

- f) Determine the nominal pipe wall thicknesses from the table in ISO 4065.
- g) Comply with the limits specified in ISO 11922 when measuring the nominal outside diameters and wall thicknesses in accordance with ISO 3126.
- h) All bends shall be long radius bends unless otherwise approved by the Engineer.
- i) uPVC-u cement and thinner shall be of the type approved by the Engineer.
 - i. The solvent cement shall have a minimum working pressure of 16 bar and a tensile strength of 112 bar after 72 hours.
 - ii. The cement shall have heavy viscosity, medium cure speed, and clear colour and be suitable for pipe diameters up to 315 mm.
 - iii. The cement will conform to ASTM-D-2564 and be NSF/UPC approved.
 - iv. The primer shall be certified to contain a minimum of 25 % THF and must meet ASTM F656.
 - v. All cans of solvent cement primer and lubricant shall have labels intact and shall be stamped with the date of manufacture and shelf life. No cans with an expired shelf life will be permitted.
- j) EPDM rubber sealing rings shall be in accordance with BS EN 681. The sealing rings shall be supplied by the pipe manufacturer.
 - i. Joints shall be capable of withstanding a "draw" of 13mm over and above the initial jointing allowance and remaining watertight. The initial jointing allowance is the gap between the spigot and the shoulder of the socket measured parallel to the centre line of the pipeline and must not be less than 6mm or greater than 13mm or as recommended by the pipe manufacturer.
 - ii. Joints shall be capable of withstanding a deflection of not less than one and a half degrees in any direction and remaining watertight.
 - iii. The pipe joints shall be capable of withstanding an external pressure equivalent to 10m head of water without leakage in both the straight and deflected positions.
 - iv. Single sockets shall be in accordance with ISO 2045.