

AMENDMENT NO. 01 APPROVED ON 1998-06-11 TO SLS 659 : PART 1 : 1993 (FIRST REVISION)

SRI LANKA STANDARD SPECIFICATION FOR UNPLASTICIZED POLYVINYL CHLORIDE PIPE JOINTS AND FITTINGS FOR POTABLE COLD WATER SUPPLIES

PART 1 - SOCKET FITTINGS FOR SOLVENT WELDING (FIRST REVISION)

PAGE 5

Clause 4.1.1 Category A

Delete "sockets" in the second line of the "NOTE" and incorporate "straight sockets".

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Clause 5.2.4 Diameter of fittings

Change the title to read as "Dimensions of socket"

TABLE 2 - Dimensions of socket

Delete the second sentence of the "NOTE" given beneath "Table 2" and incorporate the following:

"5.2.4.2 Included angle

The maximum included angle of the socketed portion of the fittings shall not exceed $0^{\circ} 30'$.

NOTES

- 1. The diameter of the socket shall decrease or be constant from mouth to root.*
- 2. On the internal surface of a socket a single ridge may be allowed at the root of the socket provided the width and depth of the ridge are less than 0.5 mm.*
- 3. The minimum socket length is defined as 80 % of the socket length obtained, after reduction of 10 % from the mouth end and 10 % from the root end".*

Clause 5.2.4.2 Out of roundness tolerances of socket inside diameter

Change the Clause No. "5.2.4.2" to "5.2.4.3"

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Clause 5.2.5 Laying lengths

Delete the contents of this clause and incorporate the following:

5.2.5.1 The laying lengths of the types of fittings covered in ISO 264 shall conform to the values specified therein.

5.2.5.2 The laying lengths of reducing sockets, reducing tees and reducing elbows shall conform to the values given in Appendix C.

5.2.5.3 The laying lengths of threaded fittings shall conform to the values given in ISO 4434.

NOTES

Laying length of a fitting is the distance between

- a. *"Pipe to Pipe" - when the opening of two pipes joined are in single direction
Example Socket, Reducing Socket.*
- b. *"Pipe to Axis" - when the opening of pipes joined are not in the single direction
Example Tee, Elbow".*

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Clause 7.2.3 Procedure

Delete the fourth word of the first line of the fourth paragraph and substitute "specimens".

Delete the last paragraph.

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7.4.3 Procedure

Delete "mm" in the first line of the second paragraph and substitute "min".

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7.5.1 Principle

Delete the formulae given in the note and substitute the following :

$$“h_1 = \frac{h_0(100 - X)}{100}”$$

7.5.2 Apparatus

Delete the first paragraph and incorporate the following:
“The apparatus consists of a press as specified in 7.5.2.1”

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Clause 7.5.2.2

Delete this clause with the NOTE and incorporate the following:
“Appropriate supports to permit the application of the force and fittings of irregular shapes”.

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Clause A.1.3.1

Delete “8.2.2” in the first line and incorporate “A.1.2.2”.

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Clause A.1.3.2

Delete “8.3.1” in the first line and substitute “A.1.3.1”
Delete “5.3.4” in the second line and substitute “5.3.5”

Clause A.1.3.3

Delete “9” in the first line and substitute “10”
Delete “8.3.2” in the second line and substitute “A.1.3.2”

TABLE 6

Delete “3” in the last row of Column 1 and substitute “4”

Clause A.2.1

Delete “8.3.1” and “8.3.2” and substitute “A.1.3.1” and “A.1.3.2” respectively.

Clause A.2.2

Delete the contents and incorporate the following;

“Each fitting tested as in A.1.3.3 satisfies the relevant requirements”.

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Incorporate the following as Appendix C.

APPENDIX C

LAYING LENGTHS OF REDUCING SOCKETS, REDUCING TEESAND REDUCING ELBOWS

C.1 The laying lengths of reducing sockets, reducing tees and reducing elbows shall be as given in Tables 7 (a), 7 (b), 8 and 9 respectively.

Table 7 (a) - Laying lengths of reducing sockets [see Figure 4 (a)]

MINOR DIAMETER OF JOINTING (d_1)	MAJOR DIAMETERS OF JOINTING (d_2)										
	2	3	4	5	6	7	8	9	10	11	12
	25	32	40	50	63	75	90	110	125	140	160
	LAYING LENGTHS (Z)										
	+1	± 1.5					± 2				
20	6	8	10	15							
25		8	10	13	20						
32			10	13	17	21					
40				13	17	19	25				
50					17	19	23	30			
63						19	23	27	32		
75							23	27	32	35	
90								27	32	35	40
110									32	35	40
125										35	40
140											40

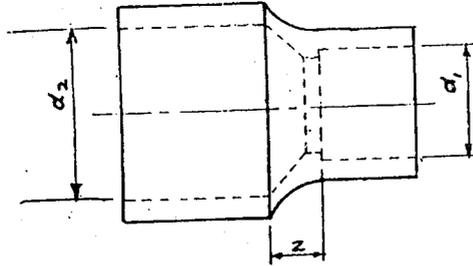


FIGURE 4(a)

TABLE 7(b) - Laying length of reducing sockets (short bush type) (see Fig. 4 b)

Size (mm)	Laying length (mm) (z)
(1)	(2)
25 x 20	3 +1 -1
32 x 20	3 +1.6 -1
32 x 25	3 +1.6 -1
40 x 20	3 +2 -1
40 x 25	3 +2 -1
40 x 32	3 +2 -1
50 x 32	3 +2 -1
50 x 40	3 +2 -1
63 x 32	3 +2 -1
63 x 40	3 +2 -1
63 x 50	3 +2 -1
75 x 63	4 +2 -1
90 x 75	5 +2 -1

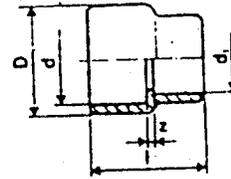


FIGURE 4(b)

TABLE 8 Laying length of reducing tees (see Figure 5)

Size mm (1)	Laying length (Z) mm (2)
25 x 20	13.5 + 1.2 -1
32 x 20	17 + 1.6 -1
32 x 25	17 + 1.6 -1
40 x 20	21 + 2 -1
40 x 25	21 + 2 -1
40 x 32	21 + 2 -1
50 x 25	26 + 2.5 -1
50 x 32	26 + 2.5 -1
50 x 40	26 + 2.5 -1
63 x 32	32.5 + 3.2 -1
63 x 40	32.5 + 3.2 -1
63 x 50	32.5 + 3.2 -1
75 x 40	38.5 + 4 -1
75 x 50	38.5 + 4 -1
75 x 63	38.5 + 4 -1
90 x 40	46 + 5 -1
90 x 50	46 + 5 -1
90 x 63	46 + 5 -1
90 x 75	46 + 5 -1
110 x 50	56 + 6 -1
110 x 63	56 + 6 -1
110 x 75	56 + 6 -1
110 x 90	56 + 6 -1

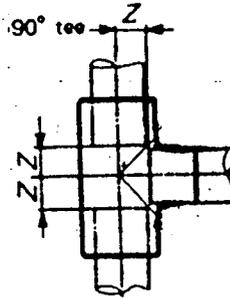


FIGURE 5

TABLE 9 - Laying length of reducing elbows (see Figure 6)

Size mm (1)	Laying length (Z) mm (2)
25 x 20	13.5 + 1.2 -1
32 x 20 32 x 25	17 + 1.6 -1
40 x 20 40 x 25 40 x 32	21 + 2 -1
50 x 32 50 x 40	26 + 2.5 -1
63 x 32 63 x 40 63 x 50	32.5 + 3.2 -1
75 x 40 75 x 50	38.5 + 4 -1
75 x 63	38.5 + 4 -1
90 x 50 90 x 63	46 + 5 -1
90 x 75	46 + 5 -1

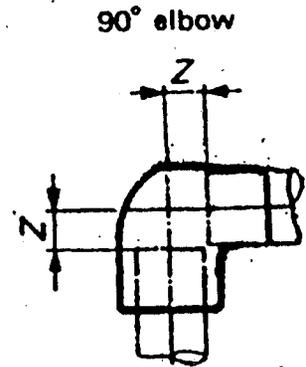


FIGURE 6