Edoburg®

International Organization for Standardization
ISO
9001

PVC-C Piping System

WATER TRANSPORT SOLUTIONS

PRODUCT CATALOGUE

Edoburg®
PIPING SYSTEMS

Edoburg®

TABLE OF CONTENTS

About Edoburg

Edoburg, an ISO 9001 certifies company, specialises in supplying high-quality piping systems that consistently meet stringent international standards, ensuring unparalleled performance of the piping systems. Our experienced team, equipped with extensive technical knowledge, coupled with our efficient operations and fast turnaround time, enables us to provide top-tier supply of piping products tailored to your needs.

Our Mission

Edoburg's mission is to supply high-quality piping systems worldwide, offering a complete solution that meets international standards to ensure superior performance in every project.

Product Range

Our stellar lineup of pipes, ready for every project:

- PEX Pipe: PEX-A, PEX-B, PEX-A EVOH, PEX-B EVOH
- PPR Pipe
- PERT Pipe
- HDPE Pipe
- MDPE Pipe
- PVC-C Pipe: Portable water, Reclaim water, Industrial
- PVC-U Pipe: Drainage, Portable water, Reclaim water, Industrial
- PVC-O
- Composite Pipe: PEX-AL-PEX, HDPE-AL-HDPE
- PVC Electrical Conduit
- PVC Hose

Complete Solution Concept

Our wide range of products represent our complete solution concept.

With our products intended for diverse sectors, we offer individual and comprehensive system solutions. Focusing on the needs of projects and entire system.

We provide high standards of products in the market at all times. We always stand by our piping systems and reliable service network.

As a global pipe supplying company that stands out with successful operations ever since our incorporation, we act as a solution point to meet all your needs based on our technical knowledge, specialization and reliability.

Quality Assurance

We are committed to excellence in every aspect of our operations. The products we supply comply with the international standards and certifications, ensuring reliability, durability, and safety in every application. With Edoburg, you can trust that you're receiving top-notch piping solutions that meet your specifications and exceed your expectations.

Our Presence in the World

Our warehousing are strategically located in various places in **India**, **Vietnam** and **China**, to ensures efficient distribution of the products. We ensure fast deliveries with our modern logistics partners deployed at our local distribution hubs which are strategically located near the ports to ease the export of products. Edoburg Piping Systems exports its products all over the world.

Our Market Segments

Based on our experience and high-quality standard of products in the sector, Edoburg Piping Systems supports its clients with a complete piping solutions for every project requirement.

- Chemical and Petrochemical
- Water and Wastewater
- Mining and Mineral Processing
- Power Generation
- Marine and Offshore
- Building and Construction
- Manufacturing Industries
- Agriculture
- Pharmaceuticals
- Infrastructure

About Plastics

Plastics are polymers created by the chemical conversion of natural products or synthesized from organic materials. The primary components that make up the building blocks of plastics are long chains of carbon (C) and hydrogen (H) known as monomers.

The raw materials used for the production of plastics are natural compounds such as cellulose, coal, oil and natural gas. In the plastics industry, around 6 % of the petroleum products that come out from refineries is used.

Plastics fall into three main categories on the basis of their internal structure and the resulting mechanical characteristics: thermoplastics, thermosetting plastics and elastomers.

Advantages of Plastics

Thermoplastics obviously demonstrate different characteristics than those of the metals traditionally used for piping.

Metal	Plastic
High density • Crane is needed for transport. • Requires wide spacing for fixings. • High anchoring forces, fixing required.	Low density • Can be carried by hand up to d110. • Requires minimal spacing for fixings. • Simple and economical.
Thermal conductivity • Insulation is needed to limit heat loss. • Formation may result in corrosion.	Low thermal conductivity • Limited heat loss. • Low levels of condensation and resistance to corrosion.
Corrosion Behaviors • Galvanic corrosion can occur. • Corrosion reduces internal diameter. • Reduced diameter causes pressure losses.	High Corrosion Resistance • Galvanic Corrosion Free. • Prevents corrosion and diameter reduction. • No pressure losses.
Chemical resistance • Low Resistance to Acids. • Damage from Incrustation.	High chemical resistance • A minimum of 25-years of life with correct jointing methods. • Incrustation free.

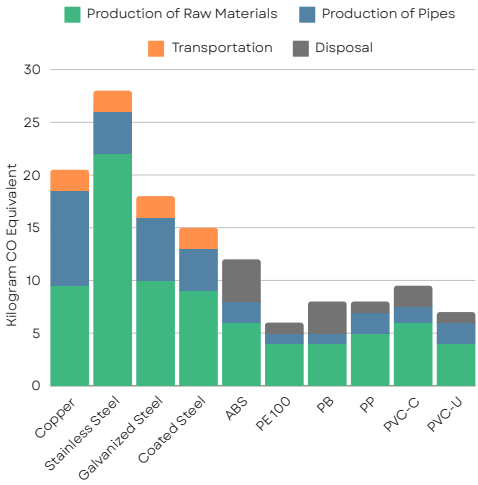
Thermoplastics in turn can be split into two main categories as partially-regulated (semi-crystalline) and iregular (amorphous) molecular structures.

- Semicrystalline thermoplastics, which have a partially ordered molecular structure: this category includes the polyolefins (polypropylene, polyethylene, polybutylene) and fluoropolymers (PP, PE, etc.)
- Amorphous thermoplastics, which have no crystalline regions and no packed molecular structure: this category includes the vinyl chlorides (PVC-U, PVC-C, etc.) and styrenes (ABS, polystyrene, etc.]

Semicrystalline materials are more suitable for hot welding, while amorphous thermoplastics are ideal for cementing or cold welding (solvent cementing).

Carbon Footprint of Plastics Vs Metal

It is the total of all greenhouse gases emitted to the atmosphere during the entire lifetime including the processes for extracting a product having carbon footprint from under the ground, refining, producing, using and disposing of that product.



PVC-C Piping System

Chlorinated Polyvinyl Chloride (PVC-C) is a high-performance thermoplastic piping material engineered for enhanced durability and versatility across various industrial applications. The chlorination process increases PVC-C's resistance to higher temperatures, making it particularly suitable for hot and cold water distribution, industrial fluid handling, and chemical processing systems.

PVC-C is specified for a wide range of piping system components, including valves, fittings, flanges, and specialized products. Its superior resistance to corrosive chemicals and high-temperature environments ensures long-term reliability and performance. The material's robust chemical and corrosion resistance, coupled with its ability to withstand elevated temperatures, makes PVC-C an ideal choice for demanding applications in industries such as water treatment, chemical processing, and industrial manufacturing.

CPVC pipes excel with high temperature and chemical resistance, low thermal conductivity, easy installation, and long-term durability. They resist corrosion, are fire-resistant, and offer environmental sustainability through recyclability, making them ideal for diverse plumbing and industrial uses.

Fields of Application

PVC-C Pipes are ideal for Hot and Cold water applications in:

- Homes, apartments
- Hotels, resort
- Hospitals
- High and low rise buildings
- Corporate and commercial houses
- Academic institutes

  etc. for pure and hygienic water supply.

Technical data

Working Temperature

- 40°C to 93°C (104°F to 200°F)

Pipe Standard

- ASTM D 2846
- ASTM F 441
- DIN 8062
- ISO 4422-2
- BS 3505/6

Fittings Standard

- ASTM D 2846

Certifications

Only those products bearing the above marks are certified.

PVC-C Pipe Range

Pipe as per ASTM D 2846

HSN Code: 39172390

PVC-C SDR-11

Nominal Size		Outside Diameter (mm)		Wall Thickness (mm)		Pressure Rating PSI (kg/cm2)			
(inch)	(mm)	Average	Tolerance	Average	Tolerance	73.4°C	23°C	23°C	82°C
½	15	0.625 (15.9)	± 0.003 (0.08)	0.068 (1.73)	± 0.020 (0.51)	400	28.1	100	7.0
3/4	20	0.875 (22.2)	± 0.003 (0.08)	0.080 (2.03)	± 0.020 (0.51)	400	28.1	100	7.0
1	25	1.125 (28.6)	± 0.003 (0.08)	0.102 (2.59)	± 0.020 (0.51)	400	28.1	100	7.0
1¼	32	1.375 (34.9)	± 0.003 (0.08)	0.125 (3.18)	± 0.020 (0.51)	400	28.1	100	7.0
1½	40	1.625 (41.3)	± 0.004 (0.10)	0.148 (3.76)	± 0.020 (0.51)	400	28.1	100	7.0
2	50	2.125 (54.0)	± 0.004 (0.10)	0.193 (4.90)	± 0.023 (0.58)	400	28.1	100	7.0

PVC-C SDR -13.5

Nominal Size		Outside Diameter (mm)		Wall Thickness (mm)		Pressure Rating PSI (kg/cm2)			
(inch)	(mm)	Average	Tolerance	Average	Tolerance	73.4°C	23°C	23°C	82°C
½	15	0.625 (15.9)	± 0.003 (0.08)	0.055 (1.40)	± 0.020 (0.51)	320	22.5	80	5.6
3/4	20	0.875 (22.2)	± 0.003 (0.08)	0.065 (1.65)	± 0.020 (0.51)	320	22.5	80	5.6
1	25	1.125 (28.6)	± 0.003 (0.08)	0.083 (2.12)	± 0.020 (0.51)	320	22.5	80	5.6
1¼	32	1.375 (34.9)	± 0.003 (0.08)	0.102 (2.59)	± 0.020 (0.51)	320	22.5	80	5.6
1½	40	1.625 (41.3)	± 0.004 (0.10)	0.120 (3.06)	± 0.020 (0.51)	320	22.5	80	5.6
2	50	2.125 (54.0)	± 0.004 (0.10)	0.157 (4.00)	± 0.023 (0.58)	320	22.5	80	5.6

Pipe as per ASTM F 441

HSN Code: 39172390

PVC-C Schedules 40 & 80

Nominal Size		Outside Diameter (mm)		Schedule 40 Wall Thickness (mm)		Schedule 80 Wall Thickness (mm)	
(inch)	(mm)	Average	Tolerance	Min	Tolerance	Min	Tolerance
½	15	0.840	± 0.004 (0.10)	± 0.004 (0.10)	± 0.004 (0.10)	± 0.004 (0.10)	± 0.004 (0.10)
¾	20	1.050	± 0.004 (0.10)	± 0.004 (0.10)	± 0.004 (0.10)	± 0.004 (0.10)	± 0.004 (0.10)
1	25	1.315	± 0.005 (0.13)	± 0.005 (0.13)	± 0.005 (0.13)	± 0.005 (0.13)	± 0.005 (0.13)
1¼	32	1.660	± 0.005 (0.13)	± 0.005 (0.13)	± 0.005 (0.13)	± 0.005 (0.13)	± 0.005 (0.13)
1½	40	1.900	± 0.006 (0.15)	± 0.006 (0.15)	± 0.006 (0.15)	± 0.006 (0.15)	± 0.006 (0.15)
2	50	2.375	± 0.006 (0.15)	± 0.006 (0.15)	± 0.006 (0.15)	± 0.006 (0.15)	± 0.006 (0.15)
2½	65	2.875	± 0.006 (0.15)	± 0.006 (0.15)	± 0.006 (0.15)	± 0.006 (0.15)	± 0.006 (0.15)
3	80	3.500	± 0.007 (0.18)	± 0.007 (0.18)	± 0.007 (0.18)	± 0.007 (0.18)	± 0.007 (0.18)
4	100	4.500	± 0.008 (0.20)	± 0.008 (0.20)	± 0.008 (0.20)	± 0.008 (0.20)	± 0.008 (0.20)
5	125	5.563	± 0.010 (0.25)	--	--	± 0.010 (0.25)	± 0.010 (0.25)
6	150	6.625	± 0.011 (0.28)	--	--	± 0.011 (0.28)	± 0.011 (0.28)
8	200	8.625	± 0.015 (0.38)	--	--	± 0.015 (0.38)	± 0.015 (0.38)
10	250	10.750	± 0.015 (0.38)	--	--	± 0.015 (0.38)	± 0.015 (0.38)
12	300	12.750	± 0.015 (0.38)	--	--	± 0.015 (0.38)	± 0.015 (0.38)

Pipe as per DIN 8062, ISO 4422-2, BS 3505/6

HSN Code: 39172390

Nominal Size (mm)
15
20
25
32
40
50
65
80
100
125
150
200
250
300

Note:

Non-Standard wall thickness, length and color can also be offered if required.

PVC-C Fittings Range

Fittings as per ASTM D2846

HSN Code: 391740

COUPLER

DN (inch)	Code	Pkg.
½	M512111001	1500
¾	M512111002	600
1	M512111003	600
1¼	M512111004	300
1½	M512111005	200
2	M512111006	50

ELBOW 45°

DN (inch)	Code	Pkg.
½	M512112301	500
¾	M512112302	200
1	M512112303	250
1¼	M512112304	60
1½	M512112305	40
2	M512112306	15

ELBOW 90°

DN (inch)	Code	Pkg.
½	M512110501	1000
¾	M512110502	800
1	M512110503	400
1¼	M512110504	200
1½	M512110505	120
2	M512110506	50

TEE

DN (inch)	Code	Pkg.
½	M512110101	800
¾	M512110102	500
1	M512110103	300
1¼	M512110104	150
1½	M512110105	90
2	M512110106	40

END CAP

DN (inch)	Code	Pkg.
½	M512114101	1000
¾	M512114102	500
1	M512114103	200
1¼	M512114104	120
1½	M512114105	100
2	M512114106	40

CROSS

DN (inch)	Code	Pkg.
½	M512112401	200
¾	M512112402	100
1	M512112403	100

REDUCER FEMALE ADAPTOR

DN (inch)	Code	Pkg.
¾ x ½	M512111614	600

MALE ADAPTOR

DN (inch)	Code	Pkg.
½	M512111301	600
¾	M512111302	600
1	M512111303	300
1¼	M512111304	200
1½	M512111305	100
2	M512111306	50

FEMALE ADAPTOR

DN (inch)	Code	Pkg.
½	M512110501	1000
¾	M512110502	800
1	M512110503	400
1¼	M512110504	200
1½	M512110505	120
2	M512110506	50

TANK ADAPTOR (THDxSOC)

DN (inch)	Code	Pkg.
¾	M5128010202	75
1	M5128010203	60
1¼	M5128010204	70
1½	M5128010205	60
2	M5128010206	35

REDUCER ELBOW 90°

DN (inch)	Code	Pkg.
½	M512110614	500
¾	M512110615	350
1	M512110616	300
1¼	A512110617	01
1½	M512110618	175
2	M512110619	150

REDUCER COUPLER

DN (inch)	Code	Pkg.
2½ x 1½	A5121110333	01
2½ x 2	A5121110334	01

UNION

DN (inch)	Code	Pkg.
½	M512112601	210
¾	M512112602	180
1	M512112603	120
1¼	M512112604	90
1½	M512112605	60
2	M512112606	30

TANK ADAPTOR (THDxTHD)

DN (inch)	Code	Pkg.
½	M512112501	80
¾	M512112502	60
1	M512112503	40
1¼	M512112504	30
1½	M512112505	20
2	M512112506	15

REDUCER TEE

DN (inch)	Code	Pkg.
½ x ½ x ¾	A512110291	01
¾ x ½ x ¾	A512110292	01
¾ x ½ x ½	A512110293	01
¾ x ¾ x ½	M512110214	300
1 x 1 x ½	M512110215	300
1 x 1 x ¾	M512110216	75
1¼ x 1¼ x ½	M512110217	100
1¼ x 1¼ x ¾	M512110218	120
1¼ x 1¼ x 1	M512110219	80
1½ x 1½ x ½	M512110220	70
1½ x 1½ x ¾	M512110221	60
1½ x 1½ x 1	M512110222	30
1½ x 1½ x 1¼	M512110223	60
2 x 2 x ½	M512110224	30
2 x 2 x ¾	M512110225	35
2 x 2 x 1	M512110226	15
2 x 2 x 1¼	M512110227	30
2 x 2 x 1½	M512110228	25

ELBOW 90° 4-WAY

DN (inch)	Code	Pkg.
¾	M5121112502	250

ELBOW 90° 3-WAY

DN (inch)	Code	Pkg.
¾	M5121112402	300

Solvent Cements

HSN Code: 35061000

Solvent Cement (Tin)

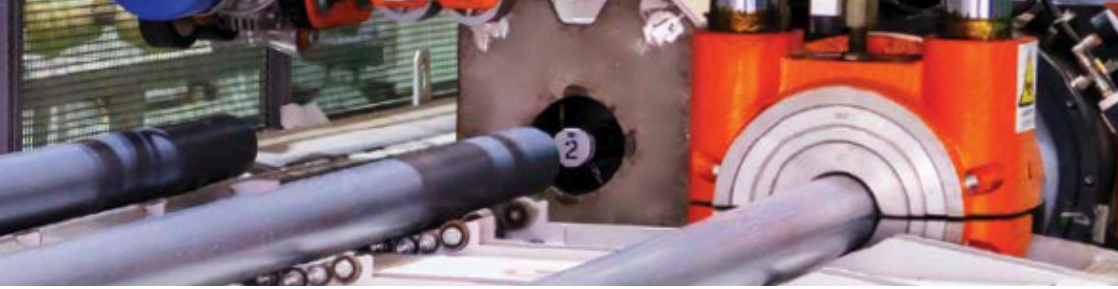
Code	Size (ml)	Pkg.
M001001015	50	48
M001001020	118	24
M001001025	237	24
M001001030	473	12
M001001035	946	12

Primer Clear (Tin)

Code	Size (ml)	Pkg.
M008401005	473	12
M008401010	946	12

Solvent Cement (Tube)

Code	Size (ml)	Pkg.
TTINS-2217	22ml	48
TTINS-44	44ml	24



Technical Properties

Technical Characteristics

Pipe Stucture	Standard PVC-C Pipe
Diameters (mm)	d15, d20, d25, d32, d40, d50, d65, d75, d90, d110, d125, d160, d200, d250, d315
Pipe Classes	1. For Cold Water Supply at 60°c 2. For Drainage Water 3. For Portable Water 4. For Hot water till 90°c
Pipe Length	Straight length - 3m, 6m
Jointing Methods	Solvent Cement
Color	White & Grey
Chemical Resistance	Resistant to organic and inorganic chemical environments for pH values between 2 and 12
Installation Temperature	Minimum: +5°C Maximum: +40°C
Operating Temperature	Standard PVC-C Pipes: 40°C to 93°C (104°F to 200°F)
Standards	ASTM D 2846, ASTM F 441, DIN 8062, ISO 4422-2 & BS 3505/6
Thermal Expansion Coefficient	0.06 mm/m°C to 0.08 mm/m°C
Thermal Conductivity Coefficient	0.14 to 0.16 W/m°K
Approvals and Certificates	USA: **NSF**, India: **ISI**, **BIS**

PHYSICAL PROPERTIES OF PVC MATERIALS

PROPERTY	UNITS	PVC	ASTM NO.
Specific Gravity	g/cc	1.41 - 1.46	D 792
Tensile Strength (73°F)	PSI	7,200	D 638
Modulus of Elasticty in Tension (73°F)	PSI	4,60,000	D 638
Flexural Strength (73°F)	PSI	13,200	D 790
Izod Impact (notched at 73°F)	ft lb/in.	0.65	D 256
Hardness (Durometer D)	----	80 ± 3	D 2240
Hardness (Rockwell R)	----	110 - 120	D 785
Compressive Strength (73°F)	PSI	9,000	D 695
Hydrostatic Design Stress	PSI	2,000	D 1598
Coefficient of Linear Expansion	in./in./°F	3.1×10^{-5}	D 696
Heat Deflection Temperature at 66 psi	°F	165	D 648
Coefficient of Thermal Conductivity	BTU/hr/sq. ft/°F/in.	1.2	C 177
Specific Heat	BTU/F/lb	0.25	D 2766
Limiting Oxygen Index	%	43	D 2863
Water Absorption (24 hrs at 73°F)	% weight gain	0.05	D 570
Cell Classification-Pipe	----	12454-B	D 1784
Cell Classification-Fittings	----	12454-B	D 1784

Above data is based upon information provided by the raw material manufacturers. It should be used only as a recommendation and not as a guarantee of performance.

EXPANSION AND CONTRACTION OF PVC-U PIPE

PVC-C pipes, like other piping materials, undergoes length changes as a result of temperature variations above and below the installation temperature. They expand and contract 4.5 to 5 times more than steel or iron pipe. The extent of the expansion - contraction depends upon the coefficient of linear expansion of piping material. The length of pipe between directional changes, and the temperature differential.

The coeffcient of thermal expansion (Y) for cPVC is 3.1 x 10-5 in./in./°F.

The amount of expansion and contratction can be calculated using the following formula:

$\Delta L = Y\ (T1-T2) \times L1$

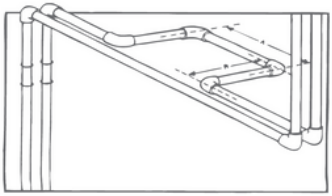
ΔL = Dimentional change due to thermal expansion or contratcion (Inch)

Y = Expansion coefficient (in./in./°F)

(T1-T2) = Temperature diffierential between the installation temperature and the maximum or minimum system tempeature, whichever provides the greatest differential (°F).

L = Length of pipe run between changes in direction (in).

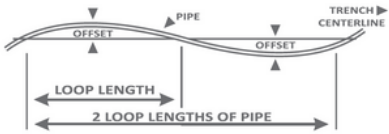
There are several ways to compensate for expansion and contratcion. The most common method are:
1. Expansion loops which consist of pipe and 90° elbows.
2. Piston type expansion joints*
3. Flexible bends*
4. Bellows and rubber expansion joints*



The length of leg "R" can be determined by using the following formula to ensure that it is long enough to absorb the expansion and contraction movement without damage. The length of leg "A" should be 1/2 the length of leg "R"

$R = 1.44\ D\ \Delta\ L$
R = Expansion loop leg length (ft)
D = Nominal outside diameter of pipe (in.) (See table below.)
ΔL = Dimensional change due to thermal expansion or contraction (in.)

When installing the expansion loop, no rigid or restraining supports should be placed within the leg lengths of the loop. The loop should be installed as closely as possible to the mid-point between anchors. Piping support guides should restrict lateral movement and direct axial movement into the loop. Lastly, the pipe and fittings should be solvent cemented together, rather than using threaded connections. Compensation for expansion and contraction in underground application is normally achieved by snaking the pipe in the trench. Proper trenching and burial procedures must be followed to protect the piping system. The table below shows recommended offsets & loop lengths for piping upto 26 inches nominal sizes.



Max. Temp. Variation °F, Between Installation and Final Operation

	10°	20°	30°	40°	50°	60°	70°	80°	90°	100°
Loop Offset in Inches	Loop Length in Feet									
20	3.0	3.5	4.5	5.0	6.0	6.5	7.0	7.0	8.0	8.0
50	7.0	9.0	11.0	13.0	14.0	15.5	17.0	18.0	19.0	20.0
100	13.0	18.0	22.0	26.0	29.0	31.5	35.0	37.0	40.0	42.0

SUPPORT SPACING FOR PVC-C PIPE

Adequate supports for any piping system is a matter of great importance. In practice, support spacings are a function of pipe size operating temperatures, the location of heavy valves or fittings and the mechanical properties of the pipe material. To ensure the satisfactory operation of a PVC-C piping system, the location and type of hangers should be carefully considered. Hangers should not compress, distort, cut or abrade the piping.

All piping should be supported with an approved hanger at intervals sufficiently close to maintain correct pipe alignment and to prevent sagging or reversal. Pipe should also be supported at all branch ends and at all changes of direction. Support trap arms as close as possible to the trap. In keeping with good plumbing practices support and brace all closet bends and fasten closet angles.

1. Concentrated loads should be supported directly so as to eliminate high stress concentrations. Should this be impractical then the pipe must be supported immediately adjacent to the load.

2. In systems where large fluctuations in temperature occur, allowances must be made for expansion and contraction of the piping system. Since changes in direction in the system are usually sufficient to allow for expansion and contraction hangers must be placed so as not to restrict this movement.

3. Since plastic pipe expands or contracts approximately five times greater than those of steel, hangers should not restrict this movement.

4. Hangers should provide as much bearing surface as possible. To prevent damage to the pipe, file smooth any sharp edges or burrs on the hangers or supports.

5. Support spacing for horizontal piping systems is determined by the maximum operating temperature the system will encounter. The piping should be supported on uniform centers with supports that do not restrict the axial movement.

6. For vertical lines, it is recommended that an engineer should design the vertical supports according to the vertical load involved.

TESTING PRESSURE SYSTEM

- Prior to testing, safety precautions should be instituted to protect personnel and property in case of test failure.
- Conduct pressure testing with water. DO NOT USE AIR OR OTHER GASES for pressure testing.
- The piping system should be adequately anchored to limit movement. Water under pressure exerts thrust forces in piping systems. Thrust blocking should be provided at changes of direction, change in size and at dead ends.
- Please refer tables given for initial set & cure times before pressure testing.
- The piping systems should be slowly filled with water, taking care to prevent surge and air entrapment. The flow velocity should not exceed 5 feet per second.
- All trapped air must be slowly released. Vents must be provided at all high points of the piping system. All valves and air relief mechanisms should be opened so that the air can be vented while the system is extremely dangerous and it must be slowly and completely vented prior to testing. For sizes 4" & above, recommends to use automatic air relief valves at every 300-400mt. distance & at furthest & highest points of pipeline to avoid any damage to the piping system.

The piping system can be pressurized to 125% of its designed working pressure. However care must be taken to ensure the pressure does not exceed the working pressure of the lowest rated component in the system (valves, unions, flanges, threaded parts etc.)

- The pressure test should not exceed one hour. Any leaking joints or pipe must be cut out and replaced and the line recharged and retested using the same procedure.

UNDERGROUND INSTALLATION

PVC-C pipes and fittings can be installed underground, Since these piping systems are flexible systems, proper attention should be given to burial conditions. The stiffness of the piping system is affected by sidewall support, soil compaction, and the condition of the trench, Trench bottoms should be smooth and regular in either undisturbed soil or a layer of compacted backfill. Pipe must lie evenly on this surface hroughout the entire length of its barrel, Excavation, bedding and backfill should be in accordance with the provision of the local Plumbing Code having jurisdiction.

TRENCHING

The following trenching and burial procedures should be used to protect the piping system.

1. The trench should be excavated to ensure the sides will be stable under all working conditions. The trench should be wide enough to provide adequate room for the following :
   i. Jointing the pipe in the trench.
   ii. Snaking the pipe from side or side to compensate for expansion and contraction.
   iii.. Filling and compacting the side fills.

   The space between the pipe and trench wall must be wider than the compaction equipment used in the compaction of the backfill. Minimum width shall not be less than the greater of either the pipe outside diameter plus 16 inches of the pipe outside diameter times 1.25 plus 12 inches. Trench width may be different if approved by the design engineer.

2. The trench bottom should be smooth, free of rocks and debris, continuous, and provide uniform support. If ledge rock, hardpan or large boulders are encountered, the trench bottom should be padded with bedding of compacted granular material to a thickness of at least 4 inches. Foundation bedding should be installed as required by the engineer.

3. Trench depth is determined by the pipe's service requirements. Plastic pipe should always be installed at least below the frost level. The minimum cover for lines subject to heavy overhead traffic is 24 inches.

4. A smooth, trench bottom is necessary to support the pipe over its entire length on firm stable material. Blocking should be used charge pipe grade or to intermittently support pipe over low sections in the trench.

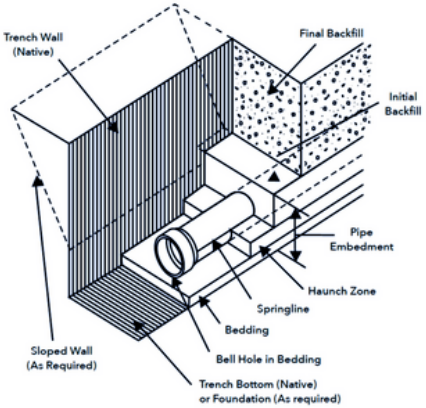
BEDDING AND BACKFILLING

1. Even though sub-soil conditions vary widely from place to place, the pipe backfill should be stable and provide protection for the pipe.

2. The pipe should be surrounded with a granular material which is easily worked around the sides of the pipe. Backfilling should be performed in layer of 6 inch with each layer being sufficiently compacted to 85% to 95% compaction.

3. A mechanical tamper is recommended for compacting sand and gravel backfill which contain a significant proportion of fine grained material, such as silt and clay. If a tamper is not available, compacting should be done by hand.

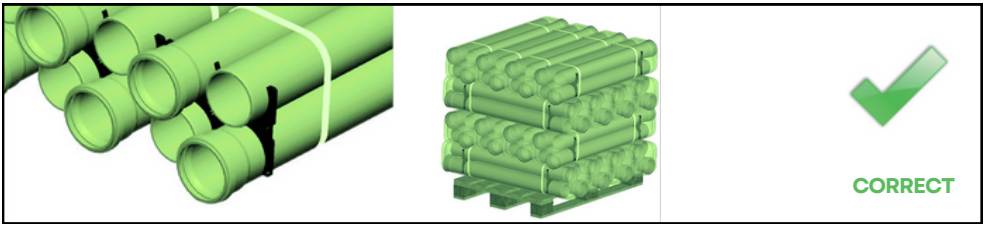
4. The trench should be completely filled. The back fill should be placed and spread in fairly uniform layers to prevent any unfilled spaces or voids. Large rocks, stones, frozen clods, or other large debris should be removed. Heavy tampers or rolling equipment should only be used to consolidate only the final backfill.



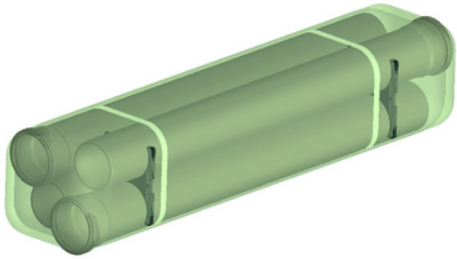
Packaging, Storage and Transportation

Packaging

Our pipes and fittings are packed as ready for transport in a customer-friendly way. Packing ensures safety, efficient storage and easy transport.

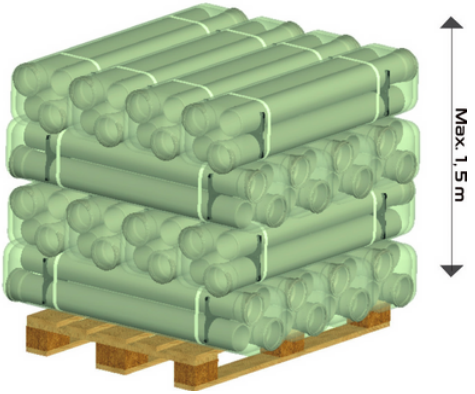


Short parts with the length of 150, 250 and 500 mm are packed in carton boxes like connection parts.



Pipes are packed by plastic clamps to hold them together. Stretch film is applied to protect pipes from pipes dust and stains.

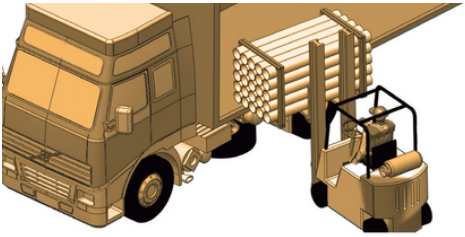
Storage

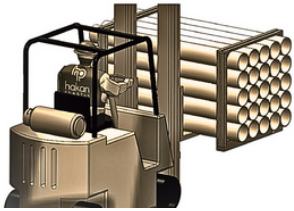


Method of storage should not cause any outflow and should not damage the pipes. As long as they are stored properly, no permanent deformations or damages will occur on the pipes and fittings. Pipes should not be stacked above 1,5 m. Pipes should be safe against sliding.

Pipes and fittings packed in carton boxes should be protected against moisture. Carton boxes should be sealed and stored in a dry area.

Transportation





Pipes should be carefully transported to prevent any damages. Avoid sudden and hard pressures on pipes and fittings that might cause freezing in cold weather conditions. Ensure that pipes are not slided and dropped on the floor. Loading and unloading and packing of pipes in a block should be carried out by means of forklifts having flat threads and extensions.

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