

SPECIFICATION FOR CLAMP SADDLES

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Specification for uPVC Clamp Saddles

1. General

uPVC Clamp/Tapping saddles shall be of uPVC in moulded type for uPVC pipes and be of the bolted type. The bolts and nuts shall be of stainless steel. Internal pipe thread of the socket of the saddle shall be a female taper thread. All Clamp/Tapping Saddles shall be leak proof on completion of tapping for water connections

2. Standards

uPVC Clamp/Tapping saddles shall be of uPVC, conforming to ISO 4422.

SLS 147 and SLS 659 is applicable for materials and testing if specified in these two Sri Lanka Standards

In addition to general material tests for uPVC, following specific tests shall be carried out for Clamp/Tapping Saddles to the satisfaction to relevant standards as given below;

1. Flattening test-SLS 659
2. Stress relief test (Oven method) -SLS 659 or ISO 580
3. Vicat softening temperature -SLS 659 or ISO 2507-2
4. Resistance of bodies to internal pressure- Table 5, ISO 4422-4

Internal pipe thread of the socket of the saddle shall be a female taper thread complying with BS21/ISO 7/1.f

The “O” ring/gasket material shall be of elastomeric materials (EPDM, natural rubber, butyl rubber, neoprene etc.) and shall conform to BSEN 681-1 and material properties conforming to Table 2 of BSEN 681-1

The bolts and nuts shall be of stainless steel grade 316.

If necessary, representatives of National Water Supply and Drainage Board (NWSDB) may visit the factory during production and all facilities shall be provided by the manufacturer for inspection and testing of Clamp/Tapping Saddles. Result of the tests carried during production shall also be available for scrutiny if requested by NWSDB.

Tests shall be carried out in Sri Lanka Standards Institute, Industrial Technology Institute or any other institute acceptable to National Water Supply and Drainage Board and test certificates shall be forwarded with the delivery of Clamp/Tapping saddles.

Details of the Saddles should be given in schedule of particulars.

3. Dimensions

Dimensions of Clamp/Tapping Saddles shall comply with Table-4 of ISO 4422-4

The Bolt lengths shall be sufficient to ensure that nuts are fully threaded when tightened in their final position with two threads visible.

4. Markings

Markings (except date or code) of the Saddle should include the information listed in table-8 of ISO 4422-4