

## **Technical Specifications of HDPE PIPES, IS:4984 & IS:14333**

	Test Results	Acceptance Norms	Reference
<b>1</b>	<b>Raw Material &amp; Test Results</b>		
1	Density Melt Flow	0.940 to 0.958 G/CC	IS:4984:1995
2	Rate (MFI)	0.2 to 1.1 Mins.	IS:14333:1996
<b>2</b>	<b>Visual Appearance</b>		
a)	Surface finish	Satisfactory. The internal & external surface of the pipes are smooth and free from grooving & other defects.	IS:4984:1995 IS:14333:1996
a. b. c. d. e.	Dimensions & Tolerances Outside Diameter Wall Thickness, of Pipe Ovality Length: Pipe/Coil	As per relevant BIS Standards	IS:4984:1995 IS:14333:1996
<b>3</b>	<b>Performance Requirement</b>		
a.	Heat Reversion	3% (Max.) Longitudinal Reversion	IS:4984:1995 IS:14333:1996
b.	Hydrostatic Pressure Resistance Test	No failure or leakage during the specified period <u>Acceptance Test:</u> Duration 48 Hrs at 80° Cat specified stress value. <u>Type Test:</u> Duration 165 Hrs at 80° C at specified Stress value.	
c.	Overall Migration Test	10 Mg/dm <sup>2</sup>	
d.	Carbon Black Content	2.5 + 0.5%	
e.	Carbon Black Dispersion	Satisfactory	
f.	Density	940.0 to 958.0 KG/M <sup>3</sup>	
g.	Melt Flow Rate	0.2 to 1.1 Gms/ 10 Mins	
<b>4</b>	<b>Identification Marking &amp; Color</b>		
		Color: Black. A pipe is marked in white color by hot embossed or by indelible ink/paint by screening as mentioned below at every meter or on the either end of pipes. Each Pipe has three equi-spaced longitudinal stripes in Blue color a) Manufacturer's Name b) Designation of Pipe c) Batch Number.	IS:4984:1995 IS:14333:1996