Z_d , shall be declared by the manufacturer.

NOTE 1 The design lengths of a fitting (see the dimension Z_d in Figures 7 to 11, Figures 14 to 19 and Figure 21) are intended to assist in the design of moulds and are not intended for quality control purposes.

NOTE 2 ISO 265-1 can be used as a guideline.

6.3.4 Wall thickness

The minimum wall thickness, e_{min} , of the body or the spigot of a fitting shall be in accordance with Table 3, except that a reduction of 5 % resulting from core shift is permitted. In that case, the average of two opposite wall thicknesses shall be greater than or equal to the values given in Table 3.

Where a fitting or adaptor provides for a transition between two nominal sizes, the wall thickness of each connecting part shall conform to the requirements for the applicable nominal size. In that case, the wall thickness of the fitting body is permitted to change gradually from one wall thickness to the other.

The wall thickness of fabricated fittings, except for spigot end and socket, may be changed locally by the fabrication process, provided that the minimum wall thickness of the body conforms to $e_{3,min}$ as given in Table 6 for the size and pipe series concerned.

6.4 Dimensions of sockets and spigots

6.4.1 Elastomeric ring seal sockets and spigots

6.4.1.1 Diameter and length

The diameters and lengths of elastomeric ring seal sockets and lengths of spigots shall conform to Table 5 (see Figures 2, 3, 4 or 5, as applicable).

Where sealing rings are firmly retained, the dimensions for the minimum value for A and the maximum value for C shall be measured to the effective sealing point (see Figure 4) as specified by the manufacturer. This point shall give a full sealing action.

Different designs of elastomeric ring seal sockets are permitted, provided the joints conform to the requirements given in Table 12.

Table 5 — Socket diameters and lengths of sockets and spigots

Dimensions in millimetres

Nominal size DN/OD	Nominal outside diameter d_n	Socket			Spigot $L_{1,min}$
		$d_{sm,min}$	A_{min}^a	C_{max}^b	
110	110	110,4	40	22	62
125	125	125,4	43	26	68
160	160	160,5	50	32	82
200	200	200,6	58	40	98
250	250	252,4	68	50	118
315	315	318,0	81	63	144
355	355	358,3	85	71	160
400	400	403,7	98	80	178
450	450	454,2	108	90	198
500	500	504,6	118	100	218
630	630	635,8	144	126	270

^a The socket is designed for an effective length of pipe of 6 m.

^b Higher values for C are allowed. In that case, the actual required $L_{1,min}$, according to the equation $L_{1,min} = A_{min} + C$, shall be stated in the manufacturer's documentation.

For sockets and spigots that have a nominal outside diameter greater than 630 mm, the values of $d_{sm,min}$, A_{min} and C_{max} , expressed in millimetres, shall be calculated using the following equations:

$$d_{sm,min} = 1,009 2 d_n;$$

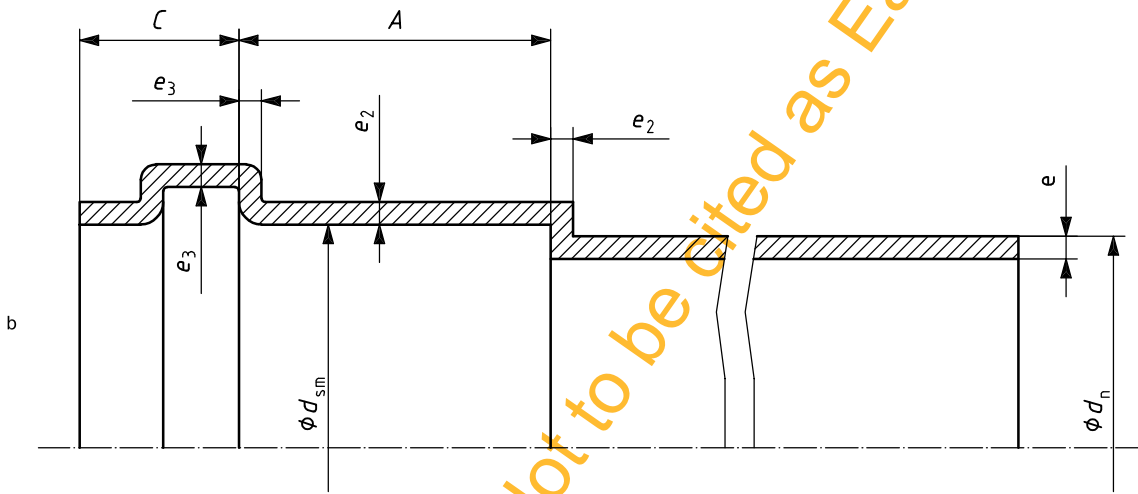
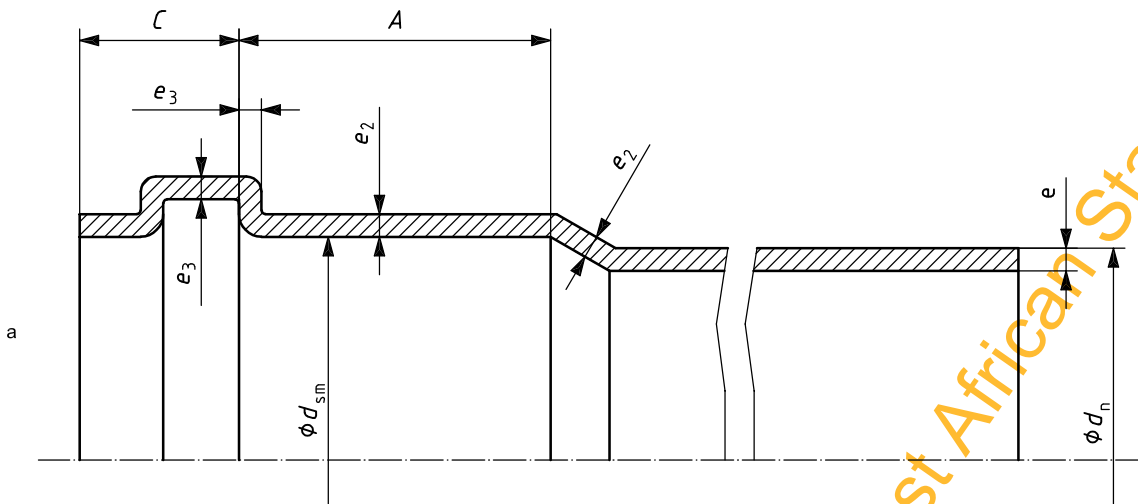
$$A_{min} = 0,2 d_n + 18;$$

$$C_{max} = 0,2 d_n.$$

For pipe lengths longer than 6 m, the length of engagement, A , in the socket, expressed in millimetres, shall be calculated from the equation:

$$A = 0,2 d_n + 3 l$$

where l is the pipe length, in metres.



- a Ring seal socket with chamfer.
- b Ring seal socket without chamfer.

Figure 2 — Dimensions of sockets for elastomeric ring seal joints

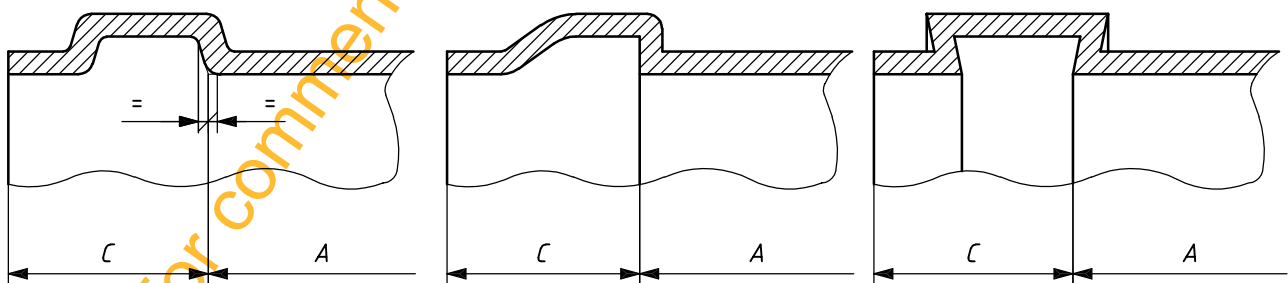


Figure 3 — Typical groove designs for elastomeric ring seal sockets

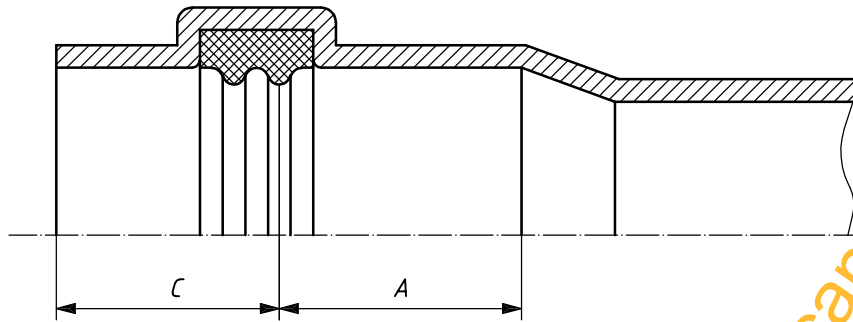


Figure 4 — Example for measuring effective sealing point

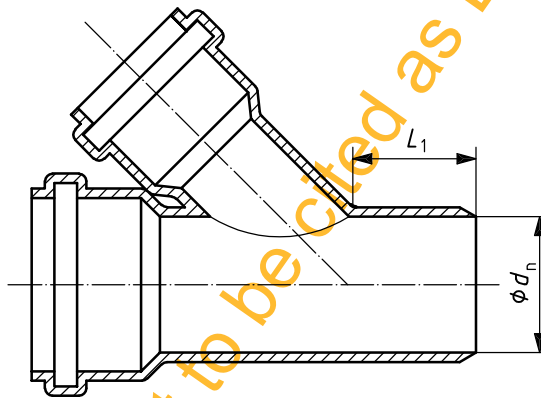


Figure 5 — Spigot lengths

6.4.1.2 Wall thickness of sockets

The wall thicknesses of sockets, e_2 and e_3 (see Figure 2), except the socket mouth, shall be in accordance with Table 6.

A reduction of 5 % of e_2 and e_3 resulting from core shift is permitted. In that case, the average of two opposite wall thicknesses shall be greater than or equal to the applicable values given in Table 6.

Table 6 — Wall thicknesses of sockets

Dimensions in millimetres

Nominal size DN/OD	Nominal outside diameter d_n	Wall thickness							
		SN 2 ^a SDR 41 ^b		SN 4 SDR 33 ^b		SN 8 SDR 23,4 ^b		SN 8 SDR 27,6 ^b	
		$e_{2,min}$	$e_{3,min}$	$e_{2,min}$	$e_{3,min}$	$e_{2,min}$	$e_{3,min}$	$e_{2,min}$	$e_{3,min}$
110	110	—	—	3,1	2,6	4,3	3,6	3,6	3,0
125	125	—	—	3,6	3,0	4,9	4,1	4,1	3,5
160	160	3,5	3,0	4,5	3,7	6,3	5,2	5,2	4,4
200	200	4,4	3,7	5,6	4,7	7,8	6,5	6,6	5,5
250	250	5,6	4,7	7,0	5,8	9,7	8,1	8,2	6,8
315	315	6,9	5,8	8,8	7,3	12,2	10,2	10,3	8,6
355	355	7,8	6,5	9,9	8,2	13,7	11,4	11,6	9,7
≥ 400	≥ 400	8,8	7,4	11,1	9,3	15,4	12,9	13,1	10,9

^a SN 2 is applicable for buried installations outside the building structure only. Respect the verifications to be carried out for the structural design of the piping and the installation conditions.

^b The standard dimension ratios (SDR) are defined in ISO 4065.

Where a sealing ring is located by means of a retaining cap or ring (see Figure 6), the wall thickness in this area shall be calculated by the addition of the wall thickness of the socket and the wall thickness of the retaining ring or cap at corresponding places in the same cross-section plane.

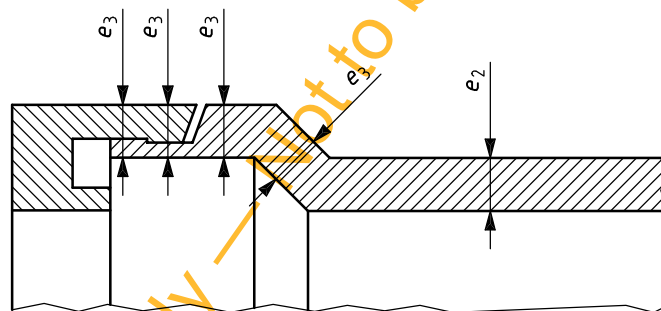


Figure 6 — Example for calculation of wall thickness of sockets with retaining cap

6.4.2 Butt-fusion spigot ends

The mean outside diameter, d_{em} , and wall thickness, e , of spigots intended for butt-fusion shall conform to the diameters and corresponding pipe size and series as given in Tables 2 and 3, respectively.

6.5 Types of fittings

This International Standard is applicable to the following generic types of fittings. Other designs of fitting are permitted.

a) Bends (see Figures 7, 8, 9, 10 or 11):

- unswept and swept angle (see ISO 265-1);
- spigot/socket and socket/socket;
- butt-fused from segments;
- heat formed without socket/with socket butt-fused on.

The nominal angle, α , may be selected from the following: 15°, 30°, 45° and 87°30' to 90°.

b) Couplers and slip couplers (see Figures 12 and 13).

c) Reducers (see Figure 14).

d) Branches and reducing branches (see Figures 15, 16, 17 or 18):

- unswept and swept angle (see ISO 265-1);
- spigot/socket and socket/socket.

The nominal angle, α , may be selected from the following: 45° and 87°30' to 90°.

e) Branches with flange and collar (see Figure 19).

f) Plugs (see Figure 20):

- minimum length of spigot, $M = (C_{\max} + 10)$ mm (see Table 4).

g) Push-fit sockets for butt-fusion pipe end (see Figure 21).

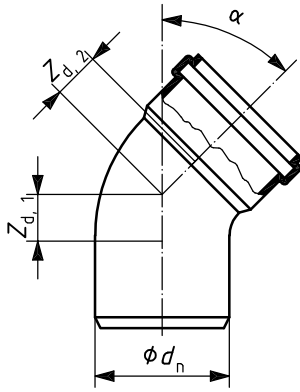


Figure 7 — Bend with single socket (unswept)

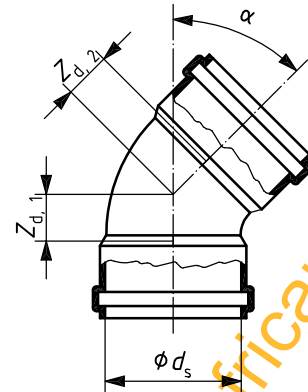


Figure 8 — Bend with all sockets (unswept)

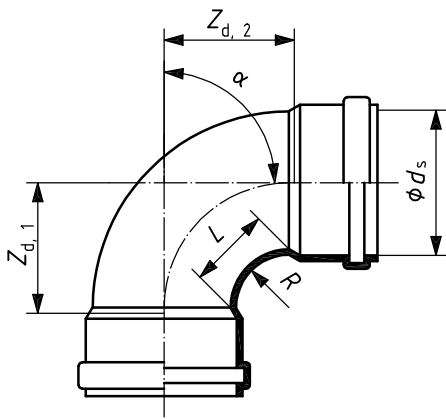


Figure 9 — Bend with all sockets (swept)

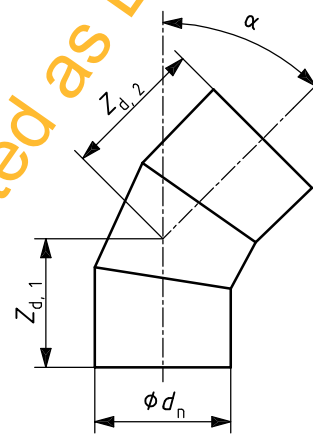


Figure 10 — Bend for butt-fusion, butt-fused from segments

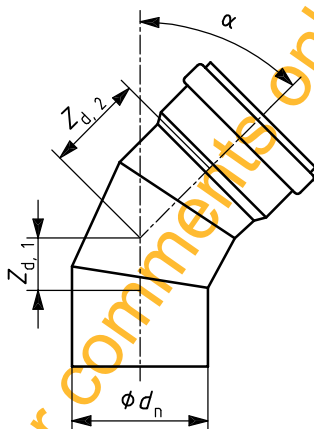


Figure 11 — Bend with socket and spigot end, butt-fused from segments

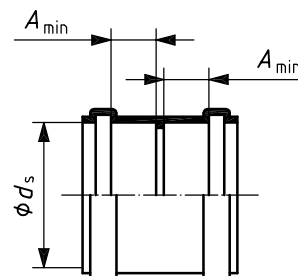


Figure 12 — Coupler

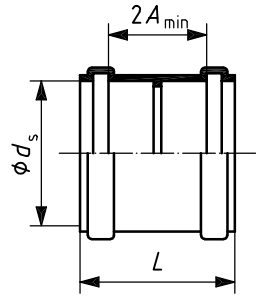


Figure 13 — Slip coupler

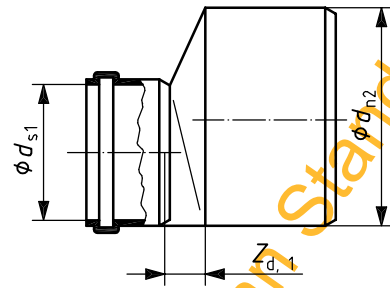


Figure 14 — Reducer

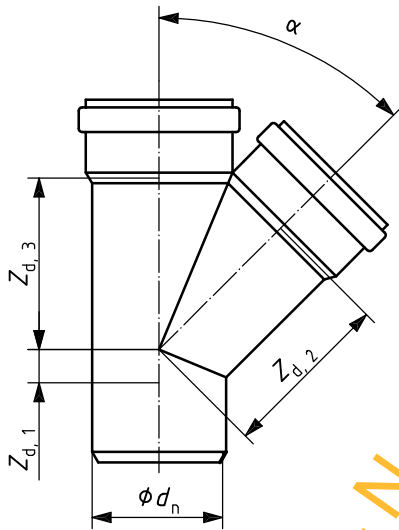


Figure 15 — Branch (unswept)

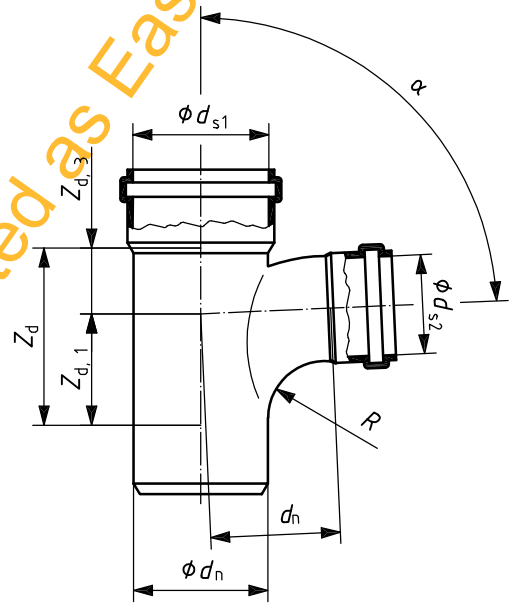


Figure 16 — Reducing branch (swept)

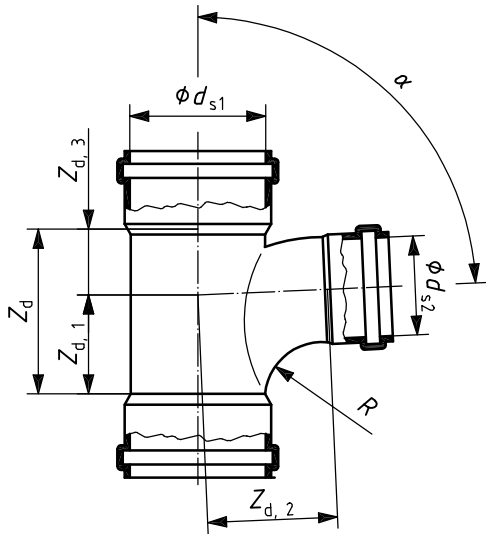


Figure 17 — All-socket reducing branch (swept)

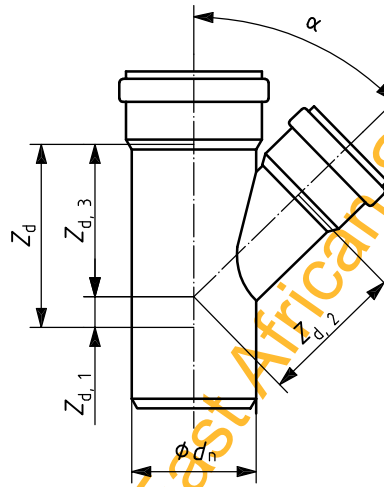


Figure 18 — Reducing branch

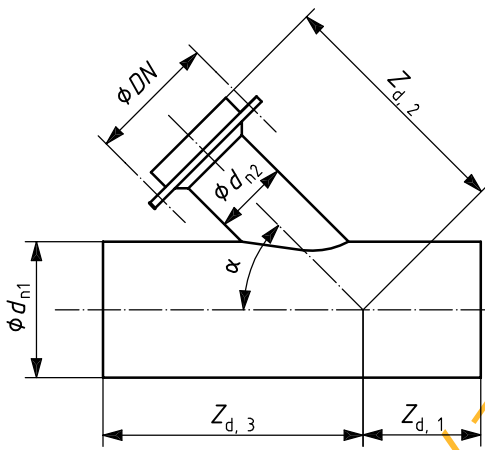


Figure 19 — Branch for butt-fusion with flange and collar

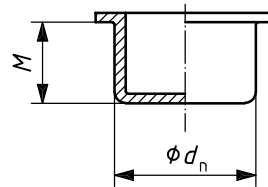


Figure 20 — Plug

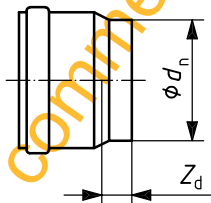


Figure 21 — Push-fit socket for butt-fusion to pipe end

7 Mechanical characteristics

7.1 Mechanical characteristics of pipes

When determined in accordance with the test methods as specified in Table 7 using the indicated parameters, the pipe shall have mechanical characteristics conforming to the requirements given in Table 7.

Table 7 — Mechanical characteristics of pipes

Characteristic	Requirements	Test parameters		Test method
Ring stiffness	SDR 41: $\geq 2 \text{ kN/m}^2$ SDR 33: $\geq 4 \text{ kN/m}^2$ SDR 27,6: $\geq 8 \text{ kN/m}^2$ SDR 23,4: $\geq 8 \text{ kN/m}^2$	Test temperature Deflection Deflection speed for: 110 mm $< d_n \leq 200$ mm 200 mm $< d_n \leq 400$ mm 400 mm $< d_n \leq 800$ mm $d_n > 800$ mm Tolerance on test speed	$(23 \pm 2) ^\circ\text{C}$ 3 % 5 mm/min 10 mm/min 20 mm/min $0,03d_i^a$ mm/min ± 5 %	ISO 9969
Impact resistance (round-the-clock method)	$\text{TIR} \leq 10 \%$	Test/conditioning temperature Conditioning medium Type of striker Mass of striker for: $d_n = 110$ mm $d_n = 125$ mm $d_n = 160$ mm $d_n = 200$ mm $d_n = 250$ mm $d_n \geq 315$ mm Drop height of striker for: $d_n = 110$ mm $d_n \geq 125$ mm	$0 ^\circ\text{C}$ Water or air d 90 1,0 kg 1,25 kg 1,6 kg 2,0 kg 2,5 kg 3,2 kg 1 600 mm 2 000 mm	ISO 3127
^a d_i is determined according to ISO 9969.				

7.2 Additional mechanical characteristics

Pipes intended to be used in areas where installation is usually carried out at temperatures below $-10 ^\circ\text{C}$ shall additionally be subjected to, and conform with the requirements of, an impact test (staircase method) in accordance with Table 8.

The pipes shall be marked in accordance with Table 13 with one ice crystal.

Table 8 — Additional mechanical characteristics of pipes

Characteristic	Requirement	Test parameters		Test method
Impact resistance (staircase method)	$H_{50} \geq 1$ m Maximum 1 break below 0,5 m	Test/conditioning temperature	- 10 °C	ISO 11173
		Type of striker	d 90	
		Mass of striker for:		
		$d_n = 110$ mm	4,0 kg	
		$d_n = 125$ mm	5,0 kg	
		$d_n = 140$ mm	6,3 kg	
		$d_n = 160$ mm	8,0 kg	
		$d_n = 180$ mm	8,0 kg	
		$d_n = 200$ mm	10,0 kg	
		$d_n = 250$ mm	12,5 kg	

7.3 Mechanical characteristics of fittings

When determined in accordance with the test methods as specified in Table 9 using the indicated parameters, the fitting shall have mechanical characteristics conforming to the requirements given in Table 9.

Table 9 — Mechanical characteristics of fittings

Characteristic	Requirement	Test parameters		Test method
Flexibility or mechanical strength ^a	No sign of splitting, cracking, separation and/or leakage	Test period	15 min	ISO 12256
		Minimum displacement ^b	170 mm	
		Minimum moment ^b for:		
		[DN] ≤ 250	$0,15 \times [DN]^3 \times 10^{-6}$ kN·m	
		[DN] > 250	$0,01 \times [DN]$ kN·m	
Impact strength (drop test)	No damage	Conditioning and test temperature	0 °C	EN 12061
		Drop height for:		
		$d_n = 110$ mm	1 000 mm	
		$d_n = 160$ mm	1 000 mm	
		$d_n = 200$ mm	500 mm	
		$d_n = 250$ mm	500 mm	
		Point of impact	Mouth of socket	
^a Only for fabricated fittings made from more than one piece. A sealing ring retaining means is not considered as a piece. ^b Choose between minimum displacement and minimum moment, as applicable.				

8 Physical characteristics

8.1 Physical characteristics of pipes

When determined in accordance with the test methods as specified in Table 10 using the indicated parameters, the pipe shall have physical characteristics conforming to the requirements given in Table 10.

Table 10 — Physical characteristics of pipes

Characteristic	Requirement	Test parameters		Test method	
Longitudinal reversion	$\leq 2\%$ The pipe shall exhibit no bubbles or cracks	Test temperature	150 °C	ISO 2505:2005, Method A (liquid) ^a	
		Immersion time for:			
		$e \leq 8$ mm	15 min		
		$e > 8$ mm	30 min		
Longitudinal reversion	$\leq 2\%$ The pipe shall exhibit no bubbles or cracks	Test temperature	150 °C	ISO 2505:2005, Method B (air) ^a	
		Immersion time for:			
		$e \leq 4$ mm	30 min		
		4 mm $< e \leq 16$ mm	60 min		
		$e > 16$ mm	120 min		

^a Choose either Method A or Method B and its corresponding parameters, as applicable.

8.2 Physical characteristics of fittings

When determined in accordance with the test method as specified in Table 11 using the indicated parameters, the fitting or mouldings used for fabricated fittings shall have physical characteristics conforming to the requirements given in Table 11.

For fittings manufactured from pipes, the pipes used for such fabricating shall conform to the requirements given in Tables 7 and 10.

Table 11 — Physical characteristics of fittings

Characteristic	Requirement	Test parameters		Test method
Effects of heating ^a	The depth of cracks, delamination or blisters shall not be more than 20 % of the wall thickness around the injection point(s). No part of the weld line shall open to a depth more than 20 % of the wall thickness.	Test temperature	150 °C	ISO 580:2005, Method A (air oven) ^a
		Heating time for:		
		$e \leq 10$ mm	30 min	
		$e > 10$ mm	60 min	

^a Mouldings used for fabricated fittings may be tested individually.

9 Performance requirements

When determined in accordance with the test methods as specified in Table 12 using the indicated parameters, the fitness-for-purpose characteristics of the joints and system shall conform to the requirements given in Table 12.

Table 12 — Fitness-for-purpose characteristics of system

Characteristic	Requirement	Test parameters		Test method
Tightness of elastomeric sealing ring joints and electrofusion joints		Test temperature	(23 ± 5) °C	EN 1277:2003, condition B
		Spigot deflection	10 %	
		Socket deflection	5 %	
	No leakage	Water pressure	5 kPa (0,05 bar)	
	No leakage	Water pressure	50 kPa (0,5 bar)	EN 1277:2003, condition D
	≤ - 27 kPa (- 0,27 bar)	Air pressure	- 30 kPa (- 0,3 bar)	
		Test temperature	(23 ± 5) °C	
		Angular deflection for:		
		$d_n \leq 315$ mm	2°	
		$315 \text{ mm} \leq d_n \leq 630$ mm	1,5°	
	$d_n > 630$ mm	1°		
No leakage	Water pressure	5 kPa (0,05 bar)		
No leakage	Water pressure	50 kPa (0,5 bar)		
≤ - 27 kPa (- 0,27 bar)	Air pressure	- 30 kPa (- 0,3 bar)		

10 Sealing rings

Sealing rings shall not have any detrimental effects on the properties of the pipe or fitting and shall not cause the test assembly to fail to conform to the requirements of Table 12.

For further requirements for rubber sealing rings for drainage purpose, see ISO 4633.

11 Marking

11.1 General

Marking elements shall be labelled or printed or formed directly on the pipe or fitting and/or labelled or printed on the packaging.

Marking on a pipe or fitting shall not initiate cracks or other types of defects likely to prevent conformity to the requirements of this International Standard.

11.2 Minimum required marking of pipes

The minimum required marking of pipes shall be in accordance with Table 13.

Pipes shall be marked at intervals of maximum 1 m, at least once per pipe.

Table 13 — Minimum required marking of pipes

Information	Marking or symbol
Number of this International Standard	ISO 8773
Manufacturer's name and/or trademark	XXX
Nominal size	e.g. DN 200
Minimum wall thickness or SDR series	e.g. 6,2 or SDR 33
Nominal ring stiffness	e.g. SN 4
Material	PP or PP-HM, as applicable
Symbol for close tolerance on pipe diameter, when applicable	CT
Manufacturer's information	^a
Cold climate performance ^b	❄ (one ice crystal)
MFR class ^c	e.g. MFR-B
^a To ensure traceability, the following details shall be given: <ul style="list-style-type: none"> — the production period (year and month), in figures or in code; — a name or code for the production site if the manufacturer is producing in different sites. ^b This marking is only applicable to pipes which are proved by testing to be in accordance with 7.1. ^c Marking only required for pipe intended for butt-fusion joints.	

11.3 Minimum required marking of fittings

The minimum required marking of fittings shall be in accordance with Table 14.

Table 14 — Minimum required marking of fittings

Information	Marking or symbol
Number of this International Standard	ISO 8773
Manufacturer's name and/or trademark	XXX
Nominal size	e.g. 200
Nominal angle	e.g. 45°
Minimum wall thickness or SDR series	e.g. 6,2 or SDR 33
Material	PP
Symbol for close tolerance on outside spigot diameter, when applicable	CT
Manufacturer's information	^a
MFR class ^b	e.g. MFR-B
^a To ensure traceability, the following details shall be given: <ul style="list-style-type: none"> — the production period (year and month), in figures or in code; — a name or code for the production site if the manufacturer is producing in different sites. ^b Marking only required for pipe intended for butt-fusion joints	

Bibliography

- [1] RAL 840 — HR, *Colour register*¹⁾
- [2] EN 1852-1, *Plastics piping systems for non-pressure underground drainage and sewerage — Polypropylene (PP) — Part 1: Specifications for pipes, fittings and the system*
- [3] ISO 265-1, *Pipes and fittings of plastics materials — Fittings for domestic and industrial waste pipes — Basic dimensions: Metric series — Part 1: Unplasticized poly(vinyl chloride) (PVC-U)*
- [4] ISO 4633, *Rubber seals — Joint rings for water supply, drainage and sewerage pipelines — Specification for materials*

1) Obtainable from national standards institutes.

Draft for comments only — Not to be cited as East African Standard

ICS 23.040.20; 23.040.45; 91.140.80; 93.030

Price based on 22 pages

Draft for comments only — Not to be cited as East African Standard