Table -19-1: Thickness of Internal Polyurethane Application

DN	Nominal thickness of polyurethane (µm)
100 - 600	1500
700-1000	1800
1100-1500	2200
1600-2000	2500

G. Surfaces which can come into contact with the effluents (internal surface of the socket and external surface of the spigot end) shall be coated with a synthetic resin (epoxy, polyurethane etc.) in accordance BS EN 598 requirements as a minimum.

19.2.4 External Protective Coatings

A. Pipes shall be protected externally with metallic zinc coat (min 200g/m2) and epoxy finish layer (min thickness 80µm), metallic zinc coat (min 200g/m2) and bituminous paint (min thickness 100µm) or polyurethane. Selection of the external coating shall be made on the base of soil and subsoil water conditions, refer to Table 19-2.

Table 19-2: External Coating of the Pipes Depending on the Soil Conditions

Soil characteristics	External Coating
Resistivity >1500 Ohmcm without water table >2500 Ohmcm with water table	Metallic zinc + epoxy finish layer Metallic zinc + bituminous paint
750Ohmcm <Resistivity ≤ 1500 Ohmcm without water table 1500 Ohmcm<Resistivity ≤ 2500 Ohmcm with water table	Metallic zinc + epoxy finish layer + polyethylene sleeve Metallic zinc + bituminous paint + polyethylene sleeve
Resistivity ≤750 Ohmcm without water table ≤1500 Ohmcm with water table	Polyurethane with average thickness 1000 µm