

**SPECIFICATION FOR COVERS DOUBLE BAND
REPAIR CLAMPS**

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Specification for covers double band Repair Clamps

1. Scope

This specification covers Mechanical Sealing Repair Clamps, double band with EPDM rubber to repair holes, cracks or other damages on PE pipes.

2. General Requirements

Double 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 an 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. Bridge/spanner plate shall bend with radius according to the sealing sizes.
- f. Stud shall be welded on the none threaded part.
- g. Passivation treatment must be done on all welding area to avoid corrosion.
- h. Design of the waffle rubber seal shall be with effective sealing and maximum grip especially when clamped around pipe with uneven surface when in compression.
- i. Repair Clamp shall be suitable for usage up to 40° C temperature without any effect to the installed life of the product.

- j. Pressure of small diameter Repair Clamp shall be of 16 bar for working and 24 bar for test pressures.

- k. The Bidder shall provide ISO 9001: 2015 Quality Management System requirement certificate for Quality Assurance for the goods manufacturing factory from an accredited agency for all Repair Clamps. Accredited Agency shall be a member of International Accredited Forum (IAF) and shall have the authority for the accreditation of mentioned goods in their scope of accreditation. Scope of the production shall be clearly specified in the certificate. Manufacturer shall maintain the validity of this certificate during the supply and delivery of the materials for contract Period. If the supply is made from several factories, ISO 9001: 2015 certificates for quality management system requirement shall be submitted for each factory. This certificate shall clearly indicate the location of the place of manufacture of pipes, fittings and accessories, etc.

3. Markings

Markings of the Repair Clamps should include the information listed in table -8 of ISO 4422-4