



Kejriwal
CASTINGS LIMITED

DUCTILE IRON
UPVC & OPVC PIPES



Ductile Iron Fittings

Suitable for
OPVC / UPVC / HDPE / PE
Piping Systems

QUALITY



We are committed to produce
quality Products
**(C.I., D.I., C.S. Valves, Pipes, Fittings,
Manhole Covers, Surface box etc.)**
consistently on schedule to the best
satisfaction of all our customers.

We shall also strive for improvement in
Quality Management System
by establishing and achieving
Quality Objectives
aimed at overall improvement
in our activities for enhanced
customer satisfaction.



Ductile Iron Fittings for OPVC/UPVC/HDPE or PE Piping System



Requirements and test methods

Scope

This European Standard specifies the requirements and associated test methods applicable to ductile iron fittings, ductile iron and mild steel couplings and flange adaptors and their joints to be used with poly (vinyl chloride) (PVC-U) pipes or polyethylene (PE) pipes

Standardized sizes

The standardized sizes of fittings, corresponding to the nominal outside diameter dn (in millimeters) of the pipes to which they shall be connected, are as follows : 63, 75, 90, 110, 125, 140, 160, 18, 200, 225, 250, 280, 315, 355, 400, 450, 500, 560, 630, 710.

Surface condition and repairs

Materials shall be free from defects and surface imperfections which could lead to non-compliance. Material characteristics

Ductile Iron

Tensile properties

Ductile iron fittings, couplings and flange adaptors shall have a minimum tensile strength of 420 Mpa and a minimum elongation after fracture of 5%. The tensile strength shall be tested in accordance.

Hardness

The Brinell hardness, shall not exceed 250 HBW. For components manufactured by welding, a higher Brinell hardness is allowed in the heat-affected zone of the weld.

Coatings

General All Materials shall be delivered with an external and internal epoxy coating in compliance with EN 14901. Alternatively, the coatings may also be supplied as required by the purchaser. (By agreement between the manufacturer and the purchaser, the lining/coating may be applied depending on the internal conditions of use)

Minimum Wall Thickness

dn	Min. Thickness, mm
dn ≤ 225	4.0
225 < dn ≤ 315	5.0
315 < dn ≤ 710	6.0

Hydrostatic Works Test Pressures

When Hydrostatic test is carried out, it shall be with the min. test pressure 16 bar for DN 40 mm to 630 mm, and the total duration of the pressure cycle shall be not less than 15 s, including 10 s at test pressure (as per EN:12842)

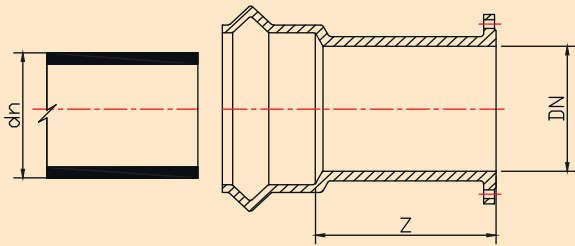
Tolerance / Deviations

The tolerance of fittings shall be as follows BS EN 12842

Note : Unless otherwise agreed between the purchaser and the manufacturer the requirement of sleeving shall comply with the requirements.

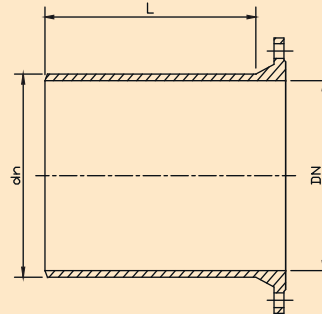


DIMENSION DETAILS - DUCTILE IRON FITTINGS FOR OPVC, UPVC, HDPE & PE PIPES



Flanged Socket

Nominal Outside Diameter of the Pipe dn	Nominal Diameter of the Flange DN	Minimum effective length Z
40	32	15
50	40	15
63	50	15
63	60	15
75	60	15
75	65	15
90	80	15
110	100	15
125	100	15
125	125	20
140	125	20
160	150	35
180	150	35
200	200	40
225	200	40
250	200	40
250	250	50
280	250	50
315	300	60
355	300	60
400	350	70
400	400	70
450	400	70
500	500	80
560	500	80
630	600	90
710	700	100

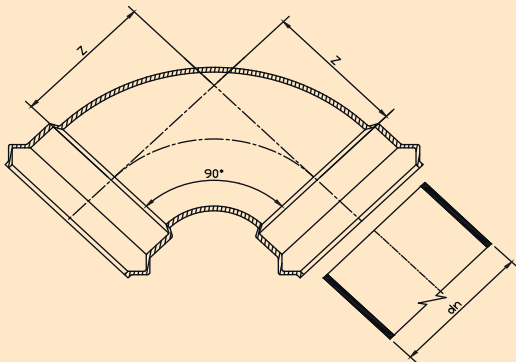


Flanged Spigot

Nominal Diameter dn	Tolerance on dn	Nominal Diameter of the Flange DN	Minimum Length L
40	0.2	32	85
50	0.2	40	89
63	0.3	50	93
63	0.3	60	93
75	0.3	60	98
75	0.3	65	98
90	0.3	80	102
110	0.4	100	110
125	0.4	100	114
125	0.4	125	114
140	0.5	125	119
160	0.5	150	127
180	0.6	150	133
200	0.6	200	139
225	0.7	200	147
250	0.8	200	156
250	0.8	250	156
280	0.9	250	166
315	1.0	300	176
355	1.1	300	187
400	1.2	350	198
400	1.2	400	198
450	1.4	400	212
500	1.5	500	224
560	1.7	500	241
630	1.9	600	260
710	2.0	700	281

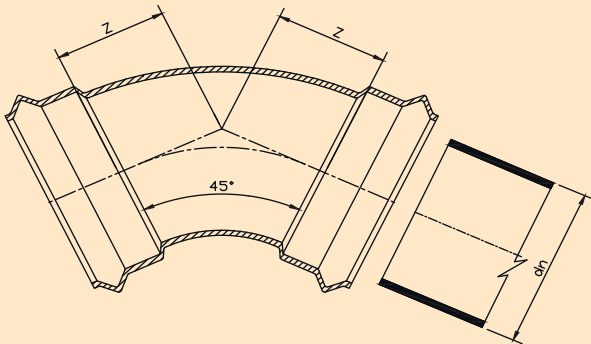
We can manufacture products of any size, type and dimensions as per Client requirement.

DIMENSION DETAILS - DUCTILE IRON FITTINGS FOR OPVC, UPVC, HDPE & PE PIPES



Double Socket 90° Bend

Nominal Outside Diameter of the Pipe dn	Minimum effective length Z
40	60
50	60
63	65
75	70
90	75
110	85
125	110
140	110
160	130
180	160
200	160
225	160
250	185
280	205
315	215



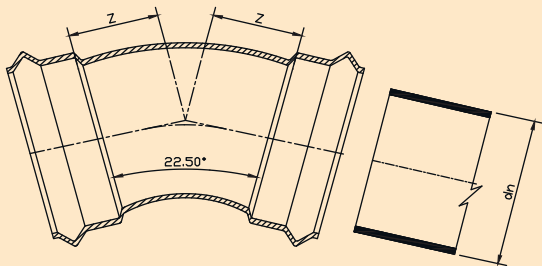
Double Socket 45° Bend

Nominal Outside Diameter of the Pipe dn	Minimum effective length Z
40	40
50	40
63	40
75	40
90	50
110	60
125	65
140	65
160	70
180	70
200	70
225	80
250	110
280	130
315	135
355	170
400	175
450	200

We can manufacture products of any size, type and dimensions as per Client requirement.

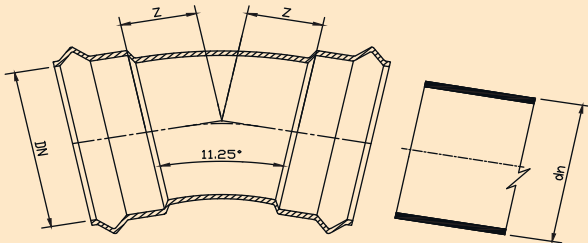


DIMENSION DETAILS - DUCTILE IRON FITTINGS
FOR OPVC, UPVC, HDPE & PE PIPES



Double Socket 22.5° Bend

Nominal Outside Diameter of the Pipe dn	Minimum effective length Z
40	20
50	20
63	20
75	25
90	25
110	30
125	30
140	30
160	35
180	40
200	40
225	45
250	50
280	75
315	85
355	95
400	110
450	120

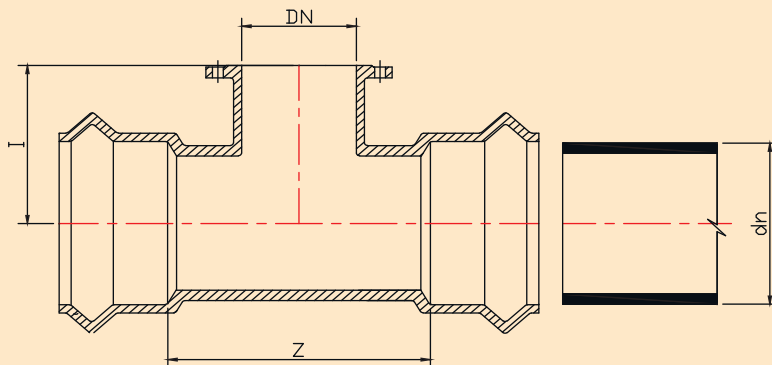


Double Socket 11.25° Bend

Nominal Outside Diameter of the Pipe dn	Minimum effective length Z
40	20
50	20
63	20
75	25
90	25
110	30
125	30
140	30
160	30
180	30
200	30
225	40
250	40
280	50
315	55
355	60
400	65
450	70

We can manufacture products of any size, type and dimensions as per Client requirement.

DIMENSION DETAILS - DUCTILE IRON FITTINGS
FOR OPVC, UPVC, HDPE & PE PIPES



Double Socket Tee with Flanged Branch

Nominal Diameter of the Pipe dn	Nominal Diameter of the Branch DN	Minimum Effective Length Z	Minimum Height I
40	40	60	130
50	40	60	130
63	40	70	140
63	50	70	140
63	60	70	140
75	40	60	130
75	50	70	140
75	60-65	85	140
90	40	65	135
90	50	75	145
90	60-65	90	155
90	80	105	160
110	40	65	145
110	50	75	145
110	60-65	90	165
110	80	105	170
110	100	125	170
125	40	65	160
125	60-65	90	160
125	80	105	170
125	100	125	180
125	125	150	180
140	40	65	160
140	60-65	90	180
140	80	105	185
140	100	125	195

Nominal Diameter of the Pipe dn	Nominal Diameter of the Branch DN	Minimum Effective Length Z	Minimum Height I
140	125	150	200
160	40	65	170
160	50	75	170
160	60-65	90	190
160	80	105	200
160	100	125	205
160	125	150	210
160	150	175	220
180	40	65	195
180	60-65	90	215
180	80	105	225
180	100	125	230
180	125	150	240
180	150	175	245
180	200	220	250
200	40	100	195
200	50	110	195
200	60-65	125	215
200	80	140	225
200	100	160	230
200	125	185	240
200	150	210	245
200	200	260	250
225	40	100	195
225	50	110	195
225	60-65	125	215

We can manufacture products of any size, type and dimensions as per Client requirement.



DIMENSION DETAILS - DUCTILE IRON FITTINGS
FOR OPVC, UPVC, HDPE & PE PIPES

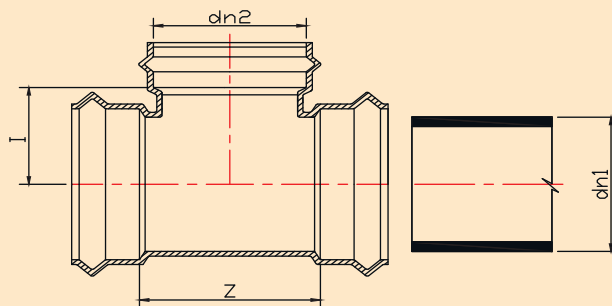
Double Socket Tee with Flanged Branch

Nominal Diameter of the Pipe dn	Nominal Diameter of the Branch DN	Minimum Effective Length Z	Minimum Height I
225	80	140	225
225	100	160	230
225	125	185	240
225	150	210	245
225	200	260	260
250	60-65	140	250
250	80	155	250
250	100	175	255
250	125	200	260
250	150	225	265
250	200	275	275
250	250	325	285
280	60-65	140	260
280	80	155	265
280	100	175	270
280	150	225	280
280	200	275	280
280	250	325	290
315	60-65	140	290
315	80	155	295
315	100	175	300
315	125	200	305
315	150	225	310
315	200	275	310
315	250	325	310
315	300	375	310

Nominal Diameter of the Pipe dn	Nominal Diameter of the Branch DN	Minimum Effective Length Z	Minimum Height I
355	60-65	140	320
355	80	155	325
355	100	175	330
355	150	225	340
355	200	275	350
355	250	325	360
355	350	420	280
400	80	175	340
400	100	210	355
400	150	275	360
400	200	325	365
400	250	370	375
400	300	420	385
400	400	520	395
450	100	210	340
450	150	275	360
450	200	325	365
450	250	370	375
450	300	420	385
450	400	520	395
450	450	570	460
500	150	275	380
500	300	420	440
600	150	275	400
600	300	420	460

We can manufacture products of any size, type and dimensions as per Client requirement.

DIMENSION DETAILS - DUCTILE IRON FITTINGS
FOR OPVC, UPVC, HDPE & PE PIPES



All Socket Tee

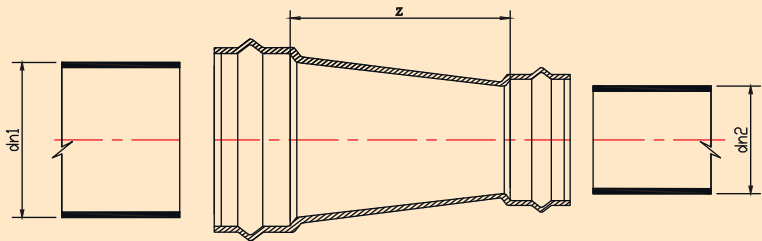
Nominal Diameter of the Pipe d_{n1}	Nominal Diameter of the Branch d_{n2}	Minimum Effective Length Z	Minimum Height I
40	40	60	25
50	50	60	30
63	63	70	30
75	63	70	45
75	75	85	45
90	63	75	50
90	75	90	50
90	90	105	50
110	63	75	60
110	75	90	60
110	90	105	60
110	110	125	60
125	63	75	70
125	75	90	70
125	90	105	70
125	110	125	70
125	125	150	70
140	63	75	75
140	75	90	75
140	90	105	75
140	110	125	75
140	125	150	75
140	140	150	75
160	63	75	85
160	75	90	85
160	90	105	85
160	110	125	85
160	125	125	85
160	140	150	85
160	160	175	85
180	63	75	95
180	90	90	95
180	110	125	95

Nominal Diameter of the Pipe d_{n1}	Nominal Diameter of the Branch d_{n2}	Minimum Effective Length Z	Minimum Height I
180	160	175	95
180	180	190	95
200	63	110	105
200	90	140	105
200	110	160	105
200	125	160	105
200	140	185	105
200	160	210	105
200	180	230	105
200	200	240	105
225	63	110	120
225	90	140	120
225	110	160	120
225	160	210	120
225	200	240	120
225	225	260	120
250	90	155	130
250	110	175	130
250	160	225	130
250	200	250	130
250	225	270	130
250	250	300	130
280	90	155	145
280	110	175	145
280	160	225	145
280	200	250	145
280	250	300	145
280	280	325	125
315	110	170	165
315	160	225	165
315	200	250	165
315	250	300	165
315	280	325	165
315	315	375	165

We can manufacture products of any size, type and dimensions as per Client requirement.



DIMENSION DETAILS - DUCTILE IRON FITTINGS
FOR OPVC, UPVC, HDPE & PE PIPES



Double Socket Taper

Nominal Outside Diameter of the Pipe		Minimum Effective Length	
d _{n1}	d _{n2}	Series A Long Z _A	Series B Short Z _B
50	40	70	20
63	50	70	20
75	63	80	20
90	50	80	30
90	63	80	25
90	75	80	20
110	63	160	35
110	75	120	35
110	90	85	130
125	75	190	55
125	90	135	45
125	110	100	40
140	75	190	55
140	90	135	45
140	110	100	40
140	125	100	40
160	90	190	55
160	110	150	50
160	125	100	40
160	140	100	40
180	90	250	90
180	110	250	80
180	125	200	70
180	140	145	65
180	160	145	60
200	90	250	95
200	110	250	85

Nominal Outside Diameter of the Pipe		Minimum Effective Length	
d _{n1}	d _{n2}	Series A Long Z _A	Series B Short Z _B
200	125	250	75
200	140	200	70
200	160	145	70
200	180	145	60
225	125	250	80
225	140	200	75
225	160	145	70
225	180	145	65
225	200	145	60
250	125	300	95
250	160	250	90
250	200	150	80
280	160	250	100
280	200	150	80
280	250	150	60
315	200	250	105
315	250	150	90
315	280	150	80
355	200	360	160
355	250	260	110
355	315	160	100
400	250	360	200
400	315	260	160
400	355	155	155
450	315	360	175
450	355	260	160
450	400	160	155

We can manufacture products of any size, type and dimensions as per Client requirement.



Eco Friendly
"GREEN IRON"
production, by maximum use of
Renewable Energy Sources,
Solar Energy
& Natural Gas

Kejriwal
CASTINGS LIMITED



*Millenium City
DN 62, Salt Lake
Sector - V, 14th Floor
Tower 2
Kolkata 700091
Bharat (India)*

*Phone: 033 4801 6753/5964
033 4804 0845/0849*

*E-mail: info@kejriwalcastings.com
Website: www.kejriwalcastings.com*

Works Unit I :
*NH-6, Chamrail,
Howrah - 711 114
West Bengal
Bharat (India)
Phone : +91 0321 2247244
+91 0321 2247527*

Works Unit II :
*Bamunara Industrial Estate
Bamunara, Durgapur 713 212
West Bengal
Bharat (India)*



Kejriwal
CASTINGS LIMITED

Mfg. of Ductile Iron, Cast Iron Pipes, Fittings, Valves Etc

You name it. We cast it !