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IS 8360-2 (1977): fabricated high density polyethylene (MDPE) fittings for potable water supplies, Part 2 Specific requirements for 90 degree tees [CED 50: Plastic Piping System]



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IS : 8360 ( Part II ) - 1977

( Reaffirmed 1992 )

## *Indian Standard*

# SPECIFICATION FOR FABRICATED HIGH DENSITY POLYETHYLENE ( HDPE ) FITTINGS FOR POTABLE WATER SUPPLIES

## **PART II SPECIFIC REQUIREMENTS FOR 90° TEES**

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**BUREAU OF INDIAN STANDARDS**  
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*Indian Standard*

# SPECIFICATION FOR FABRICATED HIGH DENSITY POLYETHYLENE ( HDPE ) FITTINGS FOR POTABLE WATER SUPPLIES

## PART II SPECIFIC REQUIREMENTS FOR 90° TEES

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## *Indian Standard*

# SPECIFICATION FOR FABRICATED HIGH DENSITY POLYETHYLENE ( HDPE ) FITTINGS FOR POTABLE WATER SUPPLIES

## PART II SPECIFIC REQUIREMENTS FOR 90° TEES

### 0. FOREWORD

**0.1** This Indian Standard ( Part II ) was adopted by the Indian Standards Institution on 17 January 1977, after the draft finalized by the Sanitary Appliances and Water Fittings Sectional Committee had been approved by the Civil Engineering Division Council.

**0.2** The fabricated HDPE fittings are used for connection, by welding process, to HDPE pipes covered by IS : 4984-1972\*.

**0.3** The requirements of fabricated HDPE fittings are covered in three parts of this standard. Part I of the series deals with the general requirements applicable to all fabricated HDPE fittings and specific requirements of different types of fittings are covered in separate parts of the standard. This Part II deals with the specific requirements for 90° tees.

**0.4** For the purpose of deciding whether a particular requirement of this standard is complied with, the final values, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS : 2-1960†. The number of significant places retained in the rounded off values should be the same as that of the specified values in this standard.

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### 1. SCOPE

**1.1** This standard ( Part II ) lays down the requirements for manufacture, dimensions and tolerances and marking for fabricated HDPE 90° tees for potable water supplies.

\*Specification for high density polyethylene pipes for potable water supplies ( *first revision* ).

†Rules for rounding off numerical values ( *revised* ).

## 2. REQUIREMENTS

**2.1 General** — The general requirements for material, sizes, method of test and sampling shall conform to IS : 8360 ( Part I )-1977\*.

### 2.2 Manufacture

**2.2.1** A typical illustration of fabricated 90° tee is shown in Fig. 1.

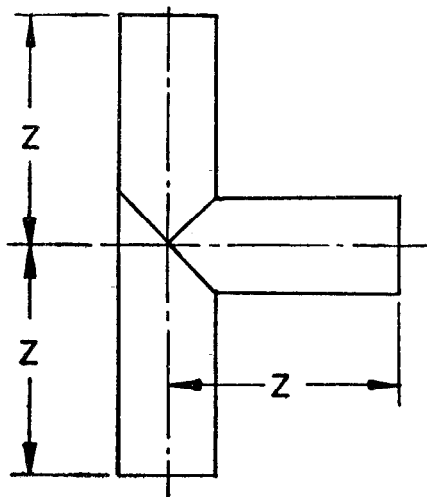


FIG. 1 90° TEE

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

**2.2.3** The outside diameters and wall thicknesses of pipes out of which 90° tees are fabricated shall comply with those given in IS : 8360 ( Part I )-1977\*. The wall thickness of a fabricated 90° tee shall not be less than that of the pipe to which it is to be welded.

## 3. MARKING

**3.1** Each fabricated 90° tee fitting shall be marked with the following information:

- Manufacturer's name or identification mark, and
- The size of the fitting and the appropriate class ( working pressure ) to which the pressure rating of the fitting corresponds.

\*Specification for fabricated high density polyethylene ( HDPE ) fittings for potable water supplies: Part I General requirements.



**TABLE 1 DIMENSIONS FOR LAYING LENGTH OF FABRICATED 90° TEES***( Clause 2.2.2 and Fig. 1 )*

SIZE	90° TEES, OVERALL LAYING LENGTH, Z
(1)	(2)
mm	mm
20	50 ± 2
25	62.5 ± 2
32	80 ± 2
40	80 ± 2
50	90 ± 2
63	94.5 ± 4
75	112.5 ± 4
90	135 ± 4
110	165 ± 4
125	181.5 ± 4
140	210 ± 6
160	240 ± 6
180	270 ± 6
200	300 ± 6
225	337.5 ± 8
250	375 ± 8
280	420 ± 8
315	472.5 ± 8
355	532.5 ± 10
400	600 ± 10
450	675 ± 10
500	750 ± 10

**3.1.1** Each fabricated 90° tee fitting may also be marked with the Standard mark.

**3.1.2** The use of the Standard Mark is governed by the provisions of the Bureau of Indian Standards Act, 1986 and the Rules and Regulations made thereunder. The details of conditions under which the licence for the use of Standard Mark may be granted to manufacturers or producers may be obtained from the Bureau of Indian Standards.

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