

SPECIFICATION FOR REPAIR CLAMPS

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Specification for Repair Clamps

1. SCOPE

This specification covers single band repair clamps to repair holes, cracks or other damages on uPVC pipes.

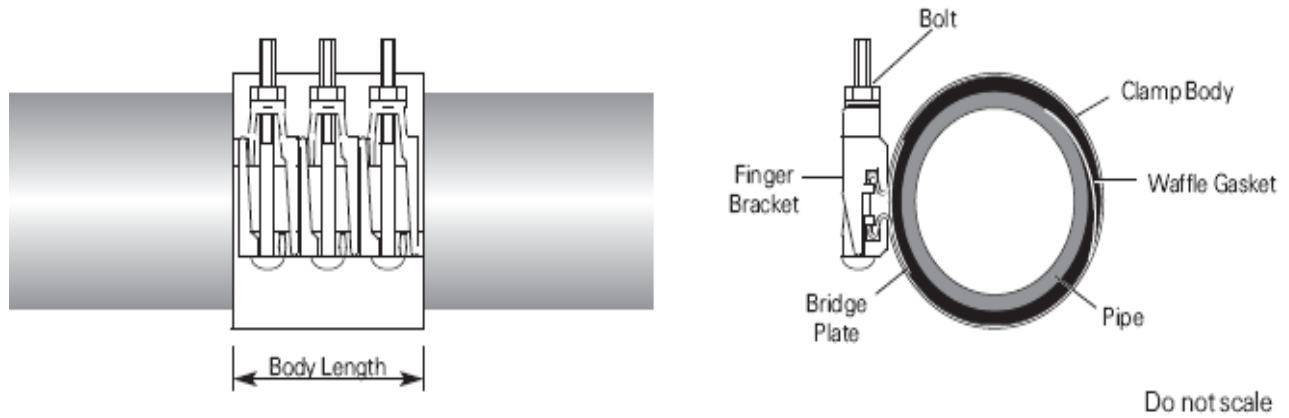
2. GENERAL REQUIREMENTS

Single Band Repair Clamps

- a. Band or shell shall be of the O.D size range and length specified. Band shall be of Type 304 stainless steel.
- b. Bolt retainer assembly or lugs shall be of a type 304 stainless steel and of a non-welded design. Lugs may be cast, forged or cold formed of type 304 stainless steel, and may include a high impact polycarbonate plastic, non corrosive retainer. Lug design shall be such that the band fully compresses the gasket to the complete working width of the repair clamp without deformation of the band.
- c. All nuts and bolts shall be 304- stainless steel and coated with an anti-seize coating such as a non-seize zinc coating to prevent galling.
- d. Waffle Gasket or Seal shall provide a 360° sealing surface and of such size and shape to provide and adequate compressive force against the pipe after assembling to affect a positive seal under all combinations of joint and gasket tolerances. Materials shall be of elastomeric materials conform to BSEN 681-1 and material properties conforming to Table 2 of BSEN 681- 1.A heavy gauge Type 304 stainless Steel bridge plate shall be vulcanized into the gasket to span the lug area.
- e. Repair Clamps shall be suitable for usage up to 40° C temperature without any effect to the installed life of the product.
- f. Pressure shall be of 16bar for working and 24bar for test pressures.
- g. All repair clamps manufacturing factory posses shall comply with ISO 9001: 2008 quality management system certificate issued from an organization accredited to issue such certification. Documentary evidence regarding accreditation together with the scope of certification should be provided.
- h. Full details of the repair clamps should be given in schedule of particulars.

3. DIMENSIONS

Dimensions of repair clamps shall comply with Table-01.



uPVC Pipe Size	Clamp Range	Clamp Body length (Minimum)	Number of Bolts	Weight (Kg)
63mm	60-70	190mm	3	3.90
75mm	70-80	190mm	3	4.00
90mm	85-95	190mm	3	4.10
110mm	105-115	190mm	3	4.20
125mm	120-130	190mm	3	4.40
140mm	135-145	190mm	3	4.60
160mm	155-165	190mm	3	4.80
225mm	220-230	190mm	3	5.40
280mm	275-285	190mm	3	5.80

Table – 01

4. MARKINGS

Markings of the repair clamps should include the information listed in table -8 of ISO 4422-4