

SPECIFICATION FOR POLY PROPYLENE CLAMP SADDLES

Revised on 02-09-2017

TABLE OF CONTENTS

1	General	6bf – 2
2	Standards	6bf – 2
3	Dimensions	6bf – 3
4	Markings	6bf – 3

Specification for Poly Propylene Clamp Saddles

1. General

Poly Propylene Clamp/Tapping saddles shall be of Poly Propylene Copolymer in moulded type for PE and PVC pipes and be of the bolted type. The bolts and nuts shall be of stainless steel. All Clamp/Tapping Saddles shall be leak proof on completion of tapping for water connections.

2. Standards

Poly Propylene Clamp/Tapping saddles shall conform to ISO 15874.

In addition to general material tests for Poly Propylene, test for Resistance to Internal pressure shall be carried out for Clamp/Tapping Saddles to the satisfaction.

Property	Requirement	Test parameters				Test method
		hydraustatic stress Mpa	Test temp. °C	test time h	number of tests	
Resistance to internal pressure	no failure	PP-R				ISO 1167-1 and ISO 1167-2
		16, 0	20, 0	1	3	
		4, 3	95, 0	22	3	
		3, 6	95, 0	165	3	
		3, 5	95, 0	1000	3	
		PP-RCT				
		15, 0	20, 0	1	3	
		4, 2	95, 0	22	3	
		4, 0	95, 0	165	3	
		3, 8	95, 0	1000	3	

Following requirement should be tested.

- Melt flow Index
- Drying loss
- Sizes and tolerance
- Change after heat treatment
- Impact bending test
- Internal pressure test
- Homogeneous material

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

The “O” ring/gasket material shall be of elastomeric materials of EPDM 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 Manufacturer’s factory or accredited Laboratory in Manufacturer’s Country or 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 ISO 15874 and SLS 147:2013/ISO 1452.

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 below;

Manufacturer	-
Material	-
Nominal outside diameter x Wall thickness	-
Nominal pressure/pipe series	-
Manufacturing data	-
ISO Standard	-