



SCHEDULE 80 FITTINGS

UPVC.CPVC

SCHEDULE 40,80,

CPVC PIPE

Scope : RThis specification covers requirements for Schedule 40 And 80 CPVC pressure pipe as described in ASTM F-441.

Material : RCPVC used is Type IV,Grade I compound, cell classification 23447-B per ASTM D-1784.

Dimensions : RDimensions and tolerances shall be as shown in the following tables when measured according to Method D-2122.Tolerances for out-of-roundness shall apply only to pipe prior to shipment.

Marking : RIndicates manufacturer's name,material designation code, nominal pipe size,Schedule size with pressure rating in PSI for water at 73cXF, ASTM designation number F-441,

Out Diameters and Tolerances

Nominal Pipe Size	Outside Diameter	Average	Tolerances	
			For Maximum and Minimum Diameter(Out-of-Roundness)	
			Schedule 40	Schedule 80
1/8	0.540	±0.004	±0.008	±0.008
3/8	0.675	±0.004	±0.008	±0.008
1/2	0.840	±0.004	±0.008	±0.008
3/4	1.050	±0.004	±0.010	±0.010
1	1.315	±0.005	±0.010	±0.010
1-1/4	1.660	±0.005	±0.012	±0.012
1-1/2	1.900	±0.006	±0.012	±0.012
2	2.375	±0.006	±0.012	±0.012
2 1/2	2.87	±0.007	±0.015	±0.015
3	3.500	±0.008	±0.015	±0.015
3 1/2	4.000	±0.008	±0.050	±0.015
4	4.500	±0.009	±0.050	±0.015
5	5.563	±0.010	±0.050	±0.030
6	4.625	±0.011	±0.050	±0.035
8	8.625	±0.015	±0.075	±0.075
10	10.750	±0.015	±0.075	±0.075
12	12.750	±0.015	±0.075	±0.075

Wall Thicknesses and Tolerances

Nominal Pipe Size	Tolerances			
	Schedule 40		Schedule 80	
	Minmum	Tolerance	Minmum	Tolerance
1/8	0.088	± 0.020	± 0.119	± 0.020
3/8	0.091	± 0.020	± 0.126	± 0.020
1/2	0.109	± 0.020	± 0.147	± 0.020
3/4	0.113	± 0.020	± 0.154	± 0.020
1	0.133	± 0.020	± 0.179	± 0.021
1-1/4	0.140	± 0.020	± 0.191	± 0.023
1-1/2	0.145	± 0.020	± 0.200	± 0.024
2	0.154	± 0.020	± 0.218	± 0.026
2 1/2	0.203	± 0.024	± 0.276	± 0.033
3	0.216	± 0.026	± 0.300	± 0.036
3 1/2	0.226	± 0.027	± 0.318	± 0.038
4	0.237	± 0.028	± 0.337	± 0.042
5	0.258	± 0.031	± 0.375	± 0.045
6	0.280	± 0.034	± 0.432	± 0.052
8	0.322	± 0.039	± 0.500	± 0.060
10	0.365	± 0.044	± 0.593	± 0.071
12	0.406	± 0.049	± 0.687	± 0.082

Note : The minimum is the lowest wall thickness of the pipe at any cross section. All tolerances are on the minimum requirement. These dimensions conform to nominal PS dimensions.

HT-PVC 管CNS 規格 : CNC Specifications of HT-PVC ipes:

標稱管徑 Nominal Pipe Size	外徑及許可差 ⁽¹⁾ Outside diameter & tolerance ⁽¹⁾	近似內徑 (參考) Approx. inside diameter	厚度 Wall thickness		質量(kg/M) ⁽²⁾ (參考) Approx. weight(kg/M) ⁽²⁾	
			最小 Minmum	許可差 Tolerance		
13	3/8"	18 ± 0.2	13	2.2	0.6	0.180
16	1/2"	22 ± 0.2	16	2.7	0.6	0.265
20	3/4"	26 ± 0.2	20	2.7	0.6	0.322
25	1"-W	32 ± 0.3	25	3.2	0.6	0.464
28	1"-B	34 ± 0.3	27	3.2	0.6	0.496
30	1 1/4"-W	38 ± 0.3	31	3.2	0.6	0.561
35	1 1/4"-B	42 ± 0.3	35	3.2	0.6	0.626
40	1 1/2"	48 ± 0.4	40	3.6	0.8	0.818
50	2"	60 ± 0.5	51	4.1	0.8	1.160
65	2 1/2"	76 ± 0.5	67	4.1	0.8	1.490
80	3"	89 ± 0.5	78	5.1	0.8	2.140
100	4"	114 ± 0.6	100	6.6	1.0	3.530
125	5"	140 ± 0.8	124	7.5	1.2	4.970
150	6"	165 ± 1.0	147	8.5	1.4	6.660
200	8"	216 ± 1.3	194	10.5	1.4	10.660
250	10"	267 ± 1.6	239	13.0	1.8	16.350
300	12"	318 ± 1.9	285	15.5	2.2	23.250
350	14"	370 ± 2.2	332	18.0	2.6	31.450
400	16"	420 ± 2.6	376	20.5	3.0	40.690

- Outer diameter shall refer to the arithmetic mean value of any 2 given O.D. at theRight angle to each other.
- Approximate weight shall be estimated by adding the minimum thickness to 1/2 of The allowable thickness tolerance at the specific gravity of 1.48.