

# Industry Design and Installation

Plan, Build, Operate



# Planning Fundamentals

**Industrial Piping Systems  
Design and Installation**

#### Disclaimer

The General Terms and Conditions of Supply of Georg Fischer Piping Systems shall apply, available from your respective Georg Fischer Piping Systems sales company.

The contents of this manual have been compiled with the greatest possible care. Georg Fischer Piping Systems and its affiliates ("GFPS") make no warranties, representations or guarantees with respect to the information and data contained in this manual.

The technical data are not binding. It does not constitute warranted characteristics or guarantees of quality or durability.

GFPS assumes no liability for the completeness, correctness or up-to-dateness of the information and data provided in this manual. In no event shall GFPS be liable to you or any third party for any direct, indirect, special or other consequential damages arising out of the use of the information or data in this manual. Any liability for loss of profit, business interruption or other financial damage etc. is also excluded.

GFPS expressly reserves the right to change, amend, delete or temporarily or permanently cease publication of the contents of this manual without prior notice.

#### Trademarks and brands

The following terms used in this manual are brand names, registered trademarks, trade names or common names of the respective manufacturers and are subject to corresponding industrial property rights. "Georg Fischer" and "+GF+" are registered trademarks of Georg Fischer Ltd.

#### Copyright

All information and data in this manual are the property of GFPS or of third parties who provide this information to GFPS. The information and data in this manual including all texts, photos and illustrations are protected by copyright. The complete or partial duplication and publication or use of this information and data in any way without the prior written consent of GFPS is not permitted.

All rights reserved.

© GFPS, Schaffhausen 01/2024

# Planning Fundamentals

## Industrial Piping Systems

### Planning Fundamentals

### Industrial Piping Systems

**Book 1 - Design and Installation**

**Book 2 - Valves and Actuators**

**Book 3 - Measurement and Control**

# Content

<b>I</b>	<b>Introduction</b> .....	<b>11</b>
1	How to use.....	12
2	GF Piping Systems.....	14
3	Quality.....	15
4	Sustainability.....	17
5	Services.....	18
6	Training.....	20
<b>II</b>	<b>Piping Solutions</b> .....	<b>21</b>
1	Market Segments.....	22
2	System and Product Solutions.....	41
<b>III</b>	<b>Plastic Piping Materials</b> .....	<b>85</b>
1	Introduction to Plastics Materials.....	86
2	Properties of Plastic Piping Materials.....	93
3	Approvals and standards.....	107
4	Material Selection – Chemical Resistance.....	120
<b>IV</b>	<b>Design and Installation</b> .....	<b>127</b>
1	Symbols, SI-Units and Conversion Tables.....	129
2	Pipeline Design.....	138
3	Hydraulic Calculation and Pressure Losses.....	180
4	Installation.....	190
5	Jointing technology – Mechanical joints.....	242
6	Jointing technology – Cementing.....	256
7	Jointing technology – Welding.....	275
<b>V</b>	<b>Double Containment Solutions</b> .....	<b>283</b>
1	CONTAIN-IT Plus.....	285
<b>VI</b>	<b>Pre-Insulated Solutions</b> .....	<b>365</b>
1	COOL-FIT 2.0.....	367
2	COOL-FIT 4.0.....	451

# Preface

GF Piping Systems is a major global provider of complete piping solutions for many demanding applications in various market segments. Founded in 1802, Georg Fischer started the first production of malleable iron fittings in 1864 and today is recognized as the pioneer in the development of corrosion-free plastic piping systems for the safe and reliable conveyance of liquids and gases. This technical handbook reflects more than 60 years of our experience and know-how in the designing and manufacturing of plastic piping systems. Today, our product portfolio consists of more than 60'000 products and we are supporting our customers with products and services day to day around the globe.

The scope of these planning fundamentals is to offer a valuable support in planning selection of the proper materials and the most suitable product range for all main industrial applications. In addition, the handbook provides extensive information about all jointing technologies for plastic materials and gives technical advises in the installation of pipes, fittings, valves, measurements and control, as well as actuation.

We strongly believe that the professional planning and the proper use of our comprehensive product range are the base for reliability, safety and high quality of plastic piping systems.

We hope that, in this handbook, you will find the qualified support that you need for your daily work.

In case of special applications our worldwide technical engineers will be glad to assist you.

We would like to thank everyone, who continues to support GF Piping Systems in its mission to delivering more value to customers, through superior piping systems.

Schaffhausen, 01/2024





# Introduction

## Content

<b>1</b>	<b>How to use</b> .....	<b>12</b>
<b>2</b>	<b>GF Piping Systems</b> .....	<b>14</b>
<b>3</b>	<b>Quality</b> .....	<b>15</b>
3.1	Quality assurance at all levels .....	15
3.2	Management systems.....	15
3.3	Accredited test center.....	15
<b>4</b>	<b>Sustainability</b> .....	<b>17</b>
4.1	Environment.....	17
4.2	Social aspects .....	17
<b>5</b>	<b>Services</b> .....	<b>18</b>
<b>6</b>	<b>Training</b> .....	<b>20</b>

# 1 How to use

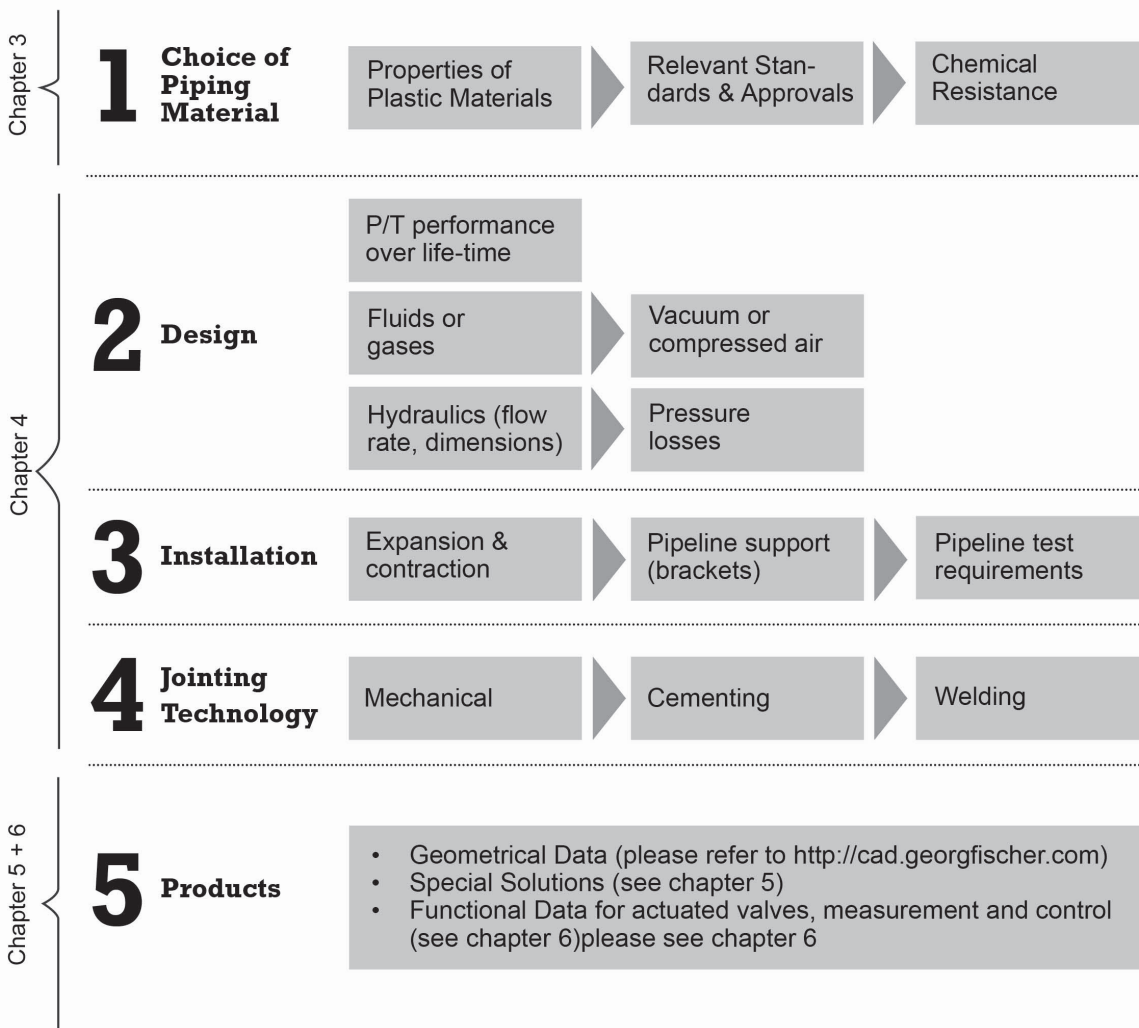
This handbook describes and explains the basic fundamentals for planning, product selection, processing and installation of pressure pipe in industrial applications.

It is suitable as a reference book as well as documents for training and education or to support the consultation. All specifications are based on the relevant international ISO and EN standards, on various national standards, DVS guidelines and additional information from raw material suppliers. In addition, the results of extensive internal investigations are incorporated. Thus the designer, engineer and installer should be given the necessary assistance to properly plan and install their plastic piping system.

Selection and weighting of the topics are focused on the explanation of the design-relevant areas. Detailed instructions of the products are to be taken from the corresponding installation and operating instructions.





Planning fundamentals for utility and building-technology systems are available in separate handbooks. For further information, please contact your local country representative or refer to: [www.gfps.com](http://www.gfps.com)

## Planning Fundamentals for Plastic Piping Systems












## Overview of symbols

### General symbols

	General information		Note
	Example		Online calculation tools and mobile applications

### Symbols of materials

	Abrasion resistance		Application limits
	Combustion behavior		Mechanical characteristics
	Chemical resistance		Physiological properties
	High-purity properties		UV and weather resistance
	Application limits		

## List of abbreviations

### Abbreviations Description

BGA	German health authority
BgVV	Federal Institute for Consumer health protection and veterinary medicine
DIBt	German Institute for construction technology
DVGW	German association of gas and water e.V.
DVS	German association of welding technology
EPDM	Ethylene propylene diene rubber
FAR	Federal Aviation Regulations
FDA	Food and Drug Administration
FKM	Fluororubber
GFK	Fiberglass reinforced plastics
KTW	Plastic drinking water recommendation by the Federal Health Office
MFR	Melt Flow Rate
MRS	Minimum Required Strength
NBR	Nitrile rubber (Buna-N)
NR	Natural rubber
PB	Polybutene
PE	Polyethylene
PE-X	Polyethylene
PP	Polypropylene
PTFE	Polytetrafluorethylene
PVC	Polyvinyl chloride
PVC-C	Polyvinyl chloride, chlorinated
PVC-U	Polyvinyl chloride, unplasticized
PVDF	Polyvinylidene fluoride
SDR	Standard Dimension Ratio
TG	Malleable iron
UP-GF	Unsaturated polyester resin, glass fiber reinforced

## 2 GF Piping Systems

### Global presence

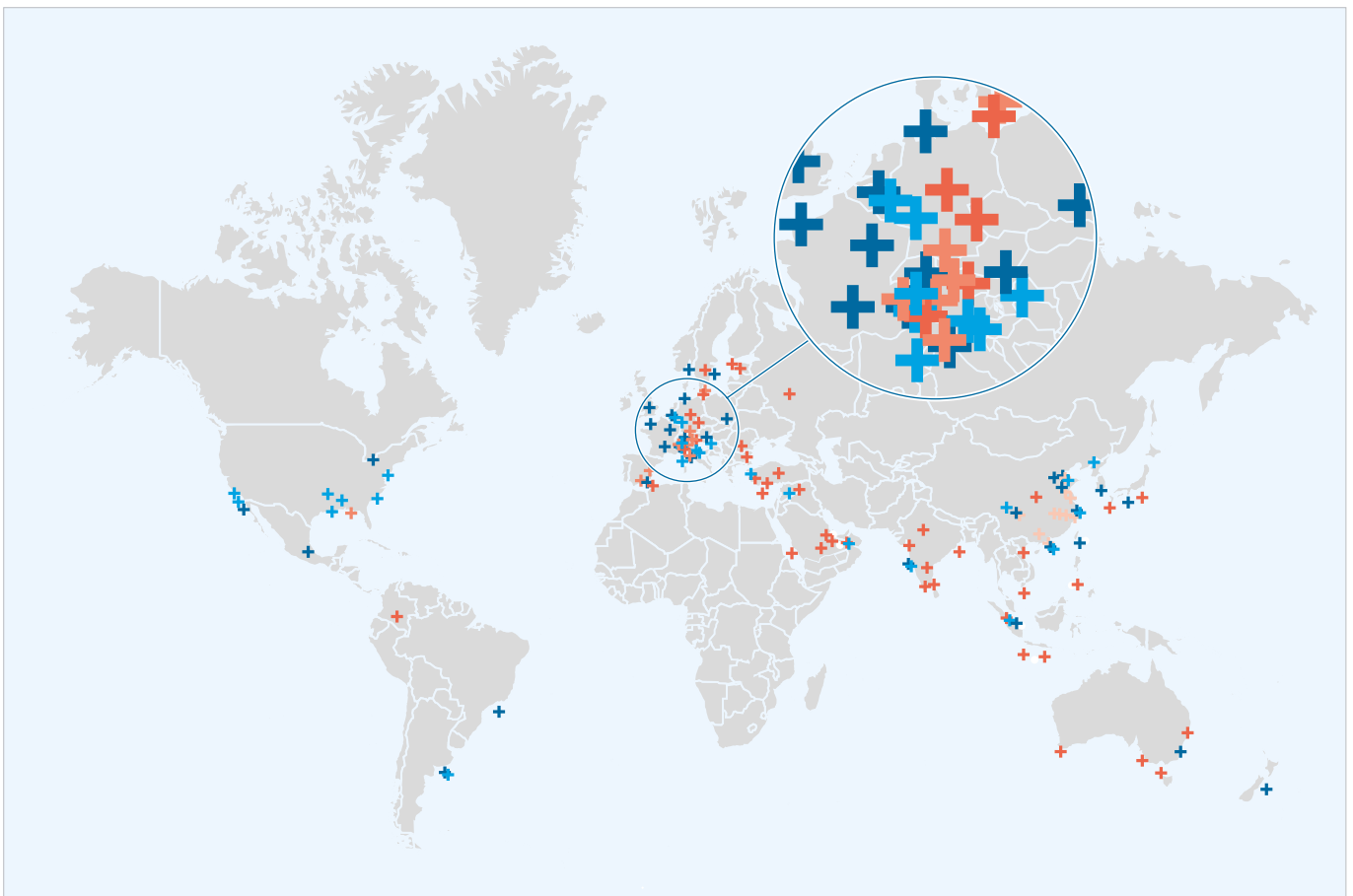
Our global presence ensures customer proximity worldwide. Sales companies in over 25 countries and representatives in another 80 countries provide customer service around the clock. With 50 production sites in Europe, Asia and the USA we are close to our customers and comply with local standards. A modern logistics concept with local distribution centers ensures highest product availability and short delivery times. GF Piping Systems specialists are always close by.

### Complete solutions provider

With over 60,000 products, we offer individual and comprehensive system solutions for a variety of industrial applications. Having the profitability of the projects in focus, we optimize processes and applications that are integrated into the complete systems. Continually setting standards in the market, we directly provide our customers with technological advantages. Due to our worldwide network of qualified contact partners, customers benefit directly from our 50 years+ experience in plastics.

From start to finish, we support our customers as a competent, reliable and experienced partner, actively contributing the know-how of an industrial company that has been successful in the market for over 200 years.

- GF corporation worldwide**
- + Sales company
  - + Production site
  - + Representatives
  - + Logistics center
  - + Suppliers



## 3 Quality

### 3.1 Quality assurance at all levels

Quality creates safety and is the basis for trust. In customer relationships as well as in project work, development, production and in the specific application of products, quality awareness and standards decide on sustainable success. The fundamental importance of quality determines our actions, shapes our understanding of quality, and is reflected in our own claim to quality.

The systematic integration of partners and suppliers is part of our comprehensive understanding of quality and guarantees the binding assurance of the quality standard along the entire value added chain.

GF Piping Systems is bound to the high quality standards of its customers and considers itself actively responsible for meeting the customer requirements as well as ensuring legal standards. The rigorous implementation of our quality policy represents an obligation for every single person. Consequently, the orientation towards quality when providing a service goes without saying for all employees working in the company.

### 3.2 Management systems

Quality, environment, occupational safety and health protection have always played a very important role in the Georg Fischer group. In line with that, all production companies as well as many sales companies of GF Piping Systems are certified in accordance with the ISO 9001 quality management system. Furthermore, all of our production sites are certified in accordance with ISO 14001. The standard defines criteria that are applicable throughout the world for efficient environmental management systems and, as a result, is considered to be the basis for optimizing environmentally relevant processes.

As part of our sustainability activities, all production sites have also been certified in accordance with OHSAS 18001, the international standard in the area of occupational health and safety. Newly acquired or newly founded production companies are bound to establish a quality, environmental and occupational safety management regime within a period of three years.



### 3.3 Accredited test center

The test center of GF Piping Systems is a test center accredited in accordance with ISO/IEC 17025 for components of piping systems. It inspects all types of pipe, pipe connections, connecting elements, fittings, manual and automatic valves as well as flow meters according to relevant standards and its own external as well as internal specifications.

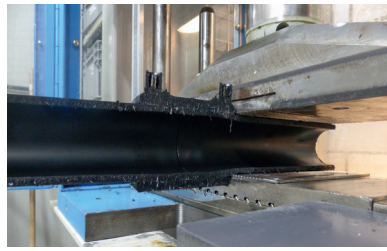
Customers for test laboratory programs are the R&D departments, manufacturing plants, as well as end-users of GF Piping Systems components and other external customers.

Development and product release tests are completed for R&D departments (TT type testing, ITT initial type testing), batch release tests (BRT) and process verification tests (PVT) for our own production units as well as other tests for external customers.

The continuous training and specific experience of our employees, the technical state of our testing systems, as well as properly documented test sequences are basic prerequisites to accrediting the test center in accordance with ISO/IEC 17025. The accreditation by SAS (Swiss Accreditation Office) is confirmed in the form of a certificate. A verification takes place annually as well as a renewal of the accreditation every 5 years.



The SAS, which is responsible for GF and has issued our accreditation, is a member of the International Laboratory Accreditation Cooperation (ILAC). All laboratories accredited by the ILAC are obliged to formally recognize any test report issued by a fellow member. This permits us, and our customers, to use all accredited test reports originating from our laboratory to obtain product approvals and quality certificates, etc. Therefore, potential expenditure and time consumption is considerably reduced.



The accredited test program also includes:

- Long-term internal pressure testing (EN ISO 10931, EN ISO 15493, EN ISO 15494, ISO 9393)
- Burst tests on fittings and pipe
- Crush tests (ISO 9853)
- Impact resistance tests (ISO 13957)
- Decohesion test of polyethylene (PE) saddle fusion joints (ISO 13956)
- Decohesion test (ISO 13955)
- Peeling test (ISO 13954)
- Tensile strength and failure mode on butt-fused test specimens (ISO 13953)
- Pressure drop test (EN ISO 17778)
- Determination of density (EN ISO 1183)
- Melt flow rate (EN ISO 1133)
- Oxidation induction time OIT (EN ISO 11357-6)

A complete listing of accredited tests can be seen in a table. This table, which is constantly updated, can be referred to by consulting the following internet site:

[www.sas.ch](http://www.sas.ch)

- ▶ Accredited bodies
- ▶ Search
- ▶ STS 094.



## 4 Sustainability

- As an internationally operating industrial group, GF is in the midst of society. It is, therefore, important to harmonize economy, ecology and social aspects. In accordance with this responsibility, our industrial and social activities carry a long-term and long-range orientation. It is our endeavor to anchor sustainability in all of our sales companies. Our sustainability goals, whose attainment we communicate regularly and transparently, drive our actions.

### 4.1 Environment

For GF Piping Systems, our own environmental responsibility is an integral aspect in all of our business activities. Because we regard environmental awareness as one of the most important values of our company, all internal structures and processes are oriented towards sustainability. We strive to save natural resources and work relentlessly on optimizing the eco-friendliness of our products and their applications. Outstanding material properties and innovative technologies form the basis of our environmentally friendly and energy-saving solutions. By supplying our customers with complete piping systems, we support and promote ecological and cost-efficient operating processes in many industries and in daily routine. To obtain detailed information about the environmental compatibility of our products, we monitor all phases of the product life cycle in detail, which also allows us ultimately to improve the life cycle assessment of our products.

### 4.2 Social aspects

Attractive workplaces, interesting tasks, a goal-oriented training and professional development, as well as a fair salary and good social benefits contribute to securing the future of the company. GF Piping Systems operates with this responsibility as its premise. With locations in over 30 countries, GF Piping Systems views the multitude of cultures, religions, nationalities, genders and age groups as a valuable source for talent, creativity and experience. This makes possible the extraordinary services performed by approximately 15,000 staff members employed by GF Piping Systems throughout the world.

**i** Additional information about sustainability can be found at [www.gfps.com/sustainability](http://www.gfps.com/sustainability)

## 5 Services

### From planning support to implementation – our specialists are always close by

As a leading provider of piping systems in plastic, we offer our customers not only reliable products, but also a comprehensive package of services. Our support ranges from a comprehensive technical manual or the extensive CAD library to an international team of experts, who work closely together with local sales companies. And when it comes to implementing a project, our customers additionally benefit from a wide range of training courses, either on site or in our modern training centers worldwide.

#### 1 Chemical resistance

Our specialist teams have decades of experience in the area of chemical resistance. They can offer individual support and advice in selecting the right material for the corresponding plastics system solution. On request, a team will examine and select the appropriate material for special applications.

#### 2 CAD library

The extensive CAD library is the most frequently used planning tool at GF Piping Systems. The database comprises over 30,000 drawings and technical data regarding pipe, fittings, measurement and control technology as well as manual and actuated valves. The big advantage of the CAD library is that the data can be integrated directly in CAD models.

#### 3 Technical support

Technical support and material selection are key factors for a successful installation. A team of specialists headquartered in Switzerland is available to support the GF Piping Systems sales companies around the world. For technical advice or for general information, our customers are supported individually by the specialist team in the corresponding sales company.

#### 4 Online and mobile calculation tools

Our numerous, multilingual online calculation tools are very useful for configuring and calculating. By means of pressure/temperature diagrams, the pressure of liquid media recommended for pipe and fittings at various temperatures can be easily defined. FlowCalc App, the mobile application of GF Piping Systems, is an on-site planning tool for pipe diameter and flow velocity calculation to select the right dimension of piping systems.

#### 5 On-site training

Our experts are available to support our customers locally and conduct training in diverse fusion and jointing techniques on location. The duration and structure of the training depends on the project and the system being installed.

#### 6 Customizing

The customizing teams at GF Piping Systems work closely together around the globe. The focus of these teams is to manufacture custom parts for special systems. In addition, a variety of special solutions can be produced in small series. Standardized processes warrant the highest level of quality for the individual solutions of our customers.

#### 7 Planning Fundamentals

For our customers, we have documented the extensive know-how of GF Piping Systems in planning and installing plastic piping systems in our technical manual. This detailed documentation is available in both printed and digital versions. The reference book is helpful in planning large and small projects.



## 8 Training courses

GF Piping Systems offers a wide range of training courses that allow participants to gain confidence in working with our products and proven jointing technologies. The practical training is clearly defined, structured and adapted to the various levels of experience of the participants.



## 6 Training

Qualified personnel is one of the key factors for the success of a company. Only highly motivated and well-trained employees with the appropriate know-how and customer focus are reliable partners.

GF Piping Systems, as a professional system and solution provider, offers you training courses with a focus on products, applications, sales arguments and different customer requirements.



The joining technologies, as well as measurement and control technology are increasingly innovative. To stay up-to-date, you need continuing education. GF Piping Systems makes an essential contribution to your know-how. No matter what your field of expertise may be – utilities, building technology or industrial applications – you can benefit from the training courses, which are adapted to the different market segments and applications.



We offer a customized program for sales personnel and occupational groups such as installers, planners and plant builders. Besides the theory, we attach great importance to hands-on practice. Our rooms are especially equipped for practical training. They are suitable for simultaneous training of up to 100 persons under ideal conditions. We work together closely with our sales personnel when selecting trainers. There are basic, advanced and master courses, which are all structured in a coordinated fashion.



For additional information about the current training program, visit [www.gfps.com](http://www.gfps.com)

# Piping Solutions

## of GF Piping Systems

## Content

<b>1</b>	<b>Market Segments.....</b>	<b>22</b>
1.1	Water Treatment.....	22
1.2	Chemical Process Industry.....	24
1.3	Microelectronics.....	26
1.4	Cooling.....	28
1.5	Energy.....	30
1.6	Marine.....	32
1.7	Water Utilities.....	34
1.8	Gas Utilities.....	36
1.9	Building Technology.....	38
1.10	Application-System Overview.....	40
<b>2</b>	<b>System and Product Solutions.....</b>	<b>41</b>
2.1	Advantages of Industrial Plastic Piping Systems.....	41
2.2	Most Important Market Segments.....	41
2.3	PVC-U Piping System.....	42
2.4	PVC-C Piping System.....	47
2.5	ABS Piping System.....	49
2.6	SYGEF Piping Systems: Standard, Plus, and ECTFE.....	52
2.7	PROGEF Piping Systems: Standard, Plus, and Natural.....	56
2.8	ecoFIT Piping System.....	59
2.9	HEAT-FIT – Ultimate Fire Protection.....	61
2.10	CONTAIN-IT Plus Piping System.....	77
2.11	COOL-FIT Piping Systems.....	79
2.12	Automation.....	83

# 1 Market Segments

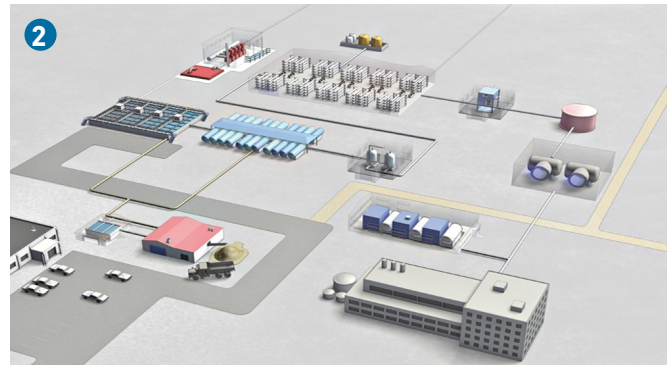
## 1.1 Water Treatment

### 1.1.1 Overview

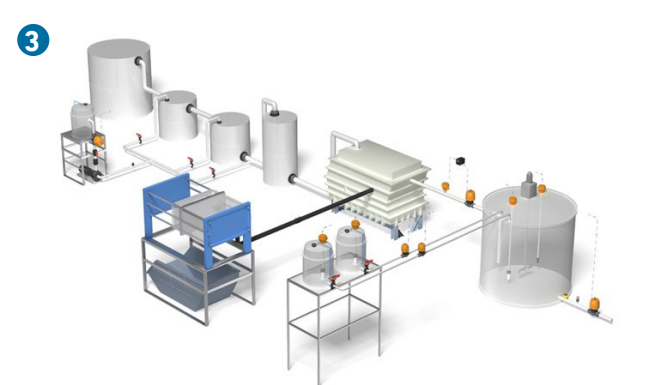
Since the late 90's, the water treatment business has been continuously growing. In water scarce countries, it is even regarded to be the most investment-intensive and important industry sector for the next decades. Depending on the application area, our customers have to face different challenges in water treatment processes ranging from securing high water quality up to providing reliable measurements to meet stringent regulations. GF Piping Systems steps up these challenges with a comprehensive system offering of pipe, fittings, valves and the ideal jointing technology as well as an optimally adapted selection of components for automation technology.



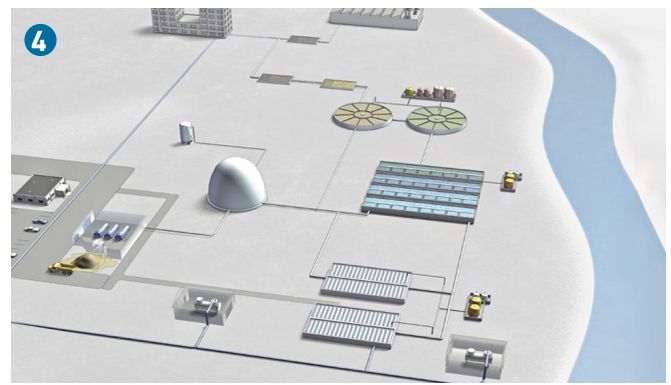
Drinking water



Industrial process water



Industrial waste water



Municipal waste water

**1 Drinking water**

Producing drinking water is a demanding challenge which requires the right system behind the scenes. Depending on the application area, the choice of plastic material for pipe, valves and fittings is essential for a long-lasting system. With the high quality plastic solutions of GF Piping Systems the optimal compatibility of all components is warranted.

**2 Industrial process water**

High water quality in terms of purity for steam boilers, cooling systems and production processes is the key requirement for industry today. Avoiding any form of contamination, scaling and corrosion is achieved through technologies as ion exchanging, ultrafiltration, reverse osmosis and electro deionization.





**3 Industrial waste water**

Waste water treatment plants for inorganic caustics and acids are small chemical plants themselves. Corrosion resistance and staff safety are the top priority issues for hazardous waste containing lines. GF Piping Systems' philosophy for safe transport of liquids and gases meets these advanced process needs.

**4 Municipal waste water**

Stringent regulations and binding laws demand state-of-the-art technologies in sewage plants today. Membrane technologies, chemical dosing systems and polymer preparation units are only some of the examples that require efficient and safe piping systems.

**1.1.2 Leading Systems (Samples)**

ecoFIT and ELGEF	PVC-U	PROGEF Standard	CONTAIN-IT Plus
			
d20 – d630 mm, PN10 – PN16	d6 – d400 mm, PN6 – PN16	d16 – d500 mm*, PN6 – PN10	d25 – d225 mm
-50 °C to +60 °C	+0 °C to +60 °C	+0 °C to +80 °C	-50 °C to +140 °C**
<b>Automation Measurement – Control – Actuation</b>			

\*bigger sizes available for certain products

\*\*acc. to primary pipe material

## 1.2 Chemical Process Industry

### 1.2.1 Overview

Chemical and Process Industry encompasses all the industrial activities related to the extraction of natural resources and their transformation into basic chemical products and specialties. Each chemical has a distinctive value chain, where careful material and components selection is a mandatory requisite for planners, designers and installers. The harsh environment in most of the industrial plants, the strive for efficiency and the responsible care policies for chemical handling, drive high demands on piping systems in regard to health and safety, environmental standards compliance, reliability and maintenance.



1 Chemicals extraction from natural resources

#### Mining and minerals processing

Mining and mineral processing industry are among the most intensive users of water and chemicals, in harsh environment and with demanding tasks for installation, reliability and resistance to corrosion. GF Piping Systems products are used in the mines utilities and for several process steps from ore beneficiation to hydrometallurgy.

#### Oil and gas industry

Water cycle in oil and gas industry is complex and demanding: a multitude of chemical additives are used to enhance process performance and increase the efficiency of water treatment operations. Evolving frontiers in offshore and hydraulic fracturing techniques for unconventional resources are more and more welcoming GF plastic piping systems for their lightweight, modularity of installation and long lasting life in aggressive environment.

### 2 Chemicals production and distribution

#### Petrochemicals

Petrochemicals are the building blocks for most of the objects surrounding people's daily life, and their value chain is growing with new installations according to the increasing standards of life in emerging economies and urbanization megatrend. Olefin, aromatics and synthesis gas processing industrial plants have high complexity flow schemes for water and chemicals, used as process additives or catalysts and in several chemical injection skids.

#### Fertilizers

Like petrochemicals, fertilizer plants play a key role in the global chemical Industry, driven by the agro-industrial need for intensive food production and being an excellent platform for ammonia gas monetization into nitrogen based fertilizers. Fertilizer plants are cross-points in the value chain of the most used mineral acids worldwide in the industry, such as sulfuric acid and phosphoric acid.

**Chlor-alkali**

Chlor-alkali plants are the backbone of the basic industrial inorganic chemistry. GF plastic piping solutions find their ideal area of application in the dual laminate systems for brine electrolysis, while downstream the chlorine tree and the infinite caustic soda industrial usages offer the perfect environment for thermoplastic installations with GF Piping Systems. Electro chlorination and water disinfection are increasing practices worldwide, GF Piping Systems offer key components for the skid, low weight and top quality installations.

**Basic inorganic chemicals, specialty chemicals, bio-chemicals**

Whether there are basic substances like titanium dioxide or bromine, pigments or ingredients for pharmaceuticals, adhesives or chemicals for water treatment or electronic industry, GF Piping Systems products are employed nearly at all process stages. The same value chain as in the traditional chemical processing, is increasingly being replicated in the growing field of the bio-chemicals, where inorganic chemicals play a distinctive role as process additives or catalysts.

**3 Chemicals used in manufacturing and process industries**

**Steel mills and metal industry**

Metallic materials are the backbone of infrastructure construction and the platform for the majority of the engineered products of industry and everyday life. Steel mills and the base metal processing plants for operations of smelting, refining, recycling are intensive users of aggressive acids and alkalis, especially in the pickling process. In this area the thermoplastic piping systems play a key role, for example in the exhaust gases scrubbing.







**Surface treatment, galvanization, batteries, painting and printing, glass industry**

Driven primarily by transportation industry and household appliances, surface treatment of the metals is a widespread industrial practice, including demanding fine-tuned electrochemical applications such in case of galvanization of fashion accessories, including watches, treatment of steel tyre cord, etching of surfaces for electronics industry components. Preparation of metal surfaces for painting involves high complexity electro-dipping treatment stages, where the excellent material purity and leach-out behavior of GF Piping Systems components are proven benefits.

**Pulp and paper, starch, yeast and sugar, cosmetic and detergents, textile industry**

Globalization and urbanization driven, increasing standards of life place a demand to manufacturing industries for several products, with challenging quality and performance requirements and within strict regulations for environmental compliance and health and safety. High quality components, durable materials, precise process control are ensured by GF Piping Systems in a multitude of applications involving chemicals.

**1.2.2 Leading Systems (Samples)**

PVC-U	PVC-C	SYGEF Standard	SYGEF ECTFE	PROGEF Standard	CONTAIN-IT Plus
					
d6 – d400 mm, PN6 – PN16	d16 – d225 mm PN10 – PN16	d16 – d315 mm PN10 – PN16	d20 – d110 mm PN10	d16 – d500 mm**, PN6 – PN10	d25 – d225 mm
0 °C to +60 °C	0 °C to +80 °C	-20 °C to +140 °C	0°C bis +80 °C*	0 °C to +80 °C	-50 °C to +140 °C***
<b>Automation Measurement – Control – Actuation</b>					

\* proven for chemicals, on raw materials: -76 to +130 °C

\*\*bigger sizes available for certain products

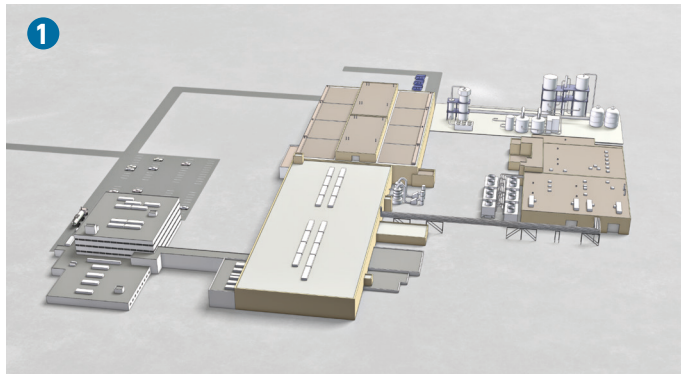
\*\*\*acc. to primary pipe material

## 1.3 Microelectronics

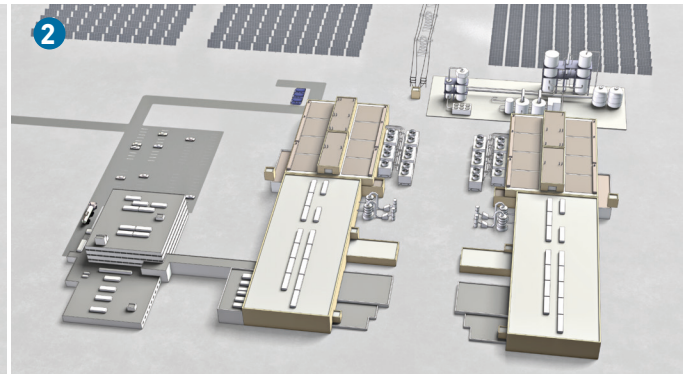
### 1.3.1 Overview

At GF Piping Systems we realize that your high tech production plants running 24/7. Having dependable, safe piping systems that can consistently deliver critical processing fluids is a must.

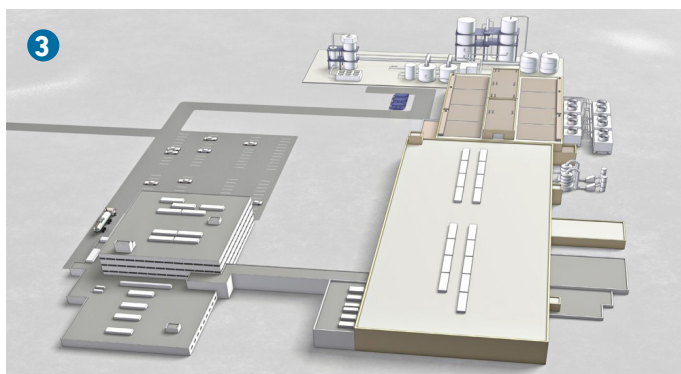
Avoiding unnecessary shutdowns is a common goal that we share. Our supply of quality plastic piping system products and jointing technologies coupled with our dedicated and knowledgeable engineering staff has kept factories like your own running 24/7 for more than two decades. During this time, end users like yourself have seen the added benefits of plastic piping systems and replaced other materials to achieve safety, quality and productivity.



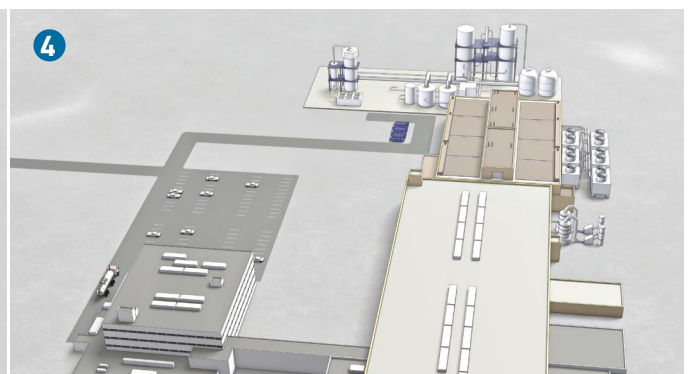
**Semiconductor**



**Photovoltaic**



**TFT/HB-LED**



**Storage media**

#### 1 Semiconductor

Highly specialized facilities handle the complexity and sensitiveness of the processes and products in the semiconductor wafer production industry by operating in strictly controlled clean room environments. GF Piping Systems offers a portfolio of high purity plastic systems for the safe and reliable conveyance of critical processing fluids to and from your Fab processing equipment installed on production floor.

#### 2 Photovoltaic

High demands regarding purity, safety and quality characterize production processes of photovoltaic systems. Reliable conveyance of media under clean conditions has to be assured and appropriately controlled. Whether it is process technology or the production flow, GF Piping Systems product portfolio covers all high end water applications in the photovoltaic industry.

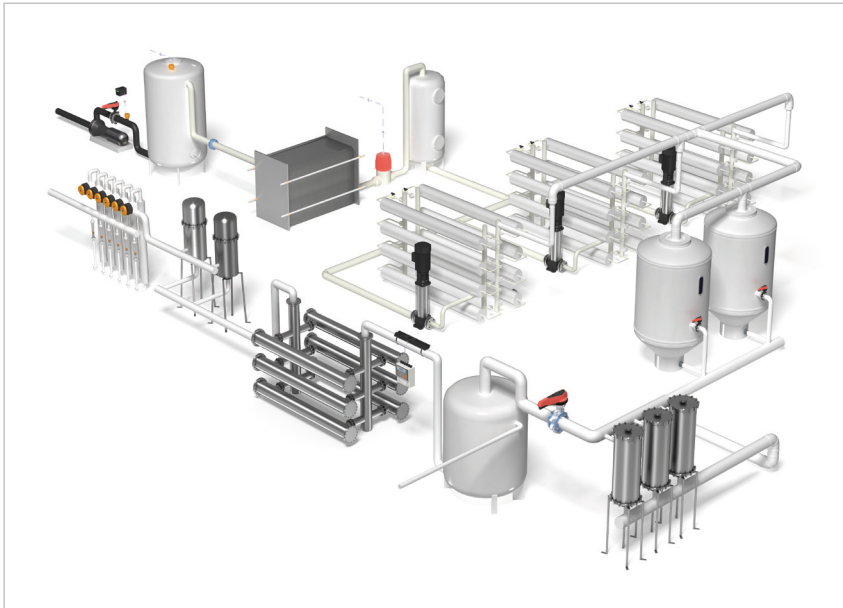


**3** TFT/HB-LED

The manufacturing of TFT/LED technologies is structured in wafer cleaning and metallization steps, patterning and etching, mapped in typical applications such as neutralization and chemical distribution as well process cooling water for tools. GF Piping Systems offers the right solution according to process requirements, temperature conditions and chemical concentrations.

**4** Storage media

Since memory capacity per footprint is continuously increasing, producers of mechanical memory devices showing also an increased demands for pure and high purity materials of constructions for their facilities in various applications.



**Applications**

- Process- / Vacuum Solutions
- CMP / Slurry process
- UPW / Hot UPW
- Chemical distribution / Conveyance
- Process cooling water
- Specialty waste
- Industrial grade water
- DI water / Specified water
- Wet bench process tools (OEM)

**1.3.2 Leading Systems (Samples)**

SYGEF Plus	PROGEF Plus	SYGEF ECTFE	CONTAIN-IT Plus
d20 – d400 mm PN10 – PN16	d16 – d500 mm*, PN6 – PN10	d20 – d110 mm PN10	d20 – d225 mm, PN10 – PN16
-20 °C to +140 °C	0°C to +80 °C	0°C bis +80 °C**	-50 °C to +60 °C***
Automation Measurement – Control – Actuation			

\*bigger sizes available for certain products

\*\*proven for chemicals, on raw materials: -76 to +130 °C

\*\*\*acc. to primary pipe material

## 1.4 Cooling

### 1.4.1 Overview

GF Piping Systems offers application orientated, value adding system solutions for the transport of chilled water at +6/+12°C in air-conditioning plants, industrial cooling water at +25/-35°C and heat pump combined cooling – heating installations as well as efficient energy saving transport of secondary refrigerants in refrigeration plants; for example in Breweries, Supermarkets, Cold Stores, Food and Beverage production factories.

Environmental regulations worldwide are restricting the use of high GWP (Global Warming Potential) refrigerant gases; this is driving the Cooling market towards ever increasing use of indirect or secondary systems to reduce the amount and leakages of man-made refrigerant gases. Efficient, economical transfer of the heat load in the secondary piping system is of vital importance to the efficiency of the complete plant.

GF Piping Systems offers a range of real value-adding systems for all types of cooling lines, all offering 100% corrosion resistance, optimum efficiency, thanks to factory made pre-insulation and simple time-saving installation on-site. Freon free and low carbon footprint expected life-span.



Cold stores



Commercial refrigeration



A/C Cooling: commercial - residential



F & B production

### Cooling media > 0 °C / 32 °F

#### Air Conditioning

Chilled water +6/+12°C air-conditioning plants are common for larger cooling capacity installations: centralized cold water loops offer efficiency and flexible for contractor and end-user alike. GF Piping Systems offers within its systems also the necessary flexible hoses and fire-wall penetration solutions necessary for such installations.

#### Industrial Cooling Water

All industrial plants require cooling water both within the factory itself for cooling of machinery and also for external dry-cooler respectively cooling tower systems. GF Piping Systems offer all decision makers real added-value for such installations offering energy efficiency and real time savings compared with traditional solutions.

**Data Centers**

All sectors from banks to universities, insurance companies to communication providers, require centralized server storage of critical information. An effective way of removing heat is a water loop associated with a non-corroding, non-scaling, pressure-bearing, all-plastic piping system.

**Cooling media < 0 °C / 32 °F**

**Commercial refrigeration**

Supermarkets and groceries stores: medium temperature for fresh foods such as meat, fish and dairy products, and low temperature for frozen goods. Secondary refrigeration systems using glycol and salt solutions require smooth, non-corroding, non-dripping piping systems for an efficient transport of cooling capacity, keeping a low carbon footprint.

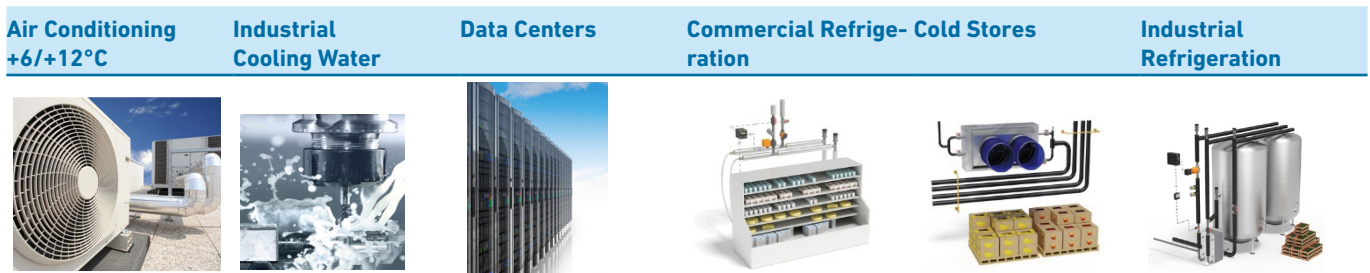
**Cold stores**

Preserving fruits or vegetables after harvest or storing dairy, meat and fish, these large installations require efficient, long lasting and maintenance-free cooling systems. Hydraulic loops using pre-insulated plastic piping systems provide the required accurate temperature and humidity control, with 25 years corrosion resistant life-span.





**Food and Beverage Production**

From ready-made meal production factories, to dairies, slaughter houses and meat production, to carbonated drinks, all forms of food and beverage production really heavily on a reliable efficient cooling plant. The safety of the workers, hygiene requirements and energy efficiency are the main drivers when designing the cooling plant. Low pressure glycol or salt solution secondary circuits with pre-insulated plastic pipe offer a simple and cost effective state-of-the-art solution for indirect refrigeration installations.

**Applications**



**1.4.2 Leading Systems (Samples)**

COOL-FIT 2.0 (pre-in- sulated)	COOL-FIT 4.0 (pre-insulated)	iFIT	ecoFIT and ELGEF
			
d32 – d140 mm, PN16	d32 – d450 mm, PN10/16	d16 - d32 mm, PN16	d20 – d630 mm, PN10 – PN16
0 °C to +60 °C	-50 °C to +60 °C	0 °C to +95 °C	-50 °C to +60 °C
Automation Measurement – Control – Actuation			

## 1.5 Energy

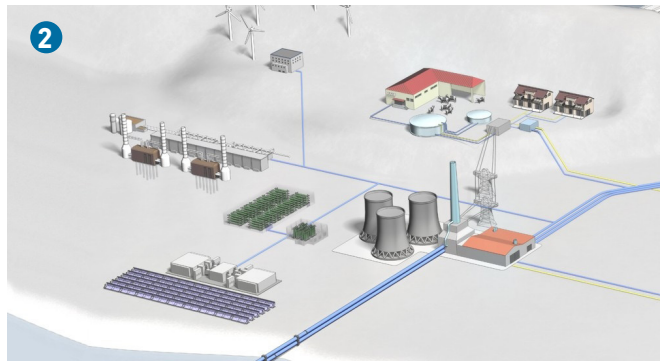
### 1.5.1 Overview

In the growing sense of sustainability, profound changes are beginning to transform the way energy is produced, delivered and used. GF Piping Systems provides intelligent corrosion resistant plastic solutions for successfully managing highly specialized water and chemical applications in today's and tomorrow's energy power generation.

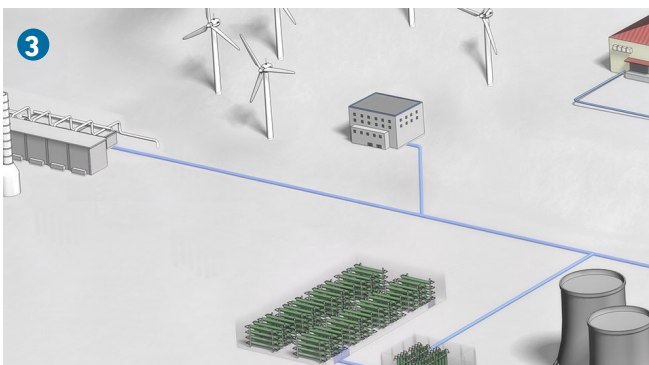
Corrosion is the biggest contributor to piping system failures in a power plant. With this in mind the goal is to replace metal piping with thermoplastic solutions. The result is corrosion resistance for up to 50 years, depending on the application.



**Conventional power plants**



**Renewable energies**



**Pioneering green solutions**

Energy production include coal, gas, nuclear, cogeneration waste to energy, biogas, biomass, algae, energy storage, carbon capture to name some examples.

#### 1 Conventional Power Plants

Conventional power generation, using fossil fuels or nuclear sources to produce energy, still has a large worldwide market share and is extended by innovative new developments. Our solutions for cooling, waste and chemical lines are maximizing safety and are corrosion free.

#### 2 Renewable Energies

Generating energy by means of renewable natural resources is a dynamic sector with high growth rates, contributing to sustainable energy production for the future. Using intelligent cooling or containment system solutions from GF Piping Systems in water and chemical treatment reduces energy costs and potential environmental effects of leaks, maximizing safety on site at the same time.





#### 3 Pioneering Green Solutions

The development of innovative green technologies for the intelligent utilization of alternative sources of energy is a highly promising market of the future. Providing state-of-the-art products and technologies in water and chemical media conveyance, GF Piping Systems offers cost efficient solutions that meet highest health, safety and environmental requirements.

Corrosion free piping systems for water and chemical applications in power generation

Industrial Cooling Water	Chemical Conveyance	Water Intake Lines	Flue Gas Desulfurization	Water Distribution	Gas Distribution	Fire Fighting
						
						
Safety Showers	Slurry Transfer	Water Treatment	Desalination	Makeup Water	Compressed Air	Hot & Cold Water in Buildings
						

1.5.2 Leading Systems (Samples)

ecoFIT and ELGEF	PVC-U	PROGEF Standard	SYGEF Standard
			
d20 – d630 mm, PN10 – PN16	d6 – d400 mm, PN6 – PN16	d16 – d500 mm*, PN6 – PN10	d16 – d315 mm PN10 – PN16
-50 °C to +60 °C	0 °C to +60 °C	0 °C to +80 °C	-20 °C to +140 °C
Automation Measurement – Control – Actuation			

\*bigger sizes available for certain products

## 1.6 Marine

### 1.6.1 Overview

Ships and platforms are exposed to the forces of nature. Wind, rain and saltwater can be harsh on structure, hulls, housing and supply lines. Preventing corrosion is more important here than anywhere else. With GF Piping Systems products corrosion is no longer an issue. The plastic piping systems reduce maintenance time and increase productivity.

Plastic piping systems weight approx. 5 time less than metal. Using plastic components contribute to a lower carbon footprint of the total installation.

GF Piping Systems offers IMO compliant and fully approved piping systems for marine applications perfectly suitable for new build and retrofit.



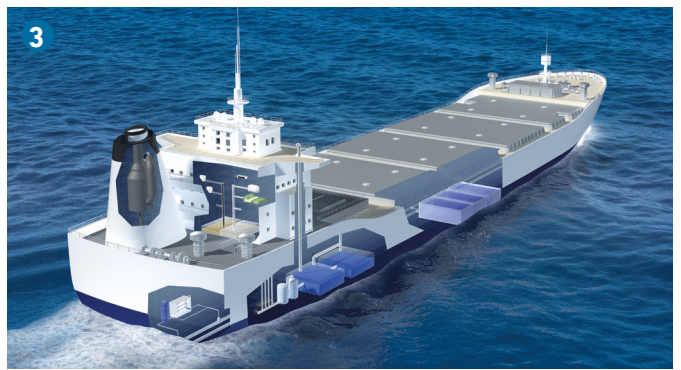
Cruisers



Ferries



Offshore



Commercial vessels

#### 1 Cruise / ferries

Cruises and ferries are floating cities which need safe conveyance of drinking water, grey and black water together with high quality water treatment. Galley and laundry have to work 24/7 requiring corrosion resistant and reliable material. Air conditioning has become essential for onboard comfort. Pre-insulated piping can also ensure higher thermal efficiency.

#### 2 Offshore

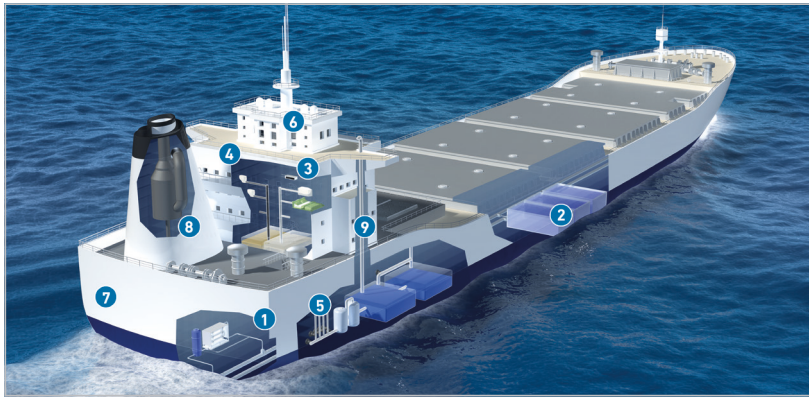
Flotels, accommodations and living barges need higher life standard onboard. Beside the hot and cold water distribution, rain catchment and chemical distribution are particularly affected internally and externally by corrosion and incrustation.

**3 Commercial vessels**

Commercial vessel fleets of large dimensions dominate today's worldwide maritime traffic. This trend is accompanied by rising environmental requirements and standards to counteract pollution resulting from the expanded trade and travel. Commercial vessels can benefit from lighter and corrosion resistant solutions on ballast piping system, water treatment, vent lines and gas scrubber effluents.

GF Piping Systems supports the industry to face these technical, operational and environmental challenges. The corrosion, abrasion and chemical resistant systems are ideally adapted to the extreme conditions on the high sea, offering outstanding cost-efficiency and a long system life cycle.

**Applications**



**Description**

- 1 Ballast Water Treatment
- 2 Ballast System
- 3 Hot & Cold Water
- 4 Grey and Black Water Ships
- 5 Water Treatment
- 6 AC Cooling
- 7 Compressed Air
- 8 Air Cleaning (Gas Scrubber)
- 9 Water Tank Venting

**1.6.2 Leading Systems (Samples)**

INSTAFLEX	JRG SANIPEX MT	SeaDrain	PVC-U	PVC-C	ecoFIT and ELGEF
d16 – d225 mm, PN16	d16 – d63 mm, PN10	1½" – 12" Schedule 40	d6 – d400 mm, PN6 – PN16	d16 – d225 mm, PN10 – PN16	d20 – d630 mm, PN10 – PN16
0 °C to +95 °C	0 °C to +95 °C	0 °C to +100 °C	0 °C to +60 °C	0 °C to +80 °C	-50 °C to +60 °C
<b>Automation Measurement – Control – Actuation</b>					

COOL-FIT 2.0 (pre-insulated)	COOL-FIT 4.0 (pre-insulated)	PROGEF Standard	HEAT-FIT Jacket System
d32 – d140 mm, PN16	d32 – d450 mm, PN10/16	d16 – d500 mm**, PN6 – PN10	d110 - d315, PN11
0 °C to +60 °C	-50 °C to +60 °C	0 °C to +80 °C	0°C bis +60°C
<b>Automation Measurement – Control – Actuation</b>			

## 1.7 Water Utilities

### 1.7.1 Overview

Hygienic drinking water, pure in taste, smell and appearance is one of the fundamental health requirements. The demand for a secure supply of clean water is increasing worldwide. For the full spectrum of water supply, GF Piping Systems has a variety of innovative techniques and specialized products designed specifically for the water distribution industry. Our leading know-how and expertise for all water distribution applications helps finding the right solution for your application.



#### 1 Water transportation lines

When transporting water, a safe and reliable connection is the key success factor. But at the same time it can be a challenging task, especially at large dimensions. GF Piping Systems understands the need for proper tooling, high performance jointing technologies and connection parts as well as expert support on site.

#### 2 Water distribution lines

For the reliable, economical and sustainable water distribution it is essential that all piping components like pipe, fittings and valves are connected safe and reliable. GF Piping Systems offers a comprehensive range of jointing technologies. The electro fusion system ELGEF Plus ensures a material homogeneous connection of pipe and fitting that contributes to a reliable network. With the MULTI/JOINT system all kinds of materials can be connected in a quick, safe and simple way.

#### 3 Water service lines and house connections

In the last stage of the water grid, service lines bring water to the meter. Due to its flexibility and material homogeneous jointing technologies, amongst many other positive characteristics, PE is today's main used material for new installations. Thanks to the modular ELGEF Plus electro fusion system an appropriate solution can be found for every application. Each individual ELGEF fitting and saddle is made to match and when put together they form reliable leak-proof connections. Many different combinations can be devised using just a few products. Also PE valves will contribute to a reliable and safe network as part of the ELGEF Plus system.

#### 4 Pressure sewage lines






Rather than gravity, the pressure sewage system is using pumps to move the waste water along to the waste water treatment plant. Pressure sewage systems are using generally smaller diameter pipe that are less expensive and easier to install. Choosing here the GF PE system, a reliable network for 100 years can be built.



5 Irrigation

A growing world population and the changing climate enhance the food and water scarcity. More and more food production will be separated from the local weather by building large glass houses or doing extended irrigation increasing the output of food per m<sup>2</sup>. Systems simple to install and ensuring a secure water distribution over the total product life span will become an important attribute. GF Piping Systems provides a comprehensive product range for irrigation as well as on the local training and fast deliveries.

1.7.2 Leading Systems (Samples)

ELGEF	MULTI/JOINT	iJOINT	Machines	Tools
				
d160 – d2000 mm, PN10 d20 – d1200 mm, PN16	DN50 – DN600 mm	d16 – d110 mm	<b>Butt fusion</b> d160 mm – d1600 mm (with CNC technology up to d630 mm)	d20 – d2000 mm
Electro fusion fittings, spigot fittings, seamless bends and segmented fittings	Wide-range of couplings, restrained	couplings, tees, bends, reducers and saddles, transition fittings, universal fittings	<b>Electrofusion (Transformer)</b> MSA 210, 230, 330, 340	A wide range of different installation tools enable easy installation and result in high quality joints
			<b>Electrofusion (Inverter technology)</b> MSA 2.0, 2.1, 4.0, 4.1	

## 1.8 Gas Utilities

### 1.8.1 Overview

For decades, gas has been delivered through a network of buried transmission and distribution pipe to homes and industries throughout the world. It has grown to become the most dependable form of energy and being one of the cleanest, safest and most useful of all energy sources.

During recent years the gas supply industry has invested greatly to ensure and enhance consistent quality in the operation and maintenance of gas supply networks.

GF Piping Systems continues to provide high quality systems and services for building and maintaining these networks thus contributing to the transportation of gas in the safest, most secure and reliable way.



#### 1 Gas transportation lines

When transporting gas, a safe and reliable connection is the key success factor. But at the same time it can be a challenging task, especially at larger dimensions. GF Piping Systems understands the need for proper tooling, high performance jointing technologies and connection parts as well as expert support on site.






#### 2 Gas distribution lines

For the reliable, economical and sustainable gas distribution it is essential that all piping components like pipe, fittings and valves are connected safe and reliable. GF Piping Systems offers a comprehensive range of jointing technologies. The electro fusion system ELGEF Plus ensures a material homogeneous connection of pipe and fitting that contributes to a reliable network. With the MULTI/JOINT system all kinds of materials can be connected in a quick, safe and simple way.

#### 3 Gas service lines and house connections

In the last stage of the gas grid, service lines bring gas to the meter. Due to its flexibility and material homogeneous jointing technologies, amongst many other positive characteristics, PE is today's main used material for new installations. Thanks to the modular ELGEF Plus electro fusion system an appropriate solution can be found for every application. Each individual ELGEF fitting and saddle is made to match and when put together they form reliable leak-proof connections. Many different combinations can be devised using just a few products. Also PE valves will contribute to a reliable and safe network as part of the ELGEF Plus system.

1.8.2 Leading Systems (Samples)

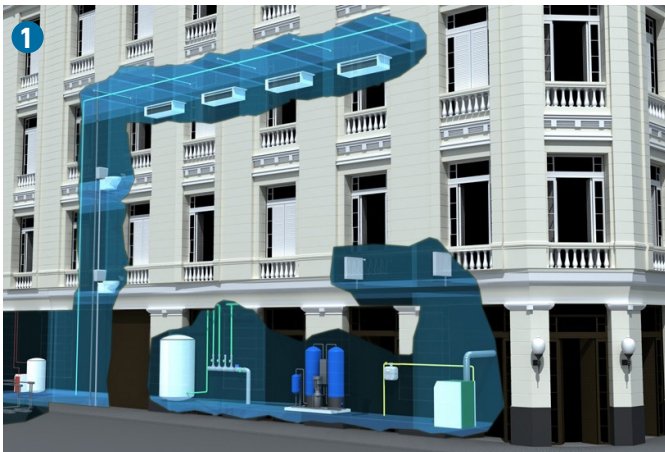
ELGEF	Valves	MULTI/JOINT	Machines	Tools
				
<p>d160 – d2000 mm, PN10 d20 – d1200 mm, PN16</p>	<p>PE ball valves up to d225 mm</p>	<p>DN50 – DN600 mm</p>	<p><b>Butt fusion</b> d160 mm – d1600 mm</p>	<p>d20 – d2000 mm</p>
<p>Electro fusion fittings, spigot fittings, seamless bends and segmented fittings</p>	<p>Pressure Tapping Valves up to d63 mm outlet , mains up to d400 mm</p>	<p>Wide-range of couplings, restrained</p>	<p>(with CNC technology up to d630 mm)</p>	<p>A wide range of different installation tools enable easy installation and result in high quality joints.</p>
			<p><b>Electrofusion</b> (Transformer) MSA 210, 230, 330, 340</p>	
			<p><b>Electrofusion</b> (Inverter technology) MSA 2.0, 2.1, 4.0, 4.1</p>	

## 1.9 Building Technology

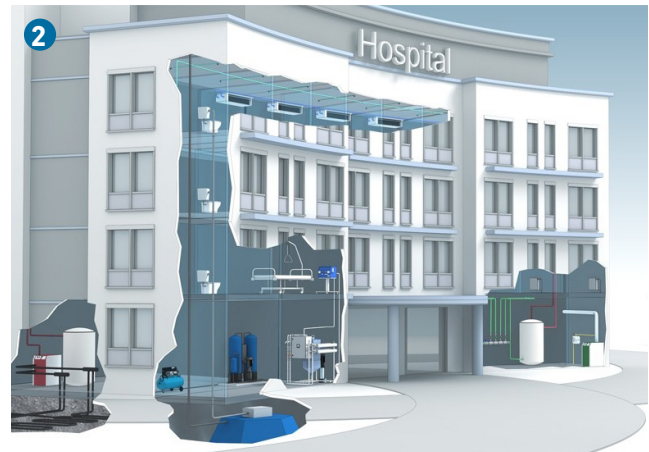
### 1.9.1 Overview

Sustainability, comfort and hygiene are at the top of the wish list for new building or renovation projects. Environment-friendly and cost-efficient piping systems make all the difference in terms of zero dead leg, noise reduction, corrosion resistance and prefabrication.

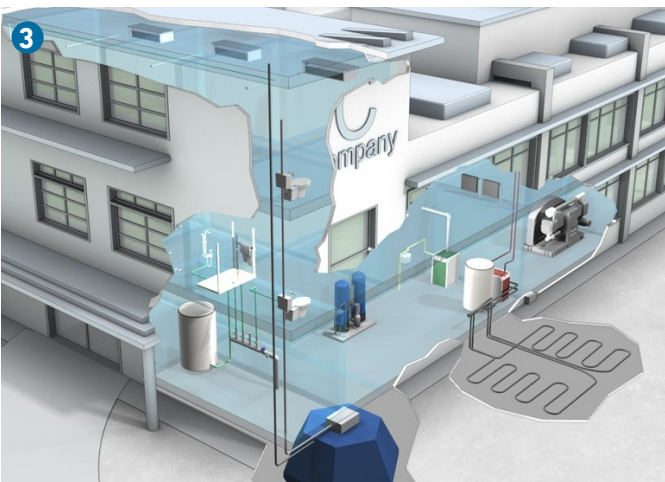
Prefabrication is big trend even including prefabricated bathroom units (PBU) which shorten the overall construction time due to factory proceedings in parallel and the 'Just-in-time' bathroom supply to the site. Incorporating design and the supply of a flexible and high quality plumbing and sanitary piping system makes all the difference.



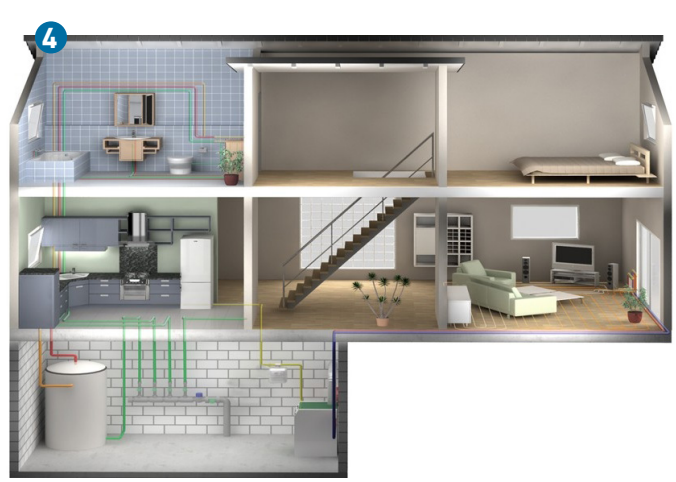
Hotel



Hospital



Industrial buildings



Residential buildings

#### 1 Hotels

Hotels are an oasis of comfort and calm. Guests expect first-class service which includes a perfectly functioning hygienic and environment-friendly piping system. Apart from providing water hygiene with a full hygienic concept, piping systems in a hotel provide optimized acoustic solutions for drainage and water supply systems. Energy saving piping solutions further contributes to a more sustainable building changeover.

#### 2 Hospitals

Hospitals and healthcare facilities are a place of healing and convalescence. In such an environment water hygiene is of utmost importance where no compromises are allowed. Thus, drinking water installations in hospitals must be carefully planned, built and operated.









### 3 Commercial and industrial buildings

Commercial and industrial buildings, as well as research facilities have one thing in common: they all need an environment-friendly heating and cooling system as well as a reliable, leak-free supply of drinking water, sprinkler water, gas and compressed air.

### 4 Residential buildings / Green buildings

Comfort, hygiene and sustainability are the current key trends in modern living. In building, renovation or extension projects one relies on environment-friendly heating and cooling systems, durable, easy handling drinking water installations and leak-free gas piping systems.

## 1.9.2 Leading Systems (Samples)

iFIT	INSTAFLEX	JRG SANIPEX	JRG SANIPEX MT
			
d16 – d32 mm, PN16 0 °C to +95 °C	d16 – d225 mm, PN16 -10 °C to +90 °C	d12 – d32 mm, PN16 0 °C to +95 °C	d16 – d63 mm, PN10 0 °C to +95 °C
AQUASYSTEM (PP-R)	Silenta Premium	iLITE	GF Malleable Iron Fittings
			
d20 – d125 mm, PN20 0 °C to +70 °C	d58 – d200 mm +10 °C to +90 °C	d16 – 32 mm, PN10 0 °C to +95 °C	1/8 to 4 inch, PN25 0 °C to +300°C

## 1.10 Application-System Overview

	ABS	AQUASYSTEM	CONTAIN-IT Plus	COOL-FIT	ecoFIT	ELGEF Plus	iFIT	iJOINT	INSTAFLEX	JRG Sanipex	JRG Sanipex MT	Malleable Fittings	PROGEF	PRIMOFIT	PVC-C	PVC-U	IR PVC-U	SeaCor	SeaDrain	Silenta Premium	SYGEF	WAGA
AC Cooling	✓	✓		✓	✓	✓	✓		✓		✓											
Advanced Water Processing on Ships					✓	✓																
Ballast Water					✓	✓																
Ballast Water Treatment on Ships	✓												✓		✓	✓	✓	✓				
Biological Media																						✓
Chemical Distribution / Conveyance			✓		✓								✓		✓	✓	✓					✓
Compressed Air					✓	✓			✓		✓	✓										
Cooling Towers				✓	✓								✓			✓	✓					
District cooling / heating				✓		✓			✓													
Dosing / Dilution			✓		✓								✓		✓	✓	✓					✓
Drainage of Buildings																				✓		
Draw-off Station					✓								✓		✓	✓	✓					✓
Fire Fighting					✓	✓																
Fire Protection / Sprinkler Systems									✓	✓		✓		✓								
Fish Farms	✓				✓											✓	✓					
Gas Distribution lines						✓																✓
Gas House Connections / Service Lines						✓								✓								✓
Gas Installations inside Buildings												✓		✓								
Gas Maintenance and Repair						✓								✓								✓
Gas Scrubber			✓		✓	✓							✓		✓	✓	✓	✓			✓	
Gas Transport lines						✓																✓
Geothermal					✓	✓			✓				✓		✓	✓	✓					
Grey and Black Water in Ships					✓	✓										✓	✓	✓	✓	✓		
Heating							✓			✓	✓	✓		✓					✓			
Hot & Cold Water		✓					✓		✓	✓	✓				✓				✓			
Industrial Cooling Water	✓			✓	✓								✓		✓	✓	✓	✓				✓
Irrigation / Agriculture						✓		✓														
Ion Exchanger					✓										✓	✓	✓					
Media Filtration			✓												✓	✓	✓					
Mixing (Batching and Ratio Control)			✓		✓								✓		✓	✓	✓					✓
Neutralization			✓										✓		✓	✓	✓					
Pressure sewage / Waste water						✓																✓
Process Cooling Water	✓			✓	✓								✓		✓	✓	✓					✓
Refrigeration	✓			✓	✓	✓	✓				✓											
Safety Showers		✓		✓								✓										
Seam Gas / LNG					✓	✓																✓
Surface Treatment			✓		✓								✓		✓	✓	✓					✓
Swimming Pools					✓	✓										✓	✓					
Tank filling			✓		✓								✓		✓	✓	✓					✓
Ultrapure Water / Hot Ultrapure Water																						✓
Water - Maintenance and Repair					✓		✓							✓								✓
Water Distribution lines					✓	✓										✓	✓		✓			✓
Water House Connections / Service Lines					✓		✓						✓			✓	✓		✓			✓
Water intake lines					✓	✓																
Water storage						✓																✓
Water Transport Lines					✓	✓																✓

Suitability of system solutions may differ acc. to respective local needs or regulation

## 2 System and Product Solutions

GF Piping Systems develops, produces and markets a comprehensive range of piping systems and components in a variety of materials used worldwide to transport water, gases and aggressive media. Our goal is to provide comprehensive system solutions, consisting of pipe, fittings, valves, tools, jointing technology and automation, for industrial applications and thus, fulfilling the expectation of our customers.

Our industrial system solutions are all based on certified raw materials, covering all requirements of the most significant international standards and offering high quality solutions to our customers.

### 2.1 Advantages of Industrial Plastic Piping Systems

#### Excellent Problem Solver

- Corrosion-free
- Good chemical and temperature resistance
- No electrical conductivity and low thermal conductivity
- Smooth inner surface
- Low weight and high flexibility

#### Economic efficiency

- Excellent price-performance ratio (in installation and operation)
- Low installation and maintenance costs

#### Complete solutions

- High-quality system components
- Broad selection of valves with many connection options
- Proven jointing technologies
- Worldwide service: Customizing, engineering services, machine rental pool, training and sales support

#### High quality

- Certified raw materials with many approvals
- 100 % traceability
- Low CO<sub>2</sub> footprint of plastic material

### 2.2 Most Important Market Segments

Industrial Systems	Water treatment	Chemical process industry	Micro-electronics	Energy	Marine	Cooling
PVC-U	✓	✓	✓	✓	✓	
PVC-C		✓	✓	✓	✓	
ABS						✓
SYGEF PVDF		✓	✓	✓		
SYGEF ECTFE	✓	✓	✓			
PROGEF PP	✓	✓	✓	✓		
ecoFIT PE	✓	✓	✓	✓	✓	✓
COOL-FIT					✓	✓
CONTAIN-IT Plus	✓	✓	✓	✓		

## 2.3 PVC-U Piping System

The piping system made of PVC-U material can be used for operating temperatures in the range of 0 °C to +60 °C. Thanks to outstanding chemical resistance, PVC-U piping systems withstand demanding conditions, particularly during the transport of aggressive media, such as acids, bases and salts. The PVC-U system is widely used in the chemical and textile industry, in water treatment processes, for drinking water applications and vacuum lines.



Pipes                      Fittings                      Jointing technology                      Automation                      Valves

### Essential system properties

- Food and drinking water approvals, proven physiological harmlessness
- First-class solution for aggressive media, such as acids, bases and salts
- Space-saving installation with PRO-FIT spigot-socket fittings
- Safe and simple joining technologies with low costs for tools and materials

### Most important market segments

- Water treatment
- Chemical process industry
- Marine
- Microelectronics
- Energy

### Technical data

<b>Nominal pressure</b>	Up to 16 bar
<b>Temperature range</b>	0 °C to +60 °C
<b>Jointing technology</b>	Solvent cementing
<b>Standards and guidelines<sup>1)</sup></b>	ISO, EN, ASTM, BS, JIS, CE, RoHS, DIN, DVS
<b>Approvals<sup>1)</sup></b>	DIBT, DVGW, GOST-R, DGS (ACS), WRAS, KIWA, CSTB, IIP, ABS, BV, CCS, DNV-GL, LR, RINA, RMROS

<sup>1)</sup> For additional information about standards, guidelines and approvals, see [www.gfps.com](http://www.gfps.com)



### PVC-U product overview

The following table uses metric units of measure.

Products	PN (bar)	d (mm)																									
		6	8	10	12	16	20	25	32	40	50	63	75	90	110	125	140	160	180	200	225	250	280	315	355	400	
		DN (mm)																									
		8	10	15	20	25	32	40	50	65	80	100	100	125	150	150	200	200	250	250	300	355	400				
Pipes	PN6-16	PVC-U System																									
Fittings	PN6-16	PVC-U System																									
Ball valves	PN6-16	PVC-U System																									
Butterfly valves	PN6-10	PVC-U System																									
Check valves	PN6-16	PVC-U System																									
Diaphragm valves	PN6-16	PVC-U System																									
Flanges	PN6-16	PVC-U System																									
Gaskets and pipe clips		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
Automation		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓

- PVC-U System
- PVC-C System
- ABS-System

For more information about the system specification of PVC-U, visit [www.gfps.com](http://www.gfps.com)

The following table uses units of measure based on the BS inch system.

Products	PN (bar)	d (mm)														
			3/8"	1/2"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"	3"	4"	5"	6"	8"	10"-12"
Pipes	PN9-15		[PVC-U System]													
Fittings	PN9-15		[PVC-U System]													
Ball valves	PN16		[PVC-U System]													
Butterfly valves	PN10		[PVC-U System]													
Check valves	PN6-16		[PVC-U System]													
Diaphragm valves	PN6-16		[PVC-U System]													
Flanges	PN10-16		[PVC-U System]													
Gaskets and pipe clips			✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
Automation	-		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓

- PVC-U System
- ABS-System

For more information about the system specification of PVC-U, visit [www.gfps.com](http://www.gfps.com)

### 2.3.1 IR PVC-U Piping System

The piping system made of PVC-U material can be used for operating temperatures in the range of 0 °C to +60 °C. Thanks to outstanding chemical resistance, PVC-U piping systems withstand demanding conditions, particularly during the transport of aggressive media, such as acids, bases and salts. For a number of demanding applications DTX or DYTEX cement is needed to create a suitable joint. The IR PVC-U System creates an alternative to cemented PVC-U, while improving on quality control and tracability through the use of IR welding machines.

The IR PVC-U system is used in the most challenging applications in the chemical industry, in water treatment processes, for drinking water applications and food applications.



Pipes	Fittings	Joining technology	Automation	Valves
-------	----------	--------------------	------------	--------

#### Essential system properties

- Food and drinking water approvals, proven physiological harmlessness
- First-class solution for aggressive media, such as acids, bases and salts
- First infrared welded PVC-U system

#### Most important market segments

- Water treatment
- Chemical process industry
- Food
- Microelectronics
- Energy

#### Technical data

<b>Nominal pressure</b>	Up to 16 bar
<b>Temperature range</b>	0 °C to +60 °C
<b>Joining technology</b>	Infrared Welding
<b>Standards and guidelines<sup>1)</sup></b>	ISO, EN, JIS, CE, RoHS, DIN, DVS
<b>Approvals<sup>1)</sup></b>	DIBT, DVGW, GOST-R, DGS (ACS), WRAS, KIWA, CSTB, IIP, ABS, BV, CCS, DNV-GL, LR, RINA, RMR05

<sup>1)</sup> For additional information about standards, guidelines and approvals, see [www.gfps.com](http://www.gfps.com)

### IR PVC-U product overview

The following table uses metric units of measure.

Products	PN (bar)	d (mm)							
		DN (mm)	15	20	25	32	40	50	63
Pipes	PN6-16								
Fittings	PN6-16								
Ball valves	PN6-16								
Butterfly Valves	PN6-16								
Check valves	PN6-16								
Diaphragm valves	PN6-16								
Flanges	PN6-16								
Gaskets and pipe clips			✓	✓	✓	✓	✓	✓	✓
Automation			✓	✓	✓	✓	✓	✓	✓

 IR PVC-U System

For more information about the system specification of IR PVC-U, visit [www.gfps.com](http://www.gfps.com)

## 2.4 PVC-C Piping System

PVC-C piping systems, having an operational temperature range from 0 °C to 80 °C, are suitable for high temperature environments. The excellent mechanical properties such as a high tensile strength, stiffness and impact strength are evident even at increased temperatures. PVC-C systems are used wherever aggressive media such as mixed acid waste or acids at a high temperature are transported, for example, in the chemical, paper and pulp industry or in metal treatment and microelectronic production.



### Essential system properties

- Very good mechanical properties, even at higher temperatures
- Flame-retardant and self-extinguishing
- Safe and simple jointing technology with low costs for tools and materials

### Most important market segments

- Chemical process industry
- Marine
- Microelectronics
- Energy

### Technical data

Nominal pressure	Up to 16 bar
Temperature range	0 °C to 80 °C
Jointing technology	Solvent cementing
Standards and guidelines <sup>1)</sup>	ISO, EN, ASTM, BS, JIS, CE, RoHS, DIN, DVS
Approvals <sup>1)</sup>	DGS (ACS), WRAS, GOST-R, ABS, BV, CCS, DNV-GL, LR, RINA, RMROS

<sup>1)</sup> For additional information about standards, guidelines and approvals, see [www.gfps.com](http://www.gfps.com)

### PVC-C product overview

The following table uses metric units of measure.

Products	PN (bar)	DN (mm)		d (mm)																									
		DN (mm)	d (mm)	6	8	10	12	16	20	25	32	40	50	63	75	90	110	125	140	160	180	200	225	250	280	315	355	400	
Pipes	PN6-16																												
Fittings	PN6-16																												
Ball valves	PN6-16																												
Butterfly valves	PN6-10																												
Check valves	PN6-16																												
Diaphragm valves	PN6-16																												
Flanges	PN6-16																												
Gaskets and pipe clips				✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
Automation				✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓

- PVC-U System
- PVC-C System
- ABS-System

For more information about the system specification of PVC-C, visit [www.gfps.com](http://www.gfps.com)

## 2.5 ABS Piping System

The outstanding characteristics of ABS allow its application in a wide temperature range between -50 °C to +60°C. The exceptionally high notched impact strength values, even at low temperatures, indicate the material's high robustness and tolerance to surface damage. ABS systems offer an energy-efficient solution for industrial low temperature applications, refrigeration and cooling systems.



### Essential system properties

- Outstanding abrasion resistance
- Low thermal conductivity
- High impact strength even at low temperatures
- Halogen-free
- Safe and simple jointing technology with low costs for tools and materials

### Most important market segments

- Cooling
- Water Treatment

### Technical data

<b>Nominal pressure</b>	Up to 10 bar
<b>Temperature range</b>	-50 °C to +60 °C
<b>Jointing technology</b>	Solvent cementing
<b>Standards and guidelines<sup>1)</sup></b>	ISO, EN, ASTM, BS, JIS, CE, RoHS, DIN, DVS
<b>Approvals<sup>1)</sup></b>	GOST-R, ABS, BV, CCS, DNV-GL, LR, RINA, RMROS

<sup>1)</sup> For additional information about standards, approvals and guidelines, see [www.gfps.com](http://www.gfps.com)

### ABS product overview

The following table uses metric units of measure.

Products	PN (bar)	DN (mm)		d (mm)																									
		8	10	6	8	10	12	16	20	25	32	40	50	63	75	90	110	125	140	160	180	200	225	250	280	315	355	400	
Pipes	PN6-16	[PVC-U System]																											
Fittings	PN6-16	[PVC-U System]																											
Ball valves	PN6-16	[PVC-U System]																											
Butterfly valves	PN6-10	[PVC-U System]																											
Check valves	PN6-16	[PVC-U System]																											
Diaphragm valves	PN6-16	[PVC-U System]																											
Flanges	PN6-16	[PVC-U System]																											
Gaskets and pipe clips		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
Automation		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓

- PVC-U System
- PVC-C System
- ABS-System

For more information about the system specification of ABS, visit [www.gfps.com](http://www.gfps.com)



The following table uses units of measure based on the BS inch system.

Produkte	PN (bar)	d (mm)															
			3/8"	1/2"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"	3"	4"	5"	6"	8"	10" - 12"	
Pipes	PN9-15		[PVC-U System]														
Fittings	PN9-15		[PVC-U System]														
Ball valves	PN16		[PVC-U System]														
Butterfly valves	PN10		[PVC-U System]														
Check valves	PN6-16		[PVC-U System]														
Diaphragm valves	PN6-16		[PVC-U System]														
Flanges	PN10-16		[PVC-U System]														
Gaskets and pipe clips			✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
Automation	-		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓

- PVC-U System
- ABS-System

For more information about the system specification of ABS, visit [www.gfps.com](http://www.gfps.com)

## 2.6 SYGEF Piping Systems: Standard, Plus, and ECTFE

### SYGEF Standard and Plus

The outstanding physical and mechanical properties of the SYGEF Standard and SYGEF Plus piping systems, made of polyvinylidene fluoride (PVDF), assure a superior performance for highly demanding applications in the industrial sector. SYGEF Standard combines the safe transport of water and aggressive chemicals with a very broad temperature range (-20 °C to +140 °C). In addition, SYGEF Plus, with its excellent surface roughness and purity, offers a benchmark solution for the supply of high-purity water in the microelectronics industry.



### Essential system properties

- Very high temperature range and chemical resistance
- Extremely smooth surface
- Excellent purity thanks to completely controlled cleanroom manufacturing

### Most important market segments

- Chemical process industry
- Microelectronics
- Energy

### Technical data

<b>Nominal pressure</b>	Up to 16 bar
<b>Temperature range</b>	-20 °C to +140 °C
<b>Jointing technology</b>	Socket fusion Butt fusion Infrared (IR) fusion Bead and crevice-free (BCF) fusion
<b>Standards and guidelines<sup>1)</sup></b>	ISO, EN, ASTM, BS, JIS, CE, RoHS, DIN, DVS, SEMI
<b>Approvals<sup>1)</sup></b>	DIBt, ASME BPE, FDA, EU 10/2011, USP 25 class VI, FM-4910

<sup>1)</sup> For additional information about standards, guidelines and approvals, see [www.gfps.com](http://www.gfps.com)

**SYGEF Standard, SYGEF Plus product overview**

The following table uses metric units of measure.

Products	PN (bar)	SDR)	d (mm)	DN (mm)																
				10	15	20	25	32	40	50	63	75	90	110	125	140	160	200	225	250
Pipes	16	21		SYGEF Standard																
	10	33		SYGEF Plus																
Socket fusion fittings	16			SYGEF Standard																
Butt fusion fittings <sup>1)</sup> IR and BCF-compatible	16	21		SYGEF Standard																
	10	33		SYGEF Plus																
Ball valves	16			SYGEF Standard																
	10			SYGEF Plus																
Diaphragm valves	16			On request																
	10			SYGEF Plus																
Butterfly valves	10			SYGEF Plus																
Check valves	16			SYGEF Standard																
	10			SYGEF Plus																
Pressure regulating valves	10			SYGEF Plus																
Ventilating and bleed valves	16			SYGEF Standard																
Flanges				SYGEF Standard																
Gaskets				SYGEF Standard																
Pipe Clips				SYGEF Standard																
Automation				SYGEF Standard																
IR-welding machine				SYGEF Standard																
BCF-welding machine				SYGEF Standard																
Butt fusion machine <sup>1)</sup>				SYGEF Standard																
Socket fusion machine				SYGEF Standard																

SYGEF Standard  
SYGEF Plus

<sup>1)</sup> Butt fusion for SYGEF Standard is technically possible, but not recommended; for SYGEF Plus it is not allowed.

## SYGEF ECTFE

The ECTFE system made of ethylene-chlorotrifluoroethylene shows excellent physical properties and mechanical characteristics. The high-performance fluoropolymer material allows applications in a very broad temperature range of -76°C to +140°C <sup>1)</sup>, on a welded system approach for the use of aggressive chemicals approved between 0°C up to 80°C. Thanks to its extremely good chemical resistance, excellent abrasion resistance and high impact strength, ECTFE meets all requirements of demanding industrial environments. The SYGEF ECTFE system in combination with most advanced IR-jointing technology is dedicated for demanding applications in segments like Chemical Process Industry, Water Treatment and Microelectronics.

<sup>1)</sup> on short term only



Pipes



Fittings



Jointing technology

### Essential system properties

- Extremely resistant against high corrosive chemicals
- Unsuspecting towards stress cracking media
- Outstanding permeation resistance
- High temperature and UV-resistance

### Most important market segments

- Chemical process industry
- Water treatment
- Microelectronics

### Technical data

<b>Nominal pressure</b>	10 bar
<b>Temperature range on chemicals</b>	0 °C to +80 °C
<b>Temperature range material</b>	-76 °C to +130 °C (140 °C) <sup>1)</sup>
<b>Jointing technology</b>	Infrared (IR) fusion Mechanical joints
<b>Standards and guidelines<sup>2)</sup></b>	ISO, EN, DIN, ASTM, DVS

<sup>1)</sup> on short term only

<sup>2)</sup> Further information on standards, directives and approvals at [www.gfps.com](http://www.gfps.com)

**SYGEF ECTFE product overview**

The following table uses metric units of measure, available in PN 10 (bar) and SDR 21.

Products	DN	d	20	25	32	40	50	63	75	90	110
	(mm)	(mm)									
Pipes	15	20									
Fittings	20	25									
Unions	25	32									
Flange rings	32	40									
Gaskets	40	50									
Valves <sup>1)</sup>	50	63									
Automation	65	80									
Pipe clips	80	100									
IR fusion machines											

<sup>1)</sup> on request (PVC/PVDF BV546 Pro with ECTFE valve ends, Type SDV SSt/PFA, BuV 065, etc.)

## 2.7 PROGEF Piping Systems: Standard, Plus, and Natural

PROGEF systems out of polypropylene show excellent physical properties and mechanical characteristics. The high-quality material allows applications in a very broad temperature range (0 °C to 80 °C). Thanks to its high chemical resistance, good abrasion resistance and high impact strength, PROGEF Standard meets all requirements of demanding industrial environments. Cleaned and packed in specified processes, the silicone-free or oil-free PROGEF Plus system has a high pureness factor. The system is widely used in demanding applications in microelectronics as well as in coating and surface treatment. PROGEF Natural is a translucent, unpigmented polypropylene that is wherever pure solutions are needed. Its beneficial properties, such as excellent clean, smooth surface, together with the bead and crevice-free welding, ensure the system quality.



### Essential system properties

- High impact strength
- High operating temperature range
- High surface quality for PROGEF Plus
- Highest cleanliness and protection against contamination for PROGEF Plus
- Bead and crevice-free jointing technology for PROGEF Natural

### Most important market segments

- Water treatment
- Chemical process industry
- Microelectronics
- Energy

### Technical data

<b>Nominal pressure</b>	Up to 10 bar
<b>Temperature range</b>	0 °C to 80 °C
<b>Jointing technology</b>	Socket fusion Butt fusion Infrared (IR) fusion Bead and crevice-free fusion (BCF) for PROGEF Natural
<b>Standards and guidelines<sup>1)</sup></b>	ISO, EN, DIN, DVS
<b>Approvals<sup>1)</sup></b>	FDA, USP 25 class VI, DIBt, DNV, Lloyd's Register

<sup>1)</sup> For additional information about standards, guidelines and approvals, see [www.gfps.com](http://www.gfps.com)

### PROGEF Standard, PROGEF Plus product overview

The following table uses metric units of measure.

Products	SDR	PN (bar)	DN (mm)		
			d (mm)	DN (mm)	
Pipes	7.4	16	16	10	
			20	15	
			25	20	
	11	10	32	25	
			40	32	
			50	40	
	17.6	6	63	50	
			75	65	
			90	80	
Socket fusion fittings	11	10	110	100	
			125	100	
			140	125	
	17.6	10	160	150	
			180	150	
			200	200	
	225	10	225	200	
			250	250	
			280	250	
355	10	355	300		
		400	350		
		450	400		
Butt fusion fittings, IR-compatible	11	10	450	400	
			500	450	
			630	500	
	17.6	10	560	500	
			600	500	
			630	600	
	Ball valves	11	10	400	400
				450	450
				500	500
17.6		10	560	560	
			600	600	
			630	630	
Diaphragm valves		11	10	400	400
				450	450
				500	500
	17.6	10	560	560	
			600	600	
			630	630	
	Butterfly valves	10	10	400	400
				450	450
				500	500
Check valves	11/17.6	10	400	400	
			450	450	
			500	500	
Pressure regulating valves	11	10	400	400	
			450	450	
			500	500	
Ventilating and bleed valves	10	10	400	400	
			450	450	
			500	500	
Flanges PP-V / PP-Steel			400	400	
Gaskets EPDM / FKM			400	400	
Pipe clips PP / PE			400	400	
Automation			Upon request		

- PROGEF Standard
- PROGEF Plus

**Product overview PROGEF Natural**

Products	SDR	PN (bar)	d (mm)													
			DN (mm)	15	20	25	32	40	50	63	75	90	110			
Pipes	11	10														
	17.6	6														
Butt fusion fittings, IR and BCF-compatible	11	10														
	17.6	6														
Sanitary adapter	11	10														
Ball valves PP-H body/PP-R	11	10														
Ball valves PP-H Flange connector		10														
Diaphragm valves PP-R	11	10														
Diaphragm valves PP-H Flange connector		10														
Butterfly valves PP-H		10														
Cone check valves PP-H body/PP-R	11	10														
Cone check valves PP-H Flange connector		10														
Flange PP-V / PP-Steel																
Flange gaskets EPDM / FKM																
Pipe clips PP / PE																
Automation																Upon request

For more information about the system specification of PROGEF Standard, Plus, Natural, visit [www.gfps.com](http://www.gfps.com)



## 2.8 ecoFIT Piping System

The ecoFIT piping system is based on the material polyethylene, which meets the highest requirements in the industrial environment. It allows applications in a broad temperature range (-50 °C to +60 °C) and features high UV resistance, good abrasion resistance and high impact strength. Valve bodies made of PVC-U or PP-H with PE end connections allow easy integration in the ecoFIT system. To provide a maximum of flexibility, the valves come with socket welding, butt welding spigots or flanges.



### Essential system properties

- UV and weather-resistant
- Outstanding abrasion resistance
- High impact strength, particularly at low temperatures
- High flexibility

### Most important market segments

- Water treatment
- Chemical process industry
- Energy
- Marine
- Cooling
- Microelectronics

### Technical data

<b>Nominal pressure</b>	Up to 16 bar
<b>Temperature range</b>	-50 °C to +60 °C
<b>Jointing technology</b>	Socket fusion Butt fusion Infrared (IR) fusion Electrofusion
<b>Standards and guidelines<sup>1)</sup></b>	ISO, EN, DVS
<b>Approvals<sup>1)</sup></b>	DIBt, FM, IIP, ABS, DNV, GL, RINA, RMROS, CCS, Nk approved

<sup>1)</sup> For additional information about standards, guidelines and approvals, see [www.gfps.com](http://www.gfps.com)

### ecoFIT product overview

The following table uses metric units of measure.

Products	Material	SDR	PN (bar)	DN (mm)																					
				15	20	25	32	40	50	63	75	90	110	125	140	150	160	180	200	225	250	280	315	355	400
Pipes	PE100	7.4	20	[Blue bar]																					
		11	16	[Blue bar]																					
		17/17.6	10	[Blue bar]																					
Socket fusion fittings	PE80	11	10	[Blue bar]																					
Butt fusion fittings, IR-compatible	PE100	11	16	[Blue bar]																					
		17/17.6	10	[Blue bar]																					
Electrofusion fittings (ELGEF)	PE100	11	16	[Blue bar]																					
		17/17.6	10	[Blue bar]																					
Valves				[Blue bar]																					
Flanges	PP-V / PP-ST			[Blue bar]																					
Gaskets	EPFM/ FKM			[Blue bar]																					
Pipe clips	PP / PE			[Blue bar]																					
Automation				[Blue bar]																					

### Valve product range

Products	Valve bodies	DN (mm)																							
		15	20	25	32	40	50	63	75	90	110	125	140	150	160	180	200	225	250	280	315	355	400	450	500
Ball valves	PP-H, PVC-U	[Blue bar]																							
Diaphragm valves	PP-H, PVC-U	[Blue bar]																							
Butterfly valves	PP-H	[Blue bar]																							
	PP-R	[Blue bar]																							
	PVC-U	[Blue bar]																							
	Metal	[Blue bar]																							
Cone check valves	PP-H, PVC-U	[Blue bar]																							
Ventilating and bleed valves	PP-H, PVC-U	[Blue bar]																							
Check valves	PP-H, PVC-U	[Blue bar]																							
Pressure control valve	PP-H, PVC-U	[Blue bar]																							

For more information about the system specification of ecoFIT, visit [www.gfps.com](http://www.gfps.com)

## 2.9 HEAT-FIT – Ultimate Fire Protection

The HEAT-FIT System is designed for applications in the maritime industry and makes the thermoplastic piping system ecoFIT resistant to temperatures up to 1.000°C or 1832°F for at least 30 minutes under pressure.



HEAT-FIT PE Fire Resistant test (IMO Res. A753 fire endurance L3 Code)

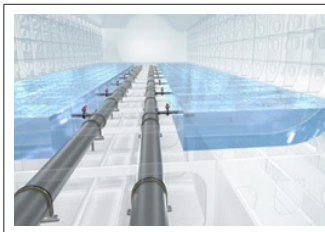
### Features & Advantages

- Easy installation: No special skills required
- Up to 30% lighter than alternative materials (metal or Glass Reinforced Plastic)
- Fire Resistant code L3 according to IMO 753 – Meets the guidelines for applications of plastic pipes on ships
- Impact resistant, deformation can be absorbed
- Reliable, sustainable and long lasting solution
- 100% corrosion free

### Most important market segments

- Marine

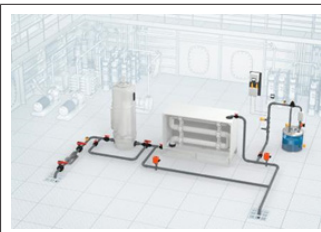
### Marine applications



#### Ballast system

Ballast system ensures the stability of a vessels

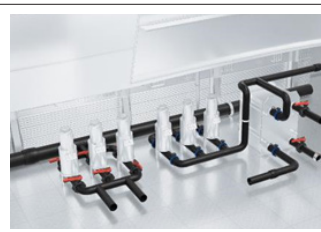
- Media: Sea water
- Temperature: up to +35°C



#### Ballast water treatment Management

Regulates the discharge

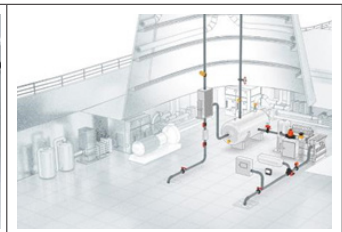
- Media: Sea water
- Temperature: up to +35°C



#### Seawater and freshwater cooling

Provide cooling to engine or other equipment

- Media: Sea and fresh water
- Temperature: up to +60°C



#### Exhaust gas scrubber

Remove Sulphur oxides from ship's exhaust gas by scrubbing it with sea water or fresh water.

- Media: Sea water - low PH and very aggressive
- Temperature: up to +60°C

IMO 753 - Fire endurance requirements matrix

Piping Systems	Location					
	A	B	C	D	J	K
	Machinery spaces of category A	Other machinery spaces and pump rooms	Cargo pump rooms	RO/RO cargo holds	Accommodation service and control spaces	Open decks
<b>Sea water</b>						
Sprinkler system						
Ballast sea water (include BWT lines)	L3	L3	L3	L3	L2	L2
Cooling water, essential services	L3	L3				L2
Tank cleaning services fixed machines			L3			
<b>Fresh water</b>						
Cooling water, essential services	L3	L3			L3	L3
Condensate return	L3	L3	L3			
Exhaust gas cleaning effluent line	L3	L3			L3	

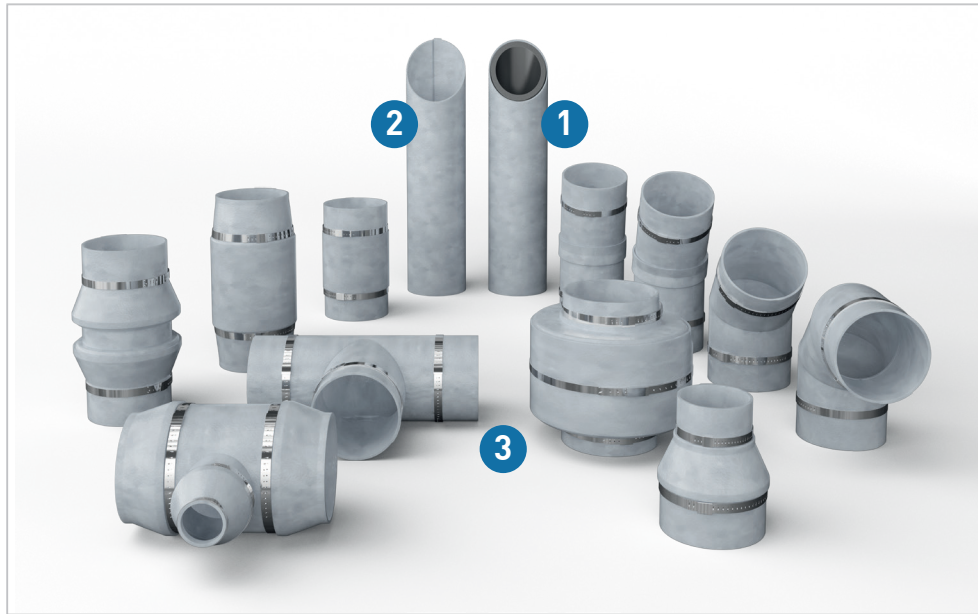
L2 : Fire Resistant code L2 according to IMO 753

L3 : Fire Resistant code L3 according to IMO 753

Source: [IMO Publications and Documents](#)

## 2.9.1 HEAT-FIT Product Range

Georg Fischer provides a HEAT-FIT JACKET and a HEAT-FIT PE system.








- 1 HEAT-FIT PE
- 2 HEAT-FIT Jacket Sleeve
- 3 HEAT-FIT Jacket

### Technical data

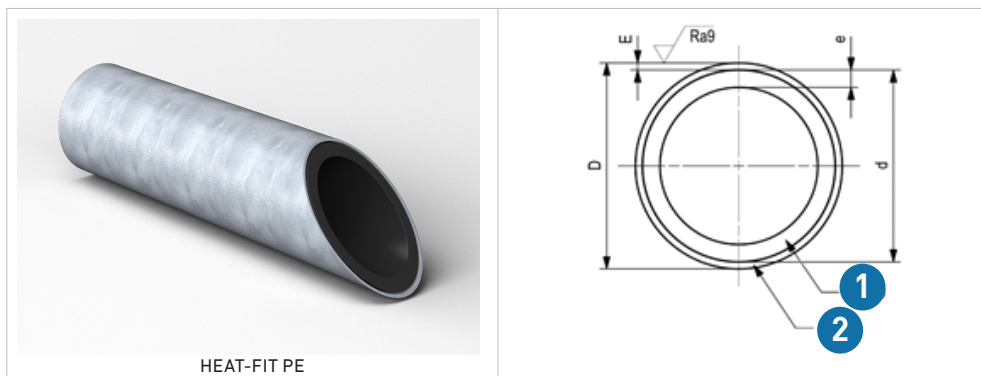
	HEAT-FIT PE	HEAT-FIT Jackets & Sleeves
<b>Dimensions</b>	d110, d160, d225, d315	d110, d160, d225, d315
<b>SDR</b>	11	Note: Combined with ecoFIT PE100 SDR 11 system
<b>PN (bar)</b>	16	Note: Combined with ecoFIT PE100 PN 16 system
<b>Materials</b>	Pipe PE100	Base fabric High Temp. Fiberglass
		Finished weight 3400 g/m <sup>2</sup>
		Thickness 3.5 mm
		Finishing TPU film
	Coating Fire Retardant (FR)	Coating Fire Retardant (FR)
<b>Fire resistant</b>	At least 30 minutes up to 1.000°C / 1832° Fahrenheit	At least 30 minutes up to 1.000°C / 1832° Fahrenheit
<b>Density</b>	~1.14 g/cm <sup>3</sup> (Acc. EN ISO 1183-1)	~1.021 g/cm <sup>3</sup> (Acc. EN ISO 1183-1)
<b>Impact resistance</b> (90° RT & 0°C & RT)	No damage	No damage
<b>Vibration</b> (5 Hz)	2'000'000 load cycles	2'000'000 load cycles
<b>Diesel Resistance</b> (RT, 24h, immersion)	0.30%	15%
<b>Humidity</b> (50 °C, 95 % r.h., 24h spray)	0.80%	20%
<b>NSS</b> (35 °C, 24h immersion, 5 % NaCl, pH-value of 6.5-7.2)	0.40%	3.0%
<b>NaCl</b> (23 °C, 24h immersion, 3.5 % NaCl, pH-value of 6.5-7.2)	0.20%	1.4%
<b>Color</b>	Light grey	Light grey as RAL 7035
<b>Service life</b>	tbd	tbd

## Approvals &amp; Testing

Approval/Test	HEAT-FIT PE	HEAT-FIT Jackets & Sleeves
 <b>ABS</b> (20-1958414-1-PDA 20-4336831)	Expected Q4/2023	X
 <b>LR</b> (LR22277454TA)	Expected Q4/2023	X
 <b>DNV</b> (TAK00001B2)	Expected Q4/2023	X
 <b>RINA</b> (Q4/2022)	Expected Q4/2023	X
 <b>BV</b> (10132/F1)	Expected Q4/2023	X
<b>Fire Resistant plastic piping systems</b> (IMO Res. A753 fire endurance L3 Code)	X	X
<b>Surface Flammability, Smoke and Toxicity</b> (IMO A653 2010 FTP Code Part 5 and Part 2)	-	X
<b>ASTM D635-22</b> Standard test method for rate of burning and/ or extent and time of burning of plastics in a horizontal position	X	

## HEAT-FIT PE

The HEAT-FIT PE piping system is a solution designed for the maritime industry. The co-extruded pipe basically consists of a media-carrying polyethylene pipe and a fire-retardant coating with a wall thickness  $e$  of 4mm.



- 1 PE100 pipe
- 2 Flame-retardant coating

## Technology



The halogen-free, high-performance intumescent coating, which is applied to the pipe by a co-extrusion process, withstands the most stringent requirements. The flame-retardant coating reacts with an intumescent reaction upon contact with flames. This intumescent reaction forms a protective layer that shields the underlying piping from flames and heat.

**Product range**

In the following table units of measurement are indicated according to the metric system.

Products	DN (mm)	110	125	140	160	180	200	225	280	315
PE100 pipe*	d (mm)	110			160			225		315
HEAT-FIT PE**	D (mm)	118			168			233		323

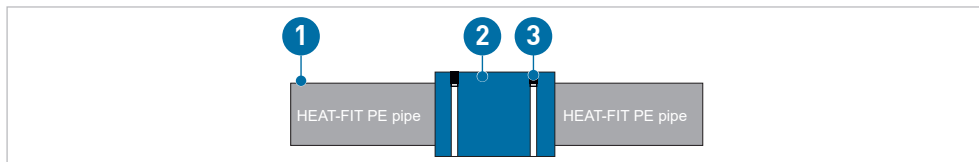
\* d Outside diameter of the PE100 pipe

\*\* D Outside diameter of the HEAT-FIT PE pipe

**i** For further information see [www.gfps.com/heat-fit](http://www.gfps.com/heat-fit)

**Connection technology**

Pipe to pipe connections must be done via butt fusion. The weld bead must be covered after the successful pressure test with a HEAT-FIT Jacket Weld Bead Cover to ensure the flame retardant functionality.



- 1 HEAT-FIT PE pipe
- 2 HEAT-FIT Jacket Weld Bead Cover
- 3 Metal strap and closure coupler



## HEAT-FIT Jacket Sleeves

HEAT-FIT Jacket is a flame-retardant system for ecoFIT PE100 pipes. All HEAT-FIT Jacket Sleeves are made of high temperature (HT) glass fiber fabric, intumescent coating, special adhesive and thermoplastic polyurethane (TPU).



## Technology



The Halogen-free water-based high performing intumescent coating which is applied to a glass fiber fabric is more flexible, more elastic, smoother and capable of surpassing the most severe requirements. In order to protect the coating and the fiberglass fabric from external influences, they are laminated with a flame retardant thermoplastic Urethane. The coating reacts with an expanding reaction upon contact with flames. This intumescent reaction forms a protective layer that protects the underlying piping from flames and heat.

**Product range**

In the following table units of measurement are indicated according to the metric system.

Products	DN (mm)	110	125	140	160	180	200	225	280	315
ecoFIT PE100 pipe*	d (mm)	110			160			225		315
HEAT-FIT Jacket Sleeves**	D (mm)	122			172			237		327

\* d Outside diameter of the ecoFIT PE100 pipe

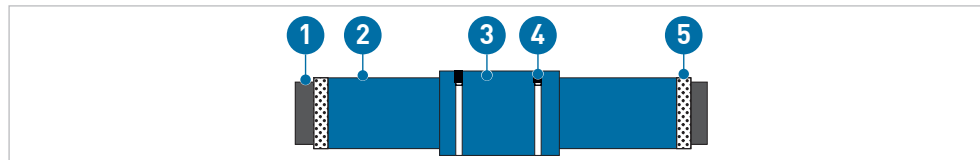
\*\* D Outside diameter of the HEAT-FIT Jacket Sleeves

**i** For further information see [www.gfps.com/heat-fit](http://www.gfps.com/heat-fit)

**Connection technology**

Pipe to pipe connections must be done via butt fusion or electrofusion.

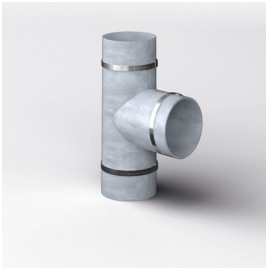
To ensure the flame retardant functionality after the succesfull pressure test, the weld bead must be covered with a HEAT-FIT Jacket Weld Bead Cover, the electrofusion coupler must be covered with HEAT-FIT Jacket Electrofusion coupler.



- 1 ecoFIT PE100 pipe
- 2 HEAT-FIT Jacket Sleeve
- 3 HEAT-FIT Jacket Weld Bead Cover / HEAT-FIT Jacket Electrofusion coupler
- 4 Metal Strap
- 5 TPU sealing tape

## HEAT-FIT Jacket

HEAT-FIT Jacket Fittings is a flame-retardant system for ecoFIT PE100 fittings. All HEAT-FIT Jacket Fittings are made of high temperature (HT) glass fiber fabric, intumescent coating, special adhesive and thermoplastic polyurethane (TPU).



HEAT-FIT  
Tee 90° Equal



ecoFIT  
Tee 90° Equal



HEAT-FIT Jackets  
combined with ecoFIT PE100 Fitting

## Technology

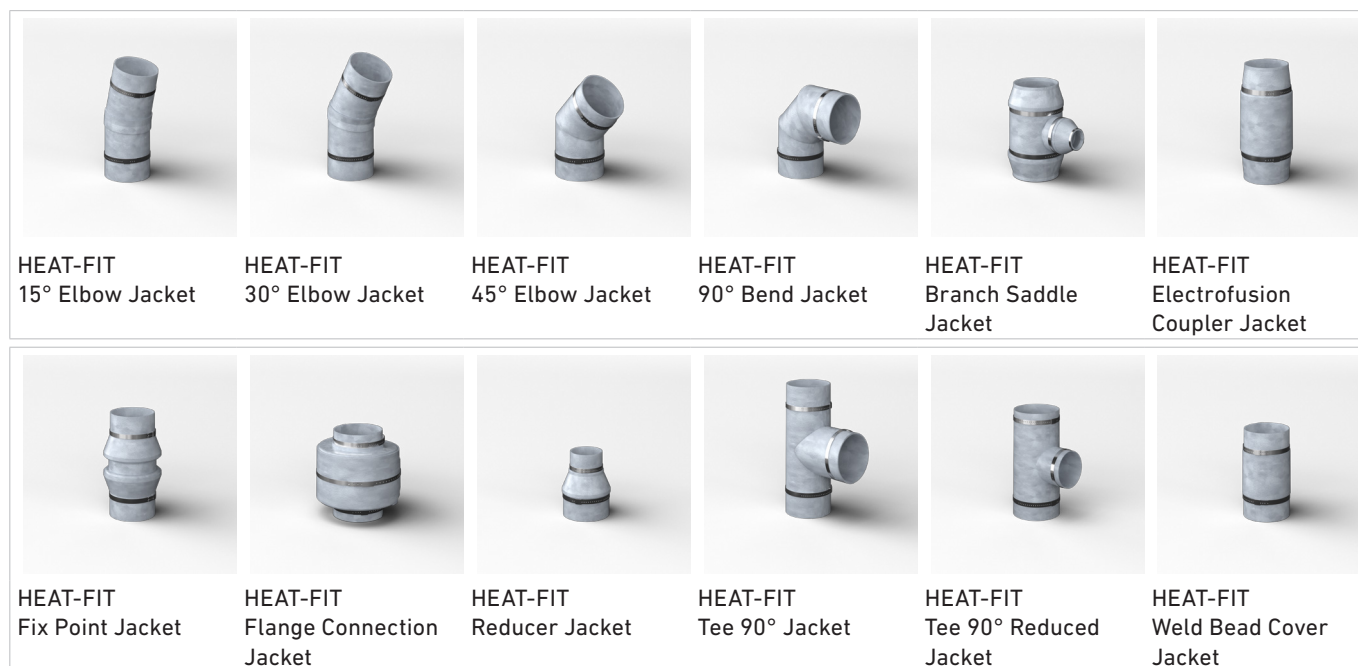
The Halogen-free water-based high performing intumescent coating which is applied to a glass fiber fabric is more flexible, more elastic, smoother, and capable of surpassing the most severe requirements. In order to protect the coating and the fiberglass fabric from external influences, they are laminated with a flame retardant thermoplastic Urethane. The coating reacts with an expanding reaction upon contact with flames. This intumescent reaction forms a protective layer that protects the underlying piping from flames and heat.

**Product range**

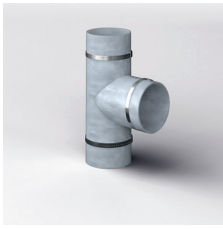



The following table uses metric units of measure.

Products	d (mm)	110	125	140	160	180	200	225	280	315
Jacket – 90° Bend										
Jacket – 45° Elbow										
Jacket – 30° Elbow Long Spigot										
Jacket – 15° Elbow Long Spigot										
Jacket – Tee 90° Equal										
Jacket – Tee 90° Reduced										
Jacket – Reducer										
Jacket – Flange Connection										
Jacket – Fix Point										
Jacket – Branch Saddle (to d63)										
Jacket – Electrofusion coupler										
Jacket – Weld Bead Cover										
Insert for pipe clamps										

**i** For further information see [www.gfps.com/heat-fit](http://www.gfps.com/heat-fit)



**HEAT-FIT Accessories**

HEAT-FIT Jacket Tee 90°	HEAT-FIT Metal Strap	HEAT-FIT Metal Closure	ecoFIT Tee 90° PE100
			
756 200 114	756 170 302	756 170 303	753 208 614
1x	1x 165cm	3x	1x

**Product range**

The following table uses metric units of measure.

Products	d (mm)	110	125	140	160	180	200	225	280	315
Sealing Tape		■			■			■		■
Metal Strap		■			■			■		■
Metal Closure		■			■			■		■

**Sealing Tape**

The thermoplastic polyurethane (TPU) tape is delivered on a role with a total length of 25m and needed in case that the HEAT-FIT Jacket Sleeves must be shortened.

**Metal Strap & Metal Closure**

Stainless steel straps are delivered on a role with a total length of 30m. All metal straps must be closed via the metal closures to ensure the flame retardant functionality.

**i** For further information see [www.gfps.com/heat-fit](http://www.gfps.com/heat-fit)

**Order information**

All components must be ordered separately. The required information, such as the required length of metal straps, quantity of metal closures and corresponding ecoFIT inner pipe code numbers are listed in the HEAT-FIT datasheets.

**Training**

Planners and installer, involved with HEAT-FIT, ELGEF-Plus and ecoFIT planning and installation, must undergo training and certification from GF Piping Systems prior to performing any operations on site. For further information and training please contact GF support.

## 2.9.2 Installation HEAT-FIT

### Installation HEAT-FIT PE

#### Connection technology HEAT-FIT PE

The system is installed analogously to the standard ecoFIT piping system by means of a conventional butt fusion. For more information, see chapter "Joining technology – Welding".

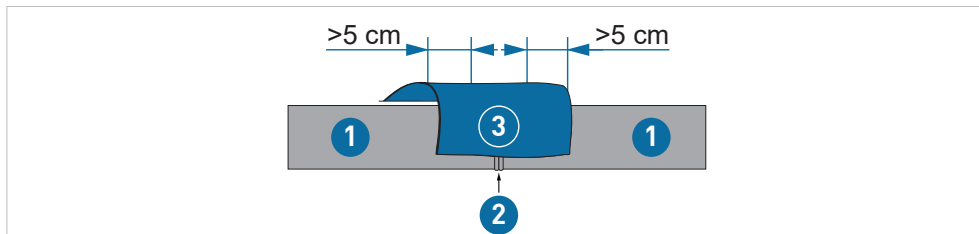
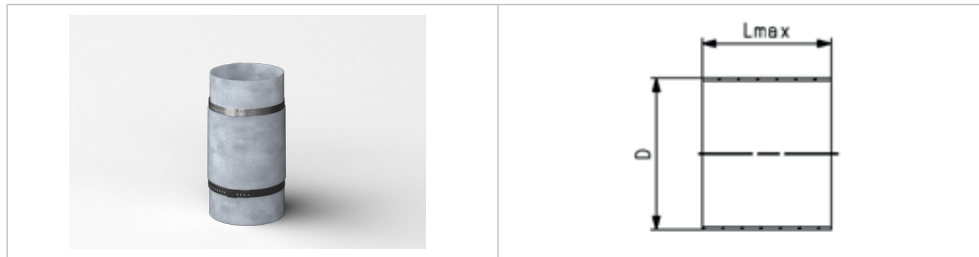
#### Welding parameters

Standard welding parameters for ecoFIT PE100 / PN16 / SDR11 must be considered for all weldings.

#### Pipe to pipe connections

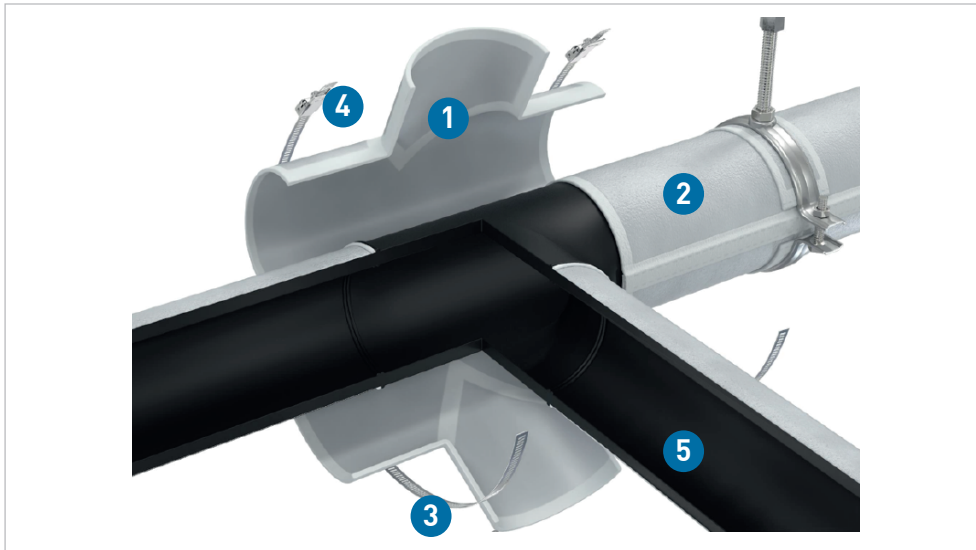
Pipe-to-pipe butt-weld joints must be covered with a HEAT-FIT Jacket.

Dimension	Code
d110	756 170 334
d160	756 170 337
d225	756 170 330
d315	756 170 333



### Pipe to fitting connections

Pipe to fitting connections must be covered with a HEAT-FIT Jacket. Care must be taken to ensure an overlap.



- 1 HEAT-FIT Jacket Tee 90°  
Art. Code 756 200 114
- 2 HEAT-FIT Jacket Art. Code  
756 170 114
- 3 Metal Strap Art. Code 756  
170 302
- 4 Metal Closure Art. Code 756  
170 303
- 5 HEAT-FIT PE Pipe Art. Code  
756 017 114

**Important:** Due to the larger outside diameter D (FR) of the HEAT-FIT PE pipe, special half-shells for the welding machines must be considered during installation. Please contact GF Piping Systems local sales company.

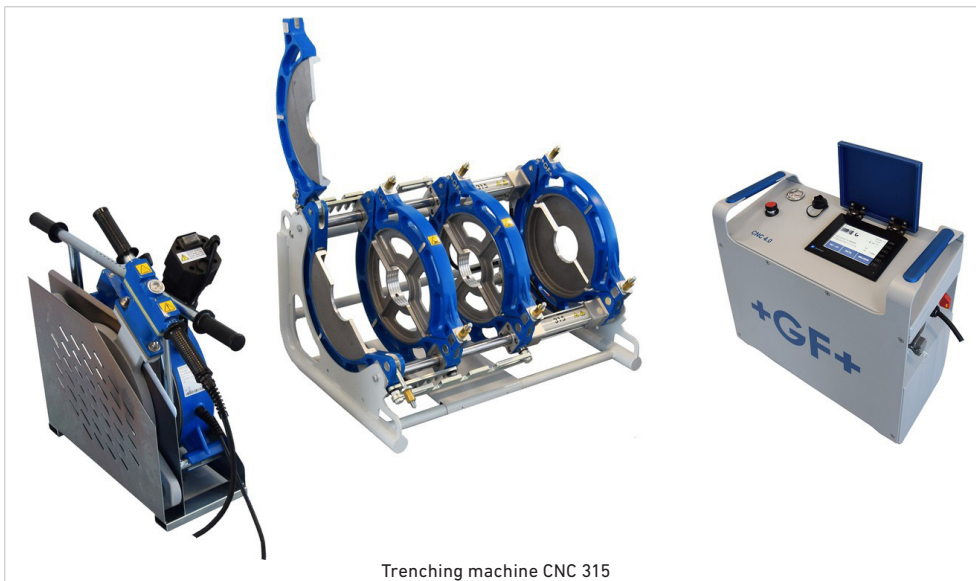
Due to the flame-retardant layer of 4mm on the outer pipe the pipe dimension is slightly bigger.

Therefore please keep an eye on the relevant welding machines.

Example:

- HEAT-FIT PE d160mm/D168mm

- Possible welding machine: TM 250 / TM 315



Trenching machine CNC 315

NOTE: Special half-shells are required!

### Installation HEAT-FIT PE

HEAT-FIT Jackets are hand-fitted to the ecoFIT piping system components using HEAT-FIT metal straps and HEAT-FIT fasteners after welding the ecoFIT inner pipe.

<p><b>1</b></p> <p><b>Fusion process</b></p>	<p>1. Carry out the butt fusion process for ecoFIT piping system according to separate instructions.</p>		<ul style="list-style-type: none"> <li><b>1</b> HEAT-FIT PE pipe</li> <li><b>2</b> Special half shells</li> <li><b>3</b> Heating element</li> </ul>
	<p>2. Observe the cool down time following the welding process.</p>		<ul style="list-style-type: none"> <li><b>1</b> Weld bead</li> </ul>
<p><b>2</b></p> <p><b>HEAT-FIT Jacket installation</b></p>	<p>1. Position HEAT-FIT Jacket on the fitting: Ensure &gt;5cm overlap from HEAT-FIT Jacket to Pipe.</p>		<ul style="list-style-type: none"> <li><b>1</b> HEAT-FIT PE pipe</li> <li><b>2</b> Weld bead</li> <li><b>3</b> HEAT-FIT Jacket Weld Bead Cover</li> <li><b>4</b> ecoFIT PE100 Tee 90°</li> <li><b>5</b> HEAT-FIT Jacket Tee 90°</li> </ul>
	<p>2. Refer to the product catalog for the number of metal straps/closures required and hand-tighten accordingly. It is mandatory to place the metal strap over each overlapping surface. Caution: Do not overtighten.</p>		<ul style="list-style-type: none"> <li><b>1</b> HEAT-FIT Metal Strap &amp; Closures</li> </ul>
	<p>3. Final inspection: The HEAT-FIT pipe must be completely covered with the HEAT-FIT Jackets.</p>		



### Installation HEAT-FIT Jackets and Sleeves

HEAT-FIT Jacket Sleeves are installed on the straight pipe runs prior to welding the ecoFIT piping system components.

HEAT-FIT Jackets are hand-fitted to the ecoFIT piping system components using HEAT-FIT metal straps and HEAT-FIT fasteners after welding the ecoFIT inner pipe.

<p>1 Cutting</p>	<p><b>Butt fusion</b> After cutting the ecoFIT pipe to the required length, cut the HEAT-FIT Jacket Sleeve 4 cm shorter than the ecoFIT pipe.</p>	<p><b>Electrofusion</b> (Pipe-pipe connections only!) After cutting the ecoFIT pipe to the required length, cut the HEAT-FIT Jacket Sleeve according to the formula below. <b>Calculation HEAT-FIT Jacket Sleeve length</b> Jacket Sleeve Length = ecoFIT Pipe Length – (Insertion depth + 2cm). Insertion depth ELGEF Plus = L / 2</p>	<p>1 ecoFIT pipe 2 HEAT-FIT Jacket Sleeve 3 ELGEF Plus electrofusion coupler</p>
<p>2 Sealing</p>	<p>1. To prevent moisture penetration, apply TPU sealing tape around the cut edge of the HEAT-FIT material and press on by hand.</p> <p>2. Align HEAT-FIT Jacket Sleeve centered on the ecoFIT pipe.</p>		<p>1 HEAT-FIT Jacket Sleeve 2 TPU sealing tape</p> <p>1 HEAT-FIT Jacket Sleeve</p>
<p>3 Fusion process</p>	<p>1. Carry out the butt fusion process for ecoFIT piping system according to separate instructions. For free access to the welding point, the HEAT-FIT Jacket Sleeve must be pushed away from the welding site.</p> <p>2. Following the welding process and after the cooling time has elapsed, the HEAT-FIT Pipe Sleeve is pushed into the center of the two welding beads.</p>		<p>1 HEAT-FIT Jacket Sleeve 2 Half shells 3 Heating element</p> <p>1 HEAT-FIT Jacket Sleeve</p>

4

**HEAT-FIT Jacket installation**

1. Position HEAT-FIT Jacket on the fitting: Ensure >5cm overlap from HEAT-FIT Jacket to Jacket Sleeve according to illustration.

Pipe

Fittings

2. Refer to the product catalog for the number of metal straps/closures required and hand-tighten accordingly. It is mandatory to place the metal strap over each overlapping surface. Caution: Do not overtighten.

Pipe

Fittings

3. Final inspection: The ecoFIT piping system must be completely covered with the HEAT-FIT.

Pipe

Fittings

- 1 HEAT-FIT Jacket Sleeve
- 2 Weld bead
- 3 HEAT-FIT Jacket Weld Bead Cover
- 4 ecoFIT PE100 pipe & HEAT-FIT Jacket Sleeve
- 5 ecoFIT PE100 Tee 90°
- 6 HEAT-FIT Jacket Tee 90° Equal

- 1 HEAT-FIT Metal Strap & Closures

## 2.10 CONTAIN-IT Plus Piping System

The CONTAIN-IT Plus piping system is used to minimize risks to humans, the environment and the plant. Existing legal regulations or ordinances could specify double containment piping systems. GF Piping Systems ensures excellent performance in transporting aggressive fluids or hazardous media in all types of different applications. The CONTAIN-IT Plus product range for media lines is available in a variety of plastics (PP, PE, PVDF, PVC-U, PVC-C and ECTFE). The protective line is made of PE, resulting in high UV and weather resistance. In addition, GF Piping Systems offers as well "PVC-U" or "transparent PVC-U" as outside piping.



### Essential system properties

- Suitable for visual inspection and identification
- Protection of personnel and the environment
- Adaptable leak monitoring system
- Compliance with legal regulations

### Most important market segments

- Water treatment
- Chemical process industry
- Microelectronics
- Energy

### Technical data

<b>Nominal pressure</b>	Up to 16 bar	
<b>Temperature range</b>	-50 °C to +140 °C (acc. to primary pipe material)	
<b>Jointing technology</b>	Inside pipe	Socket fusion
		Butt fusion
		Infrared (IR) fusion
		Solvent cementing
	Exterior line	Electrofusion / Mechanical joint with EPDM sleeve
<b>Standards and guidelines<sup>1)</sup></b>	ISO, EN ISO, ASTM, DIN, DVS	
<b>Approvals<sup>1)</sup></b>	Please refer to the PROGEF, ecoFIT, SYGEF, PVC-U and PVC-C	

<sup>1)</sup> For additional information about standards, guidelines and approvals, see [www.gfps.com](http://www.gfps.com)

**Product overview CONTAIN-IT Plus**

The following table uses metric units of measure.

Material (inner/outer)	Products	PN <sub>inner</sub> (bar)	PN <sub>outer</sub> (bar)	d <sub>o</sub> <sup>1)</sup> (mm)		d <sub>i</sub> <sup>1)</sup> (mm)													
				50	50	63	75	90	110	125	140	160	180	200	225	280	315		
PP-H/PE100	Socket fusion fittings	10	16	[Blue bar]															
		10	10	[Blue bar]															
	Butt fusion fittings, infrared-compatible	10	16	[Blue bar]															
		10	10	[Blue bar]															
	Mechanical connection	10	6	[Blue bar]															
PE100/PE100	Butt fusion/IR fusion fittings	16	16	[Blue bar]															
		16	10	[Blue bar]															
	Ball valves (housing: PVC-U)	10	6	[Blue bar]															
	Mechanical connection	10	6	[Blue bar]															
PE80/PE100	Socket fusion fittings	10	16	[Blue bar]															
		10	10	[Blue bar]															
	Ball valves (housing: PVC-U, PP-H)	10	6	[Blue bar]															
PVDF/PE100	Socket fusion fittings	16	16	[Blue bar]															
		16	10	[Blue bar]															
	Butt fusion/IR fusion fittings	16	16	[Blue bar]															
		16	10	[Blue bar]															
	10	10	[Blue bar]																
	Ball valves	16	6	[Blue bar]															
Mechanical connections	10	6	[Blue bar]																
PVC-U/PE100	Cemented sockets fittings	16	16	[Blue bar]															
		16	10	[Blue bar]															
		10	10	[Blue bar]															
	Ball valves	16	6	[Blue bar]															
	Mechanical connection	16	6	[Blue bar]															
PVC-C/PE100	Adhesive fittings	16	16	[Blue bar]															
		16	10	[Blue bar]															
	Ball valves	16	6	[Blue bar]															
	Mechanical connection	10	6	[Blue bar]															
ECTFE/PE100	IR fusion fittings	10	10	[Blue bar]															
	Mechanical connection	10	10	[Blue bar]															
Leak monitoring				[Blue bar]															

<sup>1)</sup> d<sub>o</sub> Dimension of the outer pipe  
d<sub>i</sub> Dimension of the inner pipe

For more information about the system specification of CONTAIN-IT Plus, visit [www.gfps.com](http://www.gfps.com) and see the planning fundamentals in chapter „Double containment piping system – CONTAIN-IT Plus“.

## 2.11 COOL-FIT Piping Systems

Cooling in general can be divided into basic application areas, one is typically below 0°C (32°F) called industrial refrigeration and the other one is above 0°C (32°F) with applications such as air-conditioning systems or process cooling.

GF Piping Systems offers the pre-insulated COOL-FIT range to cover all cooling applications. COOL-FIT 2.0 is based on the PE Electrofusion Technology for the primary pipe and targets above 0°C (32°F) applications. The COOL-FIT 2.0 is extended to below 0°C (32°F) applications having a thicker insulation, named COOL-FIT 4.0.

### 2.11.1 COOL-FIT 4.0

COOL-FIT systems are completely pre-insulated plastic piping systems for secondary cooling circuits that are operated with water, brine or glycol solutions as well as slurry ice. Typical application areas are industrial refrigeration systems with medium temperatures far below 0 °C and air-conditioning systems for media above 0 °C.

The COOL-FIT 4.0 media pipe is made of PE and is covered by high-quality GF HE insulation as well as a robust and UV-resistant jacket pipe. The smooth inside surface of the media pipe ensures very low pressure losses. The low thermal conductivity of the plastic and the insulation are a guarantee for life-long low energy and operating costs. In addition, the 3-in-1 design limits the installation time to a minimum.

COOL-FIT 4.0 is well suited for use in cold storage, in food production (e.g. in breweries, dairies and slaughterhouses), in supermarkets as well as for industrial cooling water systems for process cooling and in computing centers.



### Essential system properties

- 3-in-1 system: media pipe, insulation and protective outer sheath in one product
- Quick connection
  - COOL-FIT 4.0: pre-insulated electrofusion fittings
- Uses approx. 50 % less energy in operation compared to post-insulated copper systems
- UV and weather-resistant, steam jet-compatible

### Most important market segments

- Cooling
- Marine

### Technical data

<b>Nominal pressure</b>	Up to 16 bar for COOL-FIT 4.0
<b>Temperature range</b>	-50°C to +60°C for COOL-FIT 4.0
<b>Joining technology</b>	Electrofusion for COOL-FIT PE Plus
<b>Standards and guidelines<sup>1)</sup></b>	ISO, EN ISO, ASTM, DIN, DVS
<b>Approvals<sup>1)</sup></b>	Please refer ecoFIT

<sup>1)</sup> For additional information about standards, guidelines and approvals, see [www.gfps.com](http://www.gfps.com)

### COOL-FIT 4.0 product overview

Products	PN (bar)	Diameter (mm)																
		d (mm)	DN (mm)	D <sup>1)</sup> (mm)	90	110	110	125	140	160	180	250	315	355	400	450	500	560
Pipes, pre-insulated	16	32	25	90	110	110	125	140	160	180	250	315	355	400	450	500	560	630
	10	40	32	90	110	110	125	140	160	180	250	315	355	400	450	500	560	630
Elbows 45 /90 , pre-insulated	16	50	40	90	110	110	125	140	160	180	250	315	355	400	450	500	560	630
	10	63	50	90	110	110	125	140	160	180	250	315	355	400	450	500	560	630
T-90 equal, pre-insulated	16	75	65	90	110	110	125	140	160	180	250	315	355	400	450	500	560	630
	10	90	80	90	110	110	125	140	160	180	250	315	355	400	450	500	560	630
T-90 reduced, pre-insulated	16	110	100	90	110	110	125	140	160	180	250	315	355	400	450	500	560	630
	10	160	150	90	110	110	125	140	160	180	250	315	355	400	450	500	560	630
Reducers, pre-insulated	16	225	200	90	110	110	125	140	160	180	250	315	355	400	450	500	560	630
	10	250	250	90	110	110	125	140	160	180	250	315	355	400	450	500	560	630
Installation fittings, pre-insulated	16	280	250	90	110	110	125	140	160	180	250	315	355	400	450	500	560	630
	10	315	300	90	110	110	125	140	160	180	250	315	355	400	450	500	560	630
Flange joints, insulated	10/16	355	350	90	110	110	125	140	160	180	250	315	355	400	450	500	560	630
Ball valves, insulated	16	400	400	90	110	110	125	140	160	180	250	315	355	400	450	500	560	630
Butterfly valves, insulated	10	450	450	90	110	110	125	140	160	180	250	315	355	400	450	500	560	630
Transition fittings, insulated	16	450	450	90	110	110	125	140	160	180	250	315	355	400	450	500	560	630
Fixed points	-	450	450	90	110	110	125	140	160	180	250	315	355	400	450	500	560	630

<sup>1)</sup> Diameter of the protective sleeve

For more information about the system specification of COOL-FIT, visit [www.gfps.com](http://www.gfps.com) and see the planning fundamentals chapter "System COOL-FIT".

## 2.11.2 COOL-FIT 2.0

COOL-FIT 2.0 is a pre-insulated piping system for the delivery of refrigerants. Thanks to its insulation thickness of 22 mm, the system can be used in air-conditioning systems with coolants temperatures above 0 °C. COOL-FIT 2.0 is based on established, impact resistant and corrosion free PE pipe and fittings. The smooth inner surface of the fluid pipe provides minimal losses of pressure. The low thermal conductivity and high quality insulation guarantee low operating cost over the entire lifespan of the system. Thanks to the 3-in-1 design – Fluid pipe / Insulation / Jacket tube – installation time is kept very short.

The system consists of pipe, fittings, valves, flexible hoses and transition fittings. All components are pre-insulated or supplied with mountable insulation shells. The COOL-FIT 2.0 tools allow for fast and safe installation of the system.



### Essential system properties

- 3-in-1 system: media pipe, insulation and protective outer jacket
- 50% faster installation than conventional systems
- 30% better insulation performance than post insulated metal systems
- Corrosion free

### Most important market segments

- Cooling (> 0°C / 32°F)
- Marine

**Technical data**

<b>Nominal pressure</b>	16 bar, SDR 11
<b>Temperature range</b>	0°C to +60 °C
<b>Medium</b>	0°C to +55 °C
<b>Environment</b>	0°C to +55 °C
<b>Joining technology</b>	Electrofusion
<b>Standards and guidelines<sup>1)</sup></b>	ISO, EN ISO
<b>Approvals<sup>1)</sup></b>	Fire classes, please see chapter "Approvals of products" or at <a href="http://www.gfps.com">www.gfps.com</a> with up-to-date listings

<sup>1)</sup> For additional information about standards, guidelines and approvals, see [www.gfps.com](http://www.gfps.com)

**COOL-FIT 2.0 product overview**

The following table uses metric units of measure

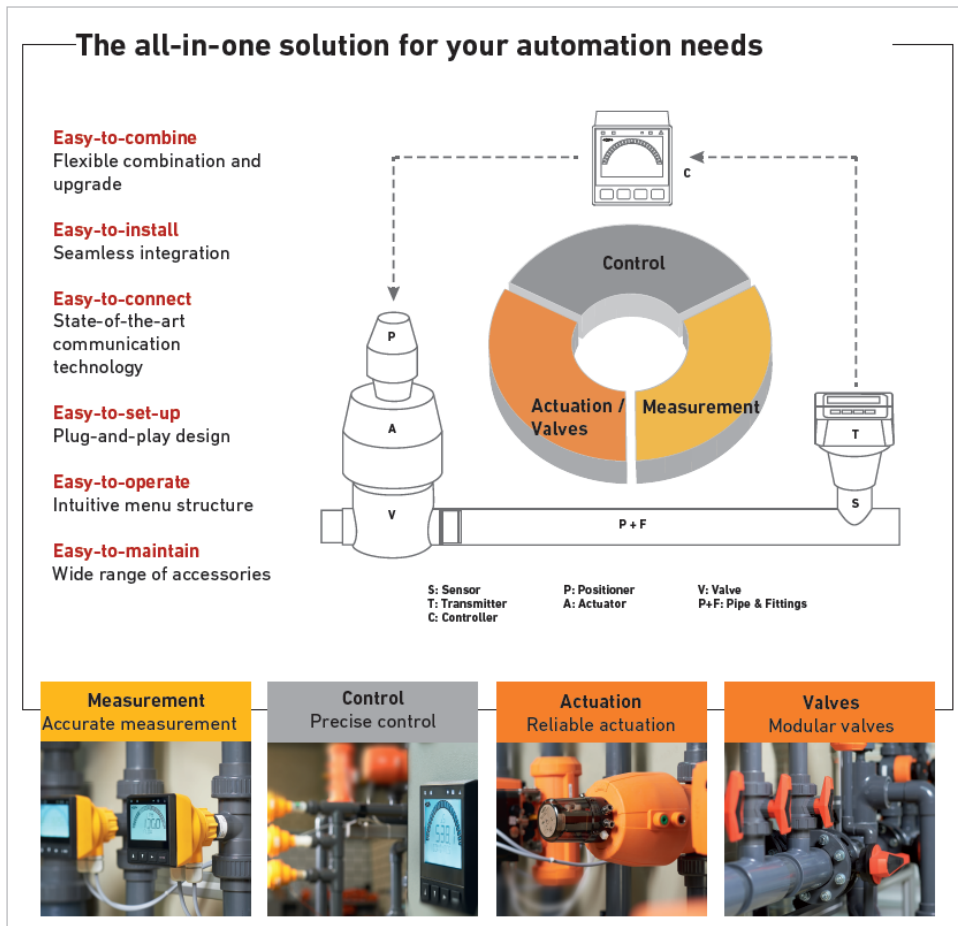
Products	d (mm)									
	25	32	40	50	63	75	90	110	140	
Pipes PN 16										
Couplers										
Elbows 90° / 45°										
T-90° equal										
T-90° reduced										
Reducers										
Flexible hoses										
Ball valves										
Butterfly valves										
Transition fittings										
Fixed points										



## 2.12 Automation

### 2.12.1 Overview

The automation closed control loop consists of three elements: measurement, control and actuation/valves. The measurement element includes a number of measuring technologies for capturing all types of parameters. Most of the sensors are available in plastic and are offered together with the corresponding fittings, which ensure a perfect integration into the piping system. The control element contains various control functions – from simple relays up to PID controllers – and common communication technologies. Actuation includes pneumatic, electrical and magnetic actuating elements, which can be combined with many different valves and accessory parts.



## 2.12.2 Measurement

### Product overview



#### Product categories

- Flow measurement  
(ultrasound, paddlewheel, electromagnetic, turbine, float)
- pH/ORP
- Conductivity/resistivity
- Pressure/fill level
- Temperature
- Clouding
- Chlorine/chlorine dioxide
- Dissolved oxygen

## 2.12.3 Control

### Product overview



#### Product categories

- Multi-parameter transmitter
- Special transmitter (e.g. batch, PID controller)
- Multi-channel transmitter
- Modular functionalities (e.g. Hart, additional relays, additional 4 to 20 mA outputs)

## 2.12.4 Actuation

### Product overview



#### Product categories

- Electrical and pneumatic actuators
- Positioners and actuator accessories
- AS interface

## 2.12.5 Valves

### Product overview



#### Product categories

- Manual valves
- Magnetic pilot valves
- Pressure regulating valves

# Plastic Piping Materials

## Content

<b>1</b>	<b>Introduction to Plastics Materials .....</b>	<b>86</b>
1.1	Plastics in general.....	86
1.2	Plastic in the environment .....	90
1.3	Manufacturing and processing methods.....	91
<b>2</b>	<b>Properties of Plastic Piping Materials .....</b>	<b>93</b>
2.1	Acrylonitrile-butadiene-styrene (ABS).....	93
2.2	Polyethylene (PE).....	95
2.3	Polypropylene (PP).....	97
2.4	Polyvinyl chloride, unplasticized (PVC-U).....	99
2.5	Polyvinyl chloride, chlorinated (PVC-C) .....	101
2.6	Polyvinylidene fluoride (PVDF).....	103
2.7	Ethylene-Chlorotrifluoroethylene (ECTFE).....	105
<b>3</b>	<b>Approvals and standards.....</b>	<b>107</b>
3.1	Approvals of products .....	107
3.2	Standards and guidelines.....	108
<b>4</b>	<b>Material Selection – Chemical Resistance.....</b>	<b>120</b>
4.1	Introduction.....	120
4.2	ChemRes Plus online database.....	124

# 1 Introduction to Plastics Materials

## 1.1 Plastics in general

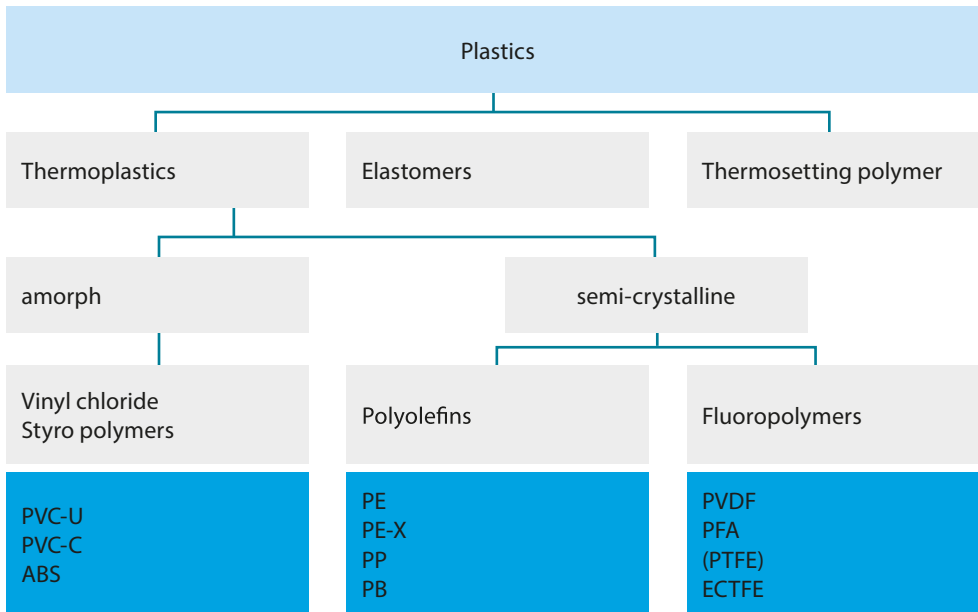
### 1.1.1 History

As early as 1838, Victor Regnault succeeded in manufacturing polyvinyl chloride in the laboratory by exposing vinyl chloride to sunlight. In 1912 Fritz Klatte discovered the fundamental principle for the technical manufacture of PVC. In their early years during the war from 1914 to 1918, the plastics had to replace other scarce materials and were thereby partly overwhelmed in terms of their applicability. Therefore, plastics had to be improved. To do this, it was necessary to investigate the inner structure of these new materials in more detail. After the versatile application possibilities were recognised, in 1938 the large-scale production of plastics began.

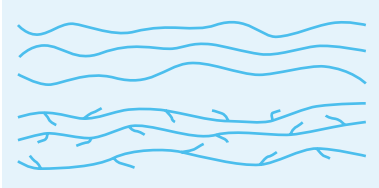
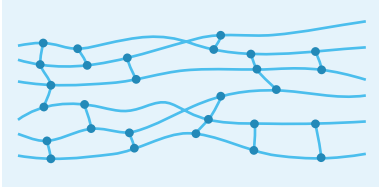

### 1.1.2 Structure and properties

Polymers are organic compounds that are obtained either by the conversion of natural products (e.g. natural rubber, cellulose), or by synthesis from petroleum derivatives. Polymer chains, together with additives such as stabilisers and processing aids, produce the actual material – referred to as plastic. These chains consist mainly of carbon and hydrogen. Depending on the type, halogens (chlorine, fluorine), oxygen, nitrogen and sulphur can also be incorporated into the polymer chain. Polymers are also referred to as macromolecules, that is to say, a single polymer chain consists of more than 1,000 basic building blocks, the monomers.

In plastic piping design, mainly thermoplastics are used, which are processed into fittings, valves and pipe with a technical processes referred to as **injection moulding** and **extrusion**. Elastomers are used as sealing material in unions, flanges and push-fit fitting. For example, thermosetting polymer are used as insulation foams or in glass-fibre reinforced liners.



Materials for piping systems – Overview

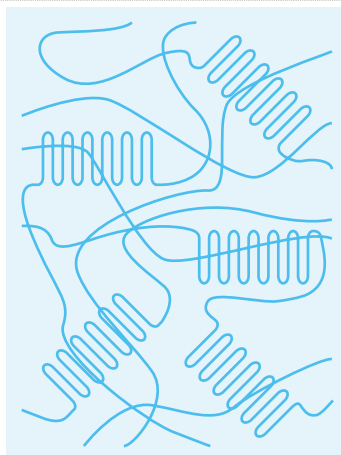
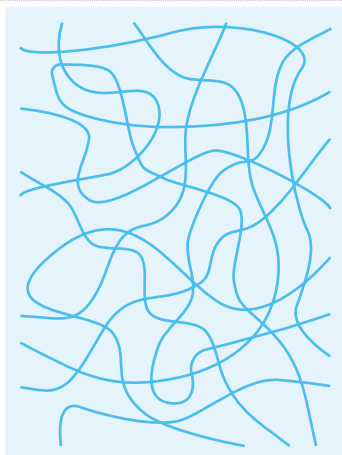
Main group		Property
Thermoplastics e.g. PE, PVC		<ul style="list-style-type: none"> <li>• Linear or branched</li> <li>• Meltable</li> <li>• Soluble, swellable</li> <li>• Plastic mouldable</li> </ul>
Elastomer e.g. NBR, EPDM		<ul style="list-style-type: none"> <li>• Poorly linked</li> <li>• Not meltable</li> <li>• Not soluble, not swellable</li> <li>• Not plastically mouldable</li> </ul>
Thermosetting plastics e.g. PUR, Epoxy		<ul style="list-style-type: none"> <li>• Strongly linked</li> <li>• Not meltable</li> <li>• Not soluble, not swellable</li> <li>• Not plastically malleable</li> </ul>

## Plastics – Main groups

The thermoplastics, the fusible agents of plastics, are subdivided into two groups:

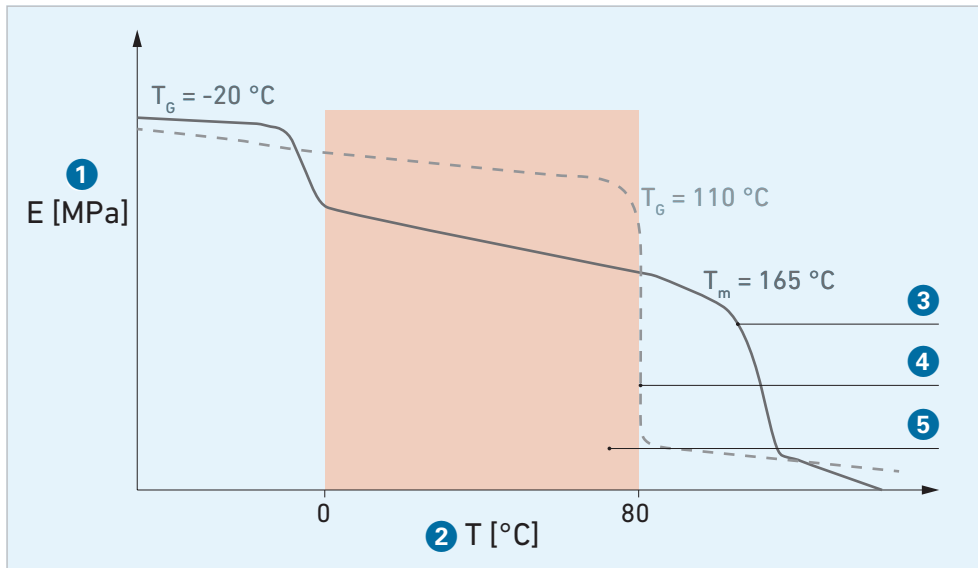
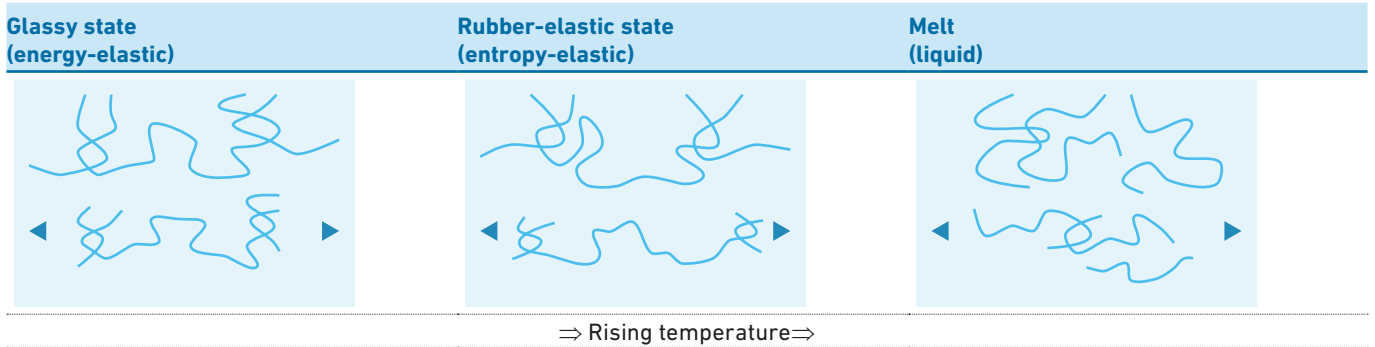
Amorphous thermoplastics	Semi-crystalline thermoplastics
<p>In the case of the amorphous (Greek “without form”) thermoplastics, the polymer chains are present as disordered, intertwined bundles. Typical representatives of this group are, for example, PVC and ABS. These plastics dissolve and swell easily by adding solvents. Therefore, they are solvent cemented together when used in piping installations.</p>	<p>The semi-crystalline thermoplastics contain not only the disordered, amorphous but also highly ordered regions in which the chains are arranged into crystalline structures. Representatives of this group are for example polyolefins such as polyethylene (PE), polypropylene (PP) and polybutene (PB). Due in part to the semi-crystalline structure, these plastics do not swell and are not soluble in solvents. Piping systems made of semi-crystalline materials are therefore usually connected by welding.</p>

## Subdivision of the Thermoplastics



### 1.1.3 Mechanical properties

The mechanical properties of plastics, especially thermoplastics, are temperature-dependent. At low temperatures below the glass-transition temperature  $T_g$  the chains become immobile and brittle, which leads to increased fragility. At higher temperatures ( $T_g < T < T_m$ ), the chains become more mobile, causing semi-crystalline materials to gain toughness, but lose strength and rigidity. At this stage, amorphous plastics are already softening. Both the embrittlement and softening temperatures are characteristic of the individual types of plastic and dependent on their molecular structure. If the temperature continues to rise ( $T > T_m$ ), the semi-crystalline thermoplastic is also present as a melt.



- Application temperature**
- 1 Modulus of elasticity (rigidity)
  - 2 Temperature
  - 3 Semi-crystalline, here PP-H
  - 4 Amorph, here PVC-C
  - 5 Application temperature

The application temperatures for semi-crystalline and amorphous thermoplastics vary due to their different properties. Semi-crystalline materials are preferably used at temperatures above their glass transition temperature. However, amorphous thermoplastics are used below the glass transition point.

Plastics also tend to creep to progressive deformation under load. Their mechanical properties are not only temperature-dependent but also time-dependent. For use in piping system construction, the materials are therefore tested for their creep internal compressive strength in accordance with ISO 1167 and ISO 9080 in order to determine the maximum operating temperatures and pressure for a service life of 50 years.

The characteristic values for mechanical properties of GF pipe materials can be found in the relevant raw materials chapter.

### 1.1.4 Advantages

Compared to metallic materials, the following general advantages for plastics result:

Property	Advantage
Low density (Plastic: 0.9 to 1.8 g/cm <sup>3</sup> )	Very light-weight
Chemical resistance	No corrosion as with metals
Low thermal conductivity	<ul style="list-style-type: none"> <li>• Minimum heat loss</li> <li>• Low condensation</li> <li>• Plastics are poor heat conductors, but good insulators</li> </ul> Thermal conductivity: <ul style="list-style-type: none"> <li>• PB: 0,19 W/(m·K)</li> <li>• PE: 0,38 W/(m·K)</li> <li>• PVC: 0,15 W/(m·K)</li> </ul>
Tight connections due to a variety of connection technologies	Plastics can be welded, glued and clamped
Smooth surface	The smooth surface causes low pressure losses

#### Properties and advantages of plastics

## 1.2 Plastic in the environment

The world is facing big challenges in the energy sector. These challenges include increasing energy consumption, the finite nature of fossil resources, rising energy prices and climate change. In order to satisfy the needs not only of today but also of future generations, sustainable development is essential. Plastics help to meet these challenges.

The products of GF Piping Systems are used by customers for years, sometimes decades. Even the smallest increases in efficiency – such as a suitable design – can significantly affect the environmental performance. GF Piping Systems therefore pursues a holistic approach in the development of piping systems. Sustainable solutions are only possible if the entire life cycle of the applications and products is considered.

### Plastics save energy

In addition to the well-known technical advantages such as corrosion resistance, plastics also characterised by their ecological advantages. Its light weight and insulating properties make it suitable for a variety of energy-efficient applications: in vehicles, packaging, insulation and piping systems. Plastics are mainly made from crude oils. About four percent of the world's oil is processed into plastic. The efforts to reduce the consumption of oil and other fossil fuels, however, do not mean a renouncement of plastic – on the contrary: The use of plastics saves energy!

In a study, Plastics Europe has quantified how energy consumption and greenhouse gas emissions affect plastic products by replacing them with other materials.

### Results

- Plastic products enable significant savings in energy and reduce greenhouse gas emissions.
- Replacing plastic products with other materials will in most cases increase energy consumption and greenhouse gas emissions.

Replacing as many plastic products as possible with other materials would require over 50% more energy than is consumed today throughout the life cycle of all plastic products. In other words: The plastic products on the market today have enabled energy savings of 2,400 million GJ per year. This is equal to an amount of 50 million tons of oil, spread over 200 very large oil tankers.



Additional information on sustainability and life cycle assessment see: [www.gfps.com/gfps-sustainability](http://www.gfps.com/gfps-sustainability) > materials.



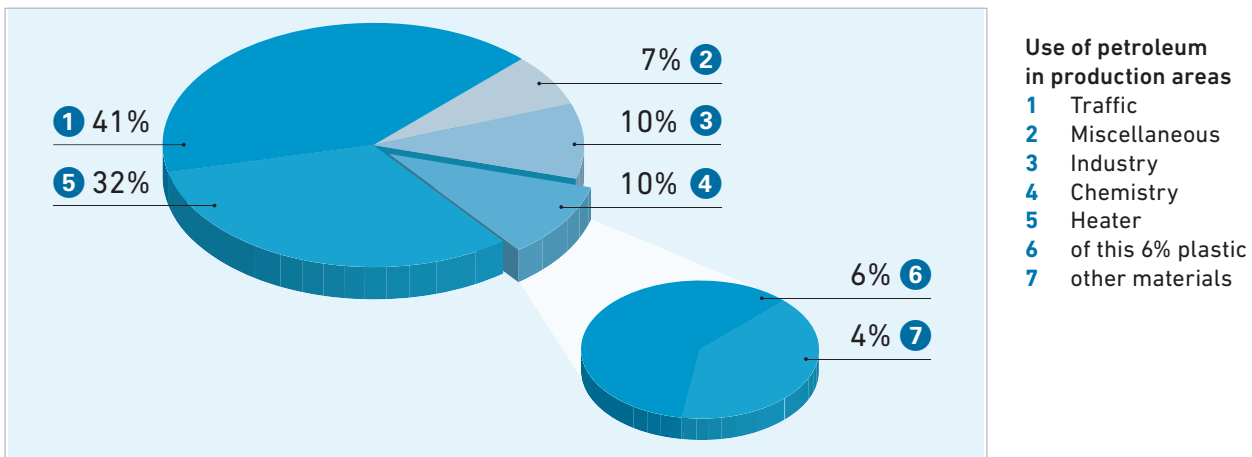
### 1.3 Manufacturing and processing methods

#### 1.3.1 Raw materials

Raw materials required for the production of plastics are natural products such as cellulose, coal, crude oil and natural gas. At the refinery, crude oil is separated by distillation into several components. It is separated into boiling ranges, distillation results in gas, petrol, petroleum and gasoil. The residue is bitumen. All components consist of hydrocarbons, which differ in size and shape of the molecules. The most important component for the production of plastics is naphtha. Naphtha is broken up and converted into ethylene, propylene, butylene and other hydrocarbon compounds in a thermal cracking process.

#### 1.3.2 Manufacturing

Plastics are formed by connecting a large number of similar basic building blocks (monomers), using a chemical bond. The majority of the raw materials required for this purpose comes from the processing of crude oil, but in some cases raw materials from renewable sources are also used. Contrary to expectations, only about 4% of crude oil products coming from the refinery go to the plastics industry. The chemical industry accounts for around 10% of total crude oil consumption in Germany, including 6% for plastics production. In the production of plastics, three different methods are used.



#### T3.1 Manufacturing of plastics

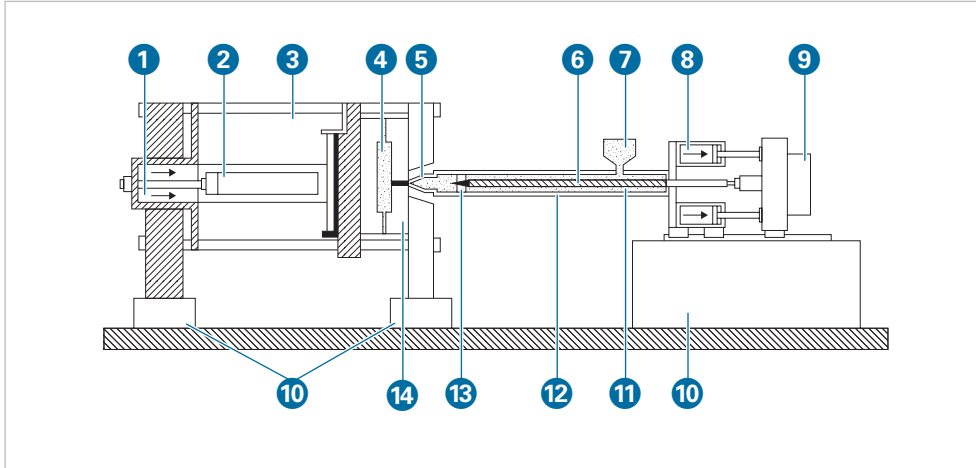
Polymerisation	Polycondensation	Polyaddition
<p>Polymerisation is the most widely used process in the synthesis of plastics. Polymerisation refers to the attachment of monomers to macromolecule chains without elimination of foreign substances. When using e.g. polymerisation, polyethylene, polybutene, polypropylene, polyvinyl chloride are formed.</p>	<p>In the polycondensation process, equal and dissimilar monomers are arranged in a macromolecule chain with simultaneous elimination of a by-product, e.g. water, hydrochloric acid. Polycondensation is used, for example, in the manufacturing of phenolic resins and polyamides.</p>	<p>When using polyaddition, macromolecules are formed from molecules of different chemical structure, but without elimination of a by-product. This process is used in the manufacturing of polyurethanes and epoxy resin, for example, araldite.</p>

#### 1.3.3 Processing

GF Piping Systems uses a variety of plastic processing techniques. A distinction is made between injection moulding, extrusion and foaming. The injection moulding process is used to produce fittings and valves; pipe are extruded. Pipes are pre-insulated with foam.

## Injection moulding

An injection moulding machine is used to melt (plasticise) the respective material and injected into a mould—the moulding tool—under pressure. Inside the mould tool, the material is cooled and thus reverts to its solid state. The resulting volume shrinkage is compensated by very high pressures. By rotating the plasticising screw, material for the next component is prepared. After opening the tool, the finished part is removed. The void (the cavity) of the tool determines the shape and the surface structure of the finished part.



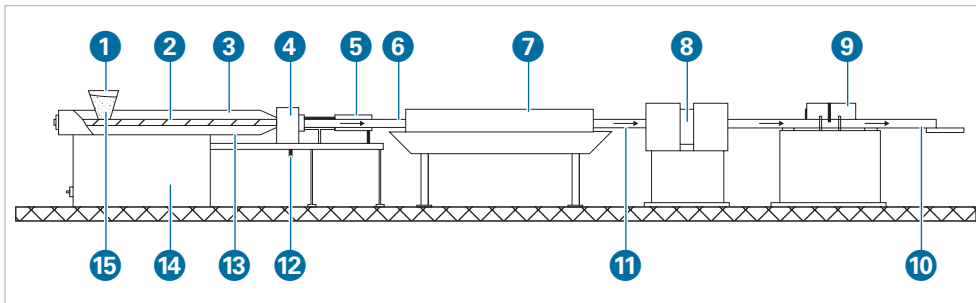
### Components of a typical plasticising/injection unit

- 1 Locking cylinder
- 2 Opening cylinder
- 3 Opening and locking cylinder
- 4 Workpiece
- 5 Injection nozzle
- 6 Plasticising screw
- 7 Plastic pellets
- 8 Injection cylinder
- 9 Worm gear drive
- 10 Machine bed
- 11 Plasticising cylinder
- 12 Heater
- 13 Non-return valve
- 14 Moulding tool

## Extrusion

An extrusion machine integrates the following process steps:

1. Extrusion
2. Shaping
3. Calibrating
4. Cooling
5. Removing
6. Separating



### Components of a typical extrusion system

- 1 Hopper
- 2 Plasticising screw
- 3 Heater
- 4 Moulding tool (profile nozzle)
- 5 Calibration distance
- 6 Pipe
- 7 Cooling section
- 8 Haul-off/pulling machine
- 9 Device for cutting into lengths
- 10 Hollow section
- 11 Pipe
- 12 Compressed air
- 13 Plasticising cylinder
- 14 Extruder
- 15 Plastic pellets

The extruder system consists of the hopper, the plasticising cylinder, one or two plasticising screw(s) and the drive. The tasks of the extruder's components are the same as in the injection unit during injection moulding.

The extruder tool rests directly against the extruder, guiding the mass around a mandrel and shaping the profile of the pipe. For pipe under d400 mm, tools with sieve rings or multiple webs are used for fixing. For larger pipe over d400 mm, spiral distribution tools are used. The cooling section and calibration section are connected in the manufacturing of the pipe. This is possible by using vacuum tank calibration with multiple water showers. A caterpillar haul-off/pulling machine is used to handle the pulling in pipe manufacturing. The speed of the haul-off/pulling machine is adapted to the performance of the extruder. The separating unit must move with the extruded pipe during cutting process.

## 2 Properties of Plastic Piping Materials

### 2.1 Acrylonitrile-butadiene-styrene (ABS)

#### ABS properties (reference values)

Property	Value <sup>1</sup>	Units	Test standard
Density	0.925	g/cm <sup>3</sup>	EN ISO 1183-1
Yield stress at 23 °C	20	N/mm <sup>2</sup>	EN ISO 527-1
Tensile modulus at 23 °C	450	N/mm <sup>2</sup>	EN ISO 527-1
Charpy notched impact strength at 23 °C	20	kJ/m <sup>2</sup>	EN ISO 179-1/1eA
Charpy notched impact strength at -40 °C	≥ 10	kJ/m <sup>2</sup>	EN ISO 179-1/1eA
Heat distortion temperature HDT A 1.80 MPa	≥ 74	°C	EN ISO 75-2
Vicat-heat distortion temperature B/50N	≥ 94	°C	ISO 306
Thermal conductivity at 23 °C	0.19	W/m K	ASTM E1530
Water absorption at 23 °C	≤ 0.45	%	EN ISO 62
Color	similar 7'001		RAL
Limiting oxygen index (LOI)	19	%	ISO 4589-1



<sup>1</sup> Typical characteristics measured at the material should not be used for calculations.

#### General

Acrylonitrile-butadiene-styrene (ABS) is a versatile polymer. In addition to its application in piping systems, ABS is mainly common in automotive applications and in high-quality household devices. The wide area of application relates to the versatile characteristic profile of ABS which can be adapted to the respective application by taking advantage of the variable composition of the components acrylonitrile, styrene and polybutadiene.

ABS belongs to the amorphous thermoplastics. While acrylonitrile provides strength to the material and contributes to an improved chemical resistance relative to polystyrene, the styrenic component provides both strength and a quality surface finish. On the other hand, the chemically bound polybutadiene rubber components give the material its impact strength, even at very low temperatures. The ABS used by GF Piping Systems shows a good balance between toughness and strength, making it especially suitable for low temperature applications. Accordingly, the areas of application are mainly refrigeration and air-conditioning systems as well as water treatment.

#### Advantages of ABS

- High impact strength even at low temperatures
- Corrosion resistance
- Simple installation via solvent cement joints
- Low thermal conductivity
- Halogen free
- Low weight
- Low pressure losses due to smooth surfaces
- Good abrasion resistance
- Trouble-free recycling



### UV and weather resistance

If the ABS piping system is exposed to direct sunlight over a long period, its surface loses its shine and the colour shifts to light grey. Due to the very high impact strength of ABS, the resulting loss of toughness generally causes no problems in moderate climate zones. For extreme weather conditions or very high loads on the piping system, we nevertheless recommend protecting the surface from direct sunlight.



### Chemical resistance

ABS shows a good resistance against a broad range of media. For detailed information, observe the comprehensive list of chemical resistance from GF Piping Systems or contact an authorized GF Piping Systems representative.



### Abrasion resistance

In addition to the excellent impact strength, the butadiene rubber components in ABS effect an outstanding resistance to abrasion. Because of this property, piping systems made of ABS have been used for solids and slurries, such as those found in mining, for a long time. ABS offers significant advantages for many of such applications compared to metals.



### Application limits

The application limits of the material on the one hand depend on embrittlement and softening temperatures and on the other hand on the nature and the expected service life of the application. The pressure-temperature diagrams give details on application temperatures and pressures.



### Combustion behavior

ABS self-ignites at temperatures exceeding 450 °C. ABS burns when exposed to an open flame, after removing the flame, the material continues burning. The oxygen index amounts to 19 %. (Materials that burn with less than 21 % of oxygen in the air are considered to be flammable).

Basically toxic substances are released though all burning processes. Carbon monoxide is generally the combustion product most dangerous to humans. When ABS burns, primarily carbon dioxide, carbon monoxide and water are formed. Tests have shown that the relative toxicity of the products of combustion are similar or even lower than those of natural products such as wood, wool and cotton. ABS combustion gases are not corrosive. Nevertheless, the burning forms soot. Because of this, smoke develops during combustion.

Water, foam and carbon dioxide are suitable fire-fighting agents.



### Electrical properties

Like most thermoplastics, ABS is not conductive. This means that no electrochemical corrosion takes place in ABS systems. However, the non-conductive properties have to be taken into account because an electrostatic charge can develop in the piping. ABS provides good electrical insulation properties. The specific volume resistance is  $3.5 \times 10^{16} \Omega\text{cm}$ , the specific surface resistance is  $10^{13} \Omega$ . These figures have to be taken into account wherever there is a danger of fires or explosion.



### Physiological properties

Formulations of ABS used by GF Piping Systems are in general non toxic and biologically inert. For details regarding existing approvals for applications with drinking water or food stuff, please contact your GF Piping Systems representative.



## 2.2 Polyethylene (PE)

### PE properties (reference values)

Property	PE 80-Value <sup>1</sup>	PE 100-Value <sup>1</sup>	Units	Test standard
Density	0.93	0.95	g/cm <sup>3</sup>	EN ISO 1183-1
Yield stress at 23 °C	18	25	N/mm <sup>2</sup>	EN ISO 527-1
Tensile modulus at 23 °C	700	900	N/mm <sup>2</sup>	EN ISO 527-1
Charpy notched impact strength at 23 °C	110	83	kJ/m <sup>2</sup>	EN ISO 179-1/1eA
Charpy notched impact strength at -40 °C	7	13	kJ/m <sup>2</sup>	EN ISO 179-1/1eA
Thermal conductivity at 23 °C	0.43	0.38	W/m K	EN 12664
Water absorption at 23 °C	0.01 - 0.04	0.01 - 0.04	%	EN ISO 62
Color	9'005	9'005	RAL	
Limiting oxygen index (LOI)	17.4	17.4	%	ISO 4589-1



<sup>1</sup> Typical characteristics measured at the material should not be used for calculations.

### General

Polymers which consist of hydrocarbons with formula  $C_nH_{2n}$  with a double bond (ethylene, propylene, butene-1, isobutene) are collectively referred as polyolefins. Polyethylene (PE) belongs to this group. It is a semi-crystalline thermoplastic. Polyethylene is the best known polymer. The chemical formula is:  $-(CH_2-CH_2)_n-$ , making polyethylene an environmentally friendly hydrocarbon product. PE as well as PP belong to the non-polar materials. Because of this, it does not dissolve in common solvents and hardly swells. As a result, PE pipe cannot be solvent cemented. The appropriate jointing method for this material is welding.

High molecular PE grades of medium to high density have become state of the art for industrial piping installations. The grades are classified in accordance with their internal pressure resistance in PE80 (MRS 8 MPa) and PE100 (MRS 10 MPa). In this context, we also talk about PE grades of the 3rd generation, while PE80 grades belong, in most cases, to the 2nd generation. PE grades of the 1st generation – PE63 according to current classifications – have practically no application anymore. The internal pressure resistance is tested according to ISO1167 and calculated in compliance to ISO 9080.

In piping construction, PE is mostly used for buried gas and water lines. For this range of applications, polyethylene has become the dominant material in numerous countries. But also building technology and industrial piping installations make use of the advantages of this material.

### Advantages of PE

- Low weight
- Outstanding flexibility
- Good abrasion resistance (abrasion resistance)
- Corrosion resistance
- Ductile breaking properties
- High impact strength even at low temperatures
- Good chemical resistance
- Fusible

### UV and weather resistance

Because of the black pigments used, polyethylene is very weather-resistant. Even longer exposure to direct sunlight, wind and rain hardly causes any damage to the material.

### Chemical resistance

Polyethylene shows a good resistance against a broad range of media. For detailed information, observe the list of chemical resistance from GF Piping Systems or contact the responsible GF Piping Systems representative.



### Abrasion resistance

Polyethylene has excellent resistance against abrasion. As a result, PE piping systems are used in numerous applications for transporting solids and slurries. Experience has shown that PE offers considerable advantages over metal for many such applications.



### Application limits

The application limits of the material on the one hand depend on embrittlement and softening temperatures and on the other hand on the nature and the expected service life of the application. The pressure-temperature diagrams give details on application temperatures and pressures.



### Combustion behavior

Polyethylene belongs to the flammable plastics. The oxygen index amounts to 17 %. With an oxygen index below 21 %, a plastic material is considered to be flammable. PE drips and continues to burn without soot after removing the flame. Basically toxic substances are released through all burning processes, particularly carbon monoxide. When PE burns, primarily carbon dioxide, carbon monoxide and water are formed.



### Electrical properties

Like most thermoplastics, polyethylene is non-conductive. This means that no electrochemical corrosion takes place in PE systems.

However, the non-conductive properties have to be taken into account because an electrostatic charge can build up in the pipe. Polyethylene provides good electrical insulation properties. The specific volume resistance is  $3.5 \times 10^{16} \Omega\text{cm}$  and the specific surface resistance is  $10^{13} \Omega$ . These figures have to be taken into account wherever there is a hazard of ignition or explosion.



### Physiological properties

The black polyethylene materials from GF Piping Systems are authorized for use in food applications. The organoleptic properties of the fittings are in accordance to the relevant standards. Usage in all related areas is thus possible. For details regarding existing approvals for applications with drinking water or foodstuffs, please contact the responsible GF Piping Systems representative.



## 2.3 Polypropylene (PP)

### PP properties (reference values)

Property	PP-R value <sup>1</sup>	β PP-H-value <sup>1</sup>	Units	Test standard
Density	0.90 - 0.91	0.90 - 0.91	g/cm <sup>3</sup>	EN ISO 1183-1
Yield stress at 23 °C	25	31	N/mm <sup>2</sup>	EN ISO 527-1
Tensile modulus at 23 °C	900	1'300	N/mm <sup>2</sup>	EN ISO 527-1
Charpy notched impact strength at 23 °C	20	50	kJ/ m <sup>2</sup>	EN ISO 179-1/1eA
Charpy notched impact strength at 0 °C	3.4	4.8	kJ/m <sup>2</sup>	EN ISO 179-1/1eA
Heat distortion temperature HDT B 0.45 MPa	75	95	°C	EN ISO 75-2
Water absorption at 23 °C	0.1	0.1	%	EN ISO 62
Color	Neutral/ 7'032	7'032		RAL
Limiting oxygen index (LOI)	19	19	%	ISO 4589-1



<sup>1</sup> Typical characteristics measured at the material should not be used for calculations.

### General

Polypropylene (PP) is a semi-crystalline thermoplastic belonging to the polyolefins. Its density is lower than that of other thermoplastics. Its mechanical characteristics, its chemical resistance and especially its relatively high heat deflection temperature have made polypropylene one of the most important materials used in piping installations today. PP is formed by the polymerisation of propylene (C<sub>3</sub>H<sub>6</sub>) using Ziegler-Natta catalysts.

There are three different material types which are conventionally supplied for piping installations:

- Isotactic PP-homopolymer (PP-H)
- PP block copolymer (PP-B)
- PP random copolymer (PP-R)

Because of its high long-term behavior, PP-H types are preferred for industrial applications. The more flexible PP-R is used predominantly in plumbing applications because of its low tensile modulus and high long-term creep resistance at high temperature. PP-B is mainly used for sewage piping systems because of its high impact strength especially at low temperatures and its relatively low resistance to elevated temperatures. Most of the PP grades are offered with nucleating agents because PP crystallizes at least 10 times slower than PE. This way, we achieve lower internal stress and a more homogenous morphology. It is differentiated between α and β nucleation. Nucleation is realized by adding only few ppm (parts per million) of nucleating agents. PP, just like PE, belongs to the non-polar materials. For this reason, PP does not dissolve in common solvents and, in addition, hardly swells. As a result, PP pipe cannot be solvent-cemented. The appropriate jointing method for this material is welding. For industrial applications, GF Piping Systems uses beta nucleated PP-H (PROGEF Standard, PROGEF Plus) and PP-R (PROGEF Standard, PROGEF Natural). The long-term behavior was tested in long-term tests according to ISO 1167 and calculated according to ISO 9080. According to ISO 12162, our industrial materials are classified as MRS 10.

### Advantages of PP

- Low weight
- Good abrasion resistance (abrasion resistance)
- Corrosion resistance
- Balanced ratio of stiffness and toughness
- Good chemical resistance
- Weldable
- High temperature resistance



### UV and weather resistance

PP is sensitive to UV radiation, particularly the non pigmented PROGEF Natural system, so that prolonged exposure to direct sunlight should be avoided. In outside applications, it can be advantageous to protect the material from direct sunlight exposure. Contact the responsible GF Piping Systems representative for suitable protective measures.



### Chemical resistance

Polypropylene shows a good resistance against a broad range of media. For detailed information, observe the list of chemical resistance from GF Piping Systems or contact the responsible GF Piping Systems representative.



### Abrasion resistance

PP has a good resistance against abrasion. For many applications, PP demonstrates similar or better properties than metals.



### Application limits

The application limits of the material on the one hand depend on embrittlement and softening temperatures and on the other hand on the nature and the expected service life of the application. The pressure-temperature diagrams give details on application temperatures and pressures.



### Combustion behavior

Polypropylene is a flammable plastic. The oxygen index amounts to 19 %. With an oxygen index below 21 %, a plastic material is considered to be flammable PP drips and continues to burn without soot after removing the flame. Basically toxic substances are released by all burning processes, while carbon monoxide is generally the combustion product most dangerous to humans. When PP burns, primarily carbon dioxide, carbon monoxide and water are formed.



### Electrical properties

Like most thermoplastics, polypropylene is non-conductive. This means that no electrochemical corrosion takes place in PP systems.

However, the non-conductive properties have to be taken into account because an electrostatic charge can build up in the pipe. Polypropylene provides good electrical insulation properties. The specific volume resistance is at least  $10^{16} \Omega\text{cm}$ , the dielectric strength is 75 kV/mm. Because of the possible development of electrostatic charges, caution is recommended when using PP in applications where there is a hazard of ignition or explosion.



### Physiological properties

Formulations used by GF Piping Systems are generally non-toxic and biologically inert. For details regarding existing approvals for applications with drinking water or foodstuffs, please contact the responsible GF Piping Systems representative.





## 2.4 Polyvinyl chloride, unplasticized (PVC-U)

### PVC-U properties (reference values)

Property	Value <sup>1</sup>	Units	Test standard
Density	1.38	g/cm <sup>3</sup>	EN ISO 1183-1
Yield stress at 23 °C	≥ 54	N/mm <sup>2</sup>	EN ISO 527-1
Tensile e-modulus at 23 °C	≥ 2'700	N/mm <sup>2</sup>	EN ISO 527-1
Charpy notched impact strength at 23 °C	≥ 8	kJ/m <sup>2</sup>	EN ISO 179-1/1eA
Charpy notched impact strength at 0 °C	≥ 3	kJ/m <sup>2</sup>	EN ISO 179-1/1eA
Vicat-heat distortion temperature B/50N	≥ 76	°C	ISO 306
Thermal conductivity at 23 °C	0.15	W/m K	EN 12664
Water absorption at 23 °C	≤ 0.1	%	EN ISO 62
Color	7'011		RAL
Limiting oxygen index (LOI)	42	%	ISO 4589-1



<sup>1</sup> Typical characteristics measured at the material should not be used for calculations.

### General

Polyvinylchloride (PVC) is one of the most important and oldest plastics. Worldwide consumption of PVC is exceeded only by PE and PP. PVC was produced for the first time as early as the middle of the 19th century. An industrial manufacturing process was not patented until the year 1913. Nowadays, PVC plays an important role in many industrial and consumer good applications.

PVC is a polymer containing approximately 56 % by weight of chlorine. The PVC resin becomes a processable and usable material only by using additives. The choice of the additives allows a wide variation of its characteristics and an adjustment to the planned application. There are two classes of PVC materials. Soft PVC (PVC-P) which is created by adding plasticizers (e.g. phthalates). This type is not used at GF Piping Systems. Hard PVC, also called unplasticized PVC (PVC-U), is used for piping system construction.

PVC-U is an amorphous thermoplastic. The properties of PVC-U molded parts are strongly dependent on the composition of the individual components, but also on the processing. Because of our 50 years of experience in PVC processing and the continuous advancement of our own formulation of materials, GF Piping Systems has become a benchmark in the field of PVC-U piping. The long-term behavior was tested in long-term tests according to ISO 1167 and calculated according to ISO 9080. According to ISO 12162, our PVC-U types are classified as MRS 25.

### Advantages of PVC-U

- Versatility of use
- Very good chemical and corrosion resistance
- Proven physiological inertness and thus usable for food applications
- No influence on the drinking water quality
- Biologically inert, no support of microbiological growth
- Excellent mechanical properties
- Safe cementing, e.g. with Tangit
- The IR PVC-U system can be welded with infrared machines

### UV and weather resistance

PVC-U is very weather-resistant. Even longer exposure to direct sunlight, wind and rain does hardly any damage to the material. Despite its very good resistance to UV radiation, PVC-U loses some of its impact strength. In extreme applications, it can be advantageous to protect the material from direct sunlight exposure. Contact the responsible GF Piping Systems representative for suitable protective measures.



### Chemical resistance

PVC-U shows a good resistance against a broad range of media. For detailed information, observe the list of chemical resistance from GF Piping Systems or contact the responsible GF Piping Systems representative.



### Abrasion resistance

As a relatively hard thermoplastic, the resistance of PVC-U against abrasion is lower than those of other pipe materials. For this reason, it is rarely used for transporting solids.



### Application limits

The application limits of the material on the one hand depend on embrittlement and softening temperatures and on the other hand on the nature and the expected service life of the application. The pressure-temperature diagrams give details on application temperatures and pressures.



### Combustion behavior

The high chlorine content of PVC-U causes an advantageous combustion behavior. Self-ignition resulting from temperature influences occurs only at 450 °C. PVC-U burns when exposed to an open flame, but extinguishes immediately after removing the flame. The oxygen index (LOI) amounts to 42 %. With an oxygen index below 21 %, a plastic material is considered to be flammable.



Because the combustion of PVC-U produces hydrogen chloride, which forms a corrosive acid in connection with water, immediate cleaning of areas susceptible to corrosion is necessary after a fire. Danger to personnel from hydrochloric acid (HCl) is minimal because its pungent odor allows early escape from toxic combustion gases, mainly from the odorless carbon monoxide. There are no restrictions for the choice of firefighting agents.

### Electrical properties

PVC-U, like all unmodified thermoplastics, is non-conductive. This means that no electrochemical corrosion takes place in PVC-U systems. On the other hand, these non-conductive properties have to be taken into account because an electrostatic charge can develop in the piping.



Special attention must be paid to this fact in environments in which explosive gases may occur. Various methods are available to prevent the occurrence of electrostatic charges. GF Piping Systems representatives can provide support a correct installation.

The specific volume resistance is at least  $10^{15} \Omega\text{cm}$ .

### Physiological properties

The PVC-U formulas were developed by GF Piping Systems for use with drinking water and food. All PVC-U product offered by GF Piping Systems are free of lead and cadmium. The residual monomer content of vinyl chloride lies below the detection limit of modern analytical methods.



For details regarding existing approvals for applications with drinking water or foodstuffs, please contact your authorized GF Piping Systems representative.

## 2.5 Polyvinyl chloride, chlorinated (PVC-C)

### PVC-C properties (reference values)

Property	Value <sup>1</sup>	Units	Test standard
Density	1.5	g/cm <sup>3</sup>	EN ISO 1183-1
Yield stress at 23 °C	≥ 53	N/mm <sup>2</sup>	EN ISO 527-1
Tensile e-modulus at 23 °C	≥ 2'700	N/mm <sup>2</sup>	EN ISO 527-1
Charpy notched impact strength at 23 °C	≥ 8	kJ/m <sup>2</sup>	EN ISO 179-1/1eA
Charpy notched impact strength at 0 °C	≥ 4	kJ/m <sup>2</sup>	EN ISO 179-1/1eA
Heat distortion temperature HDT A 1.80 MPa	≥ 102	°C	EN ISO 75-2
Vicat-heat distortion temperature B/50N	≥ 103	°C	ISO 306
Thermal conductivity at 23 °C	0.15	W/m K	EN 12664
Water absorption at 23 °C	0.1	%	EN ISO 62
Color	7'038		RAL
Limiting oxygen index (LOI)	60	%	ISO 4589-1



<sup>1</sup> Typical characteristics measured at the material should not be used for calculations.

### General

The abbreviation PVC-C stands for chlorinated polyvinyl chloride (also referred to as chlorinated PVC or PVC-C), a material in use since 1958. PVC-C is an amorphous thermoplastic that is created by postchlorinating PVC. During this process, chlorine is chemically bonded to the PVC chain. Thus, PVC-C is a PVC-U-related material which, because of its chemical structure, is characterized by a higher temperature resistance than PVC-U with other properties such as the high tensile strength, good impact resistance and the exceptional chemical resistance remain unaffected. Its flame resistance is better than that of PVC-U.

These properties have made PVC-C a preferred material for piping and fabrication of devices in the chemical industry as well as for several other industrial applications with demanding requirements (e.g. the aircraft industry). In pressure piping systems, PVC-C is suitable for strongly corrosive environments, where materials such as stainless steel or even glass-fiber reinforced plastics only reach a short service life time. PVC-C is used for semi-finished products, pumps, valves as well as for the entire range of accessories associated with transport of liquids.

#### Advantages of PVC-C

- Very good mechanical properties, even at elevated temperatures
- Excellent chemical resistance
- No electrochemical corrosion
- Long service life, even under intensely corrosive conditions
- Simple installation using solvent cementing
- Smooth inner surface
- Very low thermal conductivity
- Exceptional fire resistance

### UV and weather resistance

PVC-C is very weather-resistant. Even longer exposure to direct sunlight, wind and rain does hardly any damage to the material. Despite its very good resistance to UV radiation, PVC-C loses some of its impact strength. In extreme applications, it can be advantageous to protect the material from direct sunlight exposure. Contact the responsible GF Piping Systems representative for suitable protective measures.

### Chemical resistance

PVC-C shows a good resistance against a broad range of media. For detailed information, observe the list of chemical resistance from GF Piping Systems or contact the responsible GF Piping Systems representative.



### Abrasion resistance

As a relatively hard thermoplastic, the resistance of PVC-C against abrasion is lower than those of other pipe materials. For this reason, it is rarely used for transporting solids.



### Application limits

The application limits of the material on the one hand depend on embrittlement and softening temperatures and on the other hand on the nature and the expected service life of the application. The pressure-temperature diagrams give details on application temperatures and pressures.



### Combustion behavior

Due to its high chlorine content, PVC-C shows an exceptionally good combustion behavior without the addition of flame retardants.

PVC-C self-ignites at temperatures exceeding 400 °C. PVC-C burns when exposed to an open flame, but immediately extinguishes when the flame is removed. The oxygen index amounts to 60 % (with less than 21 % of oxygen, the plastic is considered to be flammable).

Since the combustion of PVC-C produces hydrogen chloride, which forms a corrosive acid in connection with water, immediate cleaning of areas susceptible to corrosion with water containing detergent is necessary after a fire. Danger to personnel from hydrochloric acid is minimal because its pungent odor allows recognition even in lowest concentrations (1 ppm to 5 ppm), thereby allowing an early escape from toxic combustion gases, mainly from the odorless carbon monoxide.

Recommended fire-fighting agents are water, carbon dioxide or foam.



### Electrical properties

PVC-C is, like all unmodified thermoplastics, non-conductive. This means that no electrochemical corrosion takes place in PVC-C systems. On the other hand, these non-conductive characteristics have to be taken into account because an electrostatic charge can develop in the piping.

Special attention must be paid to this fact in environments in which explosive gases may occur. Various methods are available to prevent the occurrence of electrostatic charges. GF Piping Systems representatives can provide support in selecting the right one.

The specific volume resistance is at least  $10^{15} \Omega\text{cm}$ .



### Physiological properties

For details regarding existing approvals for applications with drinking water or foodstuff, please contact your GF Piping System representative.



## 2.6 Polyvinylidene fluoride (PVDF)

### PVDF properties (reference values)

Property	Value <sup>1</sup>	Units	Test standard
Density	1.78	g/cm <sup>3</sup>	EN ISO 1183-1
Yield stress at 23 °C	≥ 48	N/mm <sup>2</sup>	EN ISO 527-1
Tensile e-modulus at 23 °C	≥ 1'800	N/mm <sup>2</sup>	EN ISO 527-1
Charpy notched impact strength at 23 °C	≥ 8	kJ/m <sup>2</sup>	EN ISO 179-1/1eA
Charpy notched impact strength at 0 °C	≥ 7	kJ/m <sup>2</sup>	EN ISO 179-1/1eA
Heat distortion temperature HDT A 1.80 MPa	≥ 104	°C	EN ISO 75-2
Crystallite melting point	≥ 168	°C	ISO 11357-3
Thermal conductivity at 23 °C	0.19	W/m K	EN 12664
Water absorption at 23 °C / 24 h	≤ 0.04	%	EN ISO 62
Color	opaque		
Limiting oxygen index (LOI)	≥ 43	%	ISO 4589-1



<sup>1</sup> Typical characteristics measured at the material should not be used for calculations.

### General

Polyvinylidene fluoride (PVDF) is a semi-crystalline thermoplastic with outstanding mechanical, physical and chemical properties. These result from the chemical structure of PVDF. PVDF belongs to the class of fluorinated polymers, whose best-known representative is polytetrafluoroethylene (PTFE). PTFE is characterized by an extreme heat resistance and the best chemical resistance of all polymers. A great disadvantage is that it cannot be processed like other thermoplastics, e.g. injection molding into fittings. PVDF, on the other hand, combines various advantages of PTFE with good processability into structural parts. The fluorine content in PVDF amounts to 59 % by weight.

PVDF from GF Piping Systems used in the SYGEF system is characterized by a very good mechanical behavior and high temperature resistance. Because of the exceptionally wide pressure-temperature range in which SYGEF PVDF can be used, it has opened, in connection with the specific properties of the PVDF material, completely new areas of application in plastic piping. This includes the semiconductor industry, the chemical and pharmaceutical industry, electroplating technology, the pulp and paper industry, the automotive industry and water treatment. Pipes, fittings and valves are not pigmented and opaque (milky, translucent). By avoiding the addition of any additives, the purity as well as the outstanding chemical resistance and physiological inertness of the material remain completely unaffected.

#### Advantages of PVDF

- Outstanding mechanical properties, even at elevated temperatures
- No electrochemical corrosion
- Long service life, even under intensely corrosive conditions
- Outstanding resistance against UV and  $\gamma$ -radiation
- Very pure material by avoiding the use of additives
- No support of microbiological growth
- Secure jointing by high-quality fusioning technology
- Very low thermal conductivity
- Excellent flame retardant properties

#### UV and weather resistance

PVDF is very weather-resistant. Even longer exposure to direct sunlight, wind and rain causes no damage to the material. Contact the responsible GF Piping Systems representative for more detailed information.



### Chemical resistance

PVDF shows a good resistance against a broad range of media. For detailed information, observe the list of chemical resistance from GF Piping Systems or contact the responsible GF Piping Systems representative.



### Abrasion resistance

PVDF has an excellent resistance against abrasion. For many applications, PVDF demonstrates similar or better properties than metals.



### Application limits

The application limits of the material on the one hand depend on embrittlement and softening temperatures and on the other hand on the nature and the expected service life of the application. The pressure-temperature diagrams give details on application temperatures and pressures.



### Combustion behavior

PVDF displays an exceptionally good combustion behavior without the addition of fire protection additives. Material decomposition starts at 380 °C. The oxygen index amounts to 44 % (with less than 21 %, the material is considered to be flammable). Since the combustion of PVDF produces hydrogen fluoride, which forms a corrosive acid in connection with water, immediate cleaning of areas susceptible to corrosion with water containing detergent is necessary after a fire. Additional combustion products are carbon monoxide and carbon dioxide. Suitable fire-fighting agents are sand and extinguishing foam. The use of water can lead to corrosive acids.



### Electrical properties

PVDF is, like all unmodified thermoplastics, non-conductive. This means that no electrochemical corrosion takes place in PVDF systems. On the other hand, these non-conductive characteristics have to be taken into account because an electrostatic charge can develop in the piping. Special attention must be paid to this fact in environments in which explosive gases may occur. Various methods are available to prevent the occurrence of electrostatic charges. GF Piping Systems representatives can provide support in selecting the right one. The specific volume resistance is greater than  $10^{14} \Omega\text{cm}$  and the specific surface resistance is  $10^{14} \Omega\text{cm}$ .



### Physiological properties

PVDF is physiologically non-toxic as long as it is used at temperatures up to a maximum of 150 °C. During processing, adequate ventilation must be ensured and developing gases must be extracted.



### High-purity properties

As is can be processed and utilized without the use of additives (no pigments, thermo-stabilizers, processing aids or fillers), PVDF is particularly suited for applications that require the highest degree of purity. The PVDF raw materials used by GF Piping Systems fulfil the requirements of the semiconductor and pharmaceutical industries. In addition, products made of PVDF exhibit a very smooth surface. Leach-out tests according to SEMI F57 are done regularly for quality control.



## 2.7 Ethylene-Chlorotrifluoroethylene (ECTFE)

### ECTFE properties (reference values)

Property	Value <sup>1</sup>	Units	Test standard
Density	1.68	g/cm <sup>3</sup>	EN ISO 1183-1 ASTM D792
Yield stress at 23 °C	≥ 30	N/mm <sup>2</sup>	EN ISO 527-1
Tensile e-modulus at 23 °C	≥ 1'600	N/mm <sup>2</sup>	EN ISO 527-1
Charpy notched impact strength at 23 °C	no break	kJ/m <sup>2</sup>	EN ISO 179-1/1eA
Charpy notched impact strength at 0 °C	≥ 6	kJ/m <sup>2</sup>	EN ISO 179-1/1eA
Heat distortion temperature HDT A 1.80 MPa	≥ 65	°C	ASTM D648
Crystallite melting point	≥ 240	°C	ISO 11357-3 DSC / ASTM D3418
Thermal conductivity at 23 °C	0.20	W/m K	ASTM C177
Water absorption at 23 °C / 24 h	≤ 0.07	%	EN ISO 62
Color	opaque		
Limiting oxygen index (LOI)	≥ 50	%	ASTM D 2863



<sup>1</sup> Typical characteristics measured at the material should not be used for calculations.

### General

As raw material for pipes only HALAR 901S ECTFE from Solvay may be used, HALAR 350LC ECTFE for fittings.



### Advantages of ECTFE

- Outstanding chemical resistance
- Long service life, even under intensely corrosive conditions
- Outstanding resistance against UV and  $\gamma$ -radiation
- Reliable jointing by high-quality jointing technology
- Very low thermal conductivity
- Excellent flame retardant properties

### UV and weather resistance

ECTFE is very weather-resistant. Even longer exposure to direct sunlight, wind and rain causes very little change in properties or appearance of the material. Contact the responsible GF Piping Systems representative for more detailed information.

### Chemical resistance

ECTFE shows an outstanding resistance against a broad range of media. For detailed information, observe the list of chemical resistance from GF Piping Systems or contact the responsible GF Piping Systems representative.



### Abrasion resistance

For the use of ECTFE in abrasive applications please contact your GF Piping Systems representative.



### Application limits

The application limits of the material on the one hand depend on embrittlement and softening temperatures and on the other hand on the nature and the expected service life of the application. The pressure-temperature diagrams give details on application temperatures and pressures.



### Combustion behavior

ECTFE displays an exceptionally good combustion behavior without the addition of fire protection additives. Material decomposition starts at 300 °C, heating above 350°C must be strictly avoided. The oxygen index is 52 % (with less than 21 %, the material is considered to be flammable). Since the combustion of ECTFE produces hydrogen fluoride and hydrogen chloride, which form corrosive acids in connection with water, immediate cleaning of areas susceptible to corrosion with water containing detergent is necessary after a fire. Additional combustion products are carbon monoxide and carbon dioxide. Suitable fire-fighting agents are sand and extinguishing powder. The use of water can lead to corrosive acids.



### Electrical properties

ECTFE is, like all unmodified thermoplastics, non-conductive. This means that no electrochemical corrosion takes place in ECTFE systems. On the other hand, these non-conductive characteristics have to be taken into account because an electrostatic charge can develop in the piping. Special attention must be paid to this fact in environments in which explosive gases may occur. Various methods are available to prevent the occurrence of electrostatic charges. GF Piping Systems representatives can provide support in selecting the right one.

The specific volume resistance is greater than  $10^{15} \Omega \text{ cm}$  and the specific surface resistance is above  $10^{14} \Omega \text{ cm}$ .



### Physiological properties

ECTFE is physiologically non-toxic as long as it is used at temperatures up to a maximum of 140 °C. During processing, adequate ventilation must be ensured and developing gases must be vented. Approvals and Standards





## 3 Approvals and standards

### 3.1 Approvals of products

Various approvals are in place for all piping systems from GF Piping Systems. The most important approvals are listed in the following overview. The current status of the approvals can be obtained from an authorized GF Piping Systems representative.

Abbreviation	Approval authority	Approved product range	Material
ABS	American Bureau of Shipping	Pipes, fittings, valves	ABS, PE100, PVC-U, PVC-C
AVS	Attestation de Conformité Sanitaire	Gaskets	EPDM
BSI	British Standard Institution	Fittings	PVC-U
BV	Bureau Veritas	Pipes, fittings, valves	ABS, PE100, PP-H, PVC-C, PVC-U
CCS	China Classification Society	Pipes, fittings, valves	PE100, PVC-C
CSTB	Centre Scientifique et Technique du Bâtiment	Fittings	PVC-U
DIBt	Deutsches Institut für Bautechnik	Pipes, fittings, valves	PVC-U, PP-H, PVDF, PE (Fittings)
DNV	Det Norske Veritas	Pipes, fittings, valves	ABS, PE100, PP-H, PVC-C, PVC-U
DVGW	Deutscher Verein des Gas- und Wasserfaches	Dichtungen Rohre, Fittings, Ventile	EPDM PE, PP-H, PVC-C, PVC-U
FDA	Food and Drug Administration	Gaskets	FKM
GL	Germanischer Lloyd	Pipes, fittings, valves	ABS, PE100, PP-H, PVC-C, PVC-U
GOST-R	Rosstandart	Pipes, fittings, valves	ABS, PB, PE, PP, PVC-C, PVC-U, PVDF
IIP	Instituto Italiano dei Plastici	Fittings	PE, PVC-U
KIWA	Keuringsinstituut voor Waterleidingsartikelen	Fittings	PE, PVC-U
KTW	Kunststoff-Trinkwasser-Bewertungsgrundlagen und Leitlinien	Gaskets Fittings	EPDM PE, PVC-U
LNE	Laboratoire Nationale d'Essais	Pipes	PVC-U
LR	Lloyd's Register of Shipping	Pipes, fittings, valves	ABS, PE100, PVC-U, PVC-C, PP-H
NAMSA	North American Science Associates	Gaskets	EPDM, FKM, PTFE
NK	Nippon Kaiji Kyokai	Pipes, fittings, valves	ABS, PB, PE, PP, PVC-C, PVC-U
NSF	National Sanitary Foundation		
ÖVGW	Austrian Association for Gas and Water	Gaskets Pipes, fittings, valves	EPDM PE, PP, PVDF
PZH	Panstwowy Zakład Higieny	Fittings, valves	ABS, PP-H, PVC-U
RINA	Registro Italiano Navale	Pipes, fittings, valves	ABS, PE100, PP-H, PVC-C, PVC-U
RMROS	Russian Maritime Register of Shipping	Pipes, fittings, valves	ABS, PE100, PVC-C, PVC-U
RTN	ROSTECHNADZOR	Pipes, fittings, valves	ABS, PB, PE, PP, PVC-C, PVC-U, PVDF
SVGW	Swiss Association for Gas and Water	Gaskets Fittings, valves	EPDM PB, PE, PP
TSSA	Technical Standards & Safety Authority	Pipes, fittings, valves	PVC-U, PVC-C, PP-H
WRAS	Water Regulations Advisory Scheme Water Byelaws Scheme	Gaskets Pipes, fittings	EPDM ABS, PE, PVC-U, PVC-C

Abbreviations of approvals (edition: July 2015)

## 3.2 Standards and guidelines

### 3.2.1 Relevant standards and standards met for valves

Standard	Name
ISO 9393-2	Thermoplastics valves for industrial applications - Pressure test methods and requirements - Part 2: Test conditions and basic requirements
ISO 9393-1	Thermoplastics valves for industrial applications - Pressure test methods and requirements - Part 1: General
ISO 14617-8	Graphical symbols for diagrams - Part 8: Valves and dampers
EN ISO 5211	Industrial valves - Part-turn actuator attachments
EN ISO 16135	Industrial valves - Ball valves of thermoplastic materials
EN ISO 16136	Industrial valves - Butterfly valves of thermoplastic materials
EN ISO 16137	Industrial valves - Check valves of thermoplastic materials
EN ISO 16138	Industrial valves - Diaphragm valves of thermoplastic materials
EN ISO 16139	Industrial valves - Gate valves of thermoplastic materials
EN ISO 21787	Industrial valves - Valves of thermoplastic materials
EN 593	Industrial valves - Metallic butterfly valves
EN 12266-2	Industrial valves - Testing of metallic valves - Part 2: Tests, test procedures and acceptance criteria - Supplementary requirements
EN 12266-1	Industrial valves - Testing of metallic valves - Part 1: Pressure tests, test procedures and acceptance criteria - Mandatory requirements
EN 12516-2	Industrial valves - Shell design strength - Part 2: Calculation method for steel valve shells
EN 13774	Valves for gas distribution systems with maximum operating pressure less than or equal to 16 bar - Performance requirements
EN 14141	Valves for natural gas transportation in piping systems - Performance requirements and tests
EN 15389	Industrial valves - Performance characteristics of thermoplastic valves when used as construction products
ASME B 16.10	Face-to-face and end-to-end dimensions of valves
DIN 3202-4	Face-to-face and center-to-face dimensions of valves; Valves with internal thread connection
DIN 3202-5	Overall lengths of valves; Valves with pipe union connections
DIN 3230-4	Technical conditions of delivery for valves; Valves for potable water service, requirements and testing
DIN 3230-5	Technical conditions of delivery of valves - Valves for gas installations and gas piping systems - Requirements and tests
DIN 3230-6	Technical delivery conditions for valves; requirements and methods of test for valves for use with flammable liquids
DIN 3266	Valves for drinking water installations on private premises - Anti-vacuum valve types D and E - Requirements and tests
DIN 3292-1	Fittings for domestic installation; nonferrous metal union nuts
DIN 3500	Stop valves for domestic water supply - Piston type gate valves - PN 10
DIN 3512	Stopvalves for domestic water supply - Two-way valves - Vertical bonnet type PN 10; Straight pattern globe valve; Technical rule of the DVGW / Caution: Applies in connection with DIN EN 1213
DIN 3537-1	Gas stop valves for domestic gas installations up to 5 bar - Requirements and tests
DIN 3544-1	High-density polyethylene (HDPE) valves; tapping valves; requirements and test
DIN 32676	Fittings for the food, chemical and pharmaceutical industries - Clamp connections for stainless steel tubes - Fusion type
DIN 28000-4	Chemical apparatus - Documentation in the life cycle of process plants - Part 4: Graphical symbols of valves, pipe and actuators
JIS B 2002	Face-to-face and end-to-end dimensions of valves
JIS B 2003	General rules for inspection of valves

Standards for valves (edition: July 2015)

### 3.2.2 Relevant standards and guidelines for flanges

Standard	Name
ISO 5752	Metal valves for use in flanged pipe systems - Face-to-face and center-to-face dimensions
ISO 7005-3	Metallic flanges - Part 3: Copper alloy and composite flanges
ISO 7005-2	Metallic flanges - Part 2: Cast iron flanges
ISO 7005-1	Pipe flanges - Part 1: Steel flanges for industrial and general service piping systems
ISO 7483	Dimensions of gaskets for use with flanges to ISO 7005
ISO 7483 Technical Corrigendum 1	Dimensions of gaskets for use with flanges to ISO 7005; Technical Corrigendum 1
ISO 8483	Plastics piping systems for pressure and non-pressure drainage and sewerage - Glass-reinforced thermosetting plastics (GRP) systems based on unsaturated polyester (UP) resin - Test methods to prove the design of bolted flange joints
ISO 9624	Thermoplastics pipe for fluids under pressure - Mating dimensions of flange adapters and loose backing flanges
EN ISO 10931	Plastics piping systems for industrial applications - Poly(vinylidene fluoride) (PVDF) - Specifications for components and the system
EN ISO 15493	Plastics piping systems for industrial applications - Acrylonitrile-butadiene-styrene (ABS), unplasticized poly(vinyl chloride) (PVC-U) and chlorinated poly(vinyl chloride) (PVC-C) - Specifications for components and the system - Metric series
EN ISO 15494	Plastics piping systems for industrial applications - Polybutene (PB), polyethylene (PE) and polypropylene (PP) - Specifications for components and the system - Metric series
EN 558+A1	Industrial valves - Face-to-face and center-to-face dimensions of metal valves for use in flanged pipe systems - PN and Class designated valves
EN 1092-1+A1	Circular flanges for pipe, valves, fittings and accessories, PN designated - Part 1: Steel flanges
EN 1092-2	Flanges and their joints - Circular flanges for pipe, valves, fittings and accessories, PN designated - Part 2: Cast iron flanges
EN 1514-8	Flanges and their joints - Dimensions of gaskets for PN-designated flanges Part 8: Polymeric O-ring gaskets for grooved flanges
EN 1515-1	Flanges and their joints - Bolting - Part 1: Selection of bolting
EN 1759-3	Flanges and their joints - Circular flanges for pipe, valves, fittings and accessories, Class designated. - Part 3: Copper alloy flanges
EN 1759-1	Flanges and their joints - Circular flanges for pipe, valves, fittings and accessories, Class designated - Part 1: Steel flanges, NPS 1/2 to 24
ASME B16.5	Pipe flanges and flanged fittings: NPS 1/2 through NPS 24 metric/inch standard
ASTM D4024	Standard specification for machine made "fiberglass" (glass-fiber-reinforced thermosetting resin) flanges
ASTM D5421	Standard specification for contact molded "fiberglass" (glass-fiber-reinforced thermosetting resin) flanges
BS 10:2009	Specification for flanges and bolting for pipe, valves and fittings
BS 1560-3.2:1989	Circular flanges for pipe, valves and fittings (Class designated). Steel, cast iron and copper alloy flanges. Specification for cast iron flanges
DIN 16831-7	Pipe fittings and joint assemblies for polybutene pressure pipe - Type PB 125 - Part 7: Dimensions of bushings, flanges and sealing elements for socket fusioning
DIN 16966-7	Pipe joints and their elements of glass fiber reinforced polyester resins - Part 7: Bushings, flanges, flanged and butt joints; general quality requirements and test methods
DIN 16966-6	Glass fiber reinforced polyester resin (UP-GF) pipe fittings and joint assemblies; collars, flanges, joint rings, dimensions
DIN 28000-4	Chemical apparatus - Documentation in the life cycle of process plants - Part 4: Graphical symbols of valves, pipe and actuators
DIN 28403	Vacuum technology; quick release couplings; clamped type couplings

Standards for flanges (edition: July 2015)

Standard	Name
DIN 28404	Vacuum technology; flanges; dimensions
DVS 2205-4	Calculation of thermoplastic tanks and apparatuses - Flanged joints
DVS 2205-4 Supplement 4	Calculation of thermoplastic tanks and apparatuses - Fused flanges, fused collars - Constructive details
DVS 2210-1 Supplement 3	Industrial piping made of thermoplastics - Design and execution - Above-ground pipe systems - Flange connections: Description, requirements and assembly
JIS B 2220	Steel pipe flanges
JIS B 2239	Cast iron pipe flanges

### 3.2.3 Relevant standards for threads

Standard	Name
ISO 7-1	Pipe threads where pressure-tight joints are made on the threads - Part 1: Dimensions, tolerances and designation
ISO 7-2	Pipe threads where pressure-tight joints are made on the threads - Part 2: Verification by means of limit gauges
ISO 68-1	ISO general purpose screw threads - Basic profile - Part 1: Metric screw threads
ISO 1502	ISO general-purpose metric screw threads - Gauges and gauging
EN ISO 228-1	Pipe threads where pressure-tight joints are not made on the threads - Part 1 : Dimensions, tolerances and designation
EN ISO 228-2	Pipe threads where pressure-tight joints are not made on the threads - Part 2: Verification by means of limit gauges
EN ISO 228-1 addendum 1	Pipe threads where pressure-tight joints are not made on the threads - Part 1: Dimensions, tolerances and designation; Limits of size
EN 10226-1	Pipe threads where pressure tight joints are made on the threads - Part 1: Taper external threads and parallel internal threads - Dimensions, tolerances and designation
EN 10226-3	Pipes threads where pressure tight joints are made on the threads - Part 3: Verification by means of limit gauges
ASME B1.20.1	Pipe Threads, general purpose, inch
ASTM F1498	Standard specification for taper pipe threads 60° for thermoplastic pipe and fittings
BS 21:1985	Specification for pipe threads for tubes and fittings where pressure-tight joints are made on the threads
DIN 103-1	ISO metric trapezoidal screw thread; Profiles
DIN 103-2	ISO metric trapezoidal screw thread; General plan
DIN 103-3	ISO metric trapezoidal screw thread; Allowances and tolerances for trapezoidal screw threads of general purpose
DIN 103-4	ISO metric trapezoidal screw thread; Nominal dimensions
DIN 103-5	ISO metric trapezoidal screw threads; Limiting sizes for nut threads from 8 to 100 mm nominal diameter
DIN 103-6	ISO metric trapezoidal screw threads; Limiting sizes for nut threads from 105 to 300 mm nominal diameter
DIN 103-7	ISO metric trapezoidal screw threads; Limiting sizes for bolt threads from 8 to 100 mm nominal diameter
DIN 103-8	ISO metric trapezoidal screw threads; Limiting sizes for bolt threads from 105 to 300 mm nominal diameter
DIN 103-9	ISO metric trapezoidal screw threads; gauging of external and internal threads; gauge dimensions and design features
DIN 405-1	General purpose knuckle threads - Part 1: Profiles, nominal sizes
DIN 405-2	General purpose knuckle threads - Part 2: Deviations and tolerances
DIN 513-1	Metric buttress threads; thread profiles
DIN 513-2	Metric buttress threads; general plan
DIN 513-3	Metric buttress threads; deviations and tolerances
DIN 3852-2	Stud ends and ports of fittings, valves and plug screws - Part 2: Dimensions for pipe thread
DIN 40430	Steel conduit thread; Dimensions

Standards for threads (edition: July 2015)

Standard	Name
DIN 28000-4	Chemical apparatus - Documentation in the life cycle of process plants - Part 4: Graphical symbols of valves, pipe and actuators
JIS K 6743	Unplasticized poly (vinyl chloride) (PVC-U) pipe fittings for water supply

### 3.2.4 Relevant standards for pipe and fittings made of ABS

Standard	Name
ISO 727-1	Fittings made from unplasticized poly(vinyl chloride) (PVC-U), chlorinated poly (vinyl chloride) (PVC-C) or acrylonitrile/butadiene/styrene (ABS) with plain sockets for pipe under pressure - Part 1: Metric series
ISO 727-2	Fittings made from unplasticized poly(vinyl chloride) (PVC-U), chlorinated poly (vinyl chloride) (PVC-C) or acrylonitrile/butadiene/styrene (ABS) with plain sockets for pipe under pressure - Part 2: Inch-based series
ISO 8283-4	Plastics pipe and fittings - Dimensions of sockets and spigots for discharge systems inside buildings - Part 4: Acrylonitrile/butadiene/styrene (ABS)
EN ISO 15493	Plastics piping systems for industrial applications - Acrylonitrile-butadiene-styrene (ABS), unplasticized poly(vinyl chloride) (PVC-U) and chlorinated poly(vinyl chloride) (PVC-C) - Specifications for components and the system - Metric series
ASTM D3965	Standard specification for rigid acrylonitrile-butadiene-styrene (ABS) materials for pipe and fittings
BS 5391-1:2006	Acrylonitrile-butadiene-styrene (ABS) pressure pipe. Specification
BS 5392-1:2006	Acrylonitrile-butadiene-styrene (ABS) fittings for use with ABS pressure pipe. Specification
DIN 28000-4	Chemical apparatus - Documentation in the life cycle of process plants - Part 4: Graphical symbols of valves, pipe and actuators
DVS 2210-2	Industrial piping made of thermoplastics - Design, structure and installation of two-pipe systems

Standards for pipe and fittings made of ABS (edition: July 2015)

### 3.2.5 Relevant standards and guidelines for pipe and fittings made of PE

Standard	Name
ISO 3458	Plastics piping systems - Mechanical joints between fittings and pressure pipe - Test method for leak-tightness under internal pressure
ISO 3459	Plastic piping systems - Mechanical joints between fittings and pressure pipe - Test method for leak-tightness under negative pressure
ISO 3501	Plastics piping systems - Mechanical joints between fittings and pressure pipe - Test method for resistance to pull-out under constant longitudinal force
ISO 3503	Plastics piping systems - Mechanical joints between fittings and pressure pipe - Test method for leak-tightness under internal pressure of assemblies subjected to bending
ISO 4437-1	Plastics piping systems for the supply of gaseous fuels - Polyethylene (PE) - Part 1: General
ISO 4437-2	Plastics piping systems for the supply of gaseous fuels - Polyethylene (PE) - Part 2: Pipes
ISO 4437-3	Plastics piping systems for the supply of gaseous fuels - Polyethylene (PE) - Part 3: Fittings
ISO 4437-4	Plastics piping systems for the supply of gaseous fuels - Polyethylene (PE) - Part 4: Valves
ISO 4437-5	Plastics piping systems for the supply of gaseous fuels - Polyethylene (PE) - Part 5: Fitness for purpose of the system
ISO 9623	PE/metal and PP/metal adaptor fittings for pipe for fluids under pressure - Design lengths and size of threads - Metric series
ISO/TS 10839	Polyethylene pipe and fittings for the supply of gaseous fuels - Code of practice for design, handling and installation
ISO 12176-3	Plastics pipe and fittings - Equipment for fusion jointing polyethylene systems - Part 3: Operator's badge

Standards for pipe and fittings made of PE (edition: July 2015)

Standard	Name
ISO 14236	Plastic pipe and fittings - Mechanical compression joints for polyethylene pressure pipe in the water supply
EN ISO 15494	Plastics piping systems for industrial applications - Polybutene (PB), polyethylene (PE) and polypropylene (PP) - Specifications for components and the system - Metric series
EN 12201-1	Plastics piping systems for water supply - Polyethylene (PE) - Part 1: General
EN 12201-2+A1	Plastics piping systems for water supply - Polyethylene (PE) - Part 2: Pipes
EN 12201-3+A1	Plastics piping systems for water supply - Polyethylene (PE) - Part 3: Fittings
EN 12201-4	Plastics piping systems for water supply - Polyethylene (PE) - Part 4: Valves
EN 12201-5	Plastics piping systems for water supply, and for drainage and sewerage under pressure - Polyethylene (PE) - Part 5: Fitness for purpose of the system
EN 1555-1	Plastics piping systems for the supply of gaseous fuels - Polyethylene (PE) - Part 1: General
EN 1555-2	Plastics piping systems for the supply of gaseous fuels - Polyethylene (PE) - Part 2: Pipes
EN 1555-3+A1	Plastics piping systems for the supply of gaseous fuels - Polyethylene (PE) - Part 3: Fittings
EN 1555-4	Plastics piping systems for the supply of gaseous fuels - Polyethylene (PE) - Part 4: Valves
EN 1555-5	Plastics piping systems for the supply of gaseous fuels - Polyethylene (PE) - Part 5: Fitness for purpose of the system
EN 12007-2	Gas infrastructure - Piping systems for maximum operating pressure up to and including 16 bar - Part 1: General functional requirements; German version EN 12007-1:2012
CEN/TS 12201-7	Plastics piping systems for water supply, and for drainage and sewerage under pressure - Polyethylene (PE) - Part 7: Guidance for the assessment of conformity
CEN/TS 1555-7	Plastics piping systems for the supply of gaseous fuels - Polyethylene (PE) - Part 7: Guidance for assessment of conformity
ASTM D2657	Standard practice for heat fusion joining of polyolefin pipe and fittings
ASTM D3261	Standard specification for butt heat fusion polyethylene (PE) plastic fittings for polyethylene (PE) plastic pipe and tubing
DIN 3544-1	High-density polyethylene (HDPE) valves; tapping valves; requirements and test
DIN 8074	Polyethylene (PE) - Pipes PE 80, PE 100 - Dimensions
DIN 8075	Polyethylene (PE) pipe - PE 80, PE 100 - General quality requirements, testing
DIN 8076	Pressure piping systems made from thermoplastics materials - Metal and plastics compression fittings for polyethylene (PE) pipe - General quality requirements and testing
DIN 19537-3	Prefabricated high density polyethylene (PE-HD) manholes for use in sewerage systems; dimensions and technical delivery conditions
DIN 28000-4	Chemical apparatus - Documentation in the life cycle of process plants - Part 4: Graphical symbols of valves, pipe and actuators
DVGW VP 302	Gas-Absperrarmaturen aus Polyethylen (PE 80 und PE 100) - Anforderungen und Prüfungen (Gas valves made of polyethylene [PE 80 and PE 100] - Requirements, testing)
DVS 2205-1 Supplement 6	Calculation of tanks and apparatus made of thermoplastics - Welding factors
DVS 2207-1	Fusioning of thermoplastics - Heated tool fusion of pipe, piping system components and sheets made of PE
DVS 2210-1	Industrial piping systems made of thermoplastics - Planning and execution - Above-ground pipe systems
DVS 2210-1 Supplement 1	Industrial piping made of thermoplastics - Design and execution - Above-ground pipe systems - Calculation example

Standard	Name
DVS 2210-1 Supplement 2	Industrial piping made of thermoplastics - Design and execution - Above-ground pipe systems - Recommendations for the internal pressure and leak tests
DVS 2210-1 Supplement 3	Industrial piping made of thermoplastics - Design and execution - Above-ground pipe systems - Flange connections: Description, requirements and assembly
DVS 2210-2	Industrial piping made of thermoplastics - Design, structure and installation of two-pipe systems
JIS K 6774	Polyethylene pipe for the supply of gaseous fuels

### 3.2.6 Relevant standards and guidelines for pipe and fittings made of PP

Norm	Bezeichnung
ISO 3213	Polypropylene (PP) pipe - Effect of time and temperature on the expected strength
ISO 9623	PE/metal and PP/metal adaptor fittings for pipe for fluids under pressure - Design lengths and size of threads - Metric series
EN ISO 15494	Plastics piping systems for industrial applications - Polybutene (PB), polyethylene (PE) and polypropylene (PP) - Specifications for components and the system - Metric series
DIN 8077	Polypropylene (PP) pipe - PP-H, PP-B, PP-R, PP-RCT - Dimensions
DIN 8078	Polypropylene (PP) pipe - PP-H, PP-B, PP-R, PP-RCT - General quality requirements and testing
DIN 8078 Supplement 1	Pipes of polypropylene (PP); chemical resistance of pipe and fittings
DIN 28000-4	Chemical apparatus - Documentation in the life cycle of process plants - Part 4: Graphical symbols of valves, pipe and actuators
DVS 2207-6	Fusioning of thermoplastics - Non-contact heated tool butt fusion of pipe, piping system components and sheets - Methods, equipment, parameters
DVS 2207-11	Fusioning of thermoplastics - Heated tool fusioning of pipe, piping parts and panels made of PP
DVS 2210-1	Industrial piping systems made of thermoplastics - Planning and execution - Above-ground pipe systems
DVS 2210-1 Supplement 1	Industrial piping made of thermoplastics - Design and execution - Above-ground pipe systems - Calculation example
DVS 2210-1 Supplement 2	Industrial piping made of thermoplastics - Design and execution - Above-ground pipe systems - Recommendations for the internal pressure and leak tests
DVS 2210-1 Supplement 3	Industrial piping made of thermoplastics - Design and execution - Above-ground pipe systems - Flange connections: Description, requirements and assembly
DVS 2210-2	Industrial piping made of thermoplastics - Design, structure and installation of two-pipe systems

Standards and guidelines for pipe and fittings made of PP (edition: July 2015)

### 3.2.7 Relevant standards and guidelines for pipe and fittings made of PVC-C

Standard	Name
ISO 727-1	Fittings made from unplasticized poly(vinyl chloride) (PVC-U), chlorinated poly(vinyl chloride) (PVC-C) or acrylonitrile/butadiene/styrene (ABS) with plain sockets for pipe under pressure - Part 1: Metric series
ISO 727-2	Fittings made from unplasticized poly(vinyl chloride) (PVC-U), chlorinated poly(vinyl chloride) (PVC-C) or acrylonitrile/butadiene/styrene (ABS) with plain sockets for pipe under pressure - Part 2: Inch-based series
EN ISO 15493	Plastics piping systems for industrial applications - Acrylonitrile-butadiene-styrene (ABS), unplasticized poly(vinyl chloride) (PVC-U) and chlorinated poly(vinyl chloride) (PVC-C) - Specifications for components and the system - Metric series
ASTM F437	Standard specification for threaded chlorinated poly (vinyl chloride) (PVC-C) plastic pipe fittings, Schedule 80
ASTM F441/F441M	Standard specification for chlorinated poly(vinyl chloride) (PVC-C) plastic pipe, Schedules 40 and 80
ASTM F1970	Standard specification for special engineered fittings, appurtenances or valves for use in poly (vinyl chloride) (PVC) or chlorinated poly (vinyl chloride) (PVC-C) systems
DIN 8079	Chlorinated polyvinyl chloride (PVC-C) pipe - Dimensions
DIN 8080	Chlorinated polyvinyl chloride (PVC-C) pipe - General quality requirements, testing
DIN 8080 Supplement 1	Chlorinated polyvinyl chloride (PVC-C) pipe, PVC-C 250 - General quality requirements and testing; chemical resistance
DIN 28000-4	Chemical apparatus - Documentation in the life cycle of process plants - Part 4: Graphical symbols of valves, pipe and actuators
DVS 2204-5	Adhesive bonding of pipe and fittings made of thermoplastics - Chlorinated polyvinyl chloride (PVC-C)
DVS 2204-5	Adhesive bonding of pipe and fittings made of thermoplastics - Chlorinated polyvinyl chloride (PVC-C)
DVS 2210-1	Industrial piping systems made of thermoplastics - Planning and execution - Above-ground pipe systems
DVS 2210-1 Supplement 1	Industrial piping made of thermoplastics - Design and execution - Above-ground pipe systems - Calculation example
DVS 2210-1 Supplement 2	Industrial piping made of thermoplastics - Design and execution - Above-ground pipe systems - Recommendations for the internal pressure and leak tests
DVS 2210-1 Supplement 3	Industrial piping made of thermoplastics - Design and execution - Above-ground pipe systems - Flange connections: Description, requirements and assembly
DVS 2210-2	Industrial piping made of thermoplastics - Design, structure and installation of two-pipe systems

Standards for pipe and fittings made of PVC-C (edition: July 2015)



### 3.2.8 Relevant standards and guidelines for pipe and fittings made of PVC-U

Standard	Name
ISO 265-1	Pipe and fittings of plastics materials - Fittings for domestic and industrial waste pipe - Basic dimensions: Metric series - Part 1: Unplasticized poly(vinyl chloride) (PVC-U)
ISO 727-1	Fittings made from unplasticized poly(vinyl chloride) (PVC-U), chlorinated poly(vinyl chloride) (PVC-C) or acrylonitrile/butadiene/styrene (ABS) with plain sockets for pipe under pressure - Part 1: Metric series
ISO 727-2	Fittings made from unplasticized poly(vinyl chloride) (PVC-U), chlorinated poly(vinyl chloride) (PVC-C) or acrylonitrile/butadiene/styrene (ABS) with plain sockets for pipe under pressure - Part 2: Inch-based series
ISO 4132	Unplasticized polyvinyl chloride (PVC) and metal adaptor fittings for pipe under pressure - Laying lengths and size of threads - Metric series
EN ISO 13783	Plastics piping systems - Unplasticized poly(vinyl chloride) (PVC-U) end-load-bearing double-socket joints - Test method for leak-tightness and strength while subjected to bending and internal pressure
EN ISO 1452-1	Plastics piping systems for water supply and for buried and above-ground drainage and sewerage under pressure - Unplasticized poly(vinyl chloride) (PVC-U) - Part 1: General
EN ISO 1452-2	Plastics piping systems for water supply and for buried and above-ground drainage and sewerage under pressure - Unplasticized poly(vinyl chloride) (PVC-U) - Part 2: Pipes
EN ISO 1452-3	Plastics piping systems for water supply and for buried and above-ground drainage and sewerage under pressure - Unplasticized poly(vinyl chloride) (PVC-U) - Part 3: Fittings
EN ISO 1452-4	Plastics piping systems for water supply and for buried and above-ground drainage and sewerage under pressure - Unplasticized poly(vinyl chloride) (PVC-U) - Part 4: Valves
EN ISO 1452-5	Plastics piping systems for water supply and for buried and above-ground drainage and sewerage under pressure - Unplasticized poly(vinyl chloride) (PVC-U) - Part 5: Fitness for purpose of the system
EN ISO 15493	Plastics piping systems for industrial applications - Acrylonitrile-butadiene-styrene (ABS), unplasticized poly(vinyl chloride) (PVC-U) and chlorinated poly(vinyl chloride) (PVC-C) - Specifications for components and the system - Metric series
ASTM D1784	Standard specification for rigid poly(vinyl chloride) (PVC) compounds and chlorinated poly(vinyl chloride) (PVC-C) compounds
ASTM D1785	Standard specification for poly(vinyl chloride) (PVC) plastic pipe, Schedules 40, 80, and 120
ASTM D2464	Standard specification for threaded poly(vinyl chloride) (PVC) plastic pipe fittings, Schedule 80
ASTM D2466	Standard specification for poly(vinyl chloride) (PVC) plastic pipe fittings, Schedule 40
ASTM F1970	Standard specification for special engineered fittings, appurtenances or valves for use in poly(vinyl chloride) (PVC) or chlorinated poly(vinyl chloride) (PVC-C) systems
BS 3506:1969	Specification for unplasticized PVC pipe for industrial uses
BS 4346-1:1969	Joints and fittings for use with unplasticized PVC pressure pipe. Injection molded unplasticized PVC fittings for solvent fusioning for use with pressure pipe, including potable water supply
DIN 8061	Unplasticized polyvinyl chloride (PVC-U) pipe - General quality requirements
DIN 8061 Supplement 1	Unplasticized polyvinyl chloride pipe; chemical resistance of pipe and fittings of (PVC-U)
DIN 16450	Fittings for pressure pipe made of plasticizer-free polyvinylchloride (PVC-U); Names, symbols, simplified presentations
DIN 28000-4	Chemical apparatus - Documentation in the life cycle of process plants - Part 4: Graphical symbols of valves, pipe and actuators
DVS 2204-4	Adhesive bonding of pipe and piping parts made of thermoplastics - Polyvinyl chloride (PVC-U)

Standards and guidelines for pipe and fittings made of PVC-U (edition: July 2015)

Standard	Name
DVS 2210-1	Industrial piping systems made of thermoplastics - Planning and execution - Above-ground pipe systems
DVS 2210-1 Supplement 1	Industrial piping made of thermoplastics - Design and execution - Above-ground pipe systems - Calculation example
DVS 2210-1 Supplement 2	Industrial piping made of thermoplastics - Design and execution - Above-ground pipe systems - Recommendations for the internal pressure and leak tests
DVS 2210-1 Supplement 3	Industrial piping made of thermoplastics - Design and execution - Above-ground pipe systems - Flange connections: Description, requirements and assembly
DVS 2210-2	Industrial piping made of thermoplastics - Design, structure and installation of two-pipe systems
JIS K 6741	Unplasticized poly (vinyl chloride) (PVC-U) pipe
JIS K 6742	Unplasticized poly (vinyl chloride) (PVC-U) pipe for water supply
JIS K 6743	Unplasticized poly (vinyl chloride) (PVC-U) pipe fittings for water supply

### 3.2.9 Relevant standards and guidelines for pipe and fittings made of PVDF

Standard	Name
ISO 10931	Plastics piping systems for industrial applications - Poly (vinylidene fluoride) (PVDF) - Specifications for components and the system
EN ISO 10931	Plastics piping systems for industrial applications - Poly (vinylidene fluoride) (PVDF) - Specifications for components and the system
ASTM F1673	Standard specification for polyvinylidene fluoride (PVDF) corrosive waste drainage systems
ASTM D3222	Standard specification for unmodified poly(vinylidene fluoride) (PVDF) molding extrusion and coating materials
DIN 28000-4	Chemical apparatus - Documentation in the life cycle of process plants - Part 4: Graphical symbols of valves, pipe and actuators
DVS 2205 Supplement 4	Calculation of tanks and apparatus made of thermoplastics - Characteristic values of the PVDF pipe
DVS 2207-6	Fusioning of thermoplastics - Non-contact heated tool butt fusion of pipe, piping system components and sheets - Methods, equipment, parameters
DVS 2207-15	Fusioning of thermoplastics - Heated tool fusion of pipe, piping system components and sheets made of PVDF
DVS 2210-1	Industrial piping systems made of thermoplastics - Planning and execution - Above-ground pipe systems
DVS 2210-1 Supplement 1	Industrial piping made of thermoplastics - Design and execution - Above-ground pipe systems - Calculation example
DVS 2210-1 Supplement 2	Industrial piping made of thermoplastics - Design and execution - Above-ground pipe systems - Recommendations for the internal pressure and leak tests
DVS 2210-1 Supplement 3	Industrial piping made of thermoplastics - Design and execution - Above-ground pipe systems - Flange connections: Description, requirements and assembly
DVS 2210-2	Industrial piping made of thermoplastics - Design, structure and installation of two-pipe systems

Standards and guidelines for pipe and fittings made of PVDF (edition: July 2015)

### 3.2.10 Relevant standards and guidelines for pipe and fittings made of ECTFE

Standard	Name
ISO 10931 (ECTFE in compliance)	Plastic piping systems for industrial applications – Poly (vinylidene fluoride) (PVDF) – Specifications for components and the system
EN ISO 10931 (ECTFE in compliance)	Plastic piping systems for industrial applications – Poly (vinylidene fluoride) (PVDF) – Specifications for components and the system
ASTM D3275-18	Standard Classification System for E-CTFE-Fluoroplastic Molding, Extrusion, and Coating Materials
DIN 28000-4	Chemical apparatus - Documentation in the life cycle of process plants- Part 4: Graphical symbols of valves, pipe and actuators
DIN EN 12814-6	Testing of welded joints of thermoplastics semi-finished products - Part 6: Low temperature tensile test
DVS 2203-1	Testing of welded joints of thermoplastic sheets and pipes – Test methods - Requirements
DVS 2205-1 Supplement 4	Calculation of tanks and apparatus made of thermoplastics – Characteristic values of the fluoropolymer material group
DVS 2207-6	Fusioning of thermoplastics – Non-contact heated tool butt fusion of pipe, piping system components and sheets – Methods, equipment, parameters
DVS 2210-1	Industrial piping systems made of thermoplastics - Planning and execution - Above-ground pipe systems
DVS 2210-1 Supplement 1	Industrial piping made of thermoplastics - Design and execution - Above-ground pipe systems - Calculation example
DVS 2210-1 Supplement 2	Industrial piping made of thermoplastics - Design and execution - Above-ground pipe systems - Recommendations for the internal pressure and leak tests
DVS 2210-1 Supplement 3	Industrial piping made of thermoplastics -Design and execution - Above-ground pipe systems - Flange connections: Description, requirements and assembly
DVS 2210-2	Industrial piping made of thermoplastics - Design, structure and installation of two-pipe systems

### 3.2.11 Relevant standards for GRP pipe

Standards for GRP pipe (edition: July 2015)

Standard	Name
ISO 10466	Plastics piping systems - Glass-reinforced thermosetting plastics (GRP) pipe - Test method to prove the resistance to initial ring deflection
ISO 10468	Glass-reinforced thermosetting plastics (GRP) pipe - Determination of the long-term specific ring creep stiffness under wet conditions and calculation of the wet creep factor
ISO 10471	Glass-reinforced thermosetting plastics (GRP) pipe - Determination of the long-term ultimate bending strain and the long-term ultimate relative ring deflection under wet conditions
ISO 10928	Plastics piping systems - Glass-reinforced thermosetting plastics (GRP) pipe and fittings - Methods for regression analysis and their use / Caution: Intended replacement by ISO/DIS 10928 (2006-03).
ISO 1172	Textile-glass-reinforced plastics - Prepregs, molding compounds and laminates - Determination of the textile-glass and mineral-filler content - Calcination methods
ISO 14828	Glass-reinforced thermosetting plastics (GRP) pipe - Determination of the long-term specific ring relaxation stiffness under wet conditions and calculation of the wet relaxation factor
ISO 15306	Glass-reinforced thermosetting plastics (GRP) pipe - Determination of the resistance to cyclic internal pressure
ISO 7432	Glass-reinforced thermosetting plastics (GRP) pipe and fittings - Test methods to prove the design of locked socket-and-spigot joints, including double-socket joints, with elastomeric seals
ISO 7509	Plastics piping systems - Glass-reinforced thermosetting plastics (GRP) pipe - Determination of time to failure under sustained internal pressure
ISO 7511	Plastics piping systems - Glass-reinforced thermosetting plastics (GRP) pipe and fittings - Test methods to prove the leak-tightness of the wall under short-term internal pressure
ISO 7685	Plastics piping systems - Glass-reinforced thermosetting plastics (GRP) pipe - Determination of initial specific ring stiffness
ISO 8483	Plastics piping systems for pressure and non-pressure drainage and sewerage - Glass-reinforced thermosetting plastics (GRP) systems based on unsaturated polyester (UP) resin - Test methods to prove the design of bolted flange joints
ISO 8513	Plastics piping systems - Glass-reinforced thermosetting plastics (GRP) pipe - Test methods for the determination of the apparent initial longitudinal tensile strength
ISO 8521	Plastics piping systems - Glass-reinforced thermosetting plastics (GRP) pipe - Test methods for the determination of the apparent initial circumferential tensile strength
ISO 8533	Plastics piping systems for pressure and non-pressure drainage and sewerage - Glass-reinforced thermosetting plastics (GRP) systems based on unsaturated polyester (UP) resin - Test methods to prove the design of cemented or wrapped joints
ISO 8639	Glass-reinforced thermosetting plastics (GRP) pipe and fittings - Test methods for leak-tightness of flexible joints
ISO/TS 10465-1	Underground installation of flexible glass-reinforced pipe based on unsaturated polyester resin (GRP-UP) - Part 1: Installation procedures
EN 637	Plastics piping systems - Glass-reinforced plastics components - Determination of the amounts of constituents using the gravimetric method
EN 705	Plastics piping systems - Glass-reinforced thermosetting plastics (GRP) pipe and fittings - Methods for regression analyses and their use
EN 761	Plastics piping systems - Glass-reinforced thermosetting plastics (GRP) pipe - Determination of the creep factor under dry conditions
EN 1394	Glass-reinforced thermosetting plastics (GRP) pipe - Determination of the long-term specific ring relaxation stiffness under wet conditions and calculation of the wet relaxation factor
EN 1447+A1	Plastics piping systems - Glass-reinforced thermosetting plastics (GRP) pipe - Determination of time to failure under sustained internal pressure

Standard	Name
AD 2000 Code HP 110 R	Construction regulations; Piping made of glass reinforced thermosetting plastics (GRP) with and without liner
BS 7159:1989	Code of practice for design and construction of glass-reinforced plastics (GRP) piping systems for individual plants or sites
BS 8010-2.5:1989	Code of practice for piping systems. Piping systems on land: design, construction and installation. Glass reinforced thermosetting plastics
DIN 16867	Glass fiber reinforced polyester resin (UP-GF) pipe, fittings and joints for use in chemical piping systems; Technical delivery conditions
DIN 16871	Centrifugally cast glass fiber reinforced epoxy resin (EP-GF) pipe; Dimensions
DIN 16964	Wound glass fiber reinforced polyester resins (UP-GF) pipe; general quality requirements and testing
DIN 16965-1	Wound glass fiber reinforced polyester resin (UP-GF); pipe, Type A pipe, dimensions
DIN 16965-2	Wound glass fiber reinforced polyester resin (UP-GF); pipe, Type B pipe, dimensions
DIN 16965-4	Wound glass fiber reinforced polyester resin (UP-GF); pipe, Type D pipe, dimensions
DIN 16965-5	Wound glass fiber reinforced polyester resin (UP-GF); pipe, Type E pipe, dimensions
DIN 16966-1	Glass fiber reinforced polyester resin (UP-GF) pipe fittings and joint assemblies; fittings; general quality requirements and testing
DIN 16966-2	Glass fiber reinforced polyester resin (UP-GF) pipe fittings and joints; Elbows, Dimensions
DIN 16966-4	Glass fiber reinforced polyester resin (UP-GF) pipe fittings and joints; Tees, Nozzles, Dimensions
DIN 16966-5	Glass fiber reinforced polyester resin (UP-GF) pipe fittings and joints; Reducers, Dimensions
DIN 16966-6	Glass fiber reinforced polyester resin (UP-GF) pipe fittings and joint assemblies; collars, flanges, joint rings, dimensions
DIN 16966-7	Pipe joints and their elements of glass fiber reinforced polyester resins - Part 7: Bushings, flanges, flanged and butt joints; general quality requirements and test methods
DIN 16966-8	Glass fiber reinforced polyester resin (UP-GF) pipe fittings and joints; Laminated joints; Dimensions
DIN 16967-2	Glass fiber reinforced epoxy resin (EP-GF) pipe fittings and joints; Elbows, Tees, Dimensions
DIN 53769-1	Testing of glass fiber reinforced plastics pipe; determination of the longitudinal shear strength of type B pipe fittings

## 4 Material Selection – Chemical Resistance

### 4.1 Introduction

Pipes made from plastics are used not only for drinking water, water for general use and wastewater, but also for transporting aggressive liquids and gases. Today expensive pipe designs, such as lined metal, ceramic or glass pipe can in many cases be replaced by plastic systems. Questions regarding the chemical resistance of piping materials to media are as important as the mechanical parameters for the installation of the piping system.

GF Piping Systems attempts to present resistance statements in order to identify the best suitable material for your application.

The recommendations given in the ChemRes Plus database are not only based upon the long and extensive applicational experience of GF but origin as well from tests in GF-own laboratories. Such tests may have been initiated by particular customer or general market demands.

Data can furthermore derive from national or international cooperations with scientific institutes and, if necessary, ISO or standardization authorities.

In any case we seek to give our recommendations as close to the individual application as possible. This includes statements to long-term stability, nature of media impact, hints to static and dynamic utilization, limits of process conditions and e.g. the impact of single, alternating or mixed media.

**i** GF Piping Systems' service comprises personal contact on site at the customer as well as by phone, email or via web pages as the ChemRes Plus database. Statements about the chemical resistance of plastics to media and materials not listed in the ChemRes Plus database can be requested from GF Piping Systems.

The GF ChemRes Plus database for the chemical resistance of plastic piping materials is subject to frequent updating and addition. Please be aware that the chemical resistance statements cannot consider the following aspects:

- Influence of synergistic effects
- Influence of dynamic effects
- Influence of long-term effects
- Behavior of media mixtures or alternating filling of piping systems
- Type of corrosion/damage

Information about the permissible operating pressure

### **!** Guarantee and liability claims

The statements in this chapter concerning chemical resistance of materials must be validated for any specific use case and do not allow any inference of guarantee and/or liability claims. The function of valves depends not only on the chemical resistance of the material and the gaskets, but on a number of additional factors. For this reason, it is not possible to unrestrictedly apply this information to valves made of the same material.

GF Piping Systems refers to the General Terms and Conditions of Sale. Subject to change without notice.

### 4.1.1 General information regarding chemical resistance

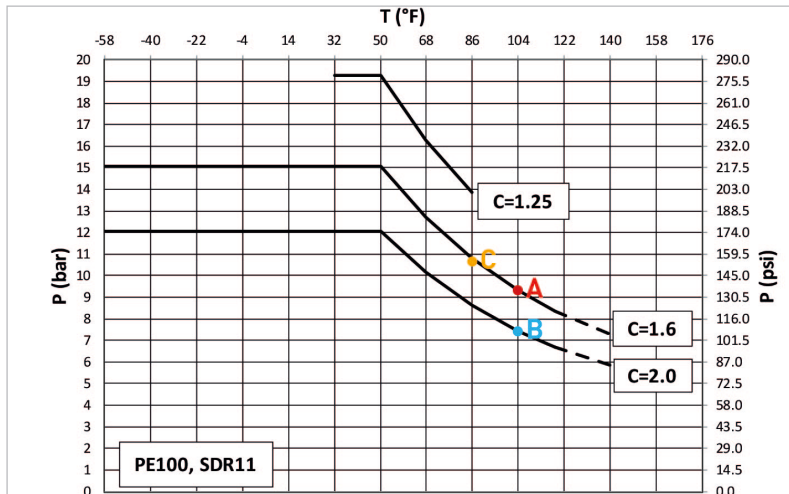
#### De-rating factor

The pressure-temperature diagrams of GF Piping Systems cover a service life of 25 years. They apply to water or aqueous solutions that do not impact the material properties.

Some media can affect the mechanical stability of piping materials without chemically attacking the material, e.g. through permeation or swelling. If pipe are exposed to elevated pressure and temperatures, the service life of the system may be reduced. A de-rating factor reduces the maximum pressure or temperature of a system.

Reduction factors are > 1, generally between 1.1 and 1.3, in a few cases higher.

#### Example



✓ An aqueous medium in a PE piping system can be operated with a maximum of 9 bar at a temperature of 40 °C (point A in the pressure-temperature diagram) at a service life of 25 years.

37 % hydrochloric acid has a reduction factor of 1.2 for PE. The maximum operating pressure at 40°C for the same service life (point B) can be calculated:

$$\frac{9}{1.2} = 7.5 \text{ bar}$$

Conversely, the maximum operating temperature can be determined at a given pressure (point C):

$$9 \cdot 1.2 = 10.8 \text{ bar}$$

A pressure of 10.8 bar on the SDR11 line corresponds to a temperature of approx. 30 °C.

#### Solvent cement joints with Tangit / DTX cement

Piping systems of ABS, PVC-U and PVC-C are preferentially cemented with Tangit. Some aggressive media at higher concentrations do, however, require DTX as a cement with a higher chemical resistance.

The use of DTX results in a few limitations:

- De-rating factor of 1.6 as specified in the data table
- Maximum application temperature

The following media or concentrations require a cement joint with DTX:

Medium	Concentration	De-rating factor	Temperature
Sulfuric acid	> 70 - 93 % H <sub>2</sub> SO <sub>4</sub>	AF: 1.6 (> 70 - 78 %) AF = 2 (> 78 %)	max. 60 °C max. 40 °C
Hydrochloric acid	> 25 - 37 % HCl	AF: 1.6	max. 60 °C
Nitric acid	> 20 - 55 % HNO <sub>3</sub>	AF: 1.6	max. 60 °C (> 20 - 30 %) max. 40 °C (>30 %)
Sodium- / Potassium hypochlorite	> 6 - 15 % NaOCl / KOCl	AF: 1.6	max. 40 °C
Hydrogen peroxide	> 5 - 70 % H <sub>2</sub> O <sub>2</sub>	AF: 1.6	max. 40 °C
Hydrofluoric acid	</= 40% HF	AF: 1.6	max. 40 °C

Dytex is recommended exclusively for sulfuric acid > 93 – 98 %, chromic acid ≥ 10 % CrO<sub>3</sub>, chromium sulfuric acid ≥ 70 % H<sub>2</sub>SO<sub>4</sub> + 5 % K<sub>2</sub>Cr<sub>2</sub>O<sub>7</sub>/Na<sub>2</sub>Cr<sub>2</sub>O<sub>7</sub>, and nitric acid > 55 – 65 %. The maximum temperature for Dytex adhesives is 40 °C.

The de-rating factor 1.6 reduces the maximum stress of a pressure level of PN16 to PN10, i.e. maximum 10 bar at a given temperature. For pressure levels of PN10 or lower, the reduction factor is no longer applied.

**!** Due to the unique properties of DTX, a special processing technique is required. For additional information, see Planning Fundamentals, chapter 12, "Jointing technology".

## Gaskets

Below are general guidelines for the use of sealing materials for this purpose:

Material	Composition	Remarks	Maximum temperature	
			Constant	Short term
EPDM	Ethylene-propylene-co-polymer	<ul style="list-style-type: none"> <li>Generally applicable for alkaline and weak acidic media</li> <li>Good resistance to aggressive media</li> <li>Unsuitable for oils and greases</li> </ul>	90 °C	120 °C
FKM, FFKM	Fluorine elastomers (Viton, Kalrez)	<ul style="list-style-type: none"> <li>Generally applicable for acidic media</li> <li>High resistance to many solvents</li> </ul>	150 °C	200 °C
NBR	Nitrile butadiene elastomer	<ul style="list-style-type: none"> <li>Good resistance to oils and fuels</li> <li>Unsuitable for oxidizing substances</li> </ul>	90 °C	120 °C
PTFE	Polytetrafluoroethylene	<ul style="list-style-type: none"> <li>Resistant to all chemicals in this list</li> </ul>	250 °C	300 °C

The selection of the sealing material depends not only on aspects of chemical resistance, but also on mechanical influences.

## Easily flammable substances

Besides questions concerning the chemical resistance many organic media require special safety measures when dimensioning piping systems due to their high flammability.

The recommendations of the ChemRes Plus database refer exclusively to the chemical resistance of the media with the corresponding materials and in no way replace technical instructions or safety guidelines for the design of piping systems. Corresponding explanations can be found, e.g., in the ATEX, ASME, ASTM or NFPA guidelines.

**i** For general notes see Planning Fundamentals, chapter 4 "Dimensioning", section 2.5 "Plastic piping systems in highly combustible locations/transport of explosive media". However, these do not replace the detailed expertise of planning companies.



## Fusion joints

Fusion joints of the semi-crystalline thermoplastics PE, PP and PVDF have basically the same chemical resistance as the respective material. However, fusion joints can exhibit elevated pressure levels due to processes which can lead to smaller or larger cracks when exposed to crack-inducing media. To minimize these risks professional execution of the fusion is essential.

**i** For more information see the corresponding fusion technologies in Planning Fundamentals, chapter 4, section 5 "Jointing technology".

## Compressible media

Particular consideration and care is demanded for the design of plastic piping systems for gases or liquids with a considerable amount of dissolved gases with high vapour pressure.

Suitable materials for compressible media are not prone to brittle fracture. The materials of choice are ductile materials like PE and ABS. PP-H, PVC-U, PVC-C and PVDF are limited to process pressures  $\leq 0.5$  bar. Higher pressures are possible if secondary containment piping systems are applied, the outer piping of which provides protection against fragments from fractures.

Low boiling media or fluids with dissolved gases may generate considerable pressure increases under unfavourable operation conditions. Typical examples are hydrochloric acid or ammonium hydroxide at critical pH. Those pressures may exceed the maximum pressure values for the given piping system and need to be prevented by suitable process conditions (e.g. adaption of the temperature profile).

Under conditions of high flow speeds several non-aqueous media may generate electrostatic charge. In combination with flammable media this can provide additional hazards to the layout of the piping systems. Experienced engineering companies are able to meet these challenges.

## 4.2 ChemRes Plus online database

### 4.2.1 General information

The ChemRes Plus database is supposed to serve as an orientation for the choice of a suitable piping material. Since the suitability of a material is not only determined by the pure chemical resistance profile but also by process details which are usually not referred to in lists, it is always recommended to contact the GF specialists for an individual and more detailed assessment.

The ChemRes Plus database is available at [www.gfps.com/tools](http://www.gfps.com/tools)

Call up the database at [www.gfps.com/tools](http://www.gfps.com/tools) under Chemical Resistance.



**Media List**

Click here to select media. ▼

**Materials**

15 selected ▼

▶ Print
▶ Contact

In order to locate a specific medium, click on the grey bar of the **Media List** and enter the corresponding name, e.g. sodium hypochlorite.

Synonyms can also be entered as an alternative, e.g. chlorine bleach.

**Media List**

Click here to select media. ▼

Search  ✕ Uncheck all

- Sodium hypochlorite
- Sodium Hypochlorite from electrochlorination plants
- Sodium hypochlorite, < 0.5 ppm active chlorine
- Sodium hypochlorite, <= 6 % active chlorine
- Sodium hypochlorite, > 6 % active chlorine
- Sodium hypochlorite, 0.5 - 2 ppm active chlorine

**Materials**

15 selected ▼

To track the resistance profile of one or several materials choose the appropriate sections in the list **Materials**. The groups Piping Systems and Jointing of PVC are pre-selected.

**Media List**

Click here to select media. ▼

▶ Print    ▶ Contact

**Technical explanations**

**Materials**

15 selected ▼

✓ Select all ✕ Uncheck all ✕

- ✓ Piping Systems
  - ✓ PVC-U
  - ✓ PVC-C
  - ✓ ABS
  - ✓ PE
  - ✓ PP
  - ✓ PVDF
  - ✓ ECTFE
  - ✓ EPDM
  - ✓ FKM
  - ✓ NBR
- ✓ Jointing of PVC
  - ✓ Tangit PVC-U
  - ✓ Tangit PVC-C

After selecting the required materials and media the resistance profiles of the chosen materials are shown.

Media List  
1 selected
Materials  
15 selected

Print
Contact

**Sodium hypochlorite, > 6 % active chlorine**

**Formula:** NaOCl      **Synonyme:** Eau de labarraque, Eau de javelle

**Comments:** PVC: DTX Solvent cement. De-Rating factor: 1.6. Unprofessional cementing can reduce the service life of the pipeline especially for aggressive media. You may contact GF for additional information.

Piping Systems	20 °C	40 °C	60 °C	80 °C	100 °C	120 °C	140 °C
PVC-U	+(1.1)	+(1.1)	○				
PVC-C	○						
ABS	-						
PE	○						
PP	-						
PVDF	-						
ECTFE	++	++	++	○	○	-	
EPDM	++	++	○	○	○	-	
FKM	○	○					
NBR							

Jointing of PVC	20 °C	40 °C	60 °C	80 °C	100 °C	120 °C	140 °C
Tangit PVC-U	○	-					
Tangit PVC-C	-						
Tangit DTX	+(1.6)	+(1.6)	-				
Tangit RAPID							
Tangit Plus							

**Classification**

The chemical resistance of materials in the ChemRes Plus database is classified by using the following symbols:

Symbol	Meaning	Description
++	Recommended	The material is unrestrictedly suitable for the medium within the temperature limits applicable for the medium. There is no or only a very small negative effect on the material properties.
+ (AF)	Recommended with restrictions	The material is suitable for the medium; however, the maximum temperature or pressure is subject to reduction by an individual de-rating factor. See the section "De-rating factor". Alternatively a flat maximum pressure or temperature may apply.
○	Consultation with GF Piping Systems	Starting at this temperature, the use of the material is limited. We recommend consulting GF to obtain an individual assessment of the conditions.
-	Not suitable	The material is not suitable for the application or only under special conditions since the medium considerably impacts material properties.



# Design and Installation of Plastic Piping Systems

## Content

<b>1</b>	<b>Symbols, SI-Units and Conversion Tables .....</b>	<b>129</b>
1.1	Metric and British system of units.....	129
1.2	Identification .....	130
1.3	Symbols (DIN 2429, ISO 14617).....	132
1.4	Abbreviations and units of measure .....	133
1.5	SI units.....	134
1.6	Conversion tables .....	136
<b>2</b>	<b>Pipeline Design .....</b>	<b>138</b>
2.1	Long-term behavior of thermoplastic materials .....	138
2.2	Range of applications for pipe and fittings.....	156
2.3	Calculation of the allowable pressure/required wall thickness .....	168
2.4	Water hammer .....	170
2.5	Piping systems in highly combustible locations/transport of explosive media .....	174
2.6	Piping systems for transporting compressed air .....	175
2.7	Piping systems under vacuum .....	177
2.8	Piping systems for surface finishing and varnishing technology .....	179
2.9	Gaskets .....	179
<b>3</b>	<b>Hydraulic Calculation and Pressure Losses.....</b>	<b>180</b>
3.1	Hydraulic calculation.....	180
3.2	Pressure loss .....	187
<b>4</b>	<b>Installation .....</b>	<b>190</b>
4.1	z-dimension method .....	190
4.2	Handling plastic pipeline systems.....	194
4.3	CAD library.....	196
4.4	Length changes and flexible sections.....	197

4.5	Installation .....	216
4.6	Pipe bracket distances and installation of pipes .....	220
4.7	Pressure and leak test.....	234
4.8	Modifications, repairs, commissioning.....	241
<b>5</b>	<b>Joining technology – Mechanical joints .....</b>	<b>242</b>
5.1	Overview.....	242
5.2	Flange connections.....	243
5.3	Unions joining plastic piping components.....	251
5.4	Adaptor unions for connections between plastic and metal pipe.....	252
5.5	Transitional and threaded fittings.....	253
5.6	Adaptor pipe fittings for connecting plastic piping systems and metal threads.....	254
5.7	Hose connections to plastic piping systems.....	254
5.8	SYGEF Plus and PROGEF Natural sanitary adaptor for standard TriClamp connections.....	255
5.9	Universal coupling.....	255
<b>6</b>	<b>Joining technology – Cementing .....</b>	<b>256</b>
6.1	Solvent cement jointing using Tangit.....	256
6.2	Solvent-free cement jointing Tangit RAPID (2-component cement) .....	266
6.3	Retrofit of branch fittings into an existing ABS, PVC-U or PVC-C piping system .....	272
6.4	Cementing different pipe materials.....	274
<b>7</b>	<b>Joining technology – Welding.....</b>	<b>275</b>
7.1	Infrared fusion jointing .....	275
7.2	Butt fusion jointing (heating element butt fusion conventional butt fusion).....	277
7.3	Socket fusion jointing (heating element socket fusion).....	278
7.4	Electrofusion (heating element fusion joints).....	279
7.5	BCF Plus fusion jointing (bead and crevice-free).....	281
6.3	Retrofit of branch fittings into an existing ABS, PVC-U or PVC-C piping system .....	272
6.4	Cementing different pipe materials.....	274

# 1 Symbols, SI-Units and Conversion Tables

## 1.1 Metric and British system of units

The metric system uses both the pipe outside diameter (d in mm) and the nominal diameter (DN in mm) for the size definition. The pipe outside diameter is the specified real outside diameter of the pipe. The nominal diameter classifies the inner diameter and makes it comparable with metal pipe. The DN numbers of metal and plastic pipe are the same.

Inch systems are only designated by the nominal diameter (in inches and fractions of it). The dimensions of the imperial pipe (to BS) and the American pipe (to ANSI / ASME) are very similar, but not identical.

Metric and inch pipe of same nominal size can be connected by adaptors.

### Comparison of metric and Inch based pipe sizes

Metric sizes		Inch sizes
Pipe outer diameter d (mm)	Nominal diameter DN (mm)	Nominal diameter DN (Inch)
10	6	1/8
12	8	1/4
16	10	3/8
20	15	1/2
25	20	3/4
32	25	1
40	32	1 1/4
50	40	1 1/2
63	50	2
75	65	2 1/2
90	80	3
110	100	4
125	100	
125 <sup>1)</sup>	125	
140	125	5
160	150	6
180 <sup>2)</sup>	150	
200	200	8
225	200	8
250	250	
280	250	10
315	300	12
355	350	14
400	400	16
450	450	18
450	500	
500	500	20
560	600	
630	600	24
710	700	28
800	800	32
900	900	36
1'000	1'000	40

<sup>1)</sup> Solvent cement socket systems only

<sup>2)</sup> Butt fusion systems only

## 1.2 Identification

### 1.2.1 Fittings

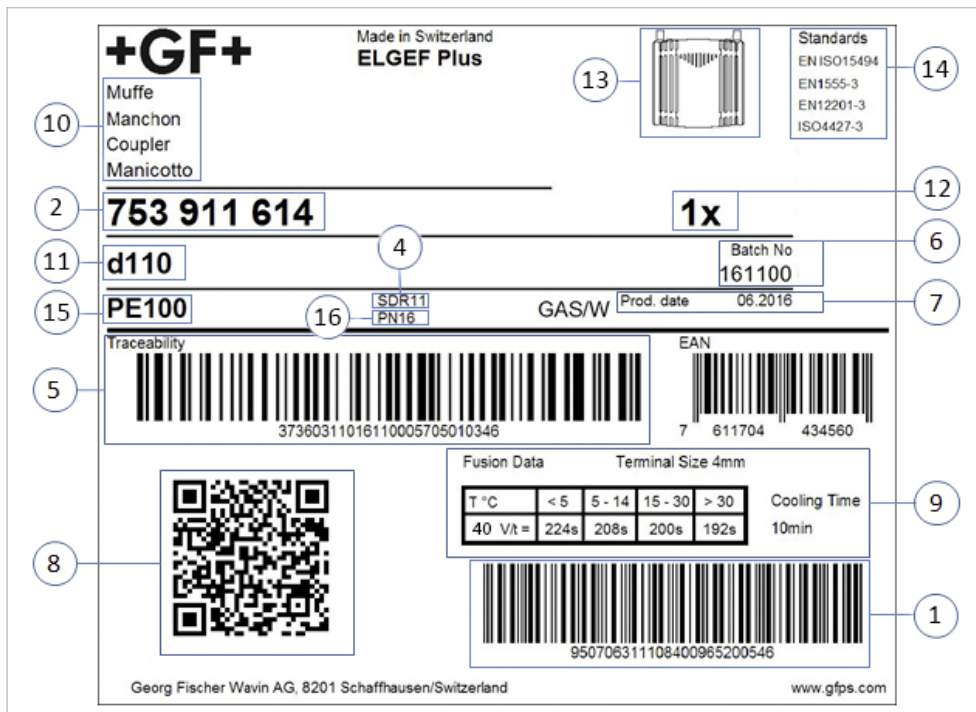
Packaging label using PE electrofusion fitting with the most comprehensive content as an example

Barcode label



- 1 Welding-Barcode, ISO 13950
- 2 Item number
- 3 Cooling time
- 4 SDR-Class of the Pipe
- 5 Traceability code, ISO 12176
- 6 Batch-Nr.
- 7 Production month and year YY.XXX
- 8 Unitary QR-Code
- 9 Manual Welding data
- 10 Product name
- 11 Dimension
- 12 Number of items
- 13 Product picture
- 14 Approval/Norms
- 15 Material
- 16 Max. bleed pressure
- 17 Color bar:  
yellow = Gas,  
blue = Water

Bag label

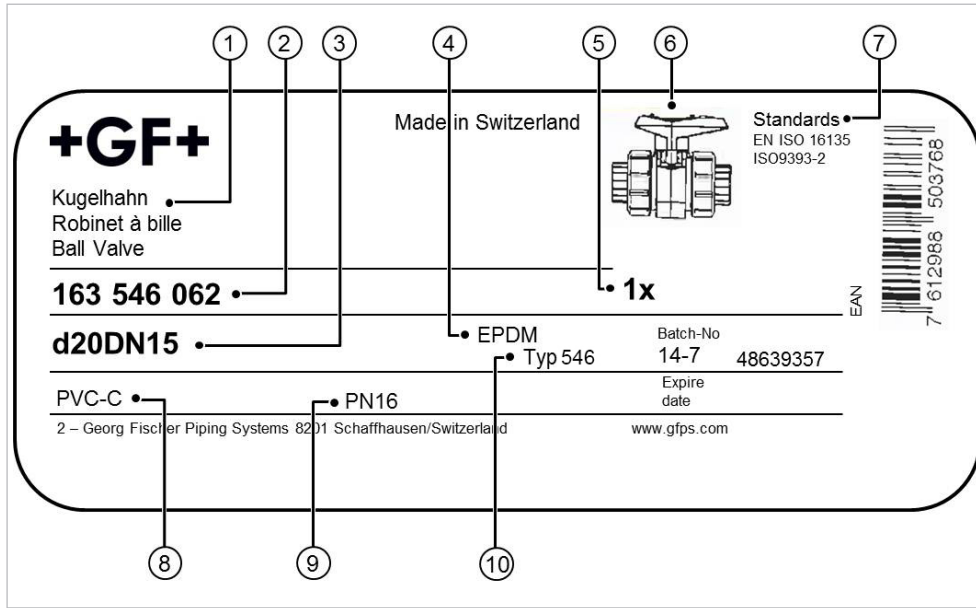


Further information to each product can be downloaded with the unitary QR-Codes from the database of our online-services. In this way a consolidation of all information from production and installation is possible in order to generate complete network documentation.



1.2.2 Valves

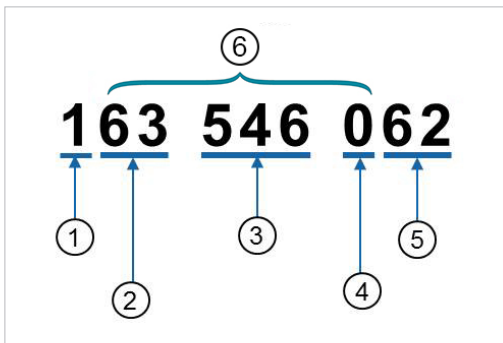
Packaging label using ball valve type 546 as an example



- 1 Product name
- 2 Code number
- 3 Dimension
- 4 Gasket material
- 5 Packaged number of units
- 6 Product image
- 7 Approvals/standards
- 8 Valve material
- 9 Nominal pressure
- 10 Type

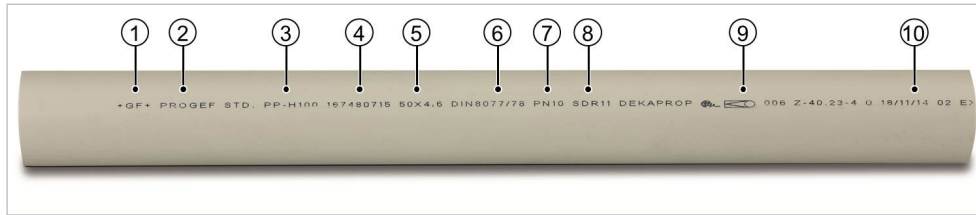
Code numbers

The code numbers typically consist of the following:



- 1 Class
- 2 Material
- 3 Type
- 4 Variant
- 5 Size

### 1.2.3 Pipe



Nr.	Designation type	Example
1	Manufacturer's logo	<b>+GF+</b>
2	Name of piping system	PROGEF
3	Material	PP-H
4	Code number	167480715
5	Outside diameter (d) x wall thickness (e)	50 x 4.6
6	Standard/approval	DIN 8077/78
7	Pressure (PN)	PN10
8	SDR	11
9	Approval symbol	
10	Date of manufacture (DD/MM/YY)	16/11/14

### 1.3 Symbols (DIN 2429, ISO 14617)

Symbols	Connection	Symbols	Valves
	Pipe		Valve, general
	Pipe, insulated		Ball valve
	Crossing without connection		Diaphragm valve
	Tee		Flap trap
	Flange connection		Pump
	Hose		Valve, flanged
	Slope		Butterfly valve
	Connection		Check valve
	Reduction		Actuator
	Container, flanged		

## 1.4 Abbreviations and units of measure

### 1.4.1 Abbreviations for materials

Abbreviation	Name
ABS	Acrylonitrile-butadiene-styrene
CR	Chloroprene rubber, e.g. neoprene
ECTFE	Ethylene-chlorotrifluoroethylene
EPDM	Ethylene propylene rubber
FKM	Fluorinated rubber, e.g. Viton
GRP	Glass-fiber reinforced plastics
Ms	Brass
NBR	Nitrile rubber
NR	Natural rubber
PB	Polybutylene
PE	Polyethylene
PE-X	Crosslinked polyethylene
PP	Polypropylene
PTFE	Polytetrafluoroethylene
PVC	Polyvinylchloride
PVC-C	Polyvinylchloride postchlorinated (increased chlorine content)
PVC-U	Polyvinylchloride unplasticised
PVDF	Polyvinylidene fluoride
MCI	Malleable cast iron
UP-GF	Unsaturated polyester resin, fiberglass-reinforced

### 1.4.2 Abbreviations for procedures

Abbreviation	Name	
C	Design factor	Consideration of variations in material composition and pipe manufacturing
S	Pipe series	Wall thickness of a pipe with a given outer diameter
SDR	Standard dimension ratio	Ratio of diameter to wall thickness
MFR	Melt flow rate	Viscosity of the molten plastic material
MRS	Minimum required strength	Pressure resistance of a pipe material

### 1.4.3 Dimensions and units

Abkürzung	Bezeichnung
d, d1, d2, d3, d4	Outer diameter
DN	Nominal diameter
SC	Size of hexagon head bolts
AL	Number of bolt holes
s	Wrench size
g	Weight in grams
SP	Number of items per standard package
GP	Number of items per large package
e	Wall thickness of pipe
PN	Nominal pressure at 20 °C, water (50 years)
Rp	Cylindrical inner pipe thread acc. to ISO 7-1
R	Conical outer pipe thread acc. to ISO 7-1
ppm	Parts per million
1 bar	= 0.1 N/mm <sup>2</sup> = 0.1 Mpa = 14.504 psi

Dimensions must be listed in mm and/or inch and refer to nominal or standard dimension. Subject to construction and design changes.

## 1.5 SI units

### 1.5.1 SI base units

Base size Name	Sign	SI base units Name	Sign
Length	l	Meter	m
Mass	m	Kilogram	kg
Time	t	Second	s
Electric current	I	Ampere	A
Thermodynamic temperature	T	Kelvin	K
Amount of substance	n	Mole	mol
Luminous intensity	ln	Candela	cd

### 1.5.2 Internationally defined prefixes

Meaning	Prefix Name	Sign	Factor as Decimal power	Decimal number
Quintillion	exa	E	10 <sup>18</sup>	= 1'000'000'000'000'000'000
Quadrillion	peta	P	10 <sup>15</sup>	= 1'000'000'000'000'000
Trillion	tera	T	10 <sup>12</sup>	= 1'000'000'000'000
Billion	giga	G	10 <sup>9</sup>	= 1'000'000'000
Million	mega	M	10 <sup>6</sup>	= 1'000'000
Thousand	kilo	k	10 <sup>3</sup>	= 1'000
Hundred	hecto	h	10 <sup>2</sup>	= 100
Ten	deka	da	10 <sup>1</sup>	= 10
Tenth	deci	d	10 <sup>-1</sup>	= 0.1
Hundredth	centi	c	10 <sup>-2</sup>	= 0.01
Thousandth	milli	m	10 <sup>-3</sup>	= 0.001
Millionth	micro	μ	10 <sup>-6</sup>	= 0.000'001
Billionth	nano	n	10 <sup>-9</sup>	= 0.000'000'001
Trillionth	pico	p	10 <sup>-12</sup>	= 0.000'000'000'001
Quadrillionth	femto	f	10 <sup>-15</sup>	= 0.000'000'000'000'001
Quintillionth	atto	a	10 <sup>-18</sup>	= 0.000'000'000'000'000'001

## 1.5.3 Units

Size	Sign	SI unit	Permissible units outside of SI	Conversion into corresponding SI unit and relationships	Units and conversions no longer permissible
Length	l	m			1" = 0.0254 m 1 Sm = 1'852 m
Area	A	m <sup>2</sup>			1 b = 10 <sup>-28</sup> m <sup>2</sup> 1 a = 10 <sup>2</sup> m <sup>2</sup> 1 ha = 10 <sup>4</sup> m <sup>2</sup> qm, qdm, qcm
Volume	V	m <sup>3</sup>	l	1 l = 10 <sup>-3</sup> m <sup>3</sup>	
Solid angle	Ω	SR		1 sr = 1 m <sup>2</sup> /m <sup>2</sup>	1° = 3.046 • 10 <sup>-4</sup> sr 1 g = 2.467 • 10 <sup>-4</sup> sr
Time	t	s	min h d	1 min = 60 s 1 h = 3'600 s 1 d = 86'400 s	
Frequency	f	Hz		1 Hz = 1/s	
Speed, rotational frequency	n	s <sup>-1</sup>	min <sup>-1</sup> U/min	1 min <sup>-1</sup> (1/60) s <sup>-1</sup> 1 U/min = 1 (1/min)	
Velocity	v	m/s	km/h	1 km/h = (1/3.6) m/s	
Acceleration	g	m/s <sup>2</sup>		Normal-Fallbeschleunigung g <sub>n</sub> = 9.80665 m/s <sup>2</sup>	1 Gal = 10 <sup>-2</sup> m/s <sup>2</sup>
Mass	m	kg	t	1 t = 10 <sup>3</sup> kg	1 q = 50 kg
Density	ρ	kg/m <sup>3</sup>	t/m <sup>3</sup> kg/l	1 t/m <sup>3</sup> = 1'000 kg/m <sup>3</sup> 1 kg/l = 1'000 kg/m <sup>3</sup>	
Moment of inertia	J	kg • m <sup>2</sup>			1 kp • m s <sup>2</sup> = 9.81 kg • m <sup>2</sup>
Force	F	N		1 N = 1 kg • m/s <sup>2</sup>	1 dyn = 10 <sup>-5</sup> N 1 p = 9.80665 • 10 <sup>-3</sup> N 1 kp = 9.80665 N
Torque	M	N • m			1 kpm = 9.80665 Nm 1 Nm = 0.7375 lb-ft
Pressure	p	Pa	bar	1 Pa = 1 N/m <sup>2</sup> 1 bar = 10 <sup>5</sup> Pa	1 atm = 1.01325 bar 1 at = 0.980665 bar 1 Torr = 1.333224 • 10 <sup>-3</sup> bar 1 m WS = 98.0665 • 10 <sup>-3</sup> bar 1 mm Hg = 1.333224 • 10 <sup>-3</sup> bar
Stress	σ	N/m <sup>2</sup> Pa		1 N/m <sup>2</sup> = 1 Pa	1 kp/m <sup>2</sup> = 9.80665 N/m <sup>2</sup> 1 kp/cm <sup>2</sup> = 98.0665 • 10 <sup>-3</sup> N/m <sup>2</sup> 1 kp/mm <sup>2</sup> = 9.80665 • 10 <sup>-6</sup> N/m <sup>2</sup>
Dynamic viscosity		Pa • s		1 Pa • s = 1 N • s/m <sup>2</sup>	1 P (Poise) = 10 <sup>-1</sup> Pa • s
Kinematic viscosity		m <sup>2</sup> /s		1 m <sup>2</sup> /s = 1 Pa • s • m <sup>3</sup> /kg	1 St (Stokes) = 10 <sup>-4</sup> m <sup>2</sup> /s
Work, energy	W E	J	eV W • h	1 J = 1 Nm = 1 WS 1 W • h = 3.6 KJ	1 cal = 4.1868 J 1 kpm = 9.80665 J 1 erg = 10 <sup>-7</sup> J
Electric charge	Q	C		1 C = 1 A • s	
Electric voltage	U	V		1 V = 1 W/A	
Electric current	I	A			
Electric resistance	R	Ω		1 Ω = 1 V/A	1 Ω abs = 1 Ω
Power	P	W		1 W = 1 J/s = 1 Nm/s 1 W = 1 V • A	1 PS = 735.498 W 1 kcal/h = 1.163 W 1 kpm/s = 10 W
Electric capacitance	C	F		1 F = 1 C/V	
Magnetic field strength	H	A/m			1 Oe = 79.5775 A/m
Magnetic flux	Φ	Wb		1 Wb = 1 V • s	1 Mx = 10 <sup>-8</sup> Wb
Magnetic flux density	B	T		1 T = 1 Wb/m <sup>2</sup>	1 G = 10 <sup>-4</sup> T
Inductance	L	H		1 H = 1 Wb/A	
Electric conductance	G	S		1 S = 1/Ω	
Thermodynamic temperature	T	K		Δ 1 °C = Δ 1 K 0 °C = 273.15 K	
Celsius; temperature	t, δ	°C		Δ 1 °C = Δ 1 K 0 K = -273.15 °C	
Thermal capacity	C	J/K			1 Kcl/grad = 4.1868 • 10 <sup>-3</sup> J/K 1 Cl = 4.1868 J/K

## 1.6 Conversion tables

### 1.6.1 Viscosities

Kinematic viscosity Centistokes density	Absolute viscosity centipoise	Degree Engler	Saybolt Universal second (SSU)	Redwood 1 second (standard)	Saybolt Furool second	Ford Cup no. 4 second	Degree Barbey	Cup no. 15 second	Absolute viscosity poise density 1.0	Kinematic viscosity $m^2/s$
1.0	1.0	1.0	31	29					0.01	$1.0 \times 10^{-6}$
2.0	2.0	1.1	34	30			3'640		0.02	$2.0 \times 10^{-6}$
3.0	3.0	1.2	35	33			2'426		0.03	$3.0 \times 10^{-6}$
4.0	4.0	1.3	37	35			1'820			$4.0 \times 10^{-6}$
5.0	5.0	1.39	42	38			1'300		0.05	$5.0 \times 10^{-6}$
6.0	6.0	1.48	45.5	40.5			1'085		0.06	$6.0 \times 10^{-6}$
7.0	7.0	1.57	48.5	43			930		0.07	$7.0 \times 10^{-6}$
8.0	8.0	1.65	53	46			814		0.08	$8.0 \times 10^{-6}$
9.0	9.0	1.74	55	48.5			723		0.09	$9.0 \times 10^{-6}$
10	10	1.84	59	52			650		0.10	$1.0 \times 10^{-5}$
20	20	2.9	97	85	15		320		0.2	$2.0 \times 10^{-5}$
40	40	5.3	185	163	21		159		0.4	$4.0 \times 10^{-5}$
60	60	7.9	280	245	30	18.7	106	5.6	0.6	$6.0 \times 10^{-5}$
80	80	10.5	370	322	38	25.9	79	6.7	0.8	$8.0 \times 10^{-5}$
100	100	13.2	472	408	47	32	65	7.4	1.0	$1.0 \times 10^{-4}$
200	200	26.4	944	816	92	60	32.5	11.2	2.0	$2.0 \times 10^{-4}$
400	400	52.8	1'888	1'632	184	111	15.9	18.4	4.0	$4.0 \times 10^{-4}$
600	600	79.2	2'832	2'448	276	162	10.6	26.9	6.0	$6.0 \times 10^{-4}$
800	800	106	3'776	3'264	368	217	8.1	35	8.0	$8.0 \times 10^{-4}$
1'000	1'000	132	7'080	4'080	460	415	6.6	68	10	$1.0 \times 10^{-3}$
5'000	5'000	660	23'600	20'400	2'300	1'356	1.23	240	50	$5.0 \times 10^{-3}$
10'000	10'000	1'320	47'200	40'800	4'600	2'713		481	100	$1.0 \times 10^{-2}$
50'000	50'000	6'600	236'000	204'000	23'000	13'560		2'403	500	$5.0 \times 10^{-2}$

Absolute viscosity (centipoise) = kinematic viscosity (centistokes) • density over 50 centistokes - conversion to SSU à SSU = centistokes • 4.62

### 1.6.2 Flow volume

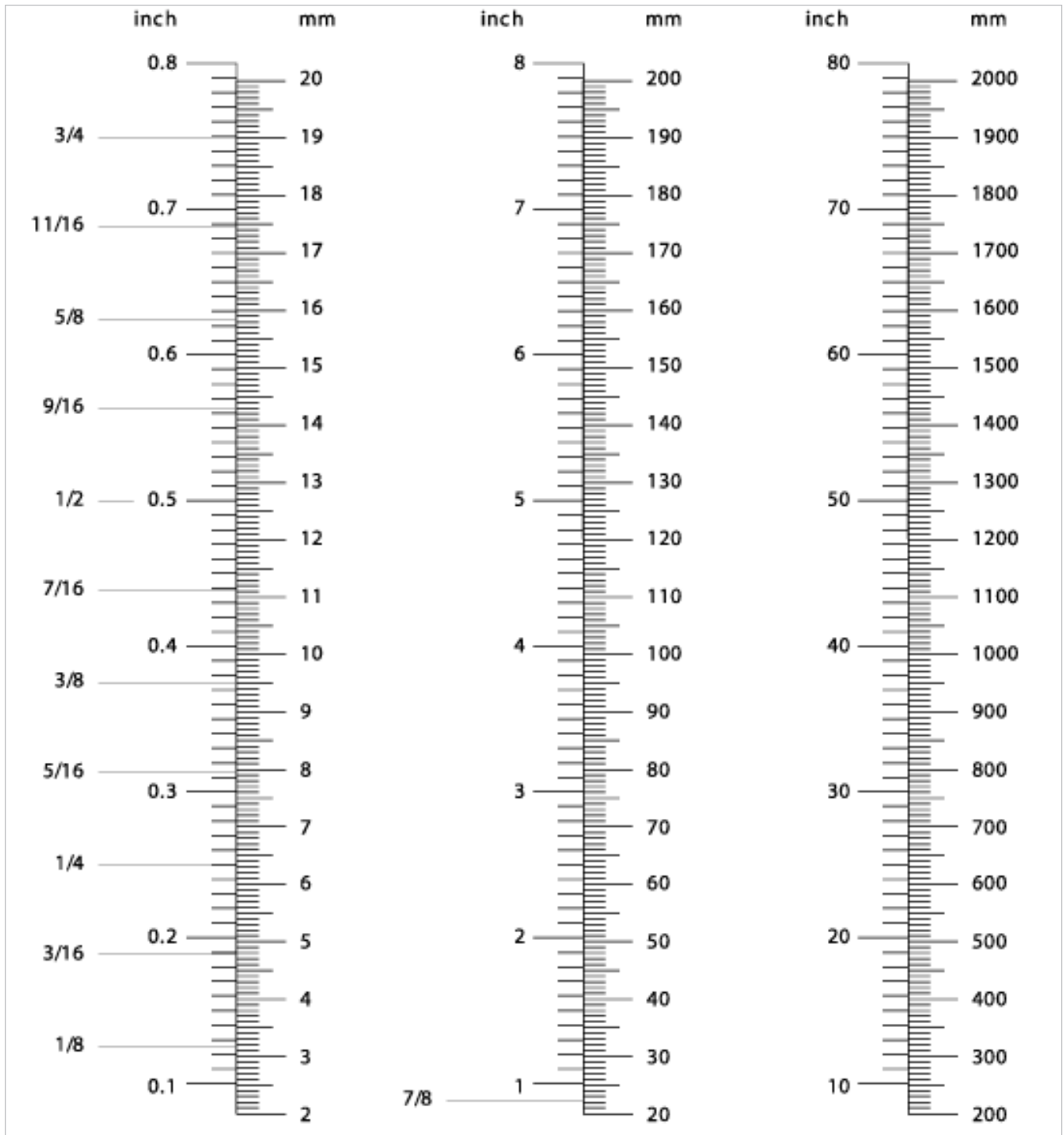
$m^3/h$	l/min	l/s	$m^3/s$	Imp. gal/min	US gal/min	cu. ft./h	cu. ft./s
1.0	16.67	0.278	$2.78 \cdot 10^{-4}$	3.667	4.404	35.311	$9.81 \cdot 10^{-3}$
0.06	1.0	0.017	$1.67 \cdot 10^{-5}$	0.220	0.264	2.119	$5.89 \cdot 10^{-4}$
3.6	60	1.0	$1.00 \cdot 10^{-3}$	13.20	15.853	127.12	$3.53 \cdot 10^{-2}$
3'600	60'000	1'000	1.0	13'200	15'838	127'118	35.311
0.2727	4.55	0.076	$7.58 \cdot 10^{-5}$	1.0	1.201	9.629	$2.67 \cdot 10^{-3}$
0.2272	3.79	0.063	$6.31 \cdot 10^{-5}$	0.833	1.0	8.0238	$2.23 \cdot 10^{-3}$
0.0283	0.47	0.008	$7.86 \cdot 10^{-6}$	0.104	0.125	1.0	$2.78 \cdot 10^{-4}$
101.94	1'699	28.32	$2.83 \cdot 10^{-2}$	373.77	448.8	3 600	1.0

1.6.3 Pressure and pressure heads

bar	kg/cm <sup>2</sup>	lbf/in <sup>2</sup>	atm	ft H <sub>2</sub> O	m H <sub>2</sub> O	mm Hg	in. Hg	kPa
1.0	1.0197	14.504	0.9869	33.455	10.197	750.06	29.530	100
0.9807	1.0	14.223	0.9878	32.808	10	735.56	28.959	98.07
0.0689	0.0703	1.0	0.0609	2.3067	0.7031	51.715	2.036	6.89
1.0133	1.0332	14.696	1.0	33.889	10.332	760.0	29.921	101.3
0.0299	0.0305	0.4335	0.0295	1.0	0.3048	22.420	0.8827	2.99
0.0981	0.10	1.422	0.0968	3.2808	1.0	73.356	2.896	9.81
13.3 · 10 <sup>-4</sup>	0.0014	0.0193	13.2 · 10 <sup>-4</sup>	0.0446	0.0136	1.0	0.0394	0.133
0.0339	0.0345	0.4912	0.0334	1.1329	0.3453	25.40	1.0	3.39
1.0 · 10 <sup>-5</sup>	10.2 · 10 <sup>-6</sup>	14.5 · 10 <sup>-5</sup>	9.87 · 10 <sup>-6</sup>	3.34 · 10 <sup>-4</sup>	10.2 · 10 <sup>-5</sup>	75.0 · 10 <sup>-4</sup>	29.5 · 10 <sup>-5</sup>	1.0

atm International standard atmosphere  
 kg/cm<sup>2</sup> Metric atmosphere

1.6.4 Conversion inch/mm



## 2 Pipeline Design

### 2.1 Long-term behavior of thermoplastic materials

One of the most important characteristics of plastic pipe is the realistic service life of a pipe that is subjected to internal pressure. This characteristic is referred to as long-term behavior. When determining the long-term behavior, the temperature and the flow medium play an essential role.

#### 2.1.1 MRS values

The following table shows the MRS values (Minimum Required Strength) for thermoplastic materials used in the construction of industrial piping systems.

The values are based on these standards:

- EN ISO 15493 (ABS, PVC-U, PVC-C)
- EN ISO 15494 (PB, PE, PP)
- EN ISO 10931 (PVDF; ECTFE in compliance)

Material	MRS value (MPa)
ABS	14
PE80	8
PE100	10
PP-H	10
PP-B	8
PP-R	8
PVC-U	25
PVC-C (pipe)	25
PVC-C (fitting)	20
PVDF	25
ECTFE	18

#### 2.1.2 Long-term behavior of ABS

##### Calculation (based on EN ISO 15493:2015)

The following log stress ologram shows the long-term behavior of ABS. For the temperature range from +10 °C to +60 °C, fracture lines are displayed. These are called LPL curves (Lower Predictable Limit); this means according to the definition that 97.5 % of all fracture points are on or above the corresponding curve.

Typically for amorphous thermoplastics like ABS, the long-term behavior shows straight lines. The curves are plotted in a double logarithmic diagram (i.e. not linear). Please take this into account when reading values for stress or time.

The long-term behavior was calculated by using the extrapolation method according to EN ISO 9080. With the following equation (4-parameter model), which was derived from that diagram, stress, temperature or time can be calculated for the temperature range of +10 °C to +60 °C.

$$\log t = -154.8961 - 35935.57 \cdot \frac{\log \sigma}{T} + 55180.34 \cdot \frac{1}{T} + 98.73749 \cdot \log \sigma$$

t Time to failure (h)

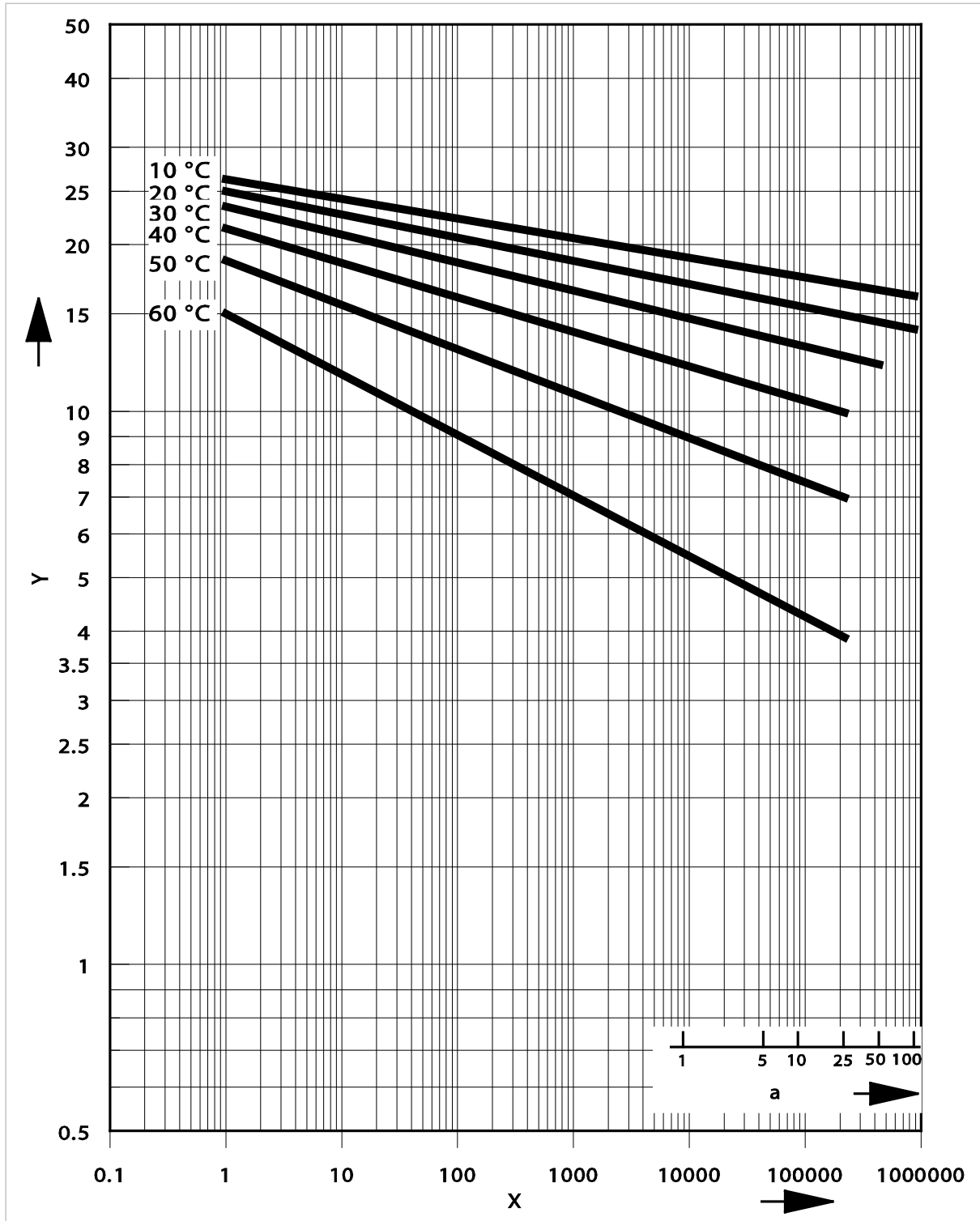
T Medium temperature (K)

$\sigma$  Hoop stress (MPa) (1 MPa = 1 N/mm<sup>2</sup>)

The pressure-temperature diagram shown for pipe and fittings made of ABS is derived from the long-term behavior, including the design factor, for a service life of 25 years.



Long-term behavior ABS (based on EN ISO 15493:2015)



Y Hoop stress (MPa) (1 MPa = 1 N/mm<sup>2</sup>)  
 X Time to failure (h)  
 a Years

### 2.1.3 Long-term behavior of PE

#### Calculation (based on EN ISO 15494:2015)

The following repeat of long-term behaviors of PE80 and PE100. For the temperature range from +10 °C to +80 °C, lines of fracture are displayed. These are called LPL curves (Lower Predictable Limit); this means according to the definition that 97.5 % of all fracture points are on or above the corresponding curve.

Straight lines represent the long term properties of PE in the hoop stress diagram.

The curves are plotted in a double logarithmic diagram (not linear), please take this into account when reading values for stress or time.

The long-term values have been calculated by using the extrapolation method according to EN ISO 9080. With the following equation (3-parameter model), which was derived from that diagram, stress, temperature or time can be calculated for the temperature range of +10 °C to 80 °C.

**First branch** (left-hand portion of the curves as shown in the following long-term behaviors)

#### PE100

$$\log t = -45.4008 + 28444.734 \cdot \frac{1}{T} - 45.9891 \cdot \log \sigma$$

#### PE80

$$\log t = -42.5488 + 24078.8 \cdot \frac{1}{T} - 37.5758 \cdot \log \sigma$$

#### PE63

$$\log t = -19.8823 + 8619.357 \cdot \frac{1}{T} - 3.039 \cdot \log \sigma$$

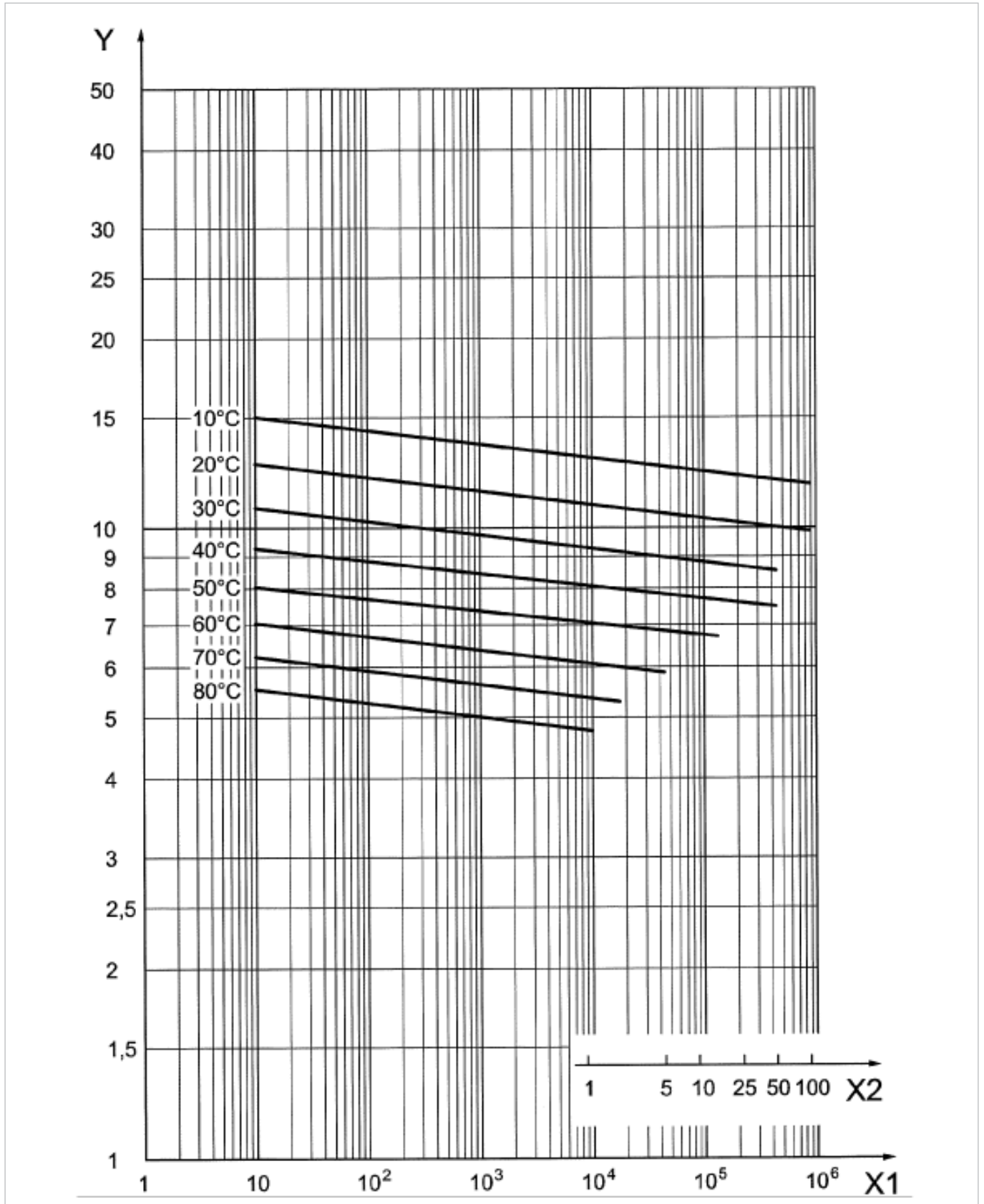
t Time to failure (h)

T Medium temperature (K)

$\sigma$  Hoop stress (MPa) (1 MPa = 1 N/mm<sup>2</sup>)

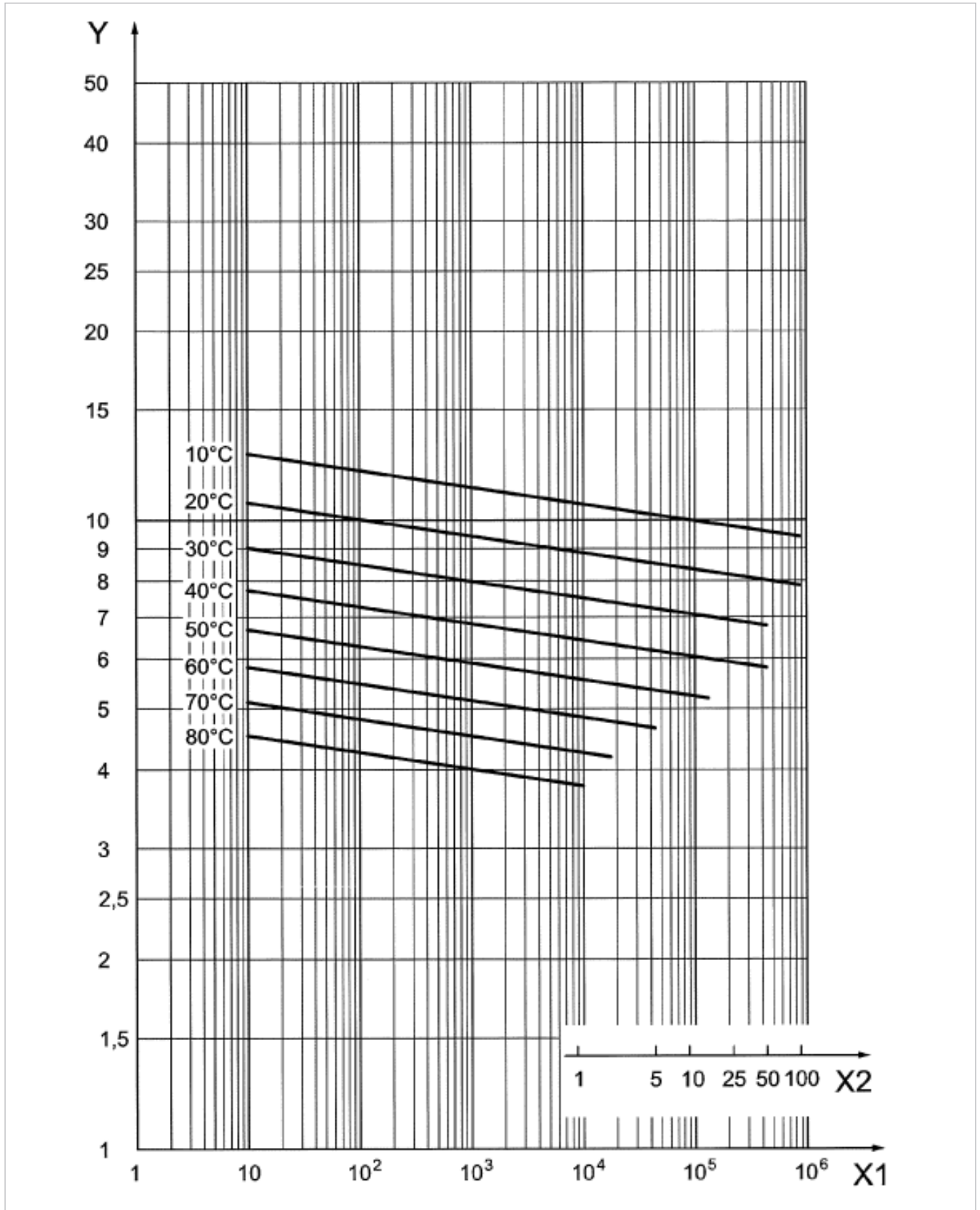
The pressure-temperature diagram that we provide for pipe and fittings made of PE80 and PE100 is derived from the long-term behavior, including the design factor, for a service life of 25 years.

Long-term behavior PE100 (EN ISO 15494:2015)



Y Hoop stress (MPa) (1 MPa = 1 N/mm<sup>2</sup>)  
 X1 Time to failure (h)  
 X2 Years

Long-term behavior PE80 (EN ISO 15494:2015)



Y Hoop stress (MPa) (1 MPa = 1 N/mm<sup>2</sup>)

X1 Time to failure (h)

X2 Years

### 2.1.4 Long-term behavior of PP

#### Calculation (based on EN ISO 15494:2015)

The following long-term behaviors show the long-term behavior of PP-H, PP-B and PP-R. For the temperature range from +10 °C to +110 °C, fracture lines are displayed. These are called LPL curves (Lower Predictable Limit); this means according to the definition that 97.5 % of all fracture points are on or above the corresponding curve.

Typically for semi-crystalline plastics like PP, the long-term curves show a knee. The curves are plotted in a double logarithmic diagram (i.e. not linear). Please take this into account when reading values for stress or time.

The long-term behavior was calculated by using the extrapolation method according to EN ISO 9080. With the following equation (4-parameter model), which was derived from that diagram, stress, temperature or time can be calculated for the temperature range of +10 °C to +95 °C.

The dotted lines of the curves apply if tests with longer testing times are carried out at 90 °C, 95 °C and 110 °C.



The 110 °C curve has been determined separately by using water inside and air outside; it cannot be calculated with the formulas below.

**First branch** (left-hand portion of the curves as shown in the following long-term behaviors)

PP-H

$$\log t = -46.346 - 9601.1 \cdot \frac{\log \sigma}{T} + 20381.5 \cdot \frac{1}{T} + 15.24 \cdot \log \sigma$$

PP-B

$$\log t = -56.086 - 10157.8 \cdot \frac{\log \sigma}{T} + 23971.7 \cdot \frac{1}{T} + 13.32 \cdot \log \sigma$$

PP-R

$$\log t = -55.725 - 9484.1 \cdot \frac{\log \sigma}{T} + 25502.2 \cdot \frac{1}{T} + 6.39 \cdot \log \sigma$$

**Second branch** (right-hand portion of the curves as shown in the following long-term behaviors)

PP-H

$$\log t = -18.387 + 8918.5 \cdot \frac{1}{T} - 4.1 \cdot \log \sigma$$

PP-B

$$\log t = -13.699 + 6970.3 \cdot \frac{1}{T} - 3.82 \cdot \log \sigma$$

PP-R

$$\log t = -19.98 + 9507 \cdot \frac{1}{T} - 4.11 \cdot \log \sigma$$

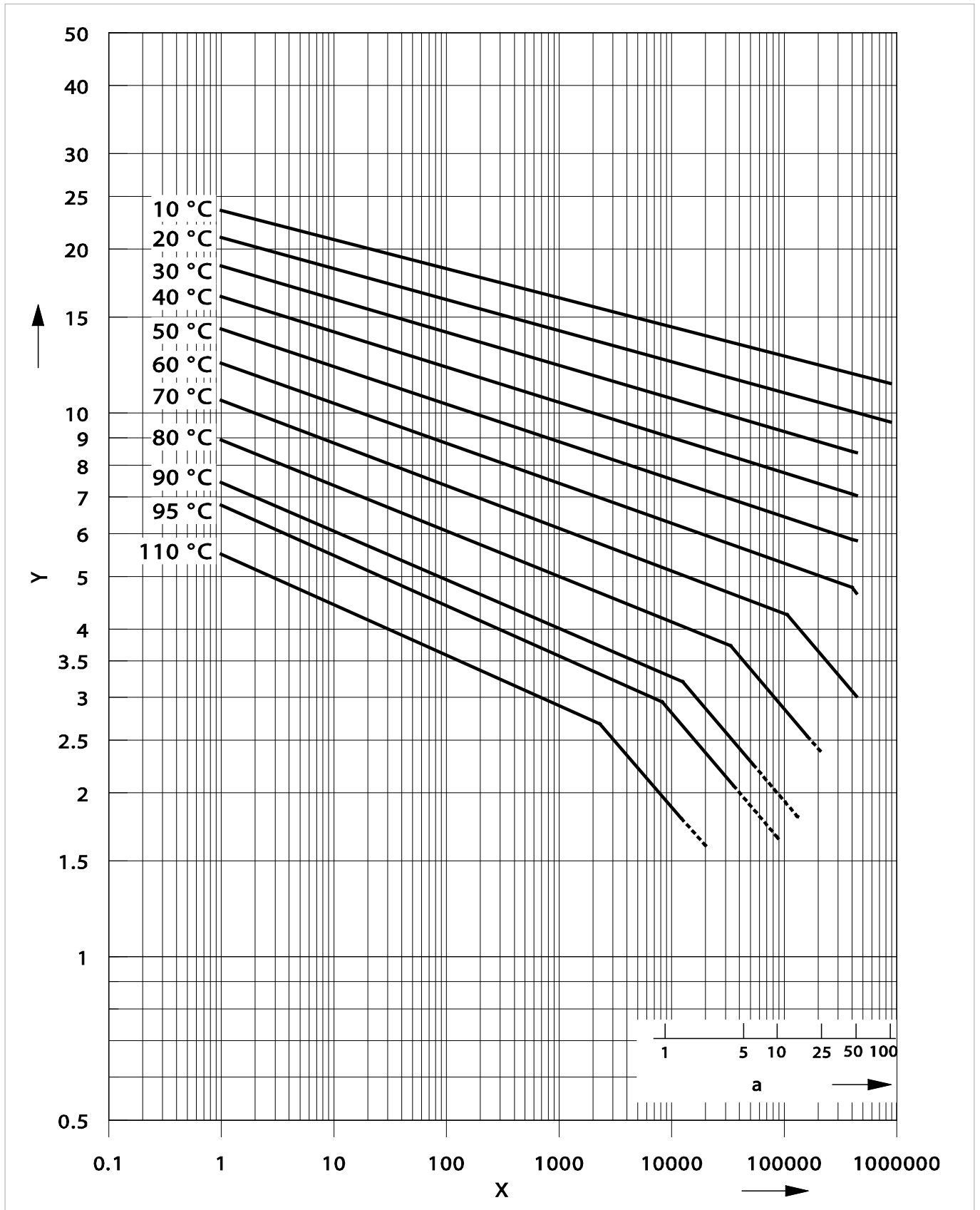
t Time to failure (h)

T Medium temperature (K)

σ Hoop stress (MPa) (1 MPa = 1 N/mm<sup>2</sup>)

The pressure-temperature diagram that we provide for pipe and fittings made of PP-H and PP-R is derived from the long-term behavior, including the design factor, for a service life of 25 years.

Long-term behavior PP-H (according EN ISO 15494:2015)

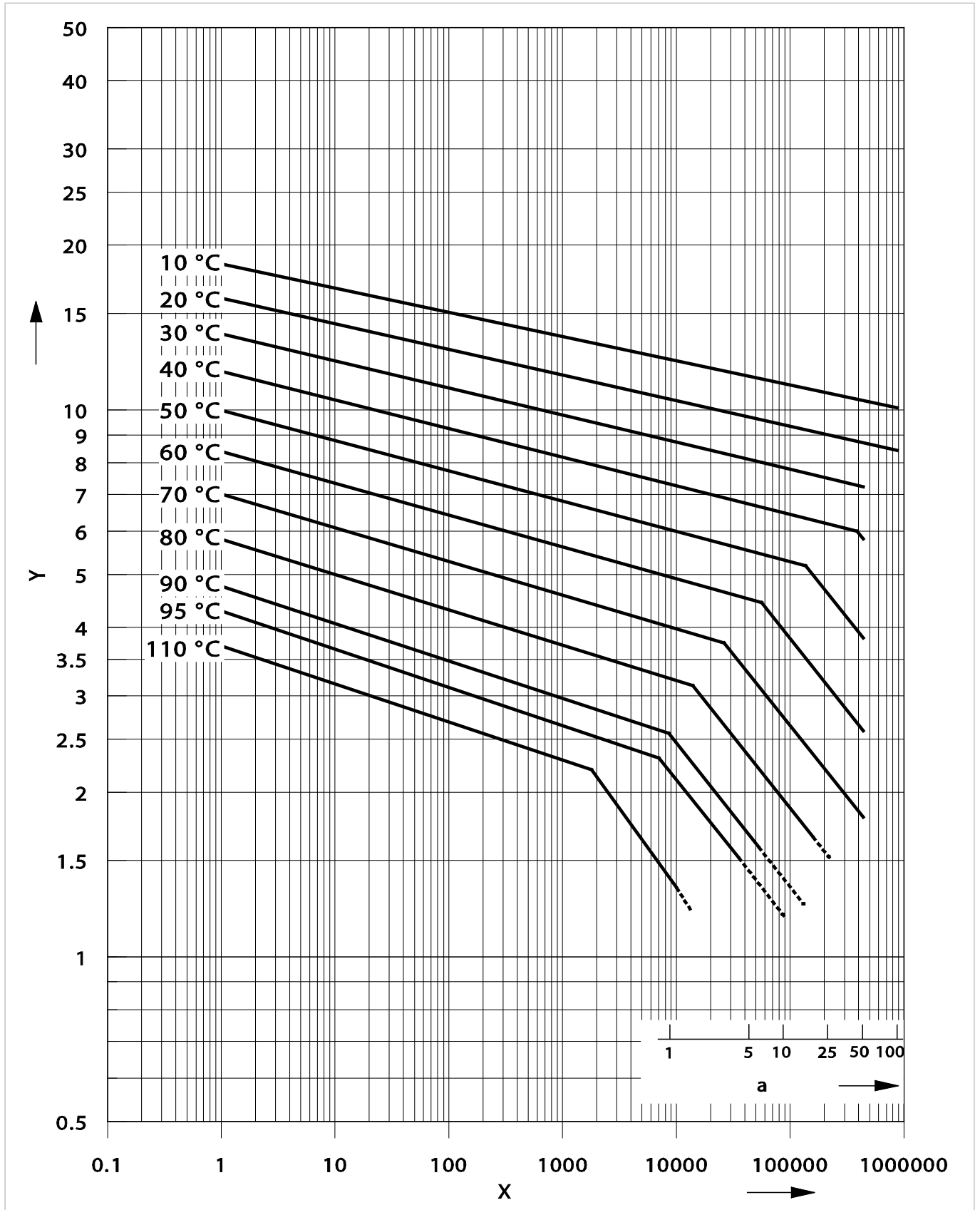


Y Hoop stress (MPa) (1 MPa = 1 N/mm<sup>2</sup>)

X Time to failure (h)

a Years

Long-term behavior PP-B (according EN ISO 15494:2015)

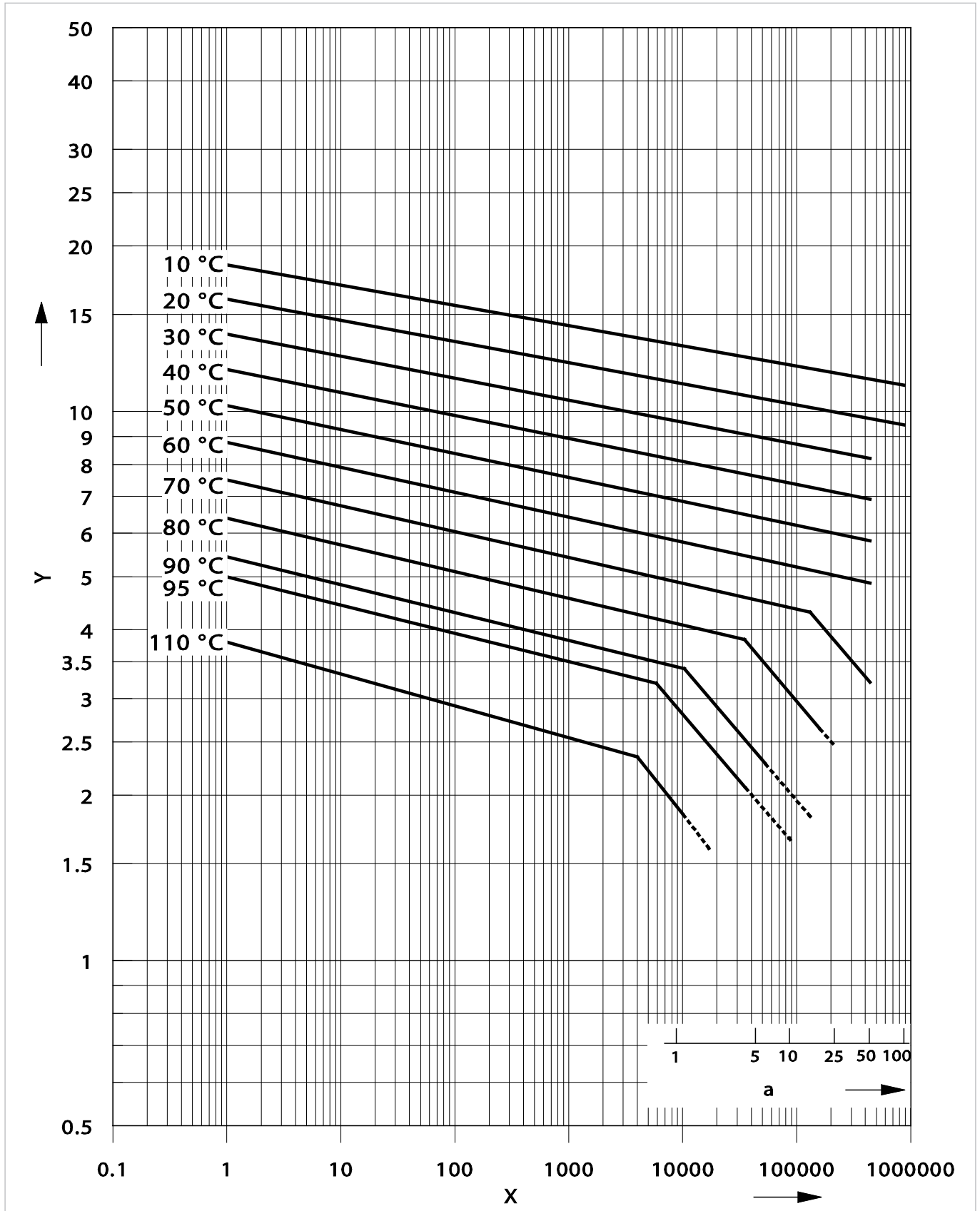


Y Hoop stress (MPa) (1 MPa = 1 N/mm<sup>2</sup>)

X Time to failure (h)

a Years

Long-term behavior PP-R (according EN ISO 15494:2015)



Y Hoop stress (MPa) (1 MPa = 1 N/mm<sup>2</sup>)  
 X Time to failure (h)  
 a Years



### 2.1.5 Long-term behavior of PVC-U

#### Calculation (based on EN ISO 15493:2015)

The following long-term behavior shows the long-term behavior of PVC-U. For the temperature range from +20 °C to +60 °C, fracture lines are displayed. These are called LPL curves (Lower Predictable Limit); this means according to the definition that 97.5 % of all fracture points are on or above the corresponding curve.

Typically for amorphous thermoplastics like PVC-U, the long-term properties are represented by straight lines. The curves are plotted in a double logarithmic diagram (i.e. not linear). Please take this into account when reading values for stress or time.

The long-term behavior was calculated by using the extrapolation method according to EN ISO 9080. With the following equation (4-parameter model), which was derived from the diagram, stress, temperature or time can be calculated for the temperature range of +20 °C to +60 °C.

$$\log t = -164.461 - 29349.493 \cdot \frac{\log \sigma}{T} + 60126.534 \cdot \frac{1}{T} + 75.079 \cdot \log \sigma$$

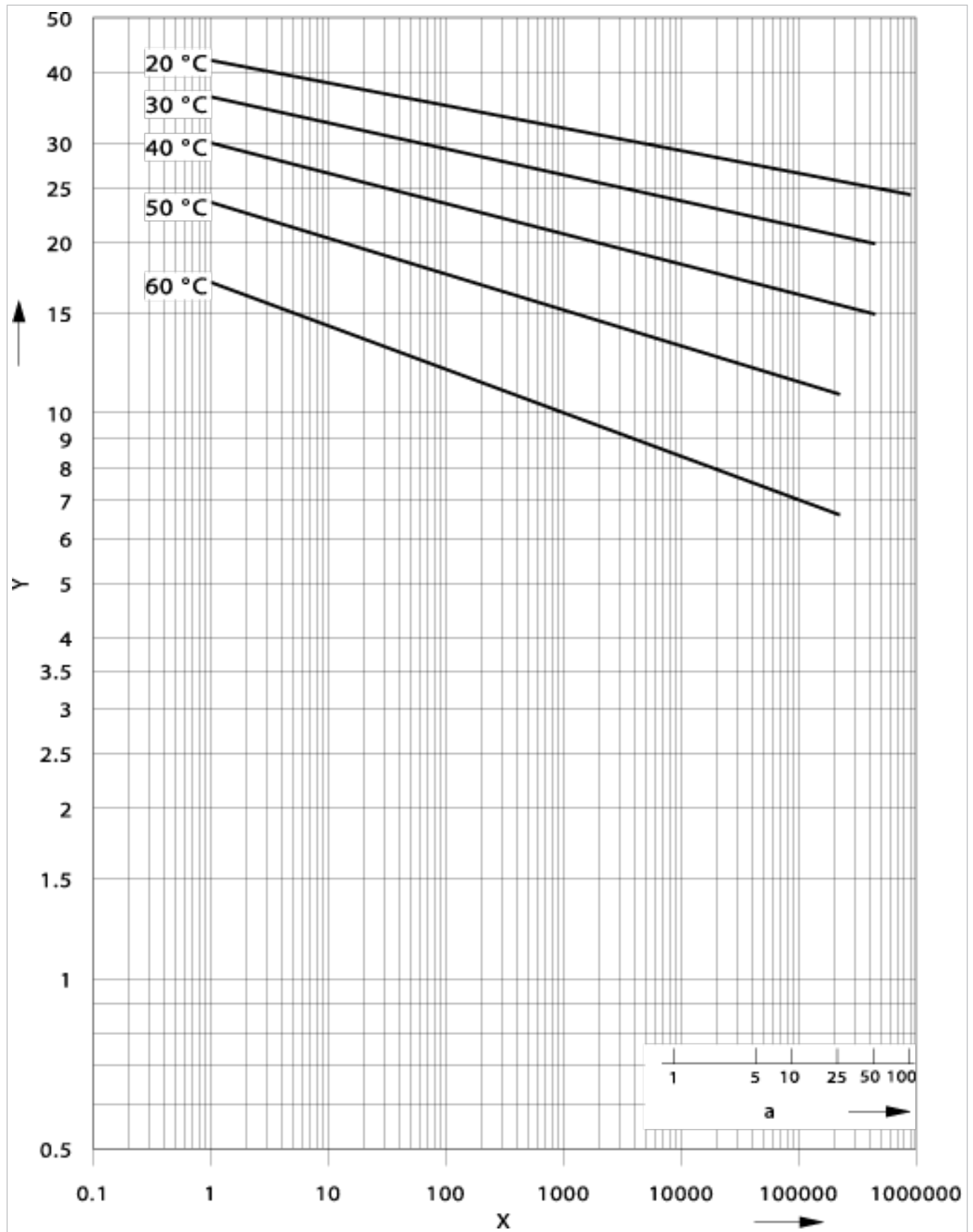
t Time to failure (h)

T Medium temperature (K)

σ Hoop stress (MPa) (1 MPa = 1 N/mm<sup>2</sup>)

The pressure-temperature diagram that we provide for pipe and fittings made of PVC-U is derived from the long-term behavior, including the design factor, for a service life of 25 years.

Long-term behavior PVC-U



Y Hoop stress (MPa) (1 MPa = 1 N/mm<sup>2</sup>)  
 X Time to failure (h)  
 a Years

## 2.1.6 Long-term behavior of PVC-C

### Calculation (based on EN ISO 15493:2015)

The following long-term diagram shows the long-term behavior of PVC-C. For the temperature range from +10 °C to +95 °C, lines of fracture are displayed. These are called LPL curves (Lower Predictable Limit); this means according to the definition that 97.5 % of all fracture points are on or above the corresponding curve.

Typically for amorphous thermoplastics like PVC-C, the long-term behavior does not show a knee.

The curves are plotted in a double logarithmic diagram (i.e. not linear). Please take this into account when reading values for stress or time.

The long-term behavior was calculated by using the extrapolation method according to EN ISO 9080. With the following equation (4-parameter model), which was derived from that diagram, stress, temperature or time can be calculated for the temperature range of +10 °C to +95 °C.

Pipe material in the temperature range of 10 °C to 95 °C

$$\log t = -109.95 - 21897 \cdot \frac{\log \sigma}{T} + 43702.87 \cdot \frac{1}{T} + 50.74202 \cdot \log \sigma$$

Fittings material in the temperature range of 10 °C to 90 °C

$$\log t = -121.699 - 25985 \cdot \frac{\log \sigma}{T} + 47143.18 \cdot \frac{1}{T} + 6303511 \cdot \log \sigma$$

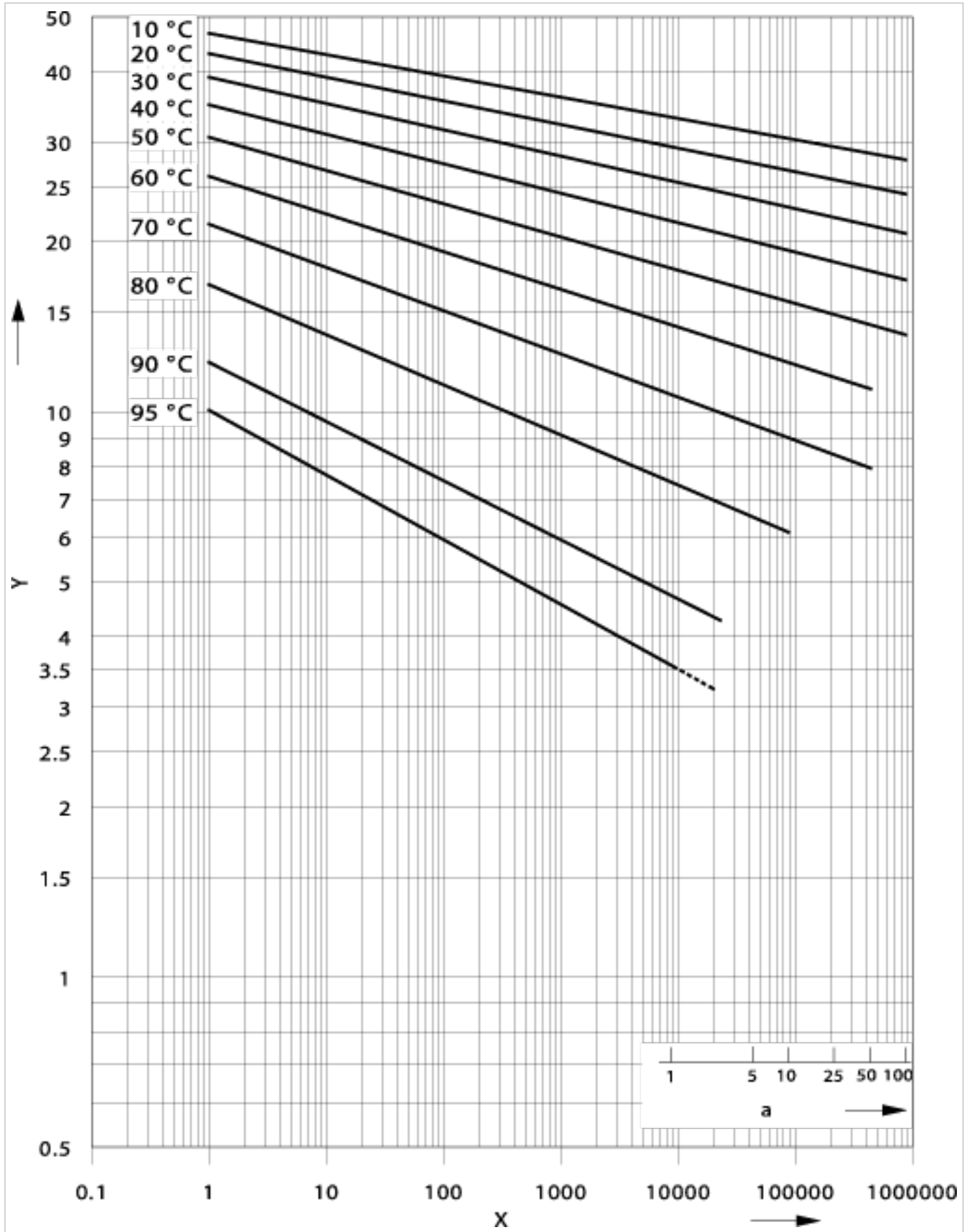
t Time to failure (h)

T Medium temperature (K)

σ Hoop stress (MPa) (1 MPa = 1 N/mm<sup>2</sup>)

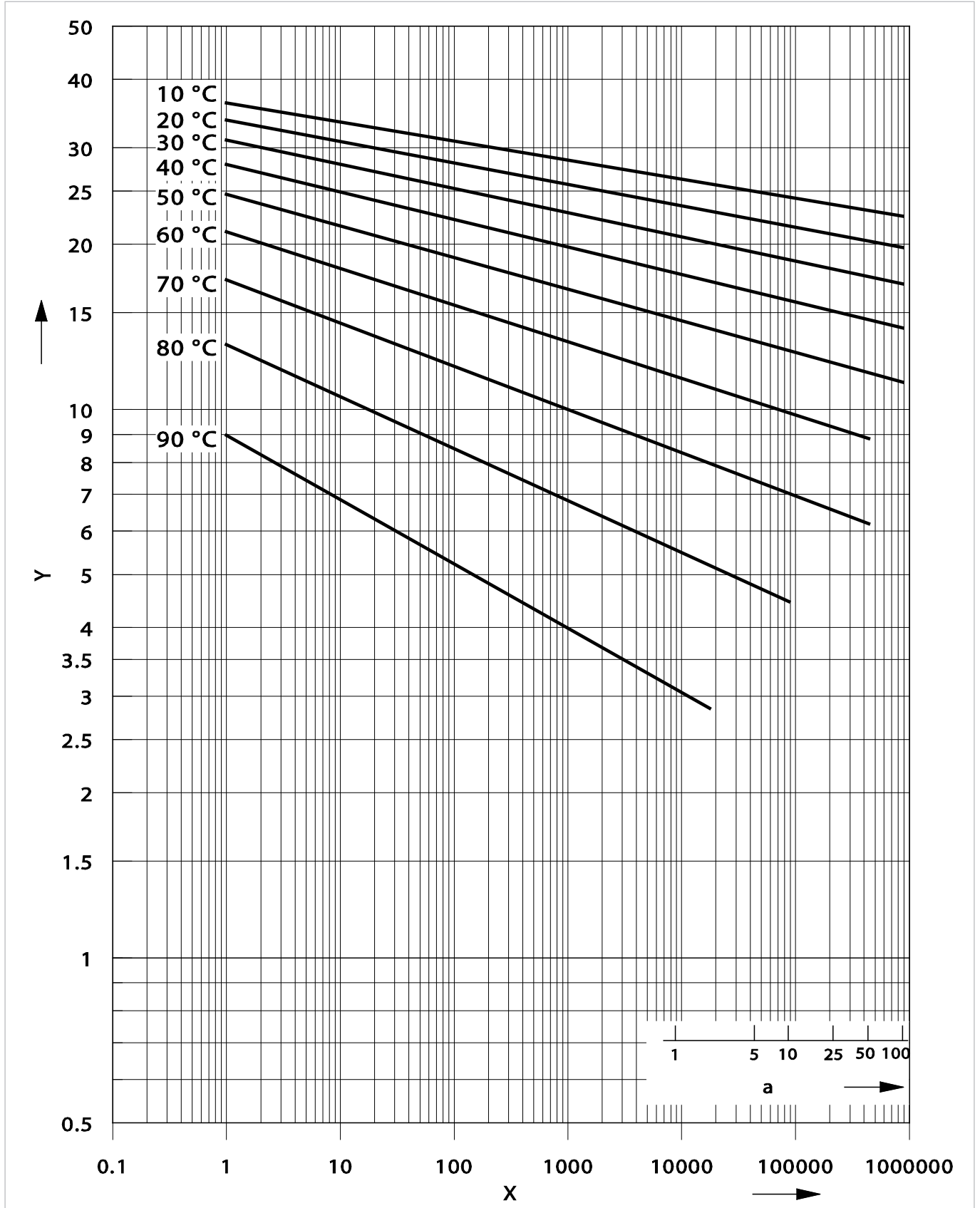
The pressure-temperature diagram that we provide for pipe and fittings made of PVC-C is derived from the long-term behavior, including the design factor, for a service life of 25 years.

Long-term behavior PVC-C pipe material



Y Hoop stress (MPa) (1 MPa = 1 N/mm<sup>2</sup>)  
 X Time to failure (h)  
 a Years

Long-term behavior PVC-C fittings material



Y Hoop stress (MPa) (1 MPa = 1 N/mm<sup>2</sup>)

X Time to failure (h)

a Years

## 2.1.7 Long-term behavior of PVDF

### Calculation (EN ISO 10931)

The following long-term behavior shows the long-term behavior of PVDF. For the temperature range from +10 °C to +140 °C, fracture lines are displayed. These are called LPL curves (Lower Predictable Limit); this means according to the definition that 97.5 % of all fracture points are on or above the corresponding curve.

The curves are plotted in a double logarithmic diagram (i.e. not linear). Please take this into account when reading values for stress or time.

The long-term behavior was calculated by using the extrapolation method according to EN ISO 9080. With the following equation (4-parameter model), which was derived from the diagram, stress, temperature or time can be calculated for the temperature range of +10 °C to +140 °C.

**First branch** (left-hand portion of the curves as shown in the following long-term behavior)

$$\log t = -165.4958 - 36518.7 \cdot \frac{\log \sigma}{T} + 78465.65 \cdot \frac{1}{T} + 57.0467 \cdot \log \sigma$$

**Second branch** (right-hand portion of the curves as shown in the following long-term behavior)

$$\log t = -23.19426 - 1611.69 \cdot \frac{\log \sigma}{T} + 12100 \cdot \frac{1}{T} - 0.40473 \cdot \log \sigma$$

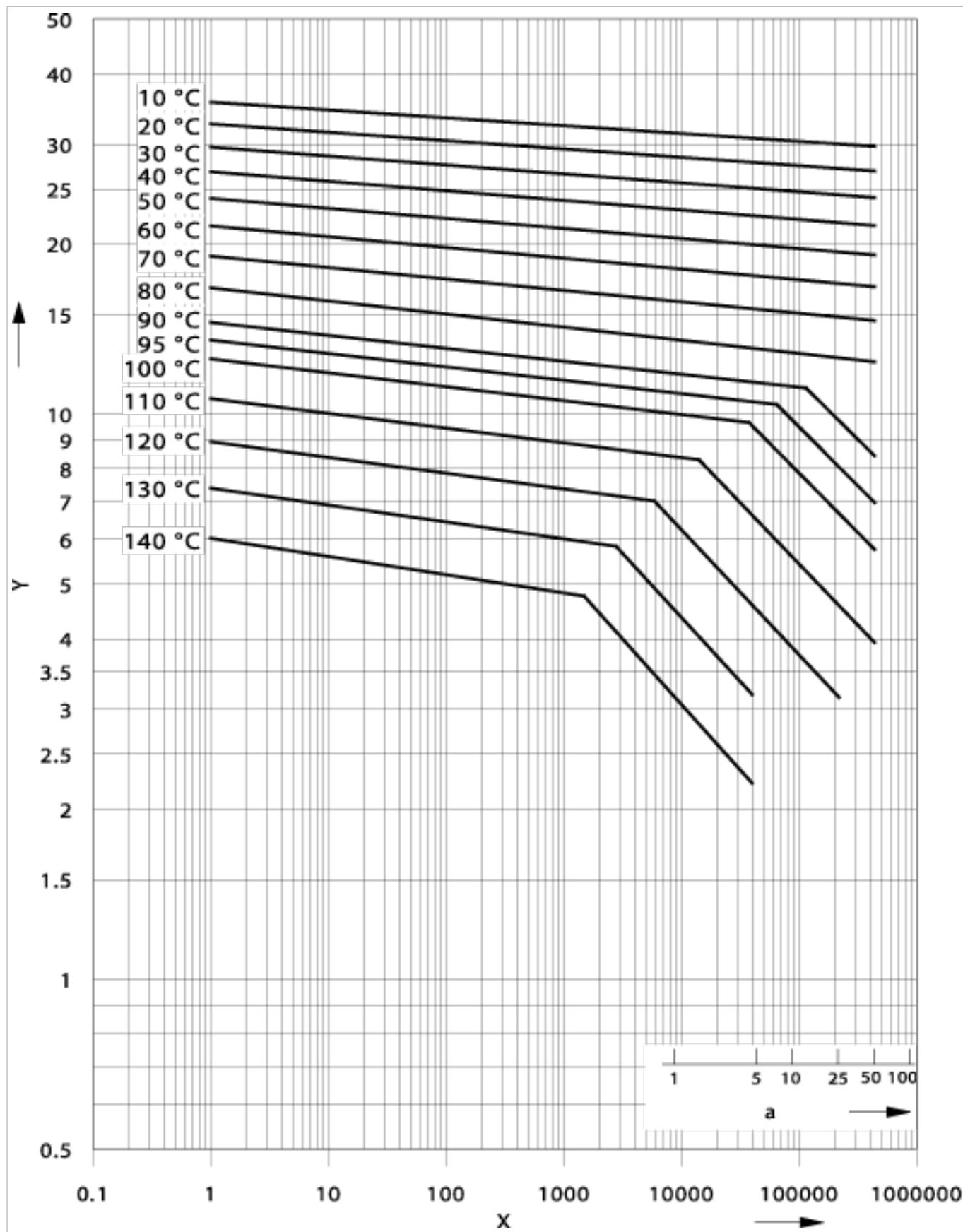
t Time to failure (h)

T Medium temperature (K)

σ Hoop stress (MPa) (1 MPa = 1 N/mm<sup>2</sup>)

The pressure-temperature diagram that we provide for pipe and fittings made of PVDF is derived from the long-term behavior, including the design factor, for a service life of 25 years.

Long-term behavior PVDF



Y Hoop stress (MPa) (1 MPa = 1 N/mm<sup>2</sup>)  
 X Time to failure (h)  
 a Years

## 2.1.8 Long-term behavior ECTFE

### Calculation (EN ISO 9080)

The following long-term behavior shows the long-term behavior of ECTFE. For the temperature range from 0 °C to +80 °C, fracture lines are displayed. These are called LPL curves (Lower Predictable Limit); this means according to the definition that 97.5 % of all fracture points are on or above the corresponding curve.

The curves are plotted in a double logarithmic diagram (i.e. not linear). Please take this into account when reading values for stress or time.

The long-term behavior was calculated by using the extrapolation method according to EN ISO 9080. With the following equation (4-parameter model), which was derived from the diagram, stress, temperature or time can be calculated for the temperature range of 0 °C to +80 °C.

**First branch** (left-hand portion of the curves as shown in the following long-term behavior)

$$\log t = -149.9727 - 30448.284 \cdot \frac{\log \sigma}{T} + 63064.546 \cdot \frac{1}{T} + 56.9484 \cdot \log \sigma$$

t Time to failure (h)

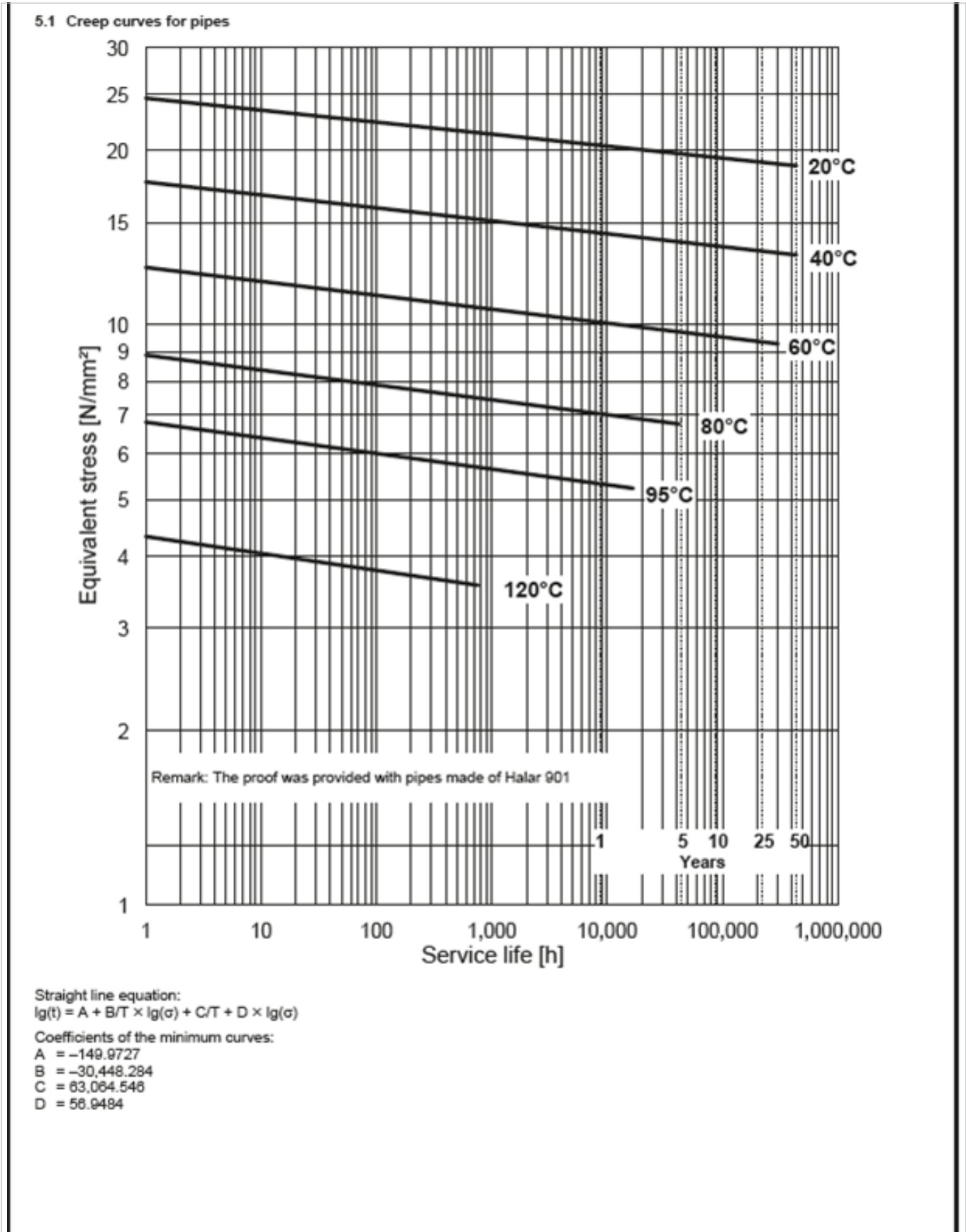
T Medium temperature (K)

σ Hoop stress (MPa) (1 MPa = 1 N/mm<sup>2</sup>)

The pressure-temperature diagram that we provide for pipe and fittings made of ECTFE is derived from the long-term behavior, including the design factor, for a service life of 25 years.



Long-term behavior ECTFE



- Y Hoop stress (MPa) (1 MPa = 1 N/mm<sup>2</sup>)
- X Time to failure (h)
- a Years

## 2.2 Range of applications for pipe and fittings

### 2.2.1 In general

The choice of material and the pressure rating of the pipe components are important for both operating safety and for attaining the specified minimum service life of the system.

The decisive influencing factors are the following:

- Operating pressure
- Operating temperature
- Medium transported
- Duration of stress

Separate calculations are necessary if design factors are different or the service life is modified. The suitability of the material for the flow medium can be determined from the list of chemical resistance provided separately by GF Piping Systems.

### 2.2.2 Pressure-temperature diagram for ABS

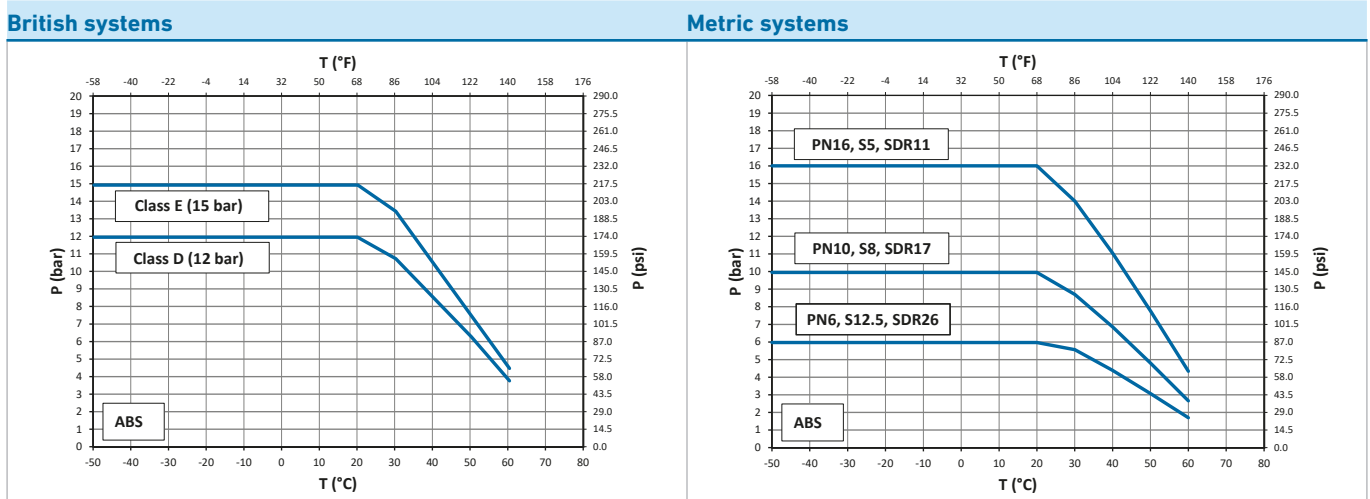
The following two pressure-temperature diagrams for ABS pipe and fittings are valid for a service life of 25 years.

The design factor of 2.1 for British systems and 1.8 for metric systems recommended by GF Piping Systems has been incorporated.

The diagram can be used for water or media resembling water, in other words, media that have no reduction factor for their chemical resistance.

**⚠** Please take into account the pressure-temperature diagrams for valves and special fittings. Because of the construction and/or sealing material used, differences are possible when compared to pipe and fittings. More information is available in the Planning Fundamentals of the relevant types of valves and special fittings.

**⚠** The influence of the anti-freeze compound has to be taken into account when calculating the allowable operating pressure. Contact your authorized GF Piping Systems representative for additional information.



P Permissible pressure (bar, psi)  
 T Temperature (°C, °F)

**⚠** The permissible operating pressure can be used as a guide value for constant operating conditions (pressure, temperature). For changing operating conditions, it is recommended to perform a strength check in accordance with DVS 2210-1.

### 2.2.3 Pressure-temperature diagram for PE

#### PE100

The following pressure-temperature diagrams apply to PE100 pipes and fittings for a service life of 25 years. The pressure-temperature curves were calculated with design factors of C=1.25, C=1.6 and C=2.0.

- C=1.25 for water applications in the supply sector
- C=1.6 for industrial applications
- C=2.0 for chemical applications or piping systems requiring DIBt approval by the building authorities

The long-term welding factor  $f_s$  (or long-term joining factor) must be taken into account if relevant (e.g. stress check in longitudinal direction).

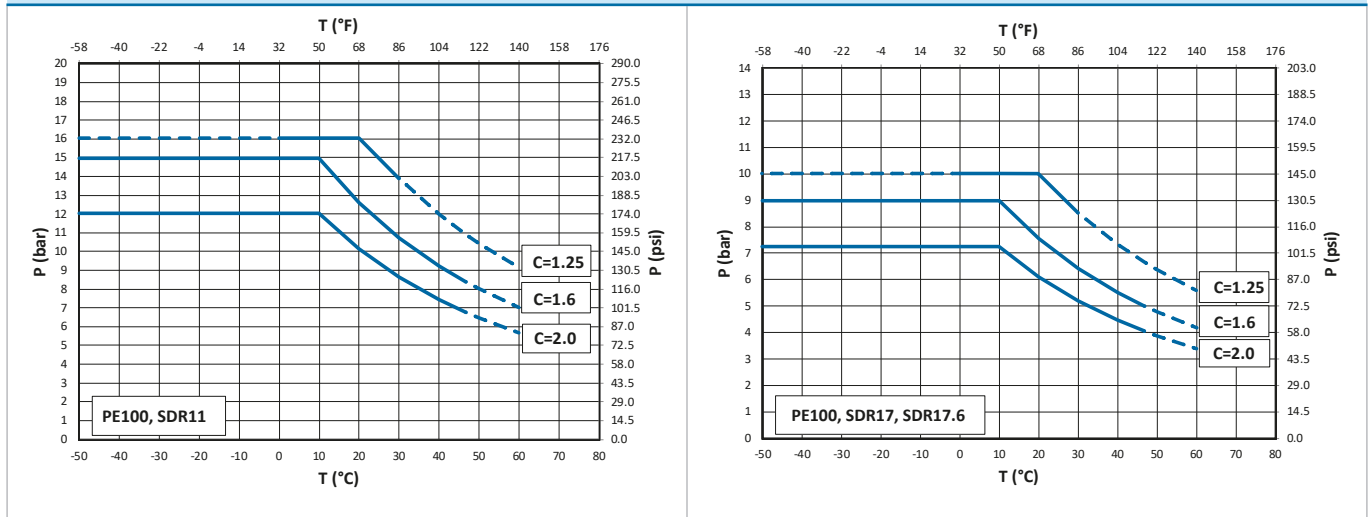
The diagrams can be used for water or media resembling water, in other words, media that have no reduction factor for chemical resistance.

**⚠** Please take into account the pressure-temperature diagrams for valves and special fittings. Because of the construction and/or sealing material used, differences are possible when compared to pipe and fittings. More information is available in the Planning Fundamentals of the relevant types of valves and special fittings.

**i** In case of operating in the temperature range shown in dotted lines, contact your authorized GF Piping Systems representative.

**PE100, SDR11**

**PE100, SDR17, SDR17.6**



P Permissible pressure (bar, psi)  
 T Temperature (°C, °F)

**⚠** The permissible operating pressure can be used as a guide value for constant operating conditions (pressure, temperature). For changing operating conditions, it is recommended to perform a strength check in accordance with DVS 2210-1.

### Determining the nominal pressure (PN)

According to the standard, the nominal pressure is a numeric value for the size of a pipeline part that refers to the mechanical properties of that pipeline part. In addition to the geometric values, such as SDR, long-term creep strength / dimensioning tension and the minimum design factor are also taken into account.

For plastic piping systems intended to transport water, the nominal pressure indicates the maximum permitted operating pressure in bar at a temperature of 20 °C and for 50 years in water, relative to the minimum value of the total (calculation) coefficients. It is calculated by using the following equation:

$$PN = 10 \cdot \frac{\sigma_s}{S} = 20 \cdot \frac{\sigma_s}{(SDR - 1)}$$

$\sigma_s$  Design stress (MPa)

PN Nominal pressure (bar)

### Minimum required strength (MRS):

The value of  $\sigma_{LCL}$  at 20 °C and for 50 years in water, rounded down to the next value in the R10 standard series of numbers.

$\sigma_{LCL}$  is the hoop stress determined from the long-term behavior for a given period and temperature. LCL stands for Lower Confidence Limit. The R10 standard series of numbers is a Renard standard series of numbers according to ISO 3 and ISO 497.

### Design stress ( $\sigma_s$ ):

The design stress is the permitted stress (unit in MPa) for a particular application or operating condition. It is derived by dividing the MRS by coefficient C and is calculated as shown in the equation below:

$$\sigma_s = \frac{MRS}{C}$$

$\sigma_s$  Design stress (MPa)

C Minimum factor

The calculated value is rounded down to the next value in the R10 standard series of numbers.

**Total operating (calculation) coefficient (C):**

A total coefficient with a value greater than one that takes into account both the operating conditions and those characteristics of the pipeline component that have not yet been included in the lower confidence limit  $\sigma_{LCI}$ .

If we use the above definition to calculate the corresponding nominal pressure for both SDR classes, the result for a PE100 pipe is as follows:

	SDR 17	SDR 17.6
MRS	10 MPa	10 MPa
C (minimum factor)	1.25	1.25
$\sigma_s$	8.0 MPa	8.0 MPa
PN	10 bar	9.6 bar

The above definitions thus produce a calculated difference of 0.4 bar in nominal pressure. But in actual practice this difference does not matter, as shown below.

Industrial piping systems are normally designed for a service life of 25 years. If we determine a hoop stress of  $\sigma_{LCI}$  for the operating point of 25 years at 20 C from the long-term behaviors for ELTEX TUB121 or CRP100, we get a tension of 10.6 MPa (minimum value for both PE100 materials according to manufacturer's data). If we use this tension to calculate the design tension  $\sigma_s$ , and do not round it down, we get the value of 8.48 MPa.

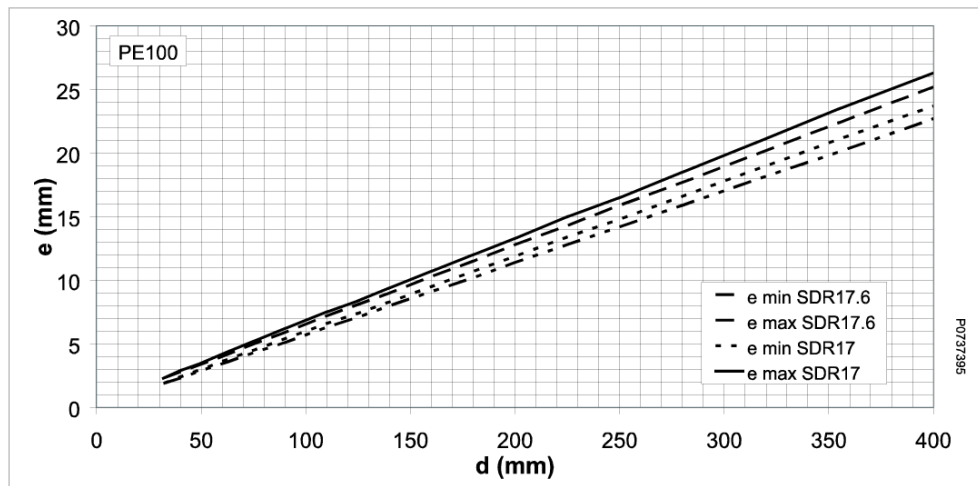
The actual nominal pressure in practice for SDR17 and SDR17.6 is:

- SDR17            PN = 10.6 bar und
- SDR17.6        PN = 10.2 bar.

Both SDR classes comply with requirements for industrial applications of a PN10 system.

**Comparison of geometric dimensions**

The two SDR classes differ only slightly in wall thickness of the pipe, as can be seen from the diagram below:



d Pipe outer diameter (mm)  
e Wall thickness (mm)

For butt fusion, the wall offset may not exceed 10 %. In light of the differences in the wall thicknesses of SDR17 and SDR17.6, the resulting wall offset is significantly below this value; this provides for trouble-free butt fusion of both SDR classes.

## 2.2.4 Pressure-temperature diagram for PP

### PROGEF Standard and PROGEF Plus piping system (PP-H)

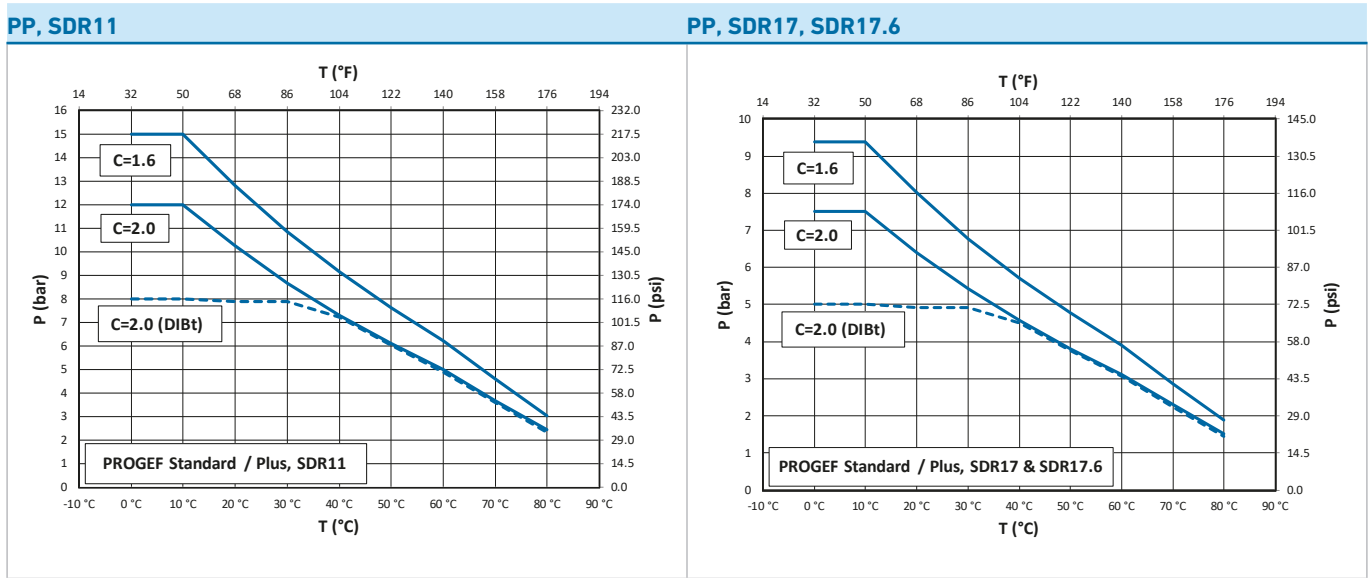
The following pressure-temperature diagrams for PP pipe and fittings are valid for a service life of 25 years. The pressure-temperature curves are calculated with design factors of C=1.6 and C=2.0. For designs with the design factor C=1.6, a static verification is recommended. For chemical applications or piping systems that require approval by the building authorities, the dashed curve applies taking into account the toughness factors A1 according to DVS 2205-1.

The long-term welding factor  $f_s$  (or long-term joining factor) must be taken into account if relevant (e.g. stress check in longitudinal direction).

The diagrams can be used for water or media resembling water, in other words, media which have no reduction factor for chemical resistance.

**⚠ Please take into account the pressure-temperature diagrams for valves and special fittings. Because of the construction and/or sealing material used, differences are possible when compared to pipe and fittings. More information is available in the Planning Fundamentals of the relevant types of valves and special fittings.**

### Pressure-temperature diagrams for PP pipe and injection-molded fittings

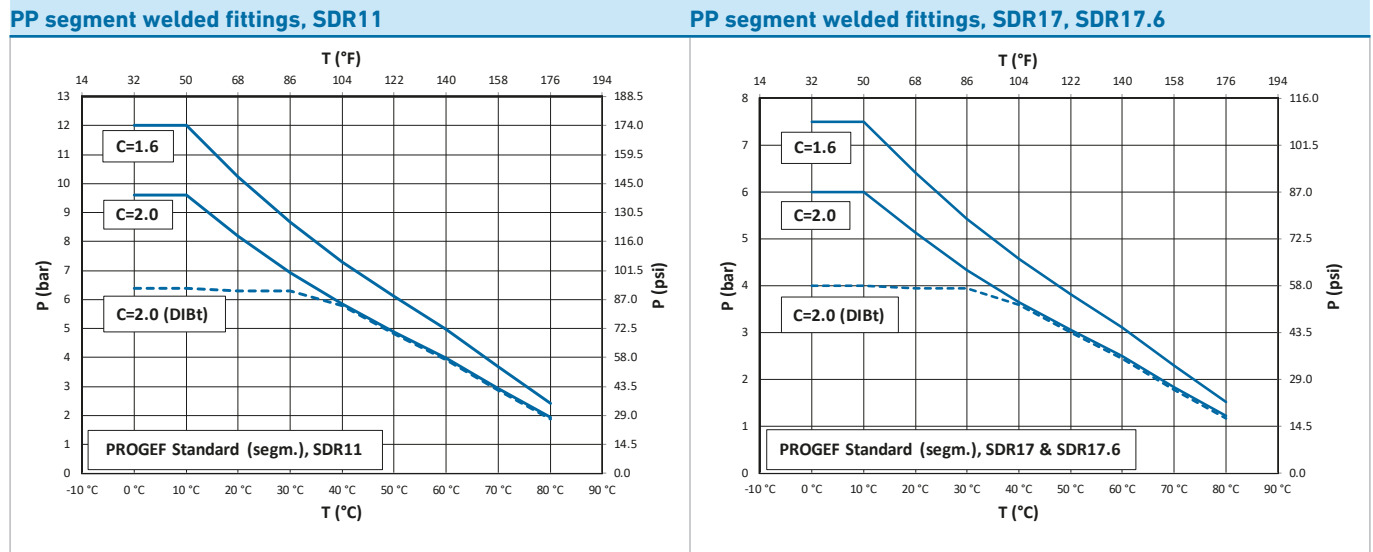


P Permissible pressure (bar, psi)  
 T Temperature (°C, °F)

**⚠ The permissible operating pressure can be used as a guide value for constant operating conditions (pressure, temperature). For changing operating conditions, it is recommended to perform a strength check in accordance with DVS 2210-1.**

### Pressure-temperature diagrams for PP segment-welded fittings

Segment-welded fittings have a reduction factor of 0.8 for the operating pressure/nominal pressure.



P Permissible pressure (bar, psi)  
 T Temperature (°C, °F)

**⚠** The permissible operating pressure can be used as a guide value for constant operating conditions (pressure, temperature). For changing operating conditions, it is recommended to perform a strength check in accordance with DVS 2210-1.

### PROGEF Natural piping system (PP-n)

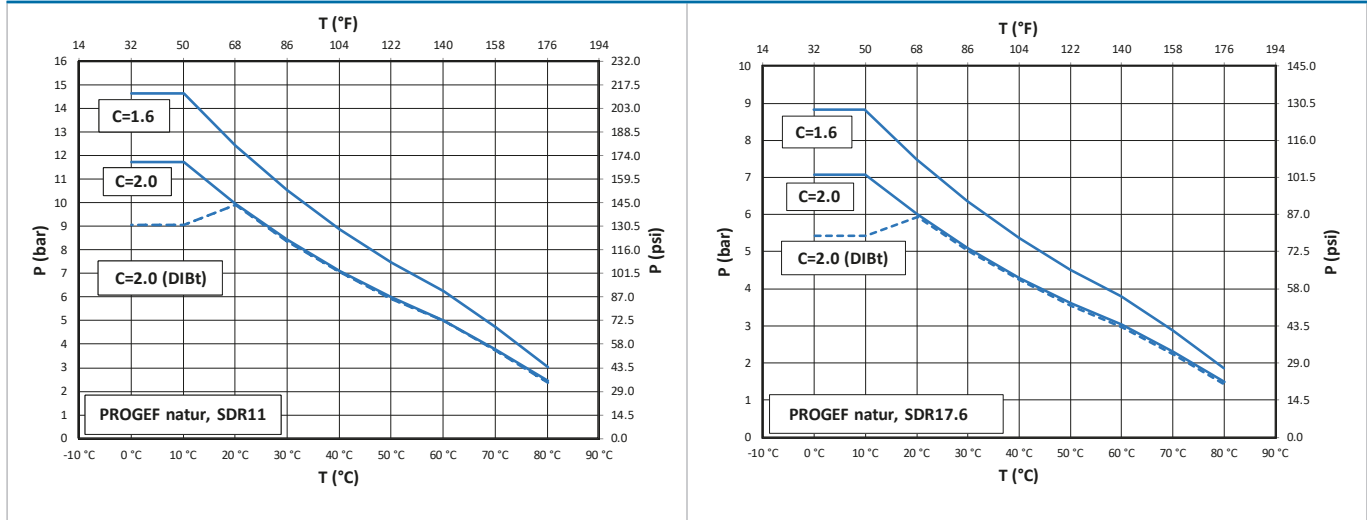
The following pressure-temperature diagram for PROGEF Natural pipe and fittings is valid for a service life of 25 years. The pressure-temperature curves have been calculated with design factors of C=1.6 and C=2.0. For designs with the design factor C=1.6, a static verification is recommended. For chemical applications and piping systems requiring approval by the building authorities, the dashed curve applies taking into account the toughness factors A1 according to DVS 2205-1.

The long-term welding factor  $f_s$  (or long-term joining factor) must be taken into account if relevant (e.g. stress check in longitudinal direction).

It can be used for water or media resembling water, in other words, media that have no reduction factor for chemical resistance.

**⚠ Please take into account the pressure-temperature diagrams for valves and special fittings. Because of the construction and/or sealing material used, differences are possible when compared to pipe and fittings. More information is available in the Planning Fundamentals of the relevant types of valves and special fittings. Using PROGEF Natural at higher temperatures can cause a discoloration of the material.**

**PROGEF Natural, SDR11**
**PROGEF Natural, SDR17.6**



P Permissible pressure (bar, psi)  
 T Temperature (°C, °F)

**⚠ The permissible operating pressure can be used as a guide value for constant operating conditions (pressure, temperature). For changing operating conditions, it is recommended to perform a strength check in accordance with DVS 2210-1.**



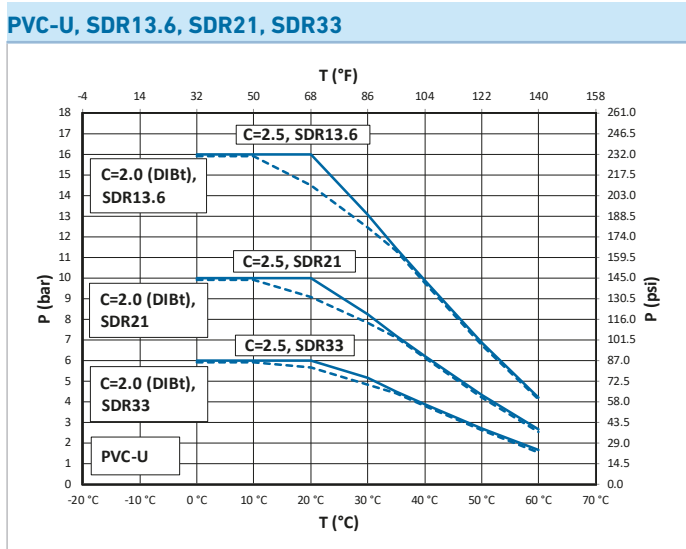
### 2.2.5 Pressure-temperature diagram for PVC-U

The following pressure-temperature diagrams for PVC-U pipe and fittings are valid for a service life of 25 years. The design factor of 2.5 recommended by GF Piping Systems has been incorporated. They can be used for water or media resembling water, in other words, media that have no reduction factor for chemical resistance.

For chemical applications or piping systems requiring approval by the building authorities, the dashed curves shown apply taking into account the toughness factors A1 according to DVS 2205-1.

The long-term welding factor  $f_s$  (or long-term joining factor) must be taken into account if relevant (e.g. stress check in longitudinal direction).

**⚠** Please take into account the pressure-temperature diagrams for valves and special fittings. Because of the construction and/or sealing material used, differences are possible when compared to pipe and fittings. More information is available in the Planning Fundamentals of the relevant types of valves and special fittings.



P Permissible pressure (bar, psi)  
 T Temperature (°C, °F)

**⚠** The permissible operating pressure can be used as a guide value for constant operating conditions (pressure, temperature). For changing operating conditions, it is recommended to perform a strength check in accordance with DVS 2210-1.

**⚠** PVC-U fittings d200 to d280 by GF Piping Systems are designed and tested for a nominal pressure of PN10. Sizes d315 to d400 are designed and tested for a nominal pressure of PN6

Our experience and tests show that pipe equal to or greater than d315 can be slightly oval, which could produce an enlarged cementing gap.

GF Piping Systems therefore recommends that pipe equal or greater than d315 should be operated at a maximum operating pressure (+20 °C) of 6 bar. Please observe the special information for this dimension range in the cementing instructions for PVC-U.

### 2.2.6 Pressure-temperature diagram for PVC-C

The following pressure-temperature diagram for PVC-C pipe and fittings is valid for a service life of 25 years.

The design factors recommended by GF Piping Systems (C=2.5 for pipes and C=2.0 for fittings) are incorporated. The pressure-temperature curves are valid for water or media resembling water, in other words, media that have no reduction factor for chemical resistance.

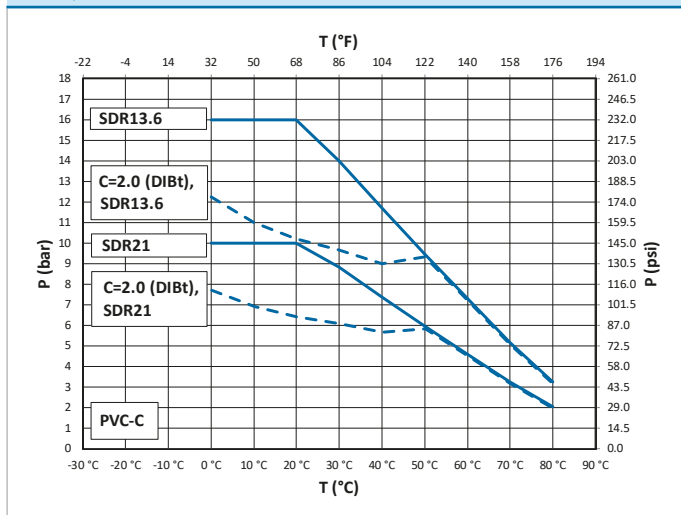
For chemical applications or piping systems that require approval by the building authorities according to DIBt, the dashed curves shown apply taking into account the toughness factors A1 according to DVS 2205-1.

The long-term welding factor  $f_s$  (or long-term joining factor) must be taken into account if relevant (e.g. stress check in longitudinal direction).

**⚠ Please take into account the pressure-temperature diagrams for valves and special fittings. Because of the construction and/or sealing material used, differences are possible when compared to pipe and fittings. More information is available in the Planning Fundamentals of the relevant types of valves and special fittings.**

Under certain conditions, working temperatures up to 90 °C are possible for limited times. Please contact your GF Piping Systems representative for advice on applications beyond GF Piping Systems' specifications.

#### PVC-C, SDR13.6 und SDR21



P Permissible pressure (bar, psi)  
 T Temperature (°C, °F)

**⚠ The permissible operating pressure can be used as a guide value for constant operating conditions (pressure, temperature). For changing operating conditions, it is recommended to perform a strength check in accordance with DVS 2210-1.**

### 2.2.7 Pressure-temperature diagram for PVDF

The following pressure-temperature diagrams for PVDF pipe and fittings are valid for a service life of 25 years.

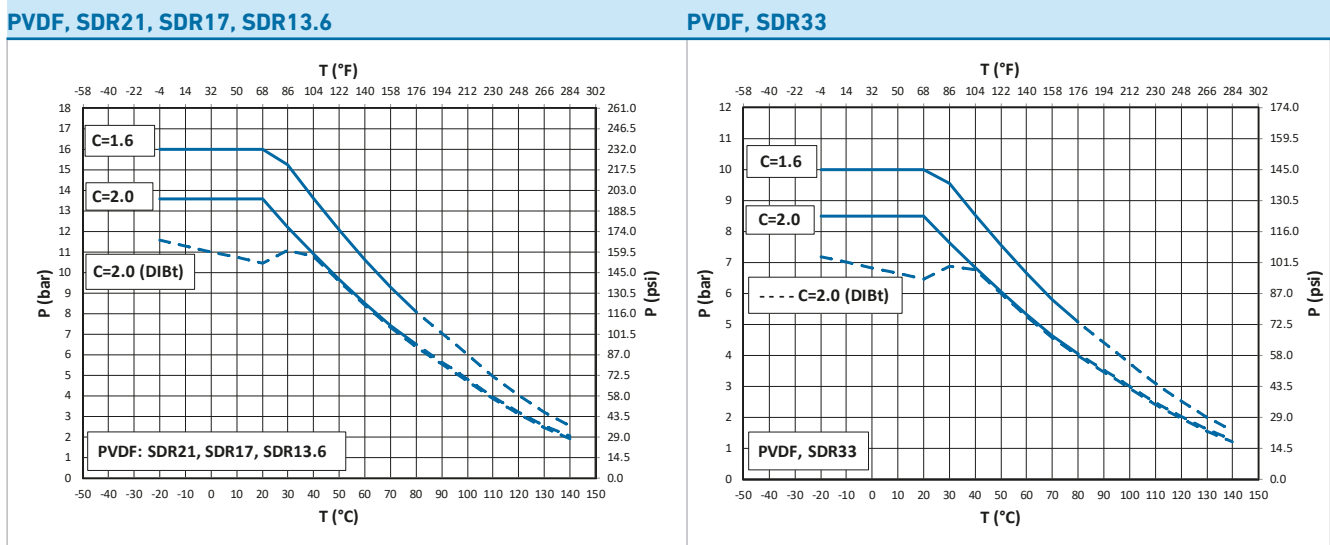
The design factor of 2.0 (or 1.6) recommended by GF Piping Systems has been incorporated. The pressure-temperature curves are valid for water or media resembling water, in other words, media that have no reduction factor for chemical resistance.

For chemical applications or piping systems that require approval by the building authorities, the dashed curves apply, taking into account the toughness factors A1 in accordance with DVS 2205-1.

The long-term welding factor  $f_s$  (or long-term joining factor) must be taken into account if relevant (e.g. stress check in longitudinal direction).

**⚠** Please take into account the pressure-temperature diagrams for valves and special fittings. Because of the construction and/or sealing material used, differences are possible when compared to pipe and fittings. More information is available in the Planning Fundamentals of the relevant types of valves and special fittings.

**i** In case of operating in the temperature range shown in dotted lines, contact your authorized GF Piping Systems representative.



P Permissible pressure (bar, psi)  
 T Temperature (°C, °F)

**⚠** The permissible operating pressure can be used as a guide value for constant operating conditions (pressure, temperature). For changing operating conditions, it is recommended to perform a strength check in accordance with DVS 2210-1.

**i** These diagrams can only be used for applications with liquids!



Application example for PVDF material

The Miner's rule (calculation method for cumulative damage) may be used to approximate the expected damage for applications with varying conditions during their expected service life. The expected service life is calculated by adding the rates of damage due to each of the intermittent operating conditions.

For continuously changing conditions of temperature or pressure, the Miner's rule is applied. The following example, an application in the pharmaceutical industry, shows the calculation steps necessary:

Calculation basis		Main application	Steam sterilization
Pipe	SDR21	Purified water PW	Saturated steam at
Design factor	2.0	(water-like medium) at	135 °C and 2.2 bar,
Service life	5 Jahre	+25 °C and 5 bar operating pressure	daily for 30 minutes

According to this rule:

$$T_x = \frac{100 \cdot T_1 \cdot T_2}{a_1 \cdot T_2 + a_2 \cdot T_1}$$

$a_1$   $a_2$  Shares of partial stress periods in overall stress period (%)

$T_1$   $T_2$  Service life at each of the operating conditions (pressure and temperature constant)

$T_x$  Calculated service life at intermittent stress

For the above example the service life is calculated as:

$$T_1 \geq 50 \text{ years} \quad T_2 = 4471 \text{ h}$$

The shares of partial stress periods in the overall stress time are:

$$a_1 = 97.9 \% \quad a_2 = 2.1 \%$$

For the calculated service life  $T_x$ , this results in:

$$T_x = 214\,608 \text{ h} = 24.5 \text{ Jahre}$$

This calculated service life is higher than the specified operating life; i.e. the dimensions of this application are sufficient.

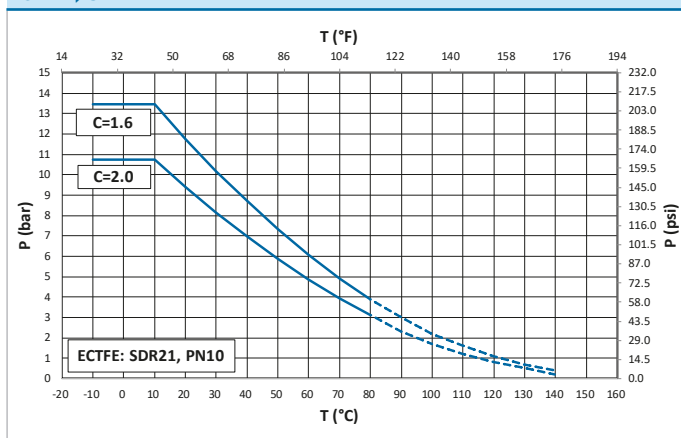
### 2.2.8 Pressure-temperature diagram for ECTFE

The pressure-temperature diagram that we provide for pipe and fittings made of ECTFE is derived from the long-term behavior, including the design factor, for a service life of 25 years. The design factor of 2.0 (or 1.6) recommended by GF Piping Systems has been incorporated. It can be used for water or media resembling water, in other words, media that have no reduction factor for chemical resistance.

**⚠** Please take into account the pressure-temperature diagrams for valves and special fittings. Because of the construction and/or sealing material used, differences are possible when compared to pipe and fittings. More information is available in the Planning Fundamentals of the relevant types of valves and special fittings.

**i** In case of operating in the temperature range shown in dotted lines, contact your authorized GF Piping Systems representative.

#### ECTFE, SDR21



P Permissible pressure (bar, psi)  
 T Temperature (°C, °F)

**⚠** For any additional project support like engineering, design and installation or chemical resistance please contact [gss@georgfischer.com](mailto:gss@georgfischer.com)

## 2.3 Calculation of the allowable pressure/required wall thickness

### 2.3.1 Selecting plastic piping components

Dimensioning of thermoplastic pipe subjected to internal pressure strictly adheres to strength requirements and is calculated by using the vessel formula. All pipe dimensions listed in the standards are based on this formula. Deviations only occur in the lower range of diameters, since practical and manufacturing considerations make it necessary to maintain certain minimum pipe wall thicknesses.

$$e = \frac{p \cdot d}{20 \cdot \sigma_{zul.} + p}$$

e Pipe wall thickness (mm)  
 d Pipe outer diameter (mm)  
 p Permissible operating pressure (bar)  
 $\sigma_{zul.}$  Allowable hoop stress (N/mm<sup>2</sup>)

### Nominal pressure PN

The designation "nominal pressure" PN (also known as pressure level) by itself is no longer sufficient. The PN classification generally used all over the world as information for pipe dimensioning is rather confusing where butt fusion is concerned.

In the case of plastic pipe established practice is to use pressure-neutral descriptions for pipe of the same pressure capacity. This avoids incorrect use of pipe in different applications or under different conditions.

ISO 4065 classifies pipe by series according to pressure rating, so that pipe with the same series number have the same pressure rating, as is also the case in designations according to nominal pressure levels. The pipe series are denoted by the letter S. The series designation is based on the following formula:

S is a dimensionless value.

$$S = \frac{10 \cdot \sigma_{zul.}}{p \cdot C} = \frac{d - e}{2 \cdot e}$$

e Pipe wall thickness (mm)  
 d Pipe outer diameter (mm)  
 p Operating pressure (bar, psi)  
 C Design factor

Hence, a PP pipe with dimension d110 and wall thickness = 10 mm results in:

$$S = \frac{(110 - 10)}{(2 \cdot 10)} = 5$$

The designation SDR (Standard Dimension Ratio) is much more common on the market. SDR indicates the ratio of outside diameter to wall thickness.

$$SDR = \frac{d}{e}$$

The pipe series designation and the SDR designation are connected by this formula:

$$SDR = 2 \cdot S + 1$$

In the case of the example above, this results in:

$$\text{SDR} = 2 \cdot 5 + 1 = 11$$

The market primarily features the designations PN and SDR. GF Piping Systems recommends the use of dimension and wall thickness, as well as SDR at all times.

### 2.3.2 Calculating the effective design factor / permissible operating pressure

To calculate the design factor and allowable operating pressure, it is necessary to know the long-term behavior of the material. Such a diagram allows the long-term creep strength to be read depending on the desired service life and operating temperature. For fittings and valves, the wall thickness is usually greater than for pipe of the same pressure level. For this reason, the outside diameter and wall thickness of the pipe are used to calculate the design factor.

The design factor is then calculated by using the following formula:

$$C = \frac{\sigma_s \cdot 20 \cdot e}{p \cdot (d - e)}$$

C	Design factor
$\sigma$	Hoop stress (N/mm <sup>2</sup> )
e	Pipe wall thickness (mm)
d	Pipe outer diameter (mm)
p	Operating pressure (bar)

Similarly, the maximum permissible operating pressure is calculated by rewriting the formula above as:

$$p = \frac{20 \cdot e \cdot \frac{\sigma_s}{C}}{d - e}$$



#### Example – Calculating the design factor and operating pressure

Intended service life	25 Jahre
Max. operating temperature	+40 °C
Max. operating pressure	3 bar
Material	PVC-U
Intended pressure level	PN16 bar
Outside diameter	110 mm
Wall thickness	8.1 mm
Hoop stress	15.5 N/mm <sup>2</sup>

$$C = \frac{15.5 \cdot 20 \cdot 8.1}{3 \cdot (110 - 8.1)} = 8.2 > 2.5$$

For the sake of clarity, the calculations are carried out using the example above, but using the usual minimum design factor for PVC-U.

$$p = \frac{20 \cdot 8.1 \cdot \left(\frac{15.5}{2.5}\right)}{(110 - 8.1)} = 9.9 \text{ bar}$$



The calculation shown applies only to freely moving piping systems. Pipe that are fixed in the axial direction (fixed installation) must be checked for buckling. In most cases such a check leads to a reduction of maximum inner pressure, as well as shorter distances between the support brackets. Furthermore, the forces that act on the fixed points must be taken into account. Contact your authorized GF Piping Systems representative for additional information.

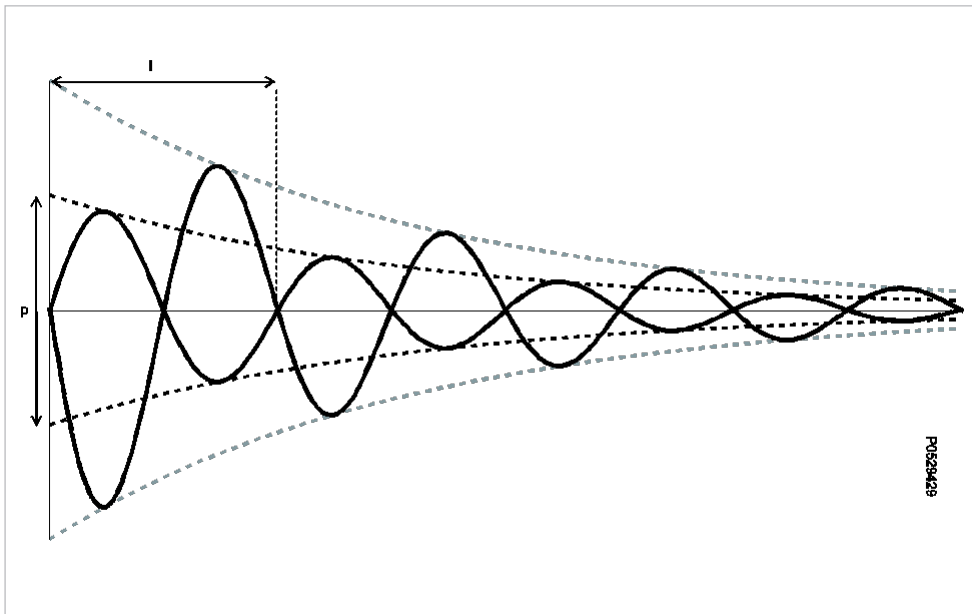
## 2.4 Water hammer

Water hammer is a term used to describe dynamic surges caused by pressure changes in a piping system. They occur whenever there is a deviation from the steady state, e.g. when the flow rate is changed, and may be transient or oscillating.

Water hammers may be generated by the following:

- Opening or closing a valve
- Pump startup or shutdown
- Change in pump or turbine speed
- Wave action in a feed tank
- Trapped air

The pressure wave created by water hammers causes the piping system to expand and contract. In the process the propagation speed of the pressure wave is limited by the speed of sound in the corresponding medium. The energy carried by the wave is dissipated in the piping system and the waves are progressively damped, see the following figure:



Damped pressure wave

$l$  Wave length

$p$  Pressure change

The maximum positive or negative addition of pressure is a function of flow rate, bulk modulus of elasticity of the fluid, pipe dimension and the modulus of elasticity of the pipe material. It can be calculated by using the following steps.



### 1 Determine the velocity of the pressure wave

$$V_w = \sqrt{\frac{K}{\rho \cdot \left(1 + \frac{K \cdot d_i}{e \cdot E}\right)}}$$

$V_w$	Velocity of pressure wave (m/s)
$K$	Bulk modulus of elasticity of fluid (Pa)
$\rho$	Fluid density (kg/m <sup>3</sup> )
$E$	Modulus of elasticity of pipe wall (Pa)
$d_i$	Inner diameter of pipe (mm)
$e$	Pipe wall thickness (mm)

The modulus of elasticity of pipe made of thermoplastic polymers varies with the operating duration and temperature. Hence, operating duration and temperature must be known for a precise calculation of water hammers.

### 2 Calculate maximum pressure change due to water hammers

$$\Delta p = V_w \cdot \Delta v \cdot \rho / 10^5$$

$\Delta p$	Maximum pressure change (bar)
$V_w$	Pressure wave velocity (m/s) (see step 1)
$\Delta v$	Change in fluid velocity (m/s) = (v1-v2)
$v_1$	Velocity of fluid before change (m/s)
$v_2$	Velocity of fluid after change (m/s)
$\rho$	Fluid density (kg/m <sup>3</sup> )

All pressure increases induced by a flow reduction will have a corresponding pressure drop on the other side (vacuum). If this exceeds the expected static minimum operating pressure, the calculated pressure must be compared to the pressure at which the pipe collapses in order to evaluate the safety factor in step 4.

### 3 Calculate the maximum and minimum total pressures

$$p_{\max} = p + \Delta p$$

$$p_{\min} = p - \Delta p$$

$p_{\max}$	Maximum total pressure (bar)
$p_{\min}$	Minimum total pressure (bar)
$p$	Expected operating pressure (bar)
$\Delta p$	Change due to water hammer (calculated in step 2)

### 4 Calculate the effective safety factor

$$C_{\max} = \frac{20 \cdot \sigma \cdot e}{p_{\max} \cdot (d - e)}$$

$C_{\max}$	Safety factor (dimensionless)
$\sigma$	Circumferential stress (N/mm <sup>2</sup> )
$t$	Pipe thickness (mm)
$d$	Outside diameter of pipe (mm)
$p_{\max}$	Maximum total pressure (bar) (calculated in step 3)

The value for the circumferential stress can be found in the creep curves. As most water hammers last for a matter of seconds, the value for a load duration of 0.1 h can be used. The exception to this rule is when the water hammers are oscillating (e.g. from a positive displacement pump). In this case the system must be treated as if a load equal to the maximum total pressure ( $p_{\max}$ ) existed throughout the entire service life of the pipe.

## 5 Safety factors

For infrequent water hammers the common minimum values can be used as safety factors.

For periodic water hammers the factor should be at least 3.

If the safety factor found in step 4 does not meet these criteria for safe operation, an increase in pipe diameter should be considered, or measures should be taken to reduce the occurrence of water hammers (e.g. powered valves, surge tanks, slow start-up pumps).

When using powered valves, valves are commonly designed with closure times greater than the critical period  $T_c$  to reduce water hammer. The critical period is the time a pressure wave needs to complete one cycle in the pipeline.

$$T_c = \frac{2 \cdot L}{V_w}$$

$T_c$	Critical period (s)
$L$	Pipe length (m)
$V_w$	Pressure wave velocity (m/s) (see step 1)

### Example



A water pipeline from a storage tank is connected to a main valve that is hydraulically activated with an electrical remote control. The valve closing time is 1.5 s and the water flow rate is  $Q = 35 \text{ m}^3/\text{h}$ .

Material	PP-H
Outside diameter	110 mm
Wall thickness	10 mm
Pipeline length	500 m
Operating temperature	+40 °C
Modulus of elasticity	$E = 800 \text{ N/mm}^2 = 800 \times 10^6 \text{ Pa}$
Water density	$\rho = 10^3 \text{ kg/m}^3$
Bulk modulus of elasticity of water	$K = 2.05 \text{ GPa}$

#### 1 Calculating the velocity of the pressure wave

$$V_w = \sqrt{\frac{2.05 \cdot 10^9}{10^3 \cdot \left(1 + \frac{90 \cdot 2.05 \cdot 10^9}{10 \cdot 800 \cdot 10^6}\right)}} = 292 \text{ m/s}$$

#### 2 Calculating the fluid velocity before the change

$$v_1 = \frac{\text{Volume flow}}{\text{cross-sectional area}}$$

$$v_1 = \frac{35/3600 \text{ m}^3/\text{s}}{\pi \cdot (0.09/2)^2 \text{ m}^2} = 1.53 \text{ m/s}$$

Assume water velocity goes to zero after the valve is closed, i.e.  $\Delta v = 1.53 \text{ m/s}$ .

#### Pressure change

$$\Delta p = 292 \cdot (1.53) \cdot 1000/10000 = 4.47 \text{ bar}$$

**3** Calculating the maximum pressure

$$p_{\max} = 10 + 4.47 = 14.47 \text{ bar}$$

$\Delta p$  is less than  $p$ . Hence, the minimum pressure does not have to be taken into account.

**4** Calculating the circumferential stress

Find the circumferential stress in the PP-H long-term behavior. Take the value for a load duration of 0.1 h as, for non-oscillating water hammers, the pipe needs to withstand this extra pressure for only a matter of seconds.

$$\sigma = 17.5 \text{ N/mm}^2$$

$$C = \frac{20 \cdot \sigma \cdot e}{p_{\max} \cdot (d - e)}$$

$$C = \frac{20 \cdot 17.5 \cdot 10}{14.47 \cdot (110 - 10)} = 2.42$$

**5** Calculating the maximum safety factor

The minimum safety factor for PP-H can be set to 2.0. Here,  $C = 2.42 > 2.0$ , so this piping is suitable for infrequent water hammers. However it would not be suitable if periodic water hammers occurred, because in that case we would need  $C > 3$ . Pipe dimensions or valve closing time would need to be adjusted in order to reduce water hammer.

## Calculating the critical period

$$T_c = \frac{2 \cdot L}{V_w} = \frac{2 \cdot 500 \text{ m}}{292 \text{ m/s}} = 3.4 \text{ s}$$

In this example, the valve closing time is less than the value of the critical period. By increasing the closing time above this critical period, water hammer would be reduced. The piping would then be suitable for all situations involving periodic water surges.

## 2.5 Piping systems in highly combustible locations/ transport of explosive media

The non-conductivity of most plastics has led to their widespread use in the electrical engineering and electronics industry. But this property can be a disadvantage under certain circumstances in other applications. In the case of plastic piping system construction, the question of electrostatic charging of the pipeline becomes important when electrically non-conductive media are to be transported or when the pipe are to be installed in highly combustible locations. In both of these cases electrostatic charging of the material is not only a disadvantage but could even be dangerous.

ABS, PVC-U, PVC-C, PE, PP, PVDF and ECTFE belong to the class of electrically non-conductive materials. Electrically non-conductive materials are those whose specific resistance exceeds  $10^6 \Omega\text{cm}$ . The values for the materials listed above are on the order of  $10^{15} \Omega\text{cm}$ . Whenever specific resistance in solids exceeds  $10^9 \Omega$  the material is deemed to be subject to electrostatic charging.

For example, in the mining industry safety dictates that plastics be used only if their specific resistance does not exceed  $10^8 \Omega\text{cm}$  (measured at  $20^\circ\text{C}$  and 5 % relative humidity).

Similar restrictions apply to the installation of plastic pipe wherever flammable mixtures could occur. No danger arises from the use of plastic pipe to transport flammable gases or fluids as long as this is a closed system. Slower flow rates also reduce the accumulation of electrostatic charges. It is possible in principle to make non-conductive plastics conductive by means of special measures, e.g. adding carbon. But such additives could adversely affect other desirable properties. It is therefore imperative to evaluate each case individually to decide which material offers the best solution.

Whenever plastic piping is to be installed in rooms where explosive gas-air mixtures could arise, and whenever plastic pipe are used for the transport of electrically non-conductive media, the following must be considered during planning.

### Installation of pipe in rooms where explosive gas-air mixtures can occur:

- Avoid the accumulation of explosive mixtures by providing for e.g. good ventilation or air extraction.
- Avoid the accumulation of electrical charge by ionizing the atmosphere.
- Discharge static electricity, e.g. by coating the pipe surface with an electrically conductive, solvent-free paint containing metallic powder or by wrapping the pipe in a conductive foil. It is essential that the pipe be grounded.
- Avoid the accumulation of electrical charges by increasing the relative humidity of the air. A conductive film of water on the surface of the pipe improves conductivity. There is hardly any accumulation of electrostatic charges when relative humidity exceeds 65 %.
- We advise strongly against relying solely on treating the pipeline with an antistatic and hygroscopic solution to improve its conductivity, because this measure is usually only effective for a limited period and accidental partial removal of the protective film cannot be ruled out.

### Transport of electrically non-conductive media:

As a rule plastic pipe are not to be recommended for the transport of dry substances that are electrically non-conductive due to the effects of accumulating electrostatic charges and extensive wear on the material. Electrically non-conductive combustible gases or fluids can only be transported in closed pipeline systems.

## 2.6 Piping systems for transporting compressed air

### Introduction

Plastic piping systems have been used to transport compressed air for many years. Experience has shown that oil originating from compressors can be found to a greater or lesser extent in the compressed air. This can only be avoided by installing, and regularly servicing, a separation filter installed after the compressor. The composition of the oils used varies considerably, and the oils may also contain aromatic substances. In addition to the effect that the compressor oils may have on the material used for the piping, we must also take into account the fracture characteristics of the material.

### Recommended material for compressed air piping systems

#### PE (polyethylene) or PB (polybutene)

Both materials are lightweight, easy to install and corrosion-free proof; they also have the advantage of high tensile strength. Therefore, GF Piping Systems recommends polyethylene up to a minimum temperature of  $-40\text{ }^{\circ}\text{C}$  (e.g. outdoor applications), polybutylene up to a minimum temperature of  $0\text{ }^{\circ}\text{C}$  (e.g. indoor installation). Explosive fractures do not occur if the operating instructions are followed.

PE and PB are generally chemically resistant to compressor oils. Only a few oils that contain esters or aromatics, should not be used. Sealing materials, such as NBR or FKM, which are regularly used for compressed air networks, are in danger in such cases.

In order to simplify the selection of a compressor oil by the operator of a compressed air system, we have summarized many of the oils offered on the market and have divided them into sections according to their chemical structure. After consulting the oil supplier, it is also possible to choose an oil that is not on the list, since we do not claim that the list is complete. The type of oil used must be included in one of the categories deemed suitable by GF. GF Piping Systems recommends that you coordinate the selection of the oil with the manufacturer of the compressor.

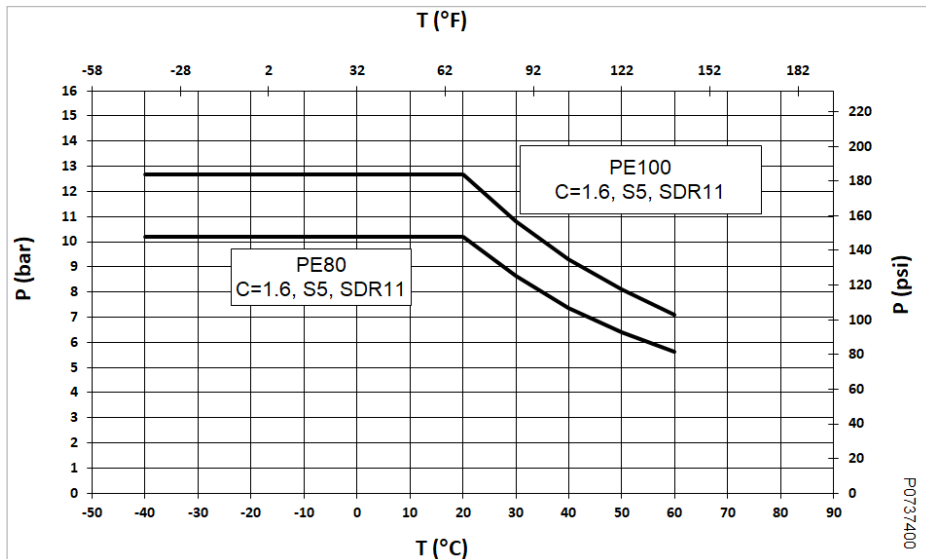
### Suitability of air compressor oils for compressed air lines made of polyethylene

Refined petroleum products (mineral oils)	Recommended
Paraffinic oils, aliphatic hydrocarbons	✓
Naphthenic oils, alicyclic hydrocarbons	✓
Aromatic oils	x
Synthetic oils (with O as an additional element of molecular structure)	Recommended
Polyalkylene glycols	✓
Poly- $\alpha$ -olefins	✓
Polyesters	x
Di-esters	x
Synthetic oils (with Si, P, N or F as an additional element of molecular structure)	Recommended
Silicone oils	✓
Phosphoric esters	x
Aromatic amines	x
Fluorine esters	x
Poly- $\alpha$ -olefins/polyol esters	x

### Maximum allowable operating pressure for PE compressed air lines

The following pressure-temperature diagram (PE80 and PE100) for compressed air piping systems made of polyethylene should be taken into account. This diagram is based on a service life of 25 years and a design factor of 1.6. The ambient temperature has to be taken into account, for example for an installation under a sunny roof or in a room with compressors running. For safety reasons, GF Piping Systems recommends using SDR11 or SDR7.4 for compressed-air piping systems.

**⚠ In case of long-term operating pressures at temperatures above +40 °C, please contact your authorized GF Piping Systems representative.**

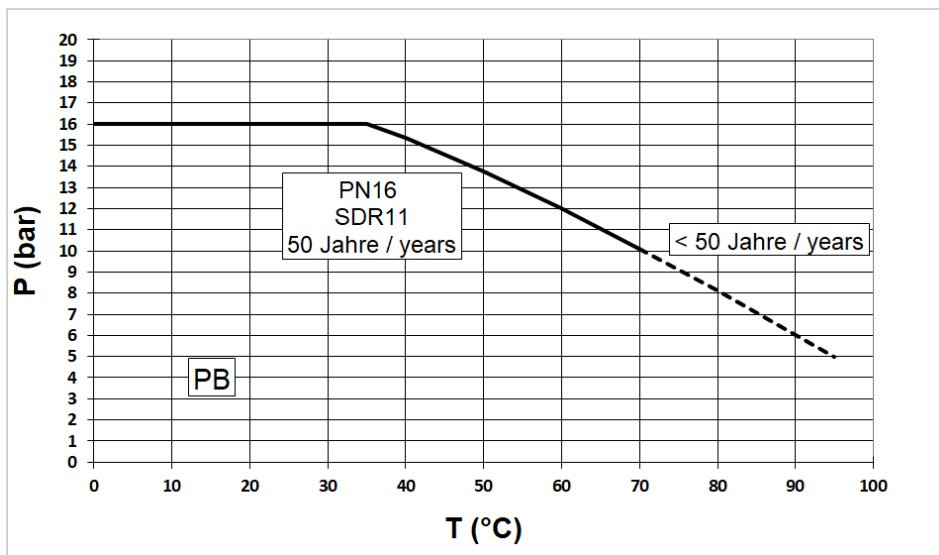


P Permissible pressure (bar, psi)  
 T Ambient temperature (°C, °F)

### Maximum allowable operating pressure for PB compressed air lines

The following pressure-temperature diagram for compressed air piping systems made of polybutylene (PB) should be taken into account. This diagram is based on a service life of 25 years and a design factor of 1.6. The ambient temperature has to be taken into account, for example for an installation under a sunny roof or in a room with compressors running. For safety reasons, GF Piping Systems recommends using SDR11 for compressed-air piping systems from PB.

**⚠ In case of long-term operating pressures at temperatures above +70 °C, please contact your authorized GF Piping Systems representative. Don't use PB lines for compressed air below 0°C!**



P Permissible pressure (bar, psi)  
 T Ambient temperature (°C, °F)

## 2.7 Piping systems under vacuum

The mechanical load at absolute vacuum corresponds to a differential partial vacuum of 1 bar, i.e. the effective pressure on the pipe's inner wall is 1 bar less than the pressure on the outer wall at standard atmospheric pressure.

In case of a differential partial vacuum special attention must be paid to the dimensional stability of the pipe. It can be calculated with the classic buckling formula for cylindrical pipe:

$$P_k = \frac{E_c}{4 \cdot (1 - \mu^2)} \cdot \left(\frac{e}{r}\right)^3$$

$P_k$  Critical buckling pressure (N/mm<sup>2</sup>) (1 N/mm<sup>2</sup> = 10 bar)  
 $E_c$  Long-term creep modulus (N/mm<sup>2</sup>)  
 $\mu$  Poisson's ratio  
 $e$  Pipe wall thickness (mm)  
 $r$  Mean pipe radius (mm)

A pipe at absolute vacuum (differential partial vacuum 1 bar) is adequately dimensioned against buckling when the critical buckling pressure  $P_k = 2$  bar, i.e. when a minimum design factor of 2 is used for calculation. Any influence caused by out-of-roundness and eccentricity must be taken into account separately. Under these assumptions, the following maximum application temperatures arise for the various pipe materials (taking into account the general application temperature limits for the specific material), see the table below. Thinner-walled pipe series are unsuitable for these conditions.

(25 year values: Poisson's ratio  $\mu = 0.4$ ; design factor = 2)

### 2.7.1 Pipe

#### Maximum application temperatures under vacuum (1 bar differential partial vacuum)

Material	PN (bar)	SDR	Temperature (°C)
ABS	10	17	60
	16	11	60
PVC-U	10	21	40
	16	13.6	60
PVC-C	10	21	70
	16	13.6	80
PE80	10	11	50
PE100	16	11	60
PP	10	11	80

#### Maximum application temperatures under vacuum (1 bar differential partial vacuum) or under 0.4 bar differential partial vacuum for PVDF PN10 system

Material	PN (bar)	SDR	Max. temperature (°C)
PVDF for $\Delta p = 0.4$ bar	10	33	20
PVDF for $\Delta p = 1.0$ bar	16	21	40
ECTFE for $\Delta p = 1.0$ bar	10	21	40

### 2.7.2 Fittings

Since GF Piping Systems fittings have a typically greater wall thickness compared to pipe, they are not critical in vacuum applications and do not have to be taken into account when determining the application temperatures.

### 2.7.3 Mechanical connections

Similar to fittings, mechanical connections feature a typically greater wall thickness compared to pipe. However, the vacuum resistance of the gaskets must be observed. The permissible vacuum for mechanical connections is listed in the following table:

Connection type	Permissible vacuum (differential partial vacuum) (bar)
Union	1
Threaded connection	1
Flange connection, flat gasket	Not possible
Flange connection, profile seal	1
Flange connection, O-ring seal	1

### 2.7.4 Valves

Ball valves are the preferred valves for vacuum applications. The permissible vacuum for valves is listed in the following table:

Valve type	DN (mm)	Permissible vacuum (differential partial vacuum) up to a maximum temperature of 50 °C (bar)
Ball valve type 546	10 - 100	1
Ball valve type 375	10 - 100	0.8
Diaphragm valve types 514-519, 314-319	15 - 50	0.5
Butterfly valve types 565, 578, 567	65 - 200	1
	250, 300	0.65



## 2.8 Piping systems for surface finishing and varnishing technology

### 2.8.1 Silicone-free/cleaned

Growing environmental awareness, continuously increasing requirements and regulations in the field of toxic substances emission (TA air) have led to the development of water-soluble paints and varnishes. With new varnishing technologies, up to 90 % of the emission values can be reduced.

For the production, transport and processing of water-soluble paints and varnishes only pipeline components that do not contain substances which interfere with the varnishing process, such as silicones, certain greases, oils and waxes, may be used.

#### GF Piping Systems – An experienced partner

GF Piping Systems has worked closely from the beginning with manufacturers, plant constructors and operators in this special sector of surface finishing and varnishing technology. GF Piping Systems has successfully supplied plant constructors and users of varnishing processes for years, e.g. the automotive industry.

Production meets the most rigorous demands:

- Silicone-free separating agents in the paint shop
- Care in cleaning, installation and packing
- Quality assurance system certified according to ISO 9001

### 2.8.2 Fittings

The composition of the raw material (granulate) is silicone-free. All standard fittings are produced in a silicone-free environment. Following injection molding, the fittings are either directly packed, or if specified, cleaned in a special cleaning process to ensure the silicone-free and point-compatible characters.

### 2.8.3 Valves and unions

The individual components of the valves and unions are cleaned with distilled water in a special cleaning process. They are assembled in a special working silicone-free area.

Sliding components are lubricated slightly with special lubricants that can be varnished. Valves and unions are individually packed in a sealed bag. The packaging of the products ensures the silicone-free characteristics during transport and storage.

## 2.9 Gaskets

Gaskets undergo the same production, cleaning and packing processes as valves and unions.



#### Maintenance

For safety reasons we recommend replacing the entire body when disassembling the valve.

# 3 Hydraulic Calculation and Pressure Losses

## 3.1 Hydraulic calculation

### 3.1.1 Required pipe diameter

#### Formulas

The following formula can be used for a first approximation of the pipe diameter required for a given flow rate:

$$d_i = 18.8 \cdot \sqrt{\frac{Q_1}{v}} \quad \text{or} \quad d_i = 35.7 \cdot \sqrt{\frac{Q_2}{v}}$$

$v$  Flow velocity (m/s)  
 $d_i$  Pipe inner diameter (mm)  
 $Q_1$  Flow rate (m<sup>3</sup>/h)  
 $Q_2$  Flow rate (l/s)  
 18.8 Conversion factor for units Q1 (m<sup>3</sup>/h)  
 35.7 Conversion factor for units Q2 (l/s)

The flow velocity must be approximated according to the intended use of the pipeline. Standard values for the flow velocity are:

#### Liquids

$v = 0.5 - 1.0$  m/s for the suction side

$v = 1.0 - 3.0$  m/s for the pressure side

#### Gases

$v = 10 - 30$  m/s

The calculations of pipe diameter have not taken into account hydraulic losses. They have to be calculated separately as described in the following sections.

(m <sup>3</sup> /h)	(l/min)	(l/s)	(m <sup>3</sup> /s)
1.0	16.67	0.278	2.78 x 10 <sup>-4</sup>
0.06	1.0	0.017	1.67 x 10 <sup>-5</sup>
3.6	60	1.0	1.00 x 10 <sup>-3</sup>
3'600	60'000	1'000	1.0

Conversion table with units for flow rate

√ Example for calculating the inner diameter  $d_i$

PP pipe SDR11  
 Flow volume  $Q_2$  8 l/s  
 Flow velocity  $v$  1.5 m/s

$$d_i = 35.7 \cdot \sqrt{\frac{8}{1.5}} = 82.4 \text{ mm}$$

A pipe with DN80 (3" inch) is used. After defining the inner diameter, the real flow velocity can be calculated with the following formula:

$$v = 354 \cdot \frac{Q_1}{d_i^2} = 1.9 \frac{\text{m}}{\text{s}} \quad \text{or} \quad v = 1275 \cdot \frac{Q_2}{d_i^2} = 1.9 \frac{\text{m}}{\text{s}}$$

$v$  Flow velocity (m/s)  
 $d_i$  Pipe inner diameter (mm)  
 $Q_1$  Flow rate (m<sup>3</sup>/h)  
 $Q_2$  Flow rate (l/s)  
 354 Conversion factor for units  $Q_1$  (m<sup>3</sup>/h)  
 1275 Conversion factor for units  $Q_2$  (l/s)

**Correlation of outer diameter – Inner diameter**

To find the outside diameter using the inside diameter and the applicable SDR, use the following formula:

$$d = d_i \cdot \frac{\text{SDR}}{\text{SDR} - 2}$$

**3.1.2 Correlation of outside diameter to inside diameter for SDR13.6, SDR21 and SDR33**

$d_i$ (mm)	SDR33 PVDF $d$ (mm)	$d_i$ (mm)	SDR13.6 PVC-U, PVC-C $d$ (mm)	$d_i$ (mm)	SDR21 PVC-U, PVDF, ECTFE $d$ (mm)
85	90	17	20	16	20
103	110	21	25	21	25
117	125	27	32	28	32
132	140	34	40	36	40
150	160	43	50	45	50
169	180	54	63	57	63
188	200	64	75	68	75
211	225	77	90	81	90
235	250	94	110	100	110
263	280	107	125	113	125
296	315	119	140	127	140
333	355	136	160	145	160
375	400			163	180
422	450			181	200
				204	225
				226	250
				253	280
				285	315
				362	400

## Correlation of outside diameter to inside diameter for SDR11 and SDR17

$d_i$ (mm)	SDR11 PE, PP d (mm)	$d_i$ (mm)	SDR17, SDR17.6 ABS, PE, PP d (mm)
16	20	16	20
20	25	21	25
26	32	28	32
33	40	35	40
41	50	44	50
52	63	56	63
61	75	66	75
74	90	79	90
90	110	97	110
102	125	110	125
115	140	124	140
131	160	141	160
147	180	159	180
164	200	176	200
184	225	199	225
205	250	221	250
229	280	247	280
258	315	278	315
290	355	313	355
327	400	353	400
368	450	397	450
409	500	441	500
458	560	494	560
515	630	556	630
581	710	626	710
655	800	705	800

### 3.1.3 Nomogram for easy determination of diameter and pressure loss

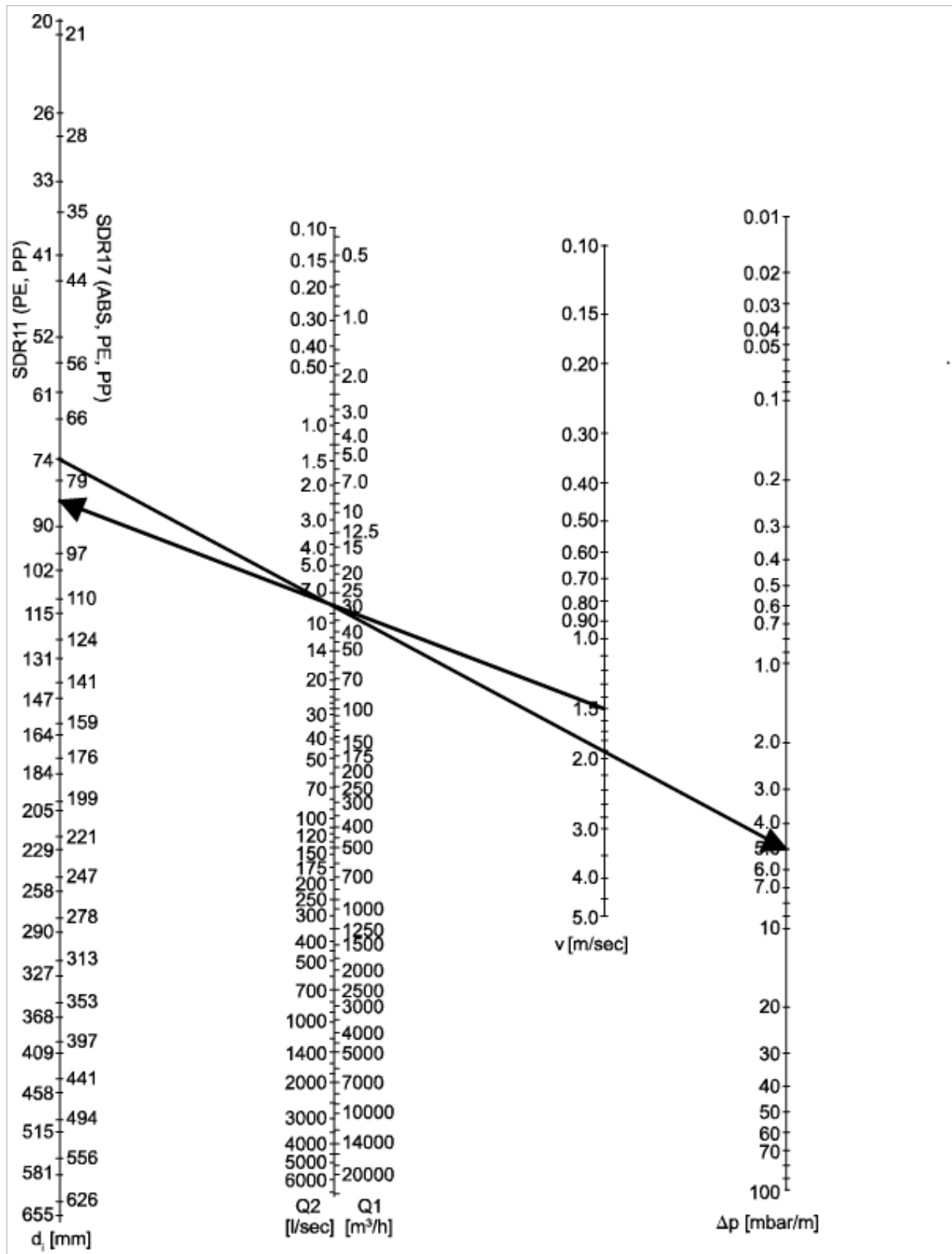
The following nomogram simplifies the determination of the required diameter. In addition, the pressure loss of the pipe per meter pipe length can be read off.



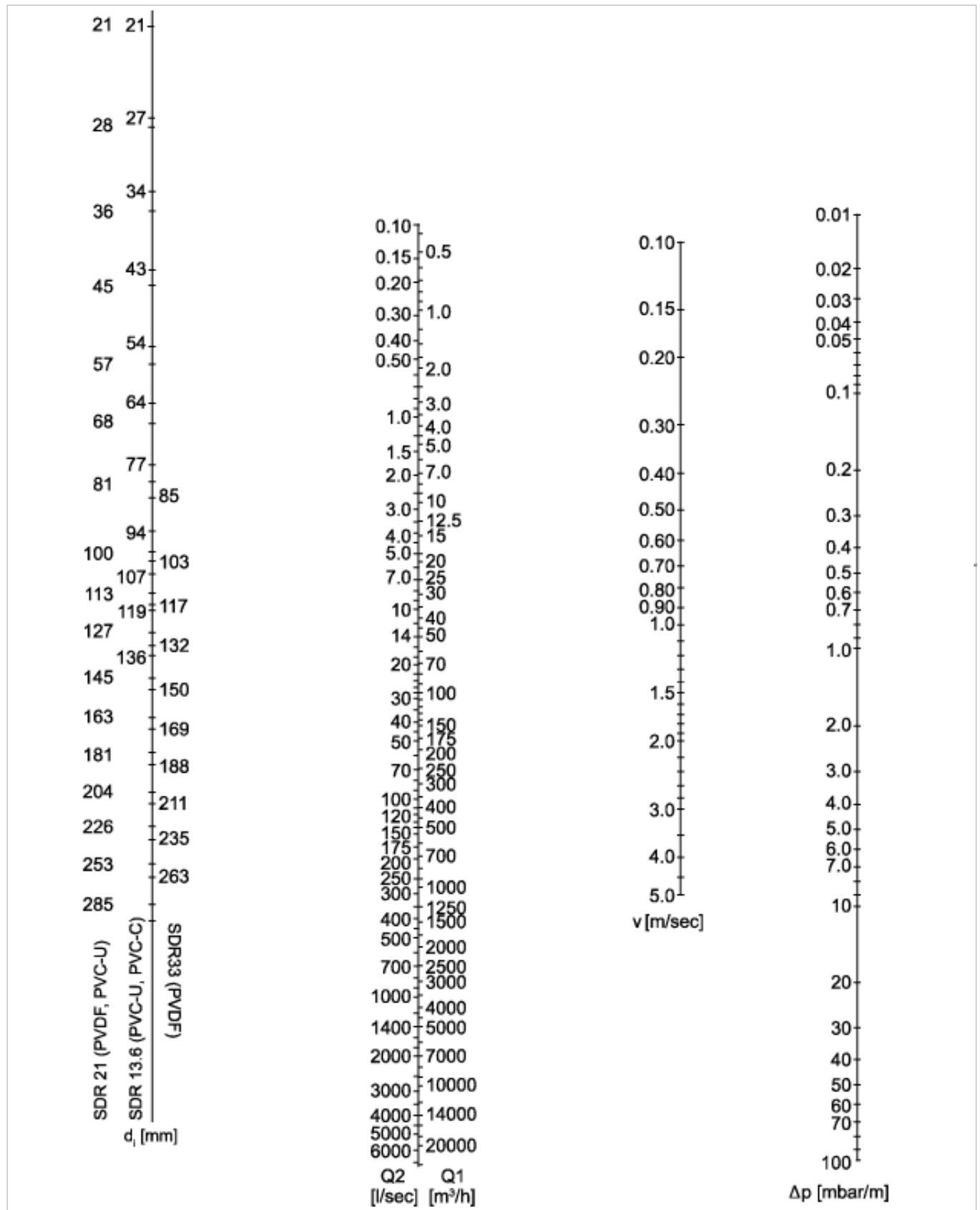
The determined pressure loss from the nomogram applies only to a density of the flow medium of 1,000 kg/m<sup>3</sup>, e.g. for water. Further pressure losses of fittings, valves, etc. have to be considered as shown in the following.

### 3.1.4 Using the nomogram

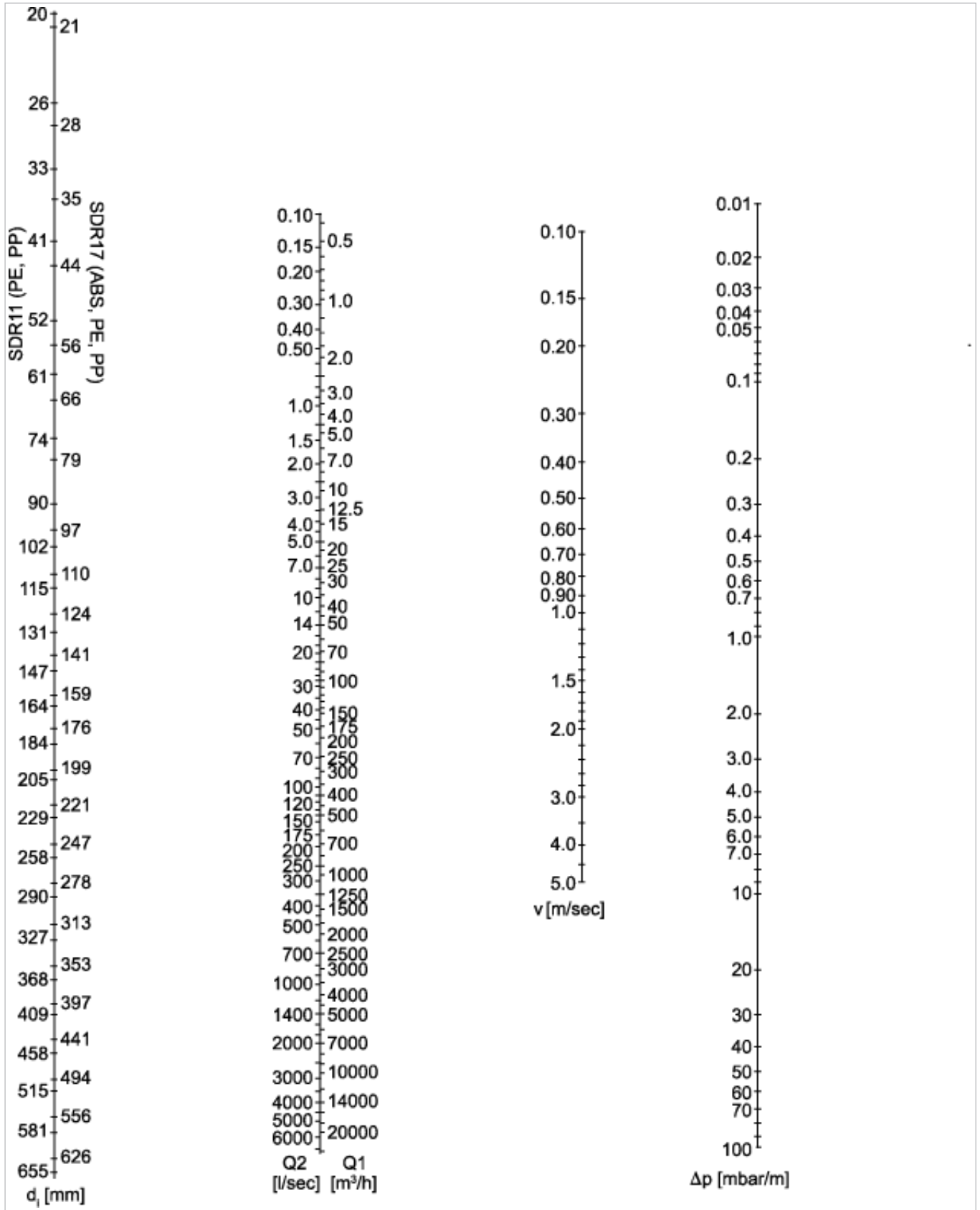
Based on a flow velocity of 1.5 m/s, a line is drawn through the desired flow rate (e.g. 30 m<sup>3</sup>/h) to the axis with an inner diameter of di (≈ 84 mm). Then select a diameter nearby (74 mm for SDR11) and draw a 2nd line through the desired flow rate up to the pressure loss axis Δp (5 mbar per meter pipe).



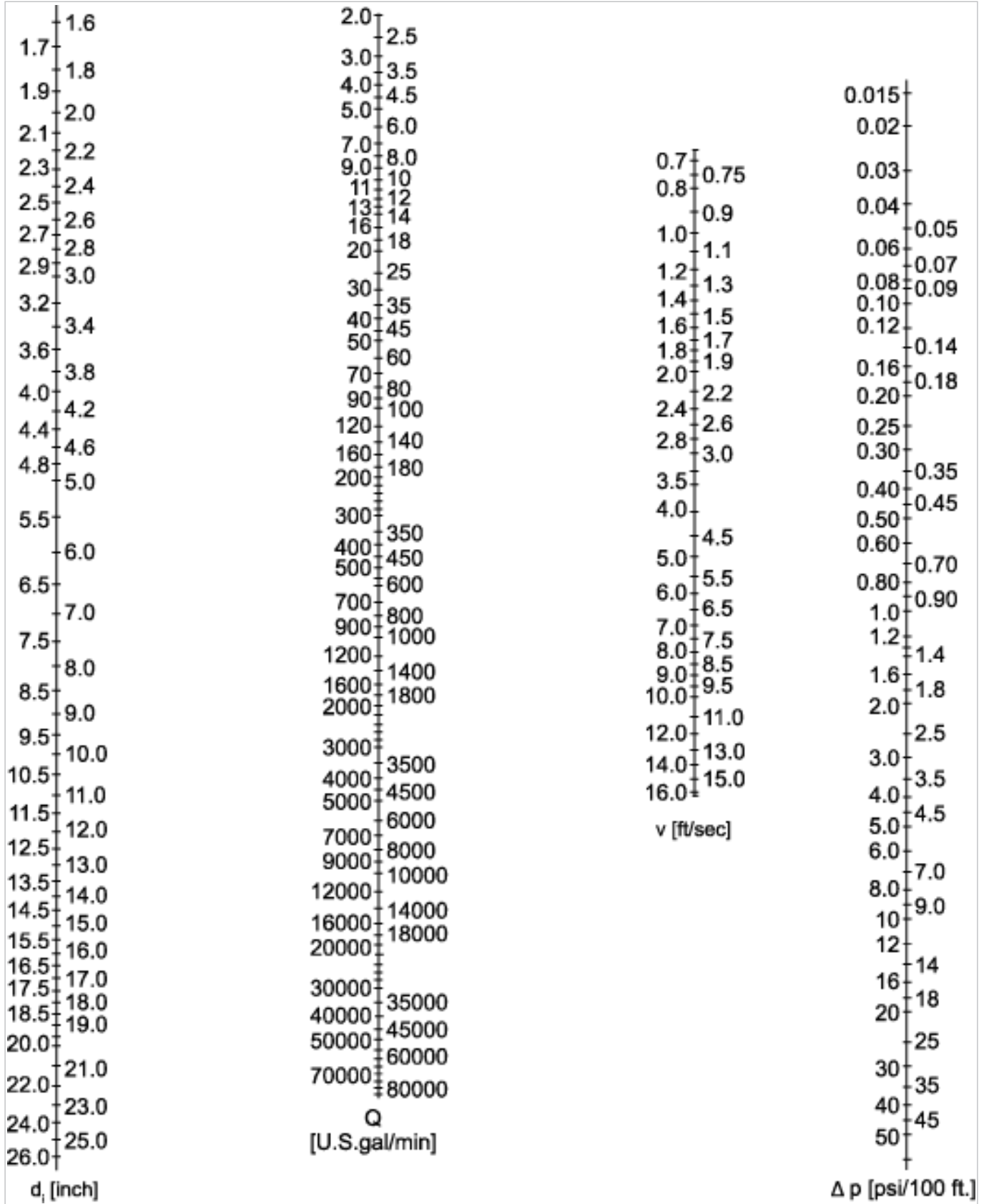
Nomogram for pipe SDR13.6, SDR21, SDR33 using the metric system



Nomogram for pipe SDR21, SDR17, SDR33 using the metric system



Nomogram for inch pipe





## 3.2 Pressure loss

### 3.2.1 Pressure loss in straight pipe

When calculating the pressure loss in straight pipe lengths there is a distinction between laminar and turbulent flow. The important unit of measurement is the Reynold's number (Re). The changeover from laminar to turbulent flow occurs at the critical value, Reynold's number  $Re_{crit} = 2320$ .

Laminar flow occurs, in practice, particularly in the transport of viscous media such as lubricating oils. In the majority of applications, including media similar to water, a turbulent flow, having an essentially steadier velocity than laminar flow in a cross-section of pipe, occurs.

The pressure loss in a straight length of pipe is inversely proportional to the pipe diameter and is calculated by the following formula:

$$\Delta p_R = \lambda \cdot \frac{L}{d_i} \cdot \frac{\rho}{2 \cdot 10^2} \cdot v^2$$

$\Delta p_R$	Pressure loss in a straight length of pipe (bar)
$\lambda$	Pipe friction factor
L	Length of the straight length of pipe (m)
$d_i$	Pipe inner diameter (mm)
$\rho$	Density of flow media (kg/m <sup>3</sup> ) (1 g/cm <sup>3</sup> = 1000 kg/m <sup>3</sup> )
v	Flow velocity (m/s)

**!** In practice, when making a rough calculation (i.e. smooth plastic pipe and turbulent flow) it is enough to use the value  $\lambda = 0.02$  to represent the hydraulic pressure loss.

### 3.2.2 Pressure loss in fittings

#### Coefficient of resistance

The pressure losses depend upon the type of fitting as well as on the flow in the fitting. The so-called coefficient of resistance ( $\zeta$ -Wert) is used for calculations.

Fitting type	Coefficient of resistance $\zeta$ bending radius R	$\zeta$ -value
90° bend	1.0 • d	0.51
	1.5 • d	0.41
	2.0 • d	0.34
	4.0 • d	0.23
45° bend	1.0 • d	0.34
	1.5 • d	0.27
	2.0 • d	0.20
	4.0 • d	0.15
90° elbow		1.2
45° elbow		0.3
Tee <sup>1</sup>		1.3
Reduction (contraction)		0.5
Reduction (extension)		1.0
Connections (flanges, unions, fusioning between two pipe)	d > 90 mm: 0.1	
	20 ≤ d ≤ 90 mm: 1.0 bis 0.1:	
	d20: 1.0	d50: 0.6
	d25: 0.9	d63: 0.4
	d32: 0.8	d75: 0.3
	d40: 0.7	d90: 0.1

<sup>1</sup> For a more detailed view, differentiate between coalescence and separation. Values for z up to a maximum of 1.3 can be found in the respective literature. Usually the part of a tee in the overall pressure loss is very small, therefore in most cases  $\zeta = 1.3$  can be used.

### Calculation of pressure loss

To calculate the total pressure loss in all fittings in a pipeline, take the sum of the individual losses, i. e. the sum of all the  $\zeta$ -values. The pressure loss can then be calculated according to the following formula:

$$\Delta p_{Fi} = \Sigma \zeta \cdot \frac{v^2}{2 \cdot 10^5} \cdot \rho$$

$\Delta p_{Fi}$	Pressure loss of fittings (bar)
$\Sigma \zeta$	Sum of the individual losses
$v$	Flow velocity (m/s)
$\rho$	Density of the medium transported in $\text{kg/m}^3$ ( $1 \text{ g/cm}^3 = 1,000 \text{ kg/m}^3$ )

#### 3.2.3 Pressure loss in valves

The  $k_v$  factor is a convenient means of calculating the hydraulic flow rates for valves. It allows for all internal resistances and for practical purposes is regarded as reliable. It is defined as the flow rate of water in liters per minute with a pressure drop of 1 bar across the valve. The technical data of the GF Piping Systems valves contains the  $k_v$  values as well as pressure loss charts. The latter make it possible to read off the pressure loss directly. But the pressure loss can also be calculated from the  $k_v$  value according to the following formula:

$$\Delta p_{Ar} = \left( \frac{Q}{k_v} \right)^2 \cdot \frac{\rho}{1000}$$

$\Delta p_{Ar}$	Pressure loss of valve (bar)
$Q$	Flow rate ( $\text{m}^3/\text{h}$ )
$\rho$	Density of the medium transported ( $\text{kg/m}^3$ ) ( $1 \text{ g/cm}^3 = 1,000 \text{ kg/m}^3$ )
$k_v$	Valve flow characteristic ( $\text{m}^3/\text{h}$ )

#### 3.2.4 Pressure difference from static pressure

If the pipeline is laid vertically, a geodetic pressure difference must also be calculated. This pressure difference is calculated as follows:

$$\Delta p_{\text{geod}} = \Delta H_{\text{geod}} \cdot \rho \cdot 10^{-4}$$

$\Delta p_{\text{geod}}$	Geodetic pressure difference (bar)
$\Delta H_{\text{geod}}$	Difference in elevation of the pipeline (m)
$\rho$	Density of media ( $\text{kg/m}^3$ ) ( $1 \text{ g/cm}^3 = 1,000 \text{ kg/m}^3$ )

### 3.2.5 Sum of pressure losses

The sum of all the pressure losses in the pipeline is given by:

$$\Sigma\Delta p = \Delta p_R + \Delta p_{Fi} + \Delta p_{Ar} + \Delta p_{geo}$$

#### Example of a pressure loss calculation

The following example shows the calculation to determine the pressure loss of a pipeline:

		Number of fittings
PVDF pipe	d40 mm	12 x elbow 90°
SDR 21 - flow rate	1.5 l/s	4 x elbow 45°
Medium	Zinn (II)-chlorid	3 x tees
Density of medium	1.9 g/cm <sup>3</sup>	3 x unions
Length of straight pipe sections	15 m	2 x flange connections
Elevation difference	2.0 m	1 x diaphragm valve, 30 % opened

The wall thickness of this pipeline can be calculated as follows with the SDR:

$$e = \frac{d}{SDR} = \frac{40 \text{ mm}}{21} = 1.9 \text{ mm}$$

The inner diameter of the pipeline is as follows:

$$d_i = d - 2 \cdot e = d - \frac{2 \cdot d}{SDR} = 36.2 \text{ mm}$$

With the required flow rate of 1.5 l/s, the flow velocity is as follows:

$$v = 1275 \cdot \frac{Q_2}{d_i^2} = 1275 \cdot \frac{1.5 \text{ m}^3/\text{sec}}{36.2^2} = 1.46 \frac{\text{m}}{\text{sec}}$$

Pressure loss	Formula
Pressure loss of strait pipe	$\Delta p_r = 0.02 \cdot \frac{15}{36.2} \cdot \frac{1900}{2 \cdot 10^2} \cdot 1.46^2 = 0.17 \text{ bar}$
Pressure loss of fittings and connections	$\Sigma \zeta = (12 \cdot 1.2) + (4 \cdot 0.3) + (3 \cdot 1.3) + (5 \cdot 0.7) = 23$ $\Delta p_{Fi} = 23 \cdot \frac{1.46^2}{2 \cdot 10^5} \cdot 1900 = 0.47 \text{ bar}$
Pressure loss of valve, 30 % opened. With the flow characteristics diagram for diaphragm valve, type 514, and 30% lift a percentile $k_v$ value of 50 % can be read out, that means 50 % of $k_v$ value 100: $0.5 \cdot 45.5 \text{ m}^3/\text{h}$ (flow rate 1.5 l/sec = $5.4 \text{ m}^3/\text{h}$ ):	$\Delta p_{Ar} = \left( \frac{5.4}{0.5 \cdot 45.5} \right)^2 \cdot \frac{1900}{1000} = 0.107 \text{ bar}$
Pressure loss of height difference	$\Delta p_{geod} = 2.0 \cdot 1900 \cdot 10^{-4} = 0.38 \text{ bar}$
Total pressure loss of the pipeline	$\Sigma \Delta p = 0.17 \text{ bar} + 0.47 \text{ bar} + 0.107 \text{ bar} + 0.38 \text{ bar} = 1.127 \text{ bar}$

Formulas for calculation of pressure losses

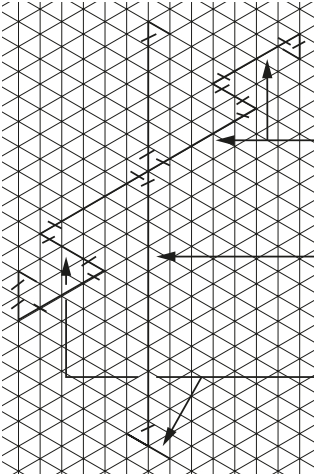
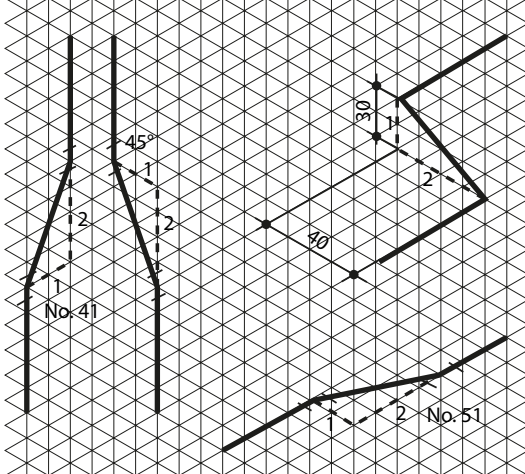
# 4 Installation

## 4.1 z-dimension method

### 4.1.1 Overview

The pressure of competition and high costs on site makes it essential to install pipeline systems efficiently. The GF Piping Systems method of assembly is highly suited to this task. It replaces the tedious and time-consuming cutting to size of one pipe at a time by a fast and precise way of preparing whole groups of pipe according to plans or jigs. The respective pipe group with the corresponding design dimensions and cut lengths can be entered in the isometric paper of GF Piping Systems.

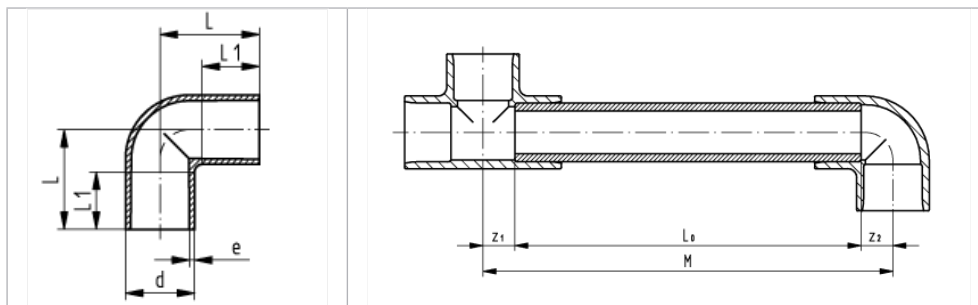
Please adhere to the following guidelines for drawing:

Pipe running perpendicular to one another	Pipe running diagonally
 <p>Horizontal: from left to right</p> <p>Vertical</p> <p>Horizontal: to front and rear</p>	

The z-dimensions of the fittings are needed for determining the actual cutting lengths of the pipe. The tables in our product ranges and in the online catalogues contain all the relevant data for the fittings. The length of pipe to be cut is given as in the following diagram by the distance between the center of adjoining fittings less the sum of the z-dimension of the fittings.

### 4.1.2 Procedure

#### Socket fusion and socket adhesive fittings



### Formula for determining the required pipe length

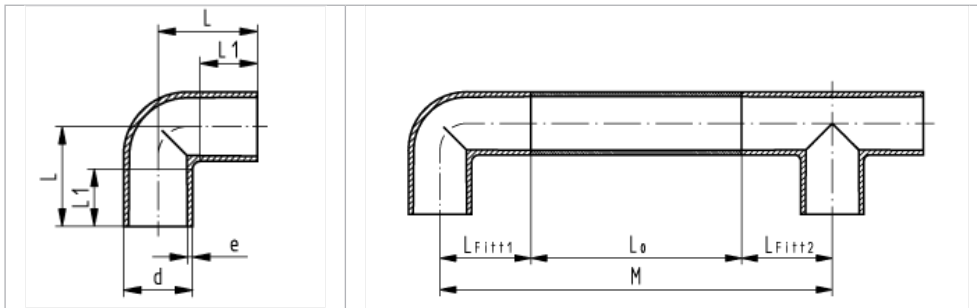
$$L_0 = M - z1 - z2$$

$L_0$	Length of pipe to be cut
$M$	Center-to-center distance of fitting
$z$	z-dimension of the fitting

#### √ Example

Material	PVC-U, d63, PN16
Center-to-center distance $M$	1000 mm
$z1$ (T 90°)	33 mm
$z2$ (angle 90°)	33 mm
$L_0 = 1000 \text{ mm} - 33 \text{ mm} - 33 \text{ mm} = 934 \text{ mm}$	

### Butt fusion fittings



### Formula for determining the required pipe length:

$$L_0 = M - L_{Fitt1} - L_{Fitt2} + L_{MatLoss}$$

$L_0$	Cut length of pipe
$L_{fitt}$	Length of fitting (z-dimension)
$M$	Distance center-to-center of fitting
$L_{MatLoss}$	Material loss through planning process and bead forming
	IR (infrared): $2 \times 2 \text{ mm} + 1 \text{ mm} = 5 \text{ mm}$
	BCF (bead and crevice-free): $2 \times 0.8$

#### √ Example

Material	PP-H, d63, SDR11, IR-fused
Center-center distance $M$	1000 mm
$L_{Fitt1}$ (T 90° equal)	66 mm
$L_{Fitt2}$ (elbow 90°)	66 mm
$L_{MatLoss}$	$2 \times 2 \text{ mm}$

Pipe and fitting are faced for each fusion. Two fusions result in  $2 \times 5 \text{ mm} = 10 \text{ mm}$ .

$$L_0 = 1000 \text{ mm} - 66 \text{ mm} - 66 \text{ mm} + 2 \cdot 5 \text{ mm} = 878 \text{ mm}$$

### 4.1.3 Material losses for IR fusion procedure

#### Fusion machine IR-63 M and IR-63 Plus

d (mm)	PP-natural SDR11 (mm)	PE100 SDR11 (mm)	PE100 <sup>1)</sup> SDR17.6 (mm)	PP-H SDR11 (mm)	PP-H <sup>1)</sup> SDR17.6 (mm)	PVDF (mm)	ECTFE (mm)	PVC-U SDR9/13.6 (mm)	PFA (mm)
20	5.0	5.5		5.0		4.5	4.5	4.5	4.5
25	5.0	5.5		5.0		4.5	4.5	4.5	4.5
32	5.0	5.5		5.0		4.5	4.5	4.5	4.5
40	5.0	6.0		5.0		4.5	4.5	4.5	4.5
50	5.0	6.0	6.0	5.0	5.5	4.5	4.5	4.5	4.5
63	5.5	6.0	6.0	5.0	5.5	4.5	4.5	4.5	4.5

<sup>1)</sup> only weldable on IR-63 M

#### Fusion machine IR-110 A and IR-110 Plus

d (mm)	PP-natural SDR11/17.6 (mm)	PE100 SDR11 (mm)	PE100 SDR17.6 (mm)	PP-H SDR11 (mm)	PP-H SDR17.6 (mm)	PVDF (mm)	ECTFE (mm)	PVC-U <sup>1)</sup> SDR9/13.6 (mm)	PFA <sup>2)</sup> (mm)
20	5.0	5.5		5.0		4.5	5.0	4.5	4.5
25	5.0	5.5		5.0		4.5	5.0	4.5	4.5
32	5.0	5.5		5.0		4.5	5.0	4.5	4.5
40	5.0	5.5		5.0		4.5	5.0	4.5	4.5
50	5.0	5.5	5.5	5.0	5.0	5.0	5.0	4.5	4.5
63	5.0	5.5	5.5	5.0	5.0	5.0	5.0	4.5	4.5
75	5.0	5.5	5.5	5.0	5.0	5.0	5.0		
90	5.0	5.5	5.5	5.0	5.0	5.0	5.0		
110	5.0	5.5	5.5	5.0	5.0	5.0	5.0		

<sup>1)</sup> only weldable on IR-110 A

<sup>2)</sup> only weldable on IR-110 Plus

#### Fusion machine IR-315 A, IR-400 A, IR-225 Plus and IR-315 Plus

d (mm)	PP-natural SDR11/17.6 (mm)	PE100 SDR11 (mm)	PE100 SDR17.6 (mm)	PP-H SDR11 (mm)	PP-H SDR17.6 (mm)	PVDF (mm)	ECTFE <sup>1)</sup> SDR21 (mm)
63	5.0	6.5		6.0	6.0	4.5	5.0
75	5.0	6.5		6.0	6.0	4.5	5.0
90	5.0	6.5		6.0	6.0	5.0	5.5
110	5.5	6.5	6.5	6.0	6.0	5.0	5.5
125		6.5	6.5	6.0	6.0	5.0	
140		6.5	6.5	6.0	6.0	5.0	
160		7.0	6.5	6.0	6.0	5.0	
180		7.0	6.5	6.0	6.0		
200		7.0	6.5	6.0	6.5	5.0	
225		7.0	6.5	6.0	6.5	5.0	
250		7.0	6.5	6.0	6.5	5.5	
280		7.0	6.5	6.0	6.5	5.5	
315		7.0	6.5	6.0	6.5	5.5	
350						5.5	
400						5.5	

<sup>1)</sup> only weldable on IR-225 Plus



Material loss is caused by facing 2mm on both pipe ends, plus the overlap.

Isometric paper

<b>+GF+</b> <b>GEORG FISCHER</b> PIPING SYSTEMS	Firma _____ Firme _____ Ditta _____	Dat. _____ Blatt Nr. _____ Feuille No. _____ Foglio No. _____	Pos. _____ M - M _____ - cm _____ L cm _____ Ø _____
	Unterteilungsblatt 30° Feuille de mesurage 30° Foglio per misura 30°	Bauobjekt _____ Bâtiment _____ Edificio _____	
X			

G4.1 Template for isometric paper

## 4.2 Handling plastic pipeline systems

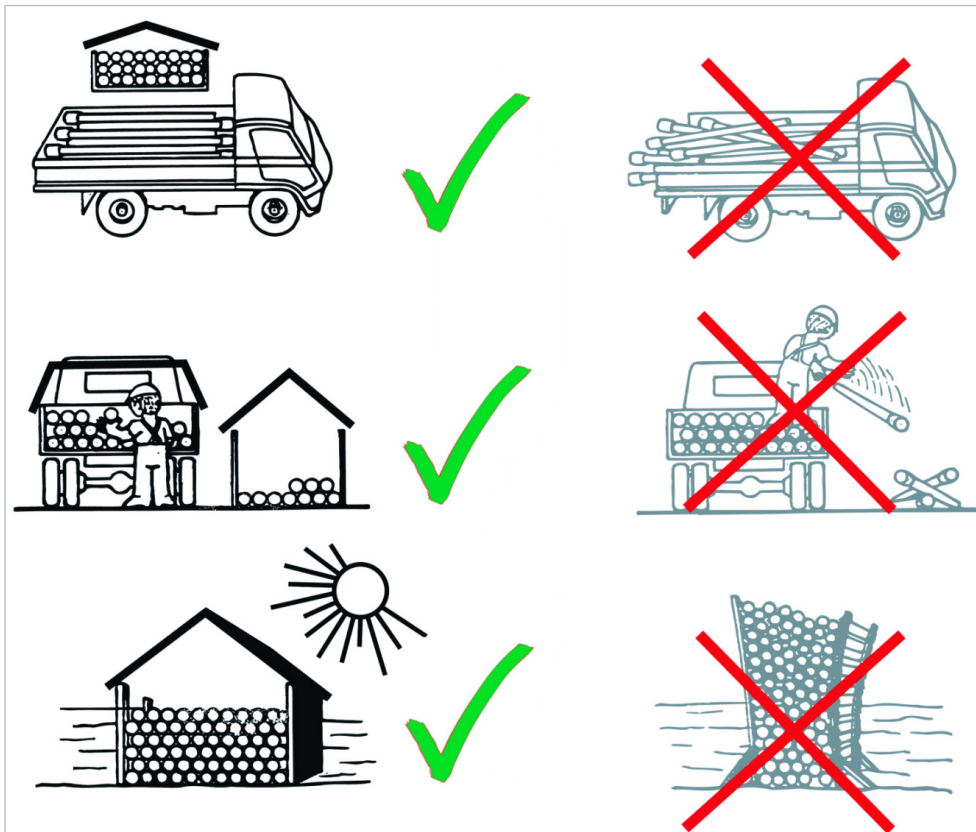
### 4.2.1 Transportation

Vehicles used to transport pipe must be capable of accommodating the full pipe length. The pipe must be supported to prevent them bending or deforming. The area where pipe rest (including side supports) should be lined with padded sheeting or corrugated cardboard to avoid damage by protruding rivets or nails. To protect against damage, pipe and fittings must not be slid over the transport vehicle's loading area, nor should they be dragged along the ground to their place of storage.

Due care must be taken with loading and unloading. If lifting gear is used, this must be fitted with special pipe grips. Throwing pipe and parts down from the cargo surface is unacceptable. Impacts must be avoided at all cost, especially at ambient temperatures below 0 °C where many plastics (e.g. PVC) have significantly lower impact resistance.

Pipe and fittings must be transported and stored so that they cannot be soiled by earth, mud, dirty water, etc. We recommend sealing pipe with protective endcaps to prevent the ingress of dirt.

We recommend that GF Piping Systems fittings and equipment are only unpacked immediately prior to use.





### 4.2.2 Storage

The pipe storage surface must be level and free of stones. Pipe must be layered and stacked in a way that avoids the risk of damage or permanent deformation. Larger-diameter, thin-walled pipe must be fitted with stiffening rings. Avoid single-point or narrow longitudinal supports.

The following table gives recommended maximum stacking heights for non-pallet pipe storage. Provided pipe are stacked on pallets and protected against sideways movement, the nominal stacking heights specified in the table may be increased by 50 %.

Pipe storage areas should be as well-protected as possible. Absorption of oil, solvents and other chemicals must be avoided at all costs during storage.

Stored pipe must not be exposed to the elements more than absolutely necessary, i.e. they should be kept in a covered warehouse. If stored outdoors (e.g. on a construction site), they should be covered with sheeting for protection against the weather (e.g. UV radiation).

One-sided warming from exposure to the sun could cause deformations.

Pipe and parts should be used in the order of manufacture/delivery, to ensure proper warehouse turnover of the plastic material.

Material	Permissible stacking height (m)
ABS	1.0
PE	1.0
PP	1.5
PVC-U	1.5
PVC-C	1.5
PVDF	1.5
ECTFE	1.0

## 4.3 CAD library

### Product library of GF Piping Systems

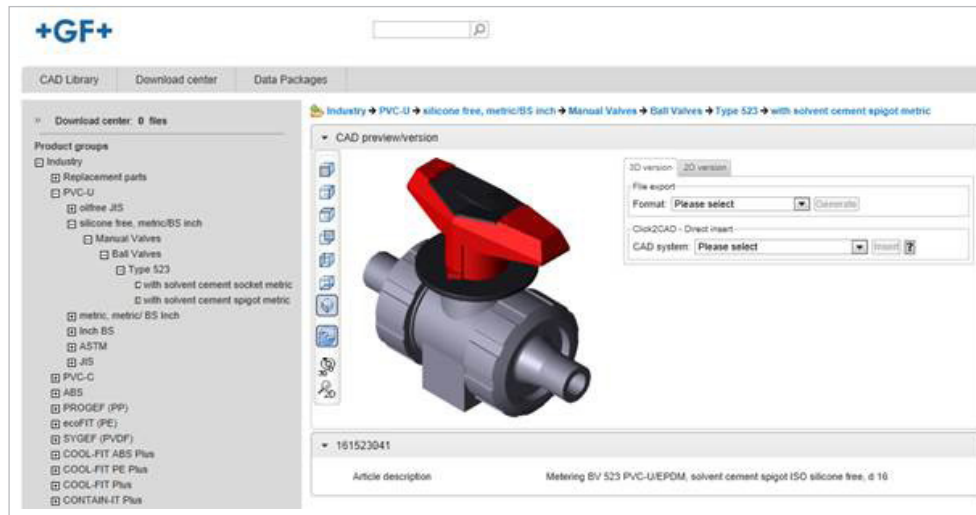
With this CAD library, GF Piping Systems aims to provide designers and engineers with even better and more efficient support for the design of piping systems.

Three-dimensional models (3-D models) of all piping components by GF Piping Systems in the area of industrial applications can be called up via the database. The user creates two dimensional drawings (2-D drawings) on his own in the desired views.

The library does work independently from the user's CAD system supporting many systems and interfaces. The database comprises over 30,000 drawings and technical data regarding pipe, fittings, measurement and control technology as well as manual and actuated valves.

The CAD library offers:

- Data packets with all the drawings of a system
- Over 30,000 drawings
- Pipe, fittings, valves, measurement & control
- Presentation in 2-D and in 3-D
- Optimized user interface
- Multifunctional drivers for the most common CAD systems
- Quick access



Sample presentation of a CAD library

■ Direct access to the online CAD library at <http://cad.georgfischer.com>



## 4.4 Length changes and flexible sections

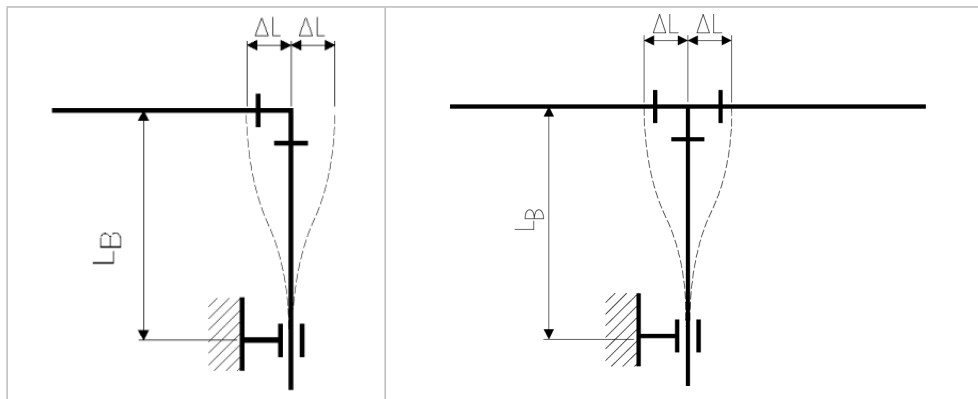
### 4.4.1 Overview

Thermoplastics are subject to greater thermal expansion and contraction than metallic materials. Pipe installed above ground, against walls or in ducts, require changes in length to be taken up in order to prevent any additional extra strain on the pipe. This applies especially to pipe exposed to operating temperature variations.

Length changes can be taken up by:

- Flexible sections
- Compensators

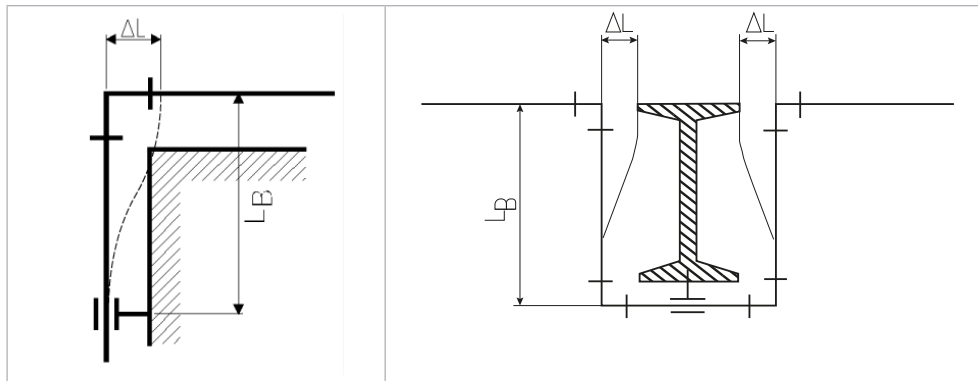
Flexible sections are the most common, the simplest and the most economical solution. The calculations for and the positioning of flexible sections are therefore described in detail.



$\Delta L$  Length change  
 $L_B$  Flexible section

### 4.4.2 Fundamentals

The low elasticity of thermoplastics allows changes in length to be taken up by special pipe sections, where pipe supports are positioned so that they can take advantage of the natural flexibility of the material. The length of such sections is determined by the diameter of the pipeline and the extent of the thermal expansion to be compensated.



$\Delta L$  Length change  
 $L_B$  Flexible section

Flexible sections arise naturally at any branching or change in direction of the pipeline. The movement  $L_B$  of the flexible section as a result of a change  $\Delta L$  in the length must not be restrained by fixed pipe brackets, wall protrusions, girders or the like.

### 4.4.3 Calculation of length changes

The change in length caused by temperature can be calculated using the following formula:

$$\Delta L = L \cdot \Delta T \cdot \alpha$$

$\Delta L$  Temperature-related length change (mm)

$L$  Length of the pipe section (m)

$\Delta T$  Difference of temperature (K)

$\alpha$  Coefficient of linear expansion (mm/m K)

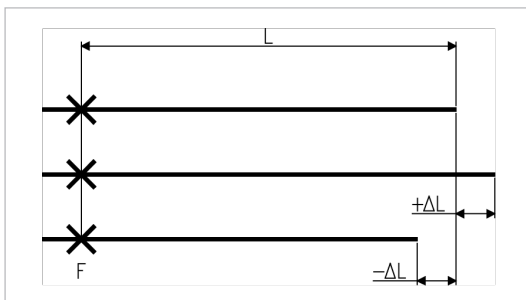
#### Coefficients of linear expansion of polymers

Material	$\alpha = \text{mm/m K}$
ABS	0.10
PA	0.10
PB	0.13
PE	0.15 – 0.20
PP	0.16 – 0.18
PPS	0.15
PVC-U	0.07 – 0.08
PVC-C	0.06 – 0.07
PVDF	0.12 – 0.18
ECTFE	0.08 – 0.135 (20°C – 100°C)



If the operating temperature is higher than the installation temperature, then the pipe expands. If, on the other hand, the operating temperature is lower than the installation temperature, then the pipe contracts in length.

- The installation temperature must therefore be incorporated into the calculations as well as the maximum and minimum operating temperatures.
- It is preferable to use "+" to indicate expansion of the pipe and "-" to indicate contraction.
- The larger change in length is the one to be used for determining the required length of the flexible section.



## Boundary conditions for using the diagram

For easy determination of the required length of flexible section please use the following diagrams. The following boundary conditions should be taken into account:

- Assembly temperature  $T_M = 20\text{ °C}$
- Operating temperature  $T_B$

$$\Delta T = T_B - T_M$$

- Allowable bending stress 15 % from  $\sigma_b$
- PN6 to PN16
- Assumed coefficient of friction of the pipe in the loose brackets  $\leq 0.5$

## Information

The following diagrams show the required flexible sections for straight pipe lengths of 10 m or 70 m. Exceeding the maximally permissible straight pipe distance would lead to buckling of the pipe due to too great friction in the pipe clamps. Therefore, the maximum possible pipe length must be considered depending on the pipe diameter visible above the shaded area.



**Example: Determining the length of the required flexible section**

### Calculating the relevant change in length

The example of an ABS process pipe serves to illustrate the procedure. Length of piping from the fixed point to the branch point where the change in length is to be taken up:

Length L	8 m
Installation temperature $T_M$	20 °C
Max. operating temperature $T_1$	35 °C
Min. operating temperature $T_2$	- 20 °C

### Expansion of the pipe section during heating

$$+\Delta L_1 = L \cdot \Delta T_1 \cdot \alpha = 8 \cdot 15 \cdot 0.10 = 12 \text{ mm}$$

### Contraction during cooling

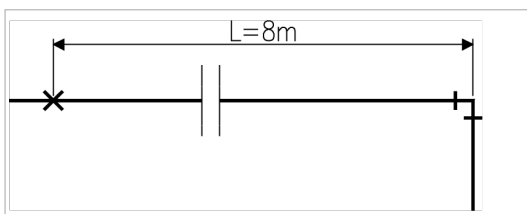
$$-\Delta L_2 = L \cdot \Delta T_2 \cdot \alpha = 8 \cdot 40 \cdot 0.10 = 32 \text{ mm}$$

### Temperature differences

$$\Delta T_1 = T_1 - T_M = 15 \text{ K} \quad \Delta T_2 = T_2 - T_M = -40 \text{ K}$$

### Maximum change in temperature selected

$$\Delta T = 40\text{ °C}$$



### Determining the length of the flexible section for ABS

The values needed to determine the necessary length are:

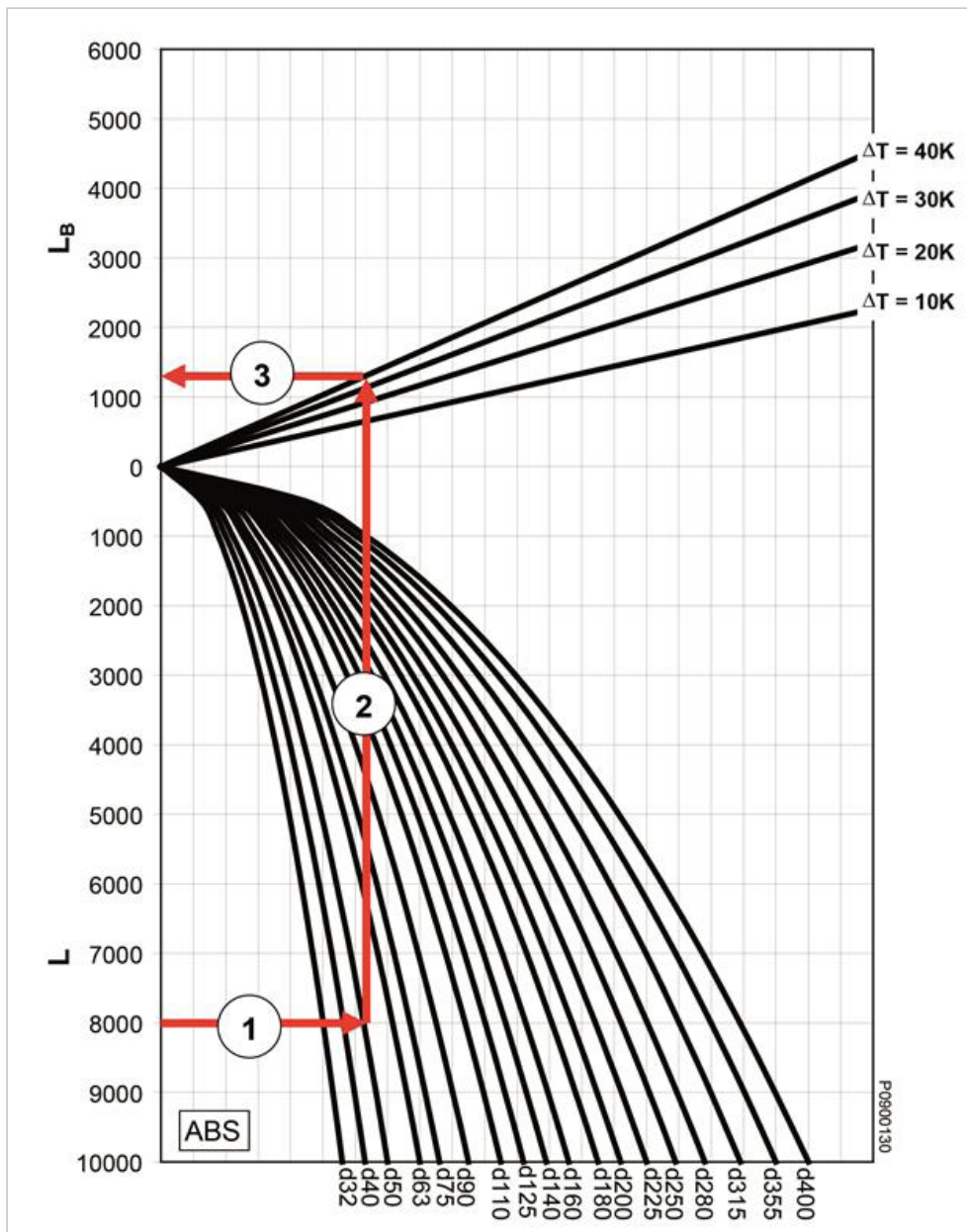
- The maximum change in temperature from the 0-position (i.e. from the position in which the pipe was installed). But remember that the pipe could contract just as well as expand.
- Inner pipe diameter  $d$
- Length of pipe section  $L$

With these values, the required length of the flexible section can be read from the diagram for ABS.

The following information can be gained from the calculation example above:

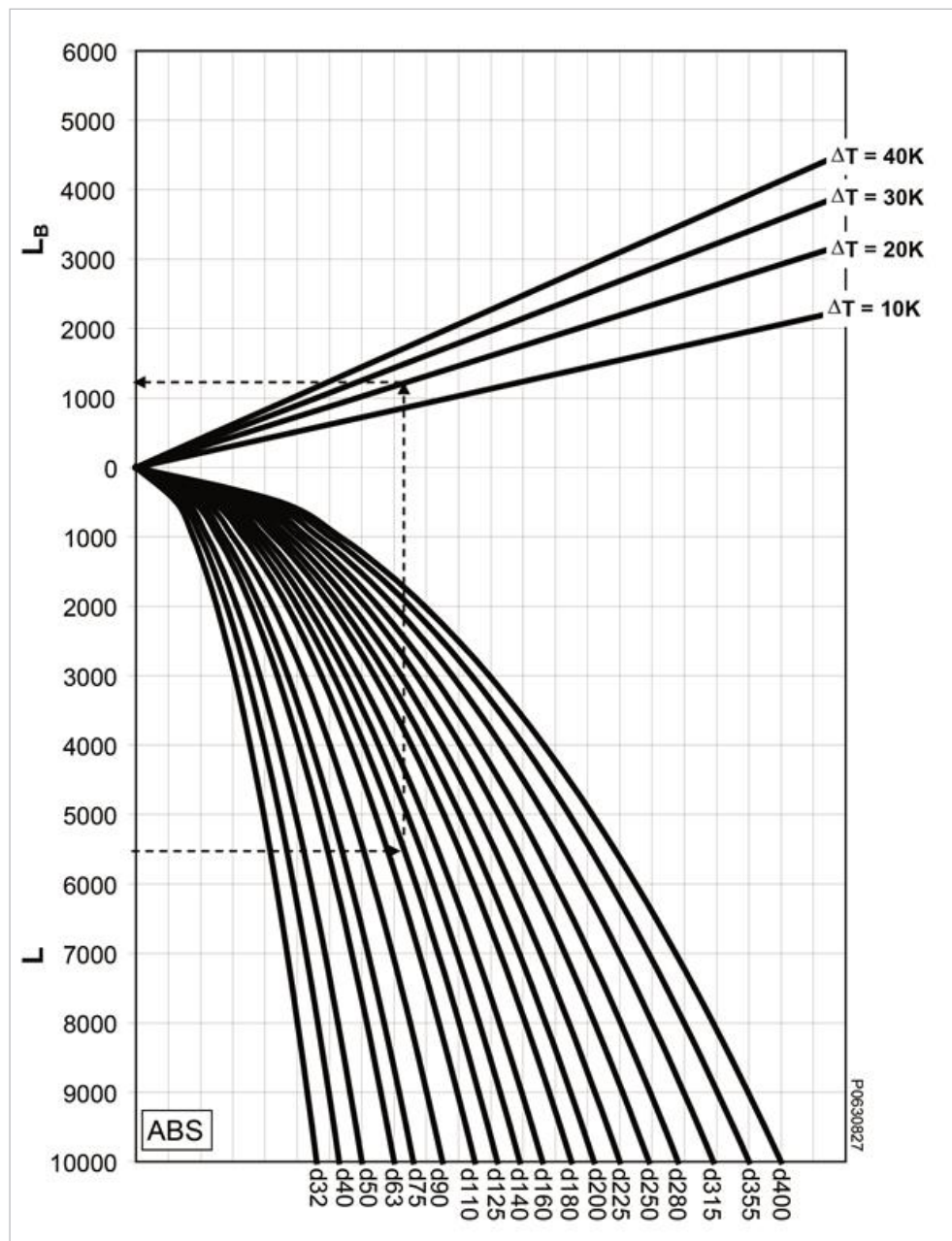
- Installing a pipe with  $d = 50 \text{ mm}$
- Maximum change in temperature  $\Delta T = 40 \text{ K}$
- Material ABS
- Length of required flexible section  $L_f = 1300 \text{ mm}$  (see diagram)

$L$  Length of pipe section (mm)  
 $L_B$  Required length of flexible section (mm)

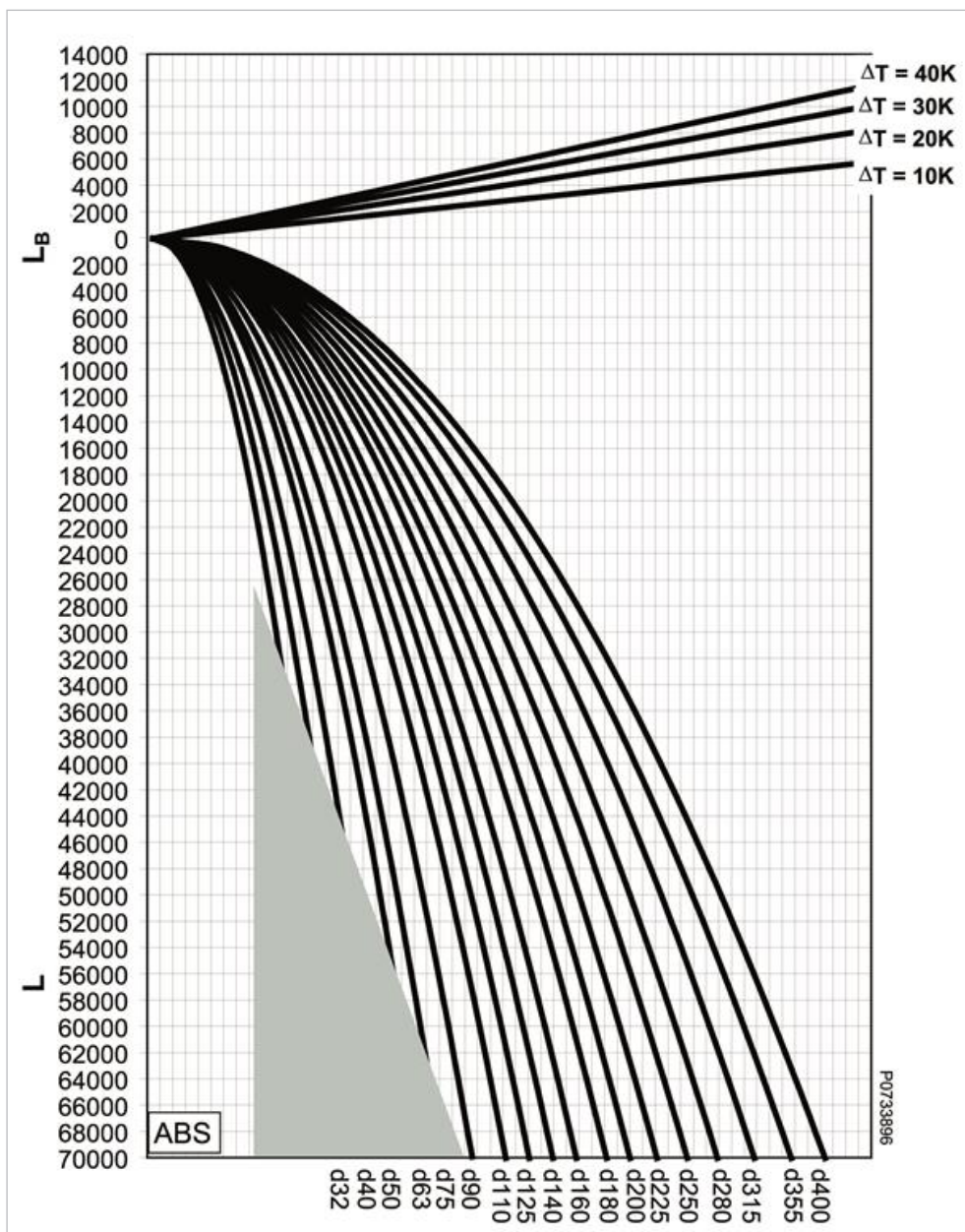


**i** The diagram can be used also the other way around, if a maximum flexible section caused by the building construction is given. Then the maximum straight length of the pipe can be determined.


4.4.4 Flexible sections of ABS piping systems



L Length of pipe section (mm)  
 $L_B$  Required length of flexible section (mm)

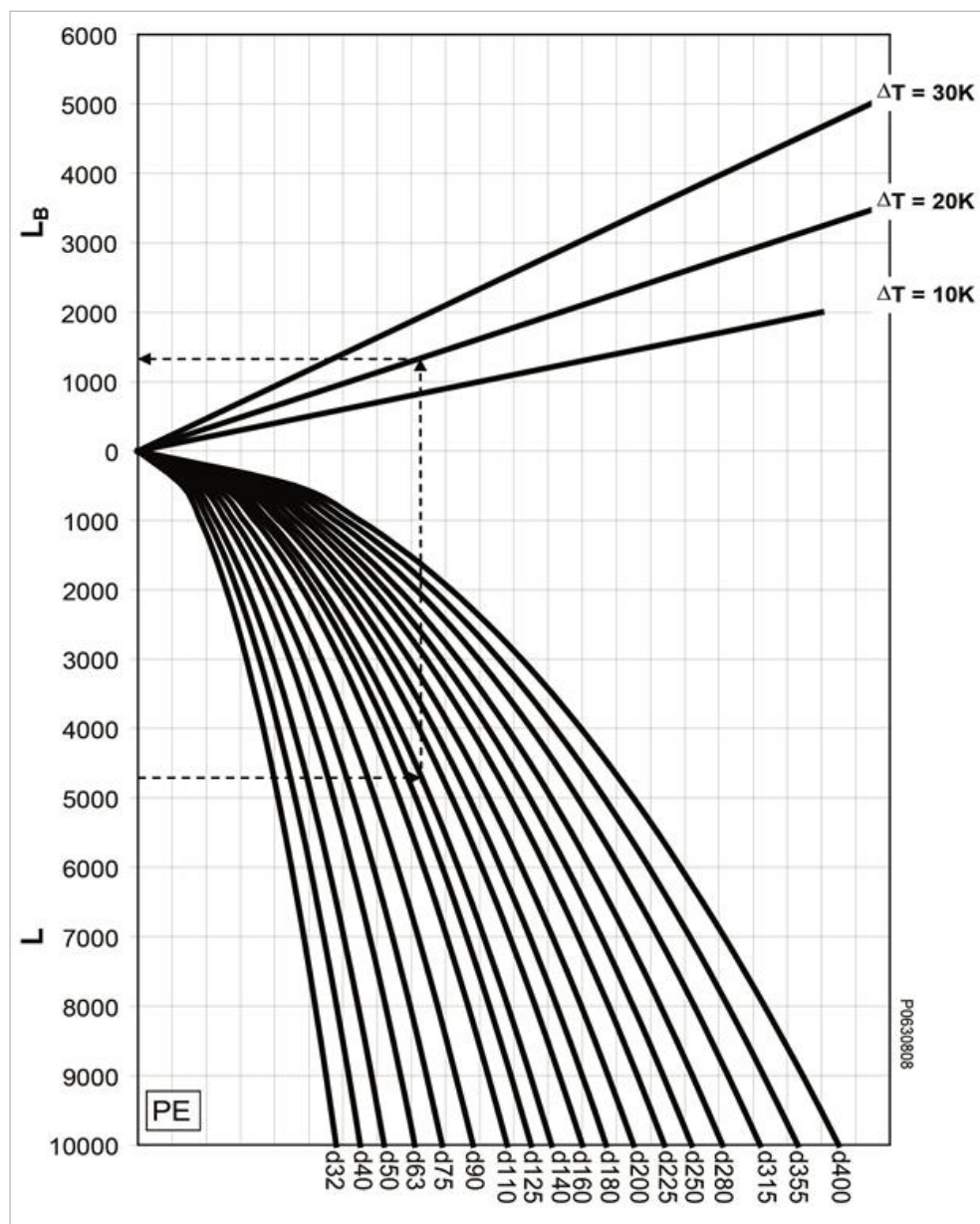


L Length of pipe section (mm)  
 $L_B$  Required length of flexible section (mm)

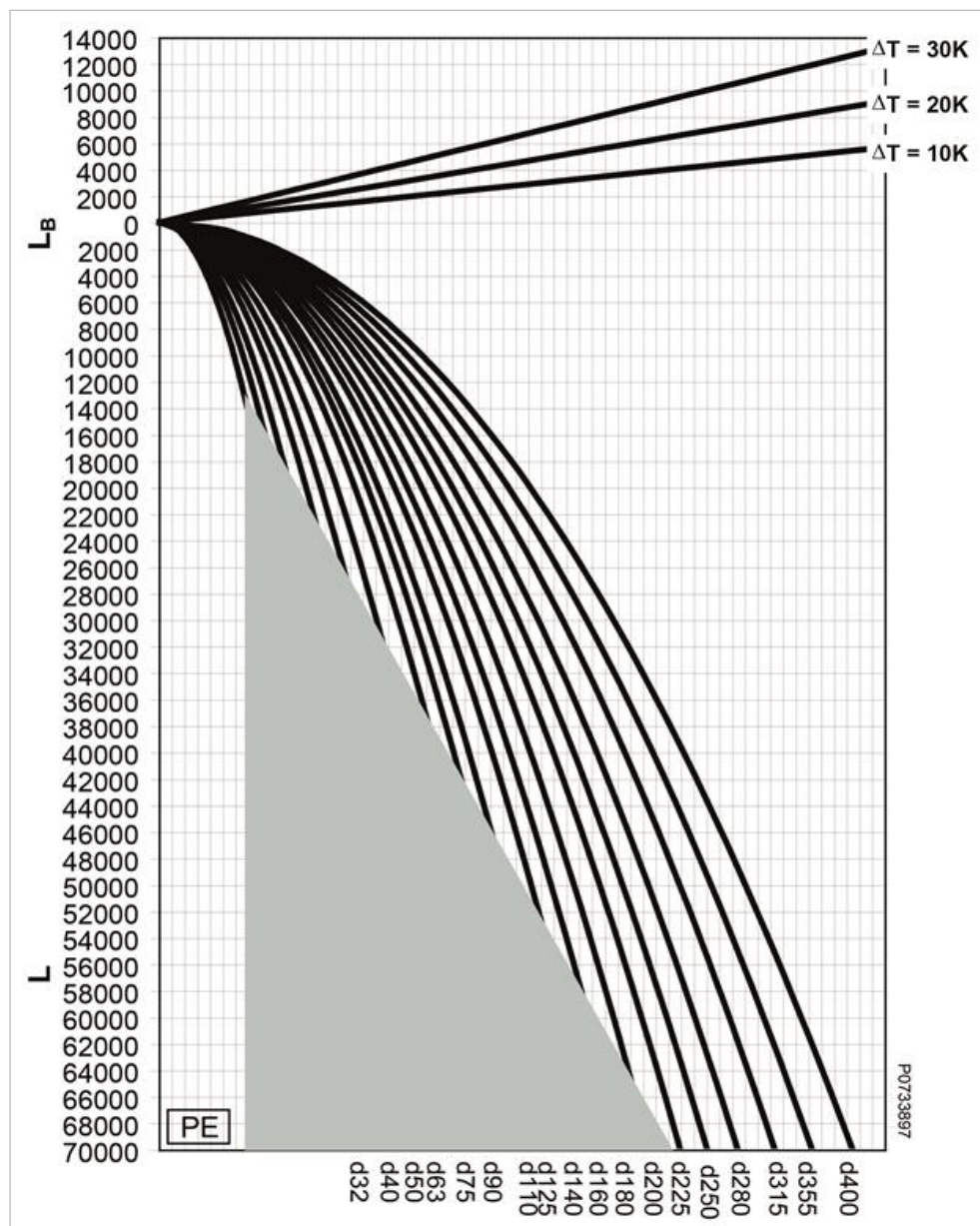
 For explanations of the shaded area, see the introductory section "Boundary conditions for using the diagram".




4.4.5 Flexible sections of PE (PE80, PE100) piping systems



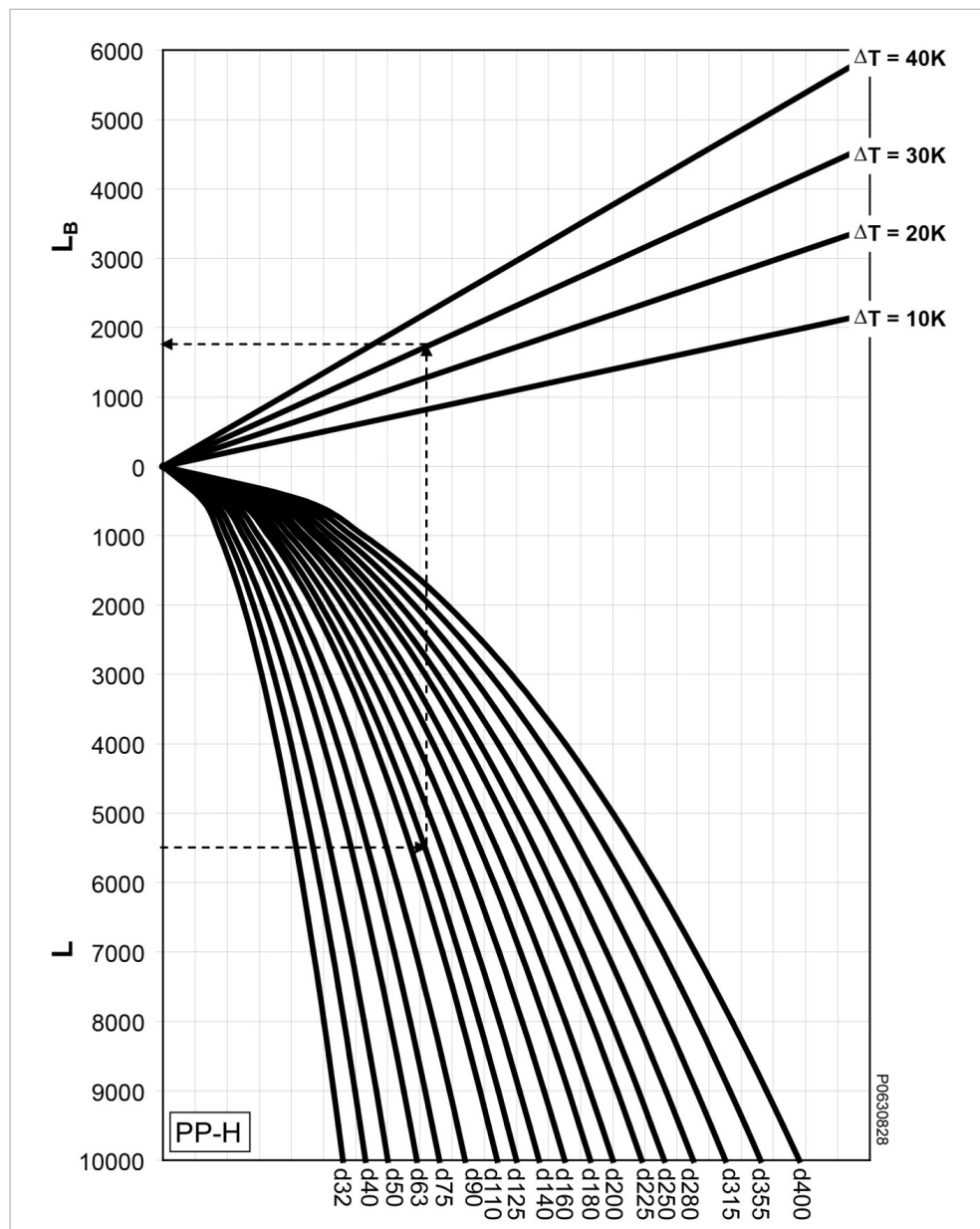
L Length of pipe section (mm)  
 $L_B$  Required length of flexible section (mm)



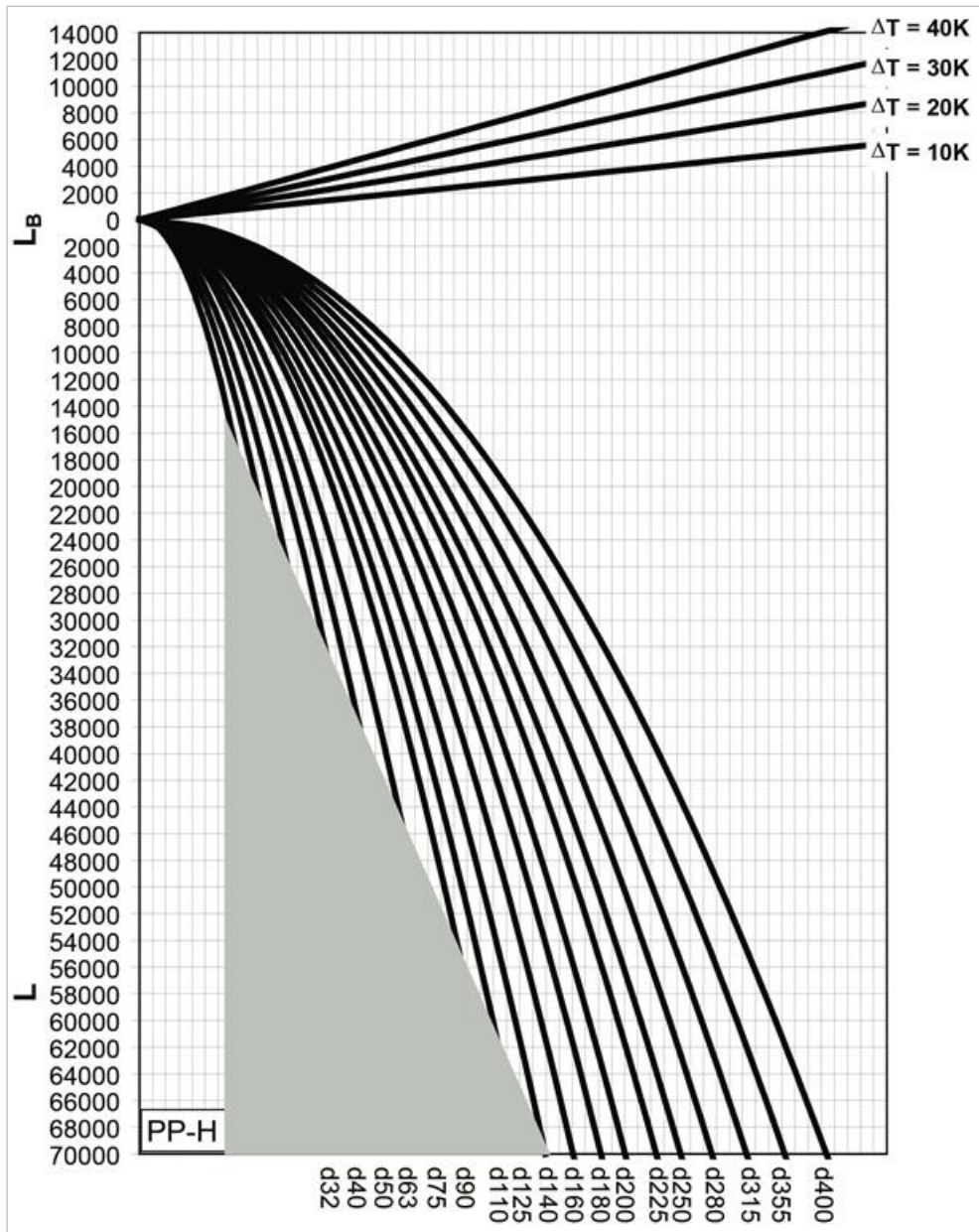
$L$  Length of pipe section (mm)  
 $L_B$  Required length of flexible section (mm)

 For explanations of the shaded area, see the introductory section "Boundary conditions for using the diagram".


4.4.6 Flexible sections of PP piping systems

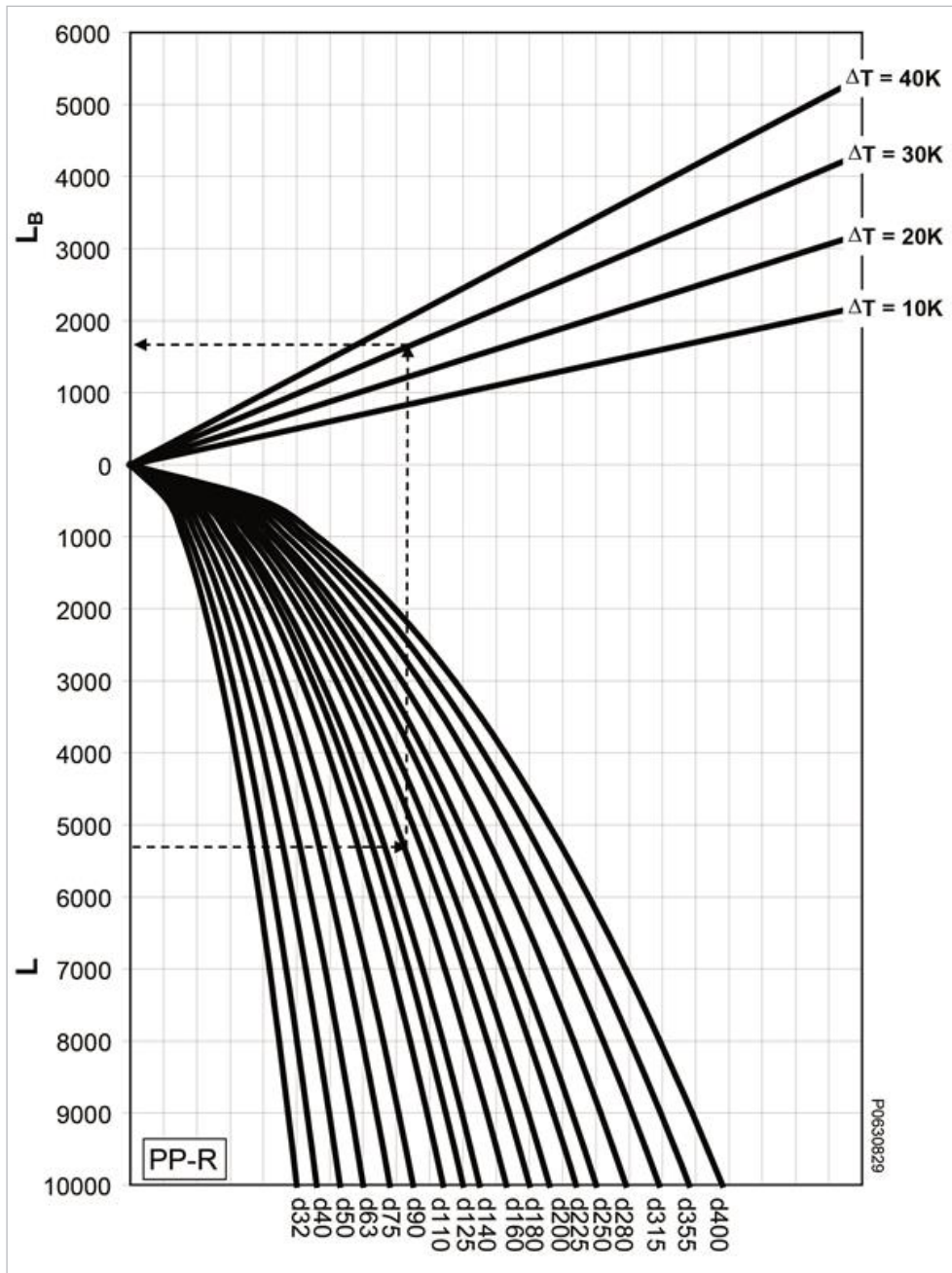


L Length of pipe section (mm)  
 $L_B$  Required length of flexible section (mm)

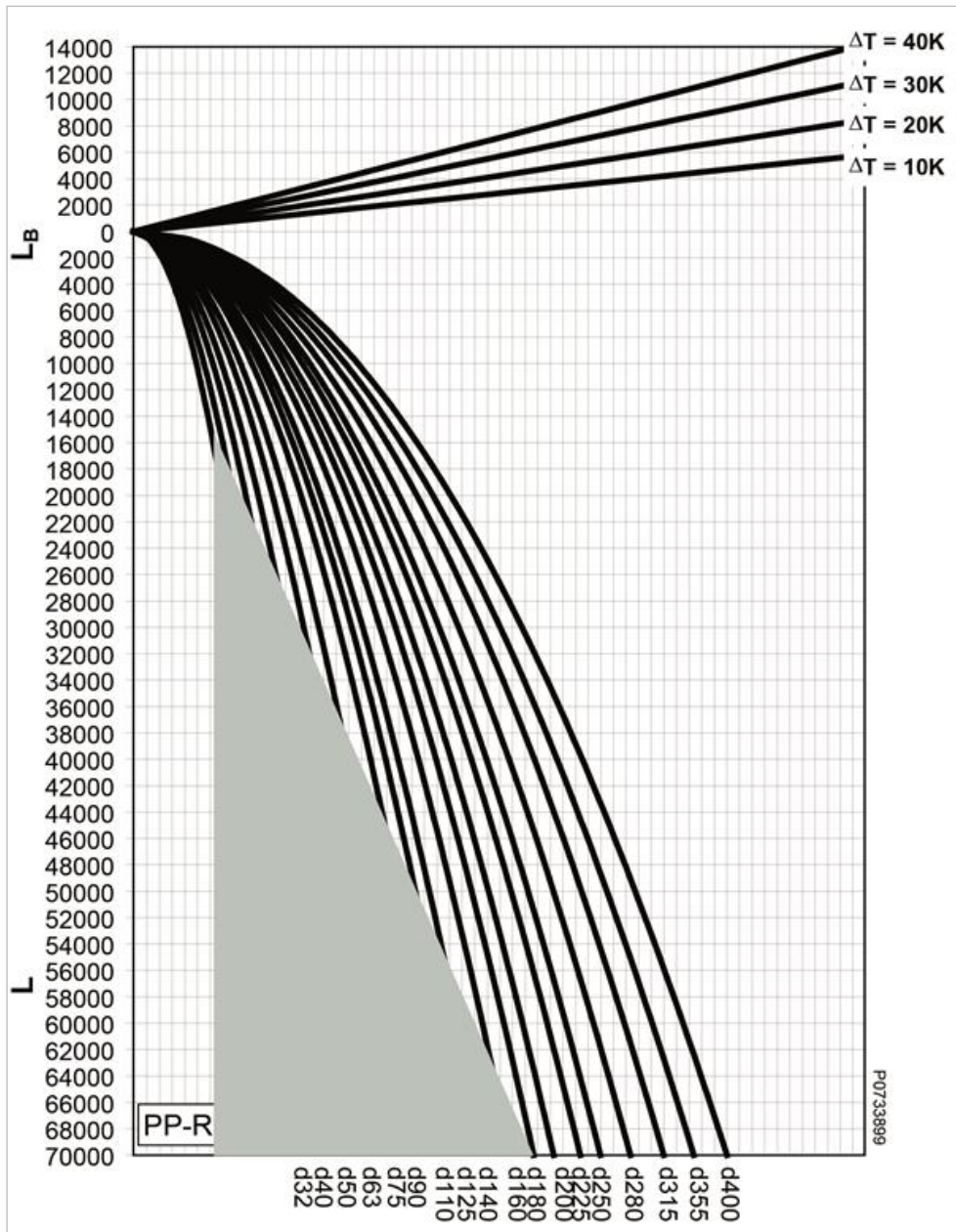


L Length of pipe section (mm)  
 $L_B$  Required length of flexible section (mm)


 For explanations of the shaded area, see the introductory section "Boundary conditions for using the diagram".



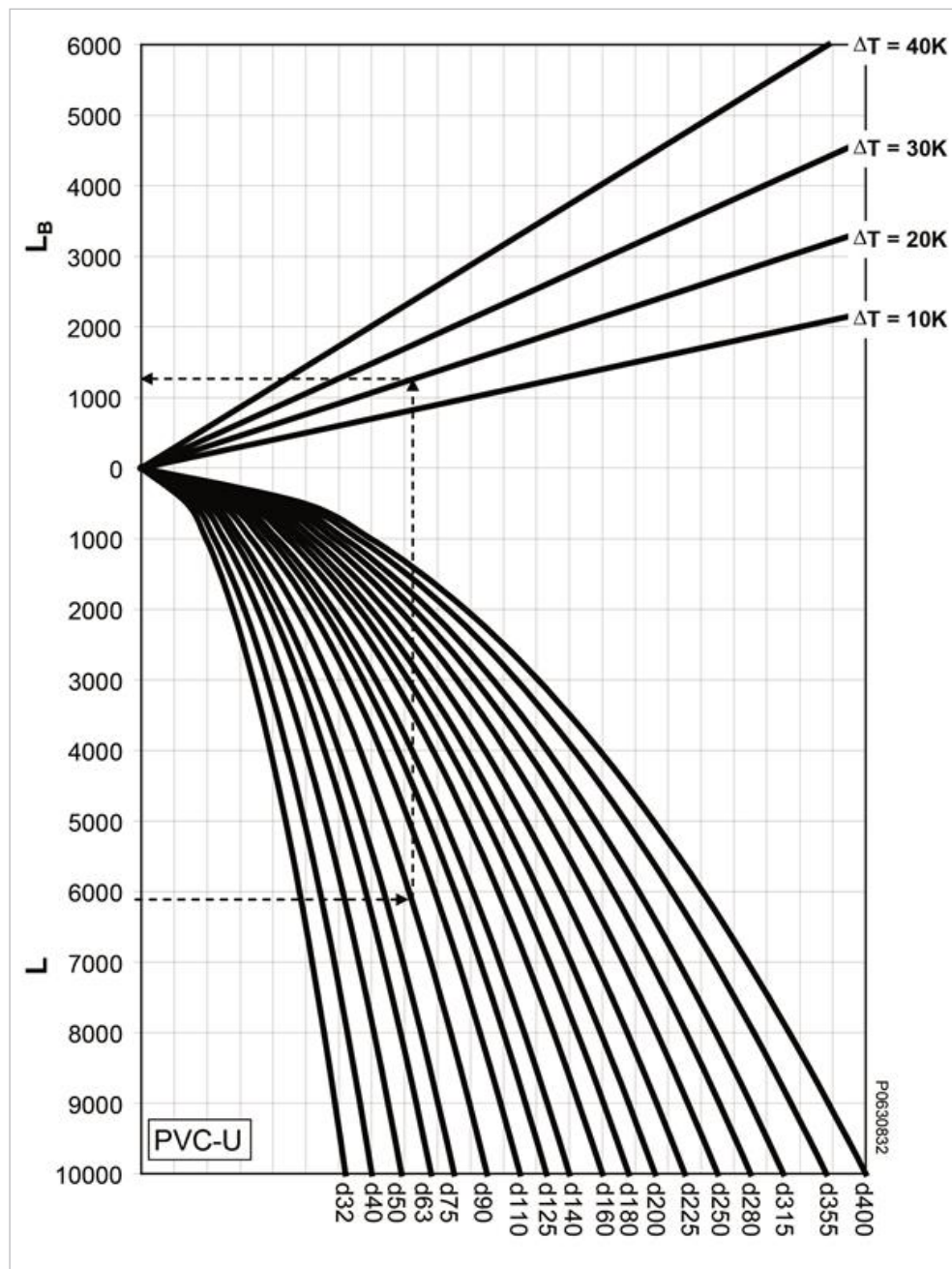
L Length of pipe section (mm)  
 $L_B$  Required length of flexible section (mm)



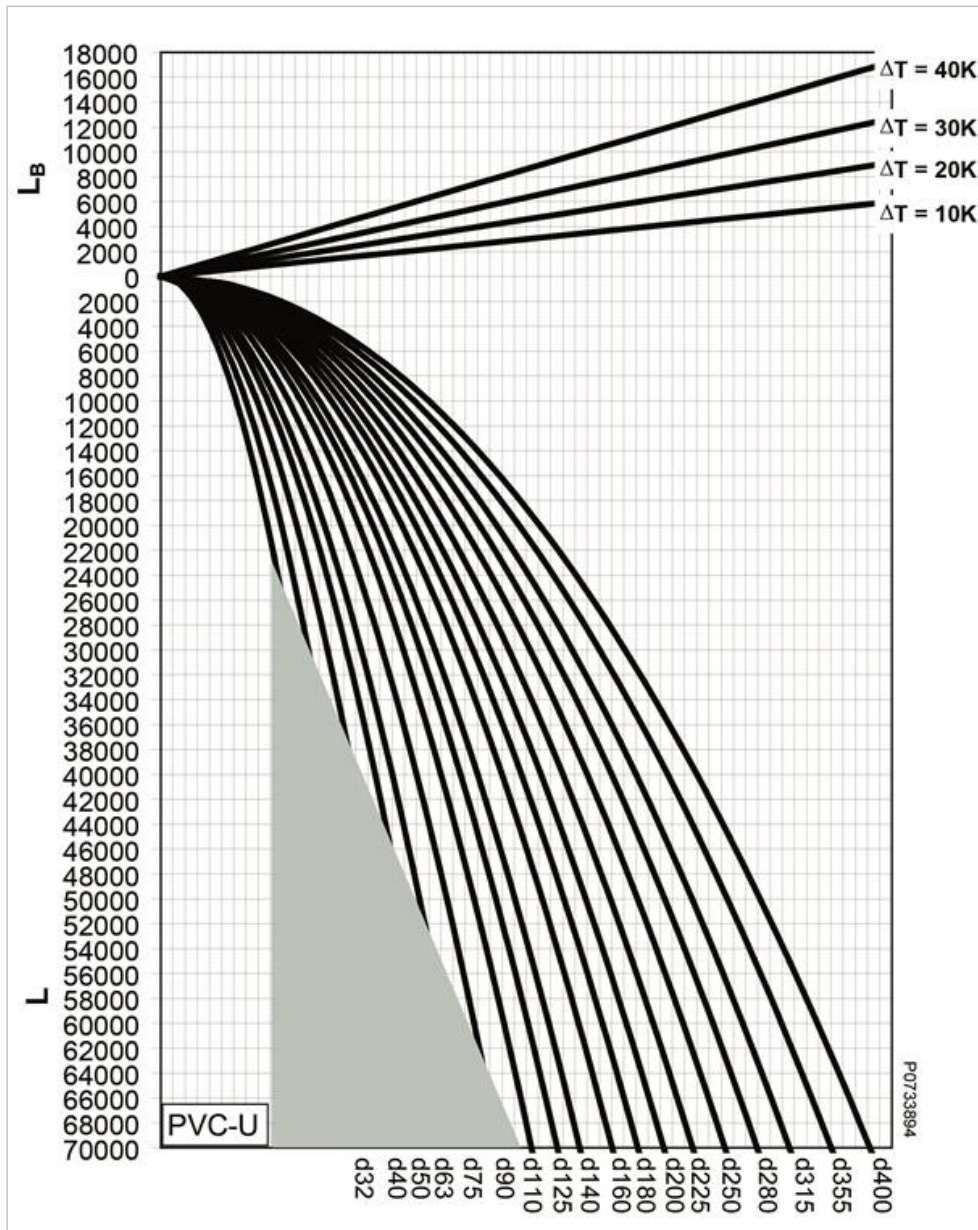
L Length of pipe section (mm)  
 $L_B$  Required length of flexible section (mm)

 For explanations of the shaded area, see the introductory section "Boundary conditions for using the diagram".


4.4.7 Flexible sections of PVC-U/PVC-C piping systems



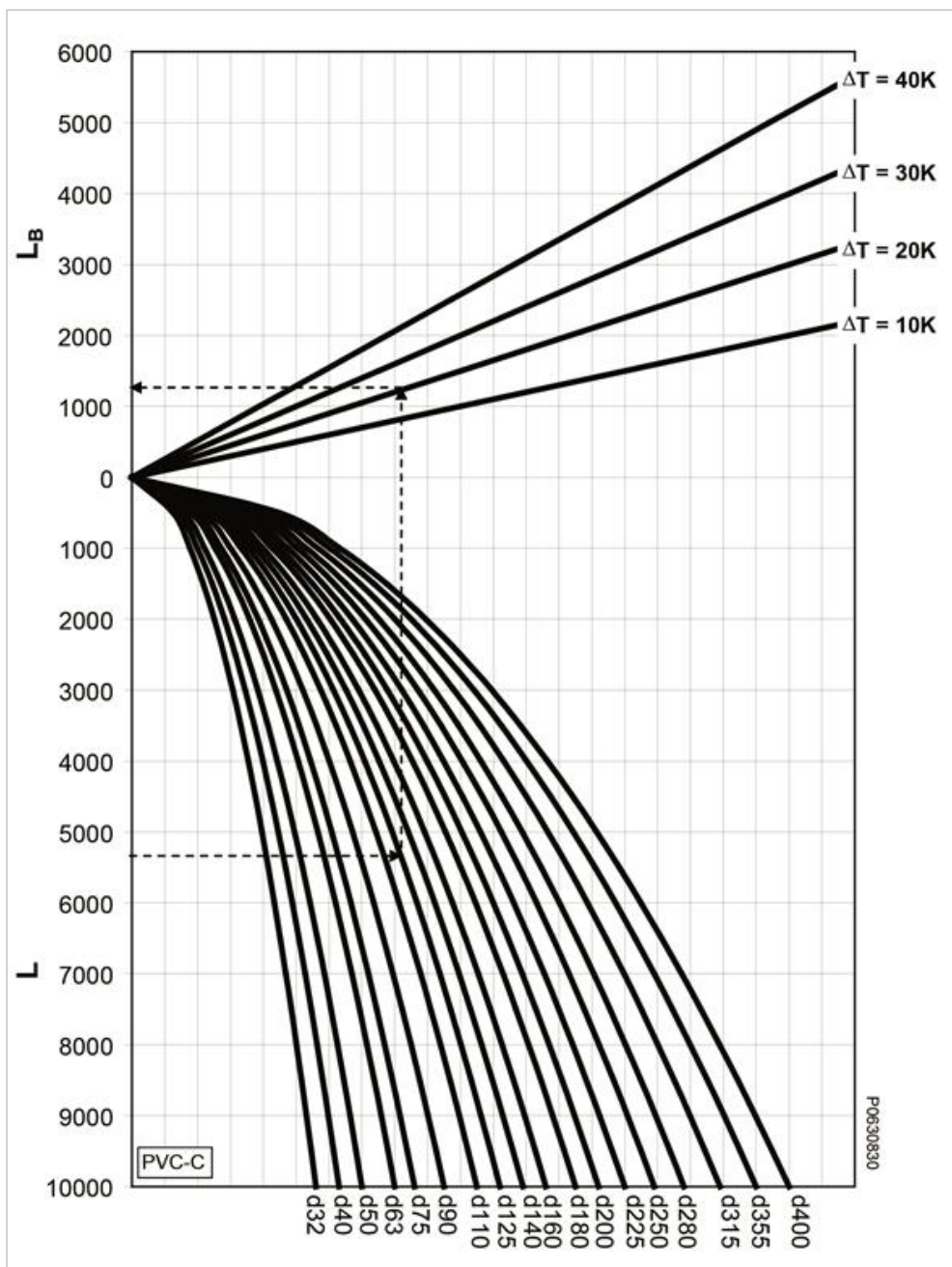
L Length of pipe section (mm)  
 $L_B$  Required length of flexible section (mm)



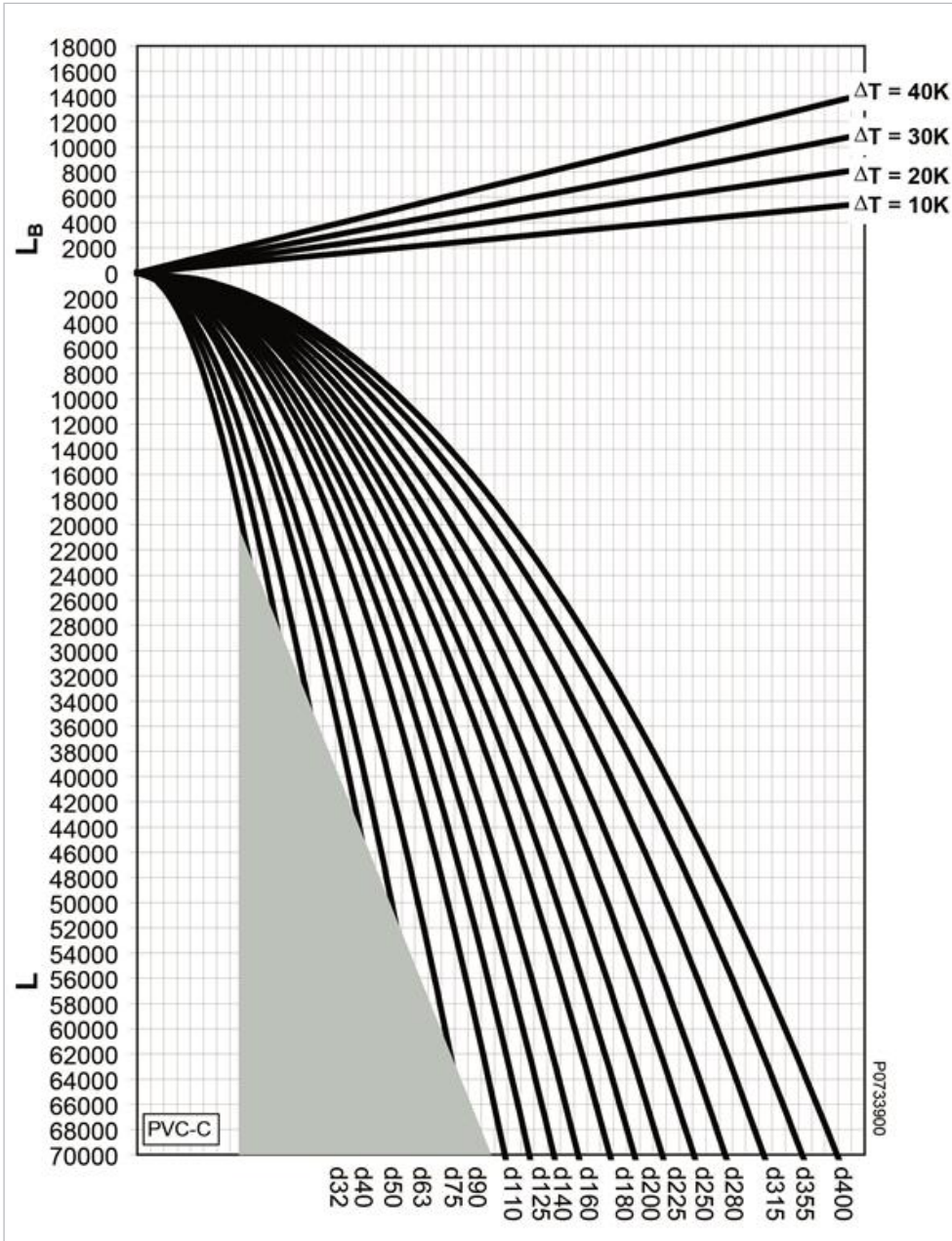
L Length of pipe section (mm)  
 $L_B$  Required length of flexible section (mm)

 For explanations of the shaded area, see the introductory section "Boundary conditions for using the diagram".






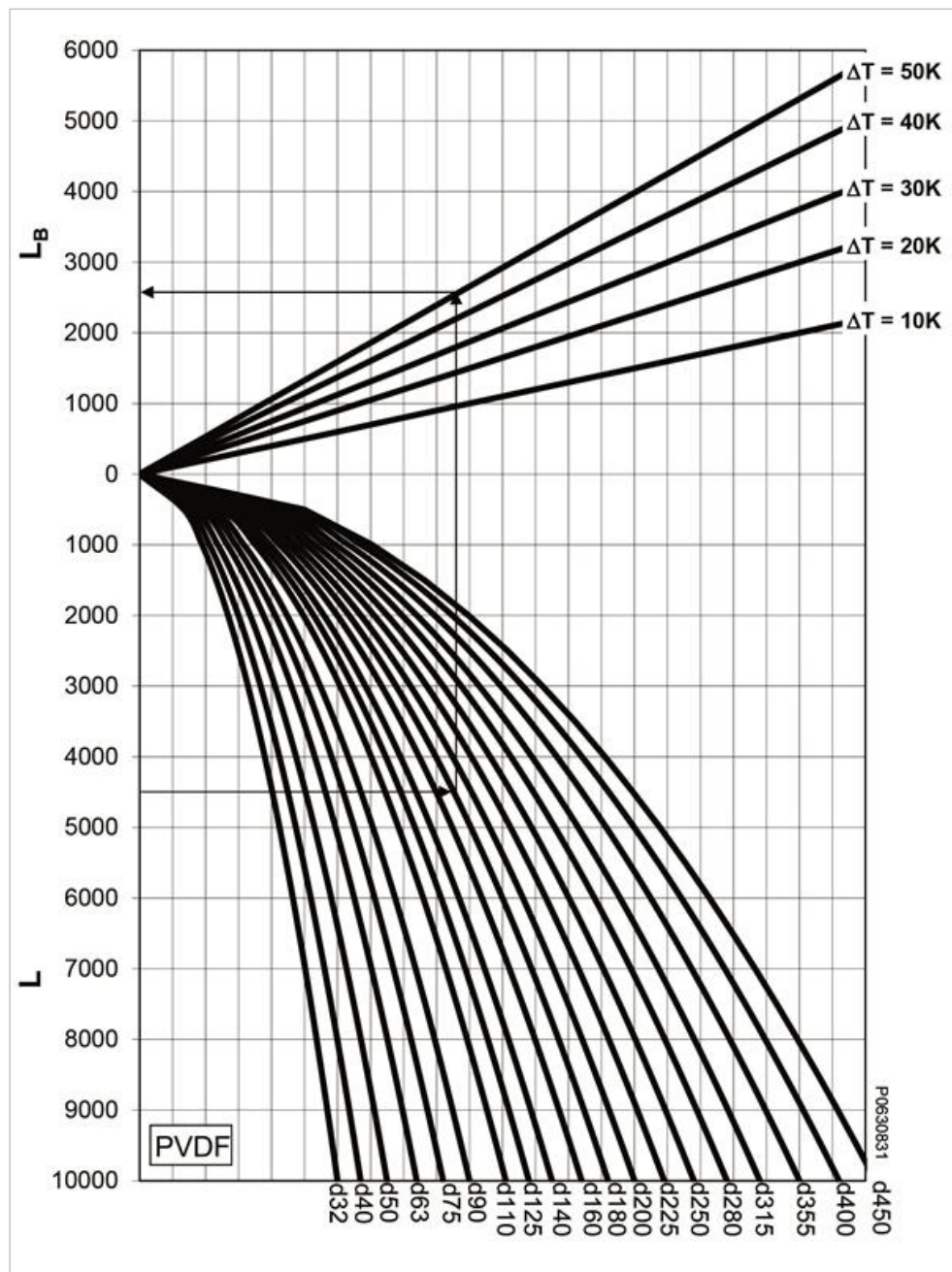
L Length of pipe section (mm)  
 $L_B$  Required length of flexible section (mm)



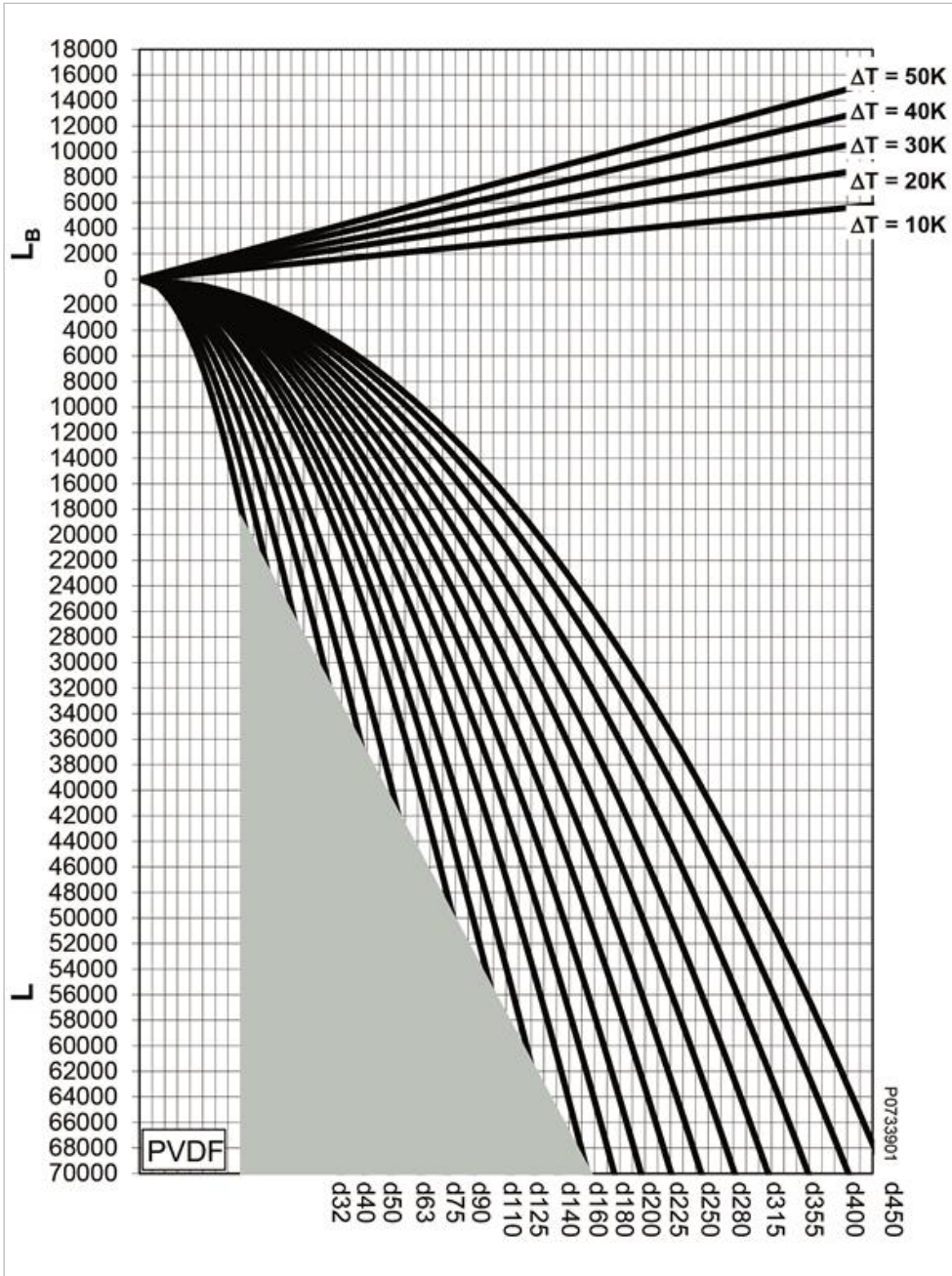
L Length of pipe section (mm)  
 $L_B$  Required length of flexible section (mm)

 For explanations of the shaded area, see the introductory section "Boundary conditions for using the diagram".


4.4.8 Flexible sections of PVDF piping systems



$L$  Length of pipe section (mm)  
 $L_B$  Required length of flexible section (mm)



L Length of pipe section (mm)  
 $L_B$  Required length of flexible section (mm)

 For explanations of the shaded area, see the introductory section "Boundary conditions for using the diagram".

#### 4.4.9 Flexible sections of ECTFE piping systems

**Determining the length of the flexible section for ECTFE piping systems:**

$$L_{B\_ECTFE} = C * (d * \Delta l)^{0.5}$$

d= pipe diameter [mm]

$\Delta l$ = temperature-related length change [mm]

C= ECTFE material factor as a function of TB= Operating temperature:

$$TB \leq 20^{\circ}\text{C} \rightarrow C = 22.6$$

$$TB > 20^{\circ}\text{C} \rightarrow C = 20.0$$

Note:

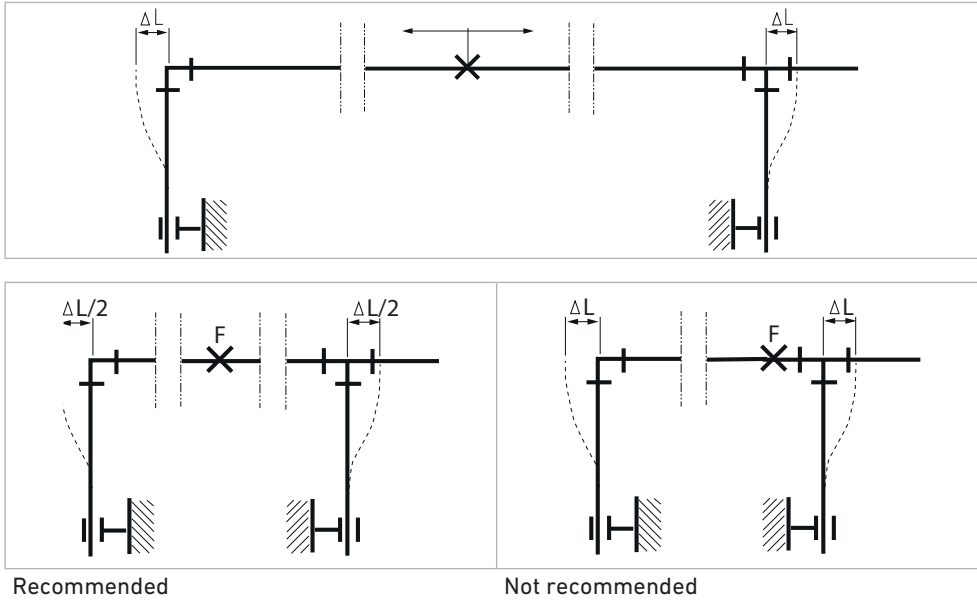
The simplified calculation of flexible section does not replace the stress analysis.

Shorter flexible sections are to be checked by means of a static evidence for the respective pipeline installation.

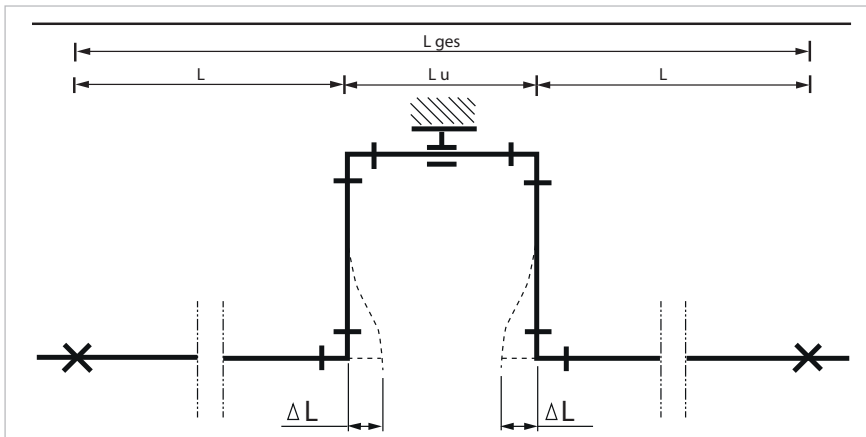
## 4.5 Installation

### 4.5.1 Recommendations for installation

Length changes in pipe sections should always be accommodated through the arrangement of fixed brackets. The following examples show how the changes can be distributed in pipe sections by suitable positioning of fixed brackets:



Expansion loops can be installed to take up changes in length when flexible sections cannot be included at a change in direction or branch in the pipeline or if substantial changes in the length of a straight section need to be taken up. In such a case the compensation for changes in length is distributed over two flexible sections.



**⚠ Leaks caused by the bending load leakages can occur at mechanical joints.**  
 Within the range of flexible sections and expansion loops no threaded connections or flange connections shall be used.

## Pre-stress

In particularly difficult situations with large changes in one direction only (either expansion or contraction), it is possible to pre-stress the flexible section during installation and thereby shorten its length  $L_B$ , as illustrated in the next example:



### Example

Installation data L	10 m
Outer diameter d	50 mm
Installation temperature	15 °C
Max. operating temperature	40 °C
Material	ABS

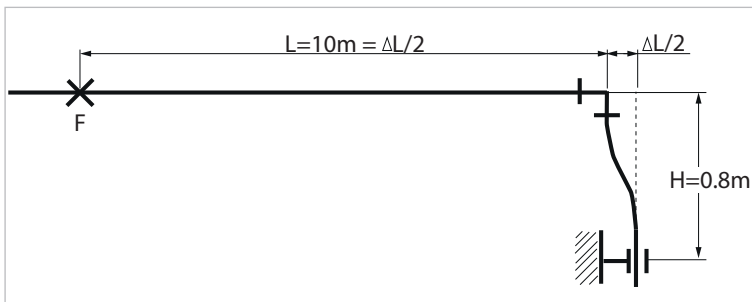
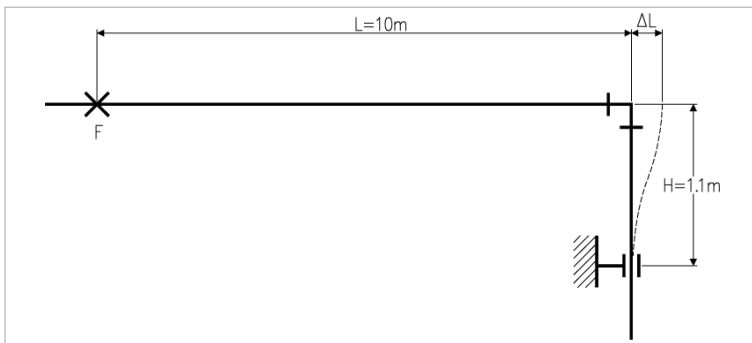
### Length change:

$$+\Delta L = L \cdot \Delta T \cdot \alpha_{\text{ABS}} = 10 \text{ m} \cdot 25 \text{ K} \cdot 0.10 \text{ mm/mK} = 25 \text{ mm}$$

A flexible section to take up a change in length of  $\Delta L = 25 \text{ mm}$  needs to be  $L_B = \text{ca. } 1150 \text{ mm}$  long according to the diagram.

If the flexible section is pre-stressed to  $\Delta L/2$  then the required length of the flexible section is reduced to about 800 mm. The variation length from the 0 position is then  $\pm \Delta L/2 = 25/2 = 12.5 \text{ mm}$ .

Pre-stressing the flexible section makes it possible to reduce its required length in installations where space is restricted. Pre-stressing also reduces the bending of the flexible section in service, improving the appearance of the pipeline.

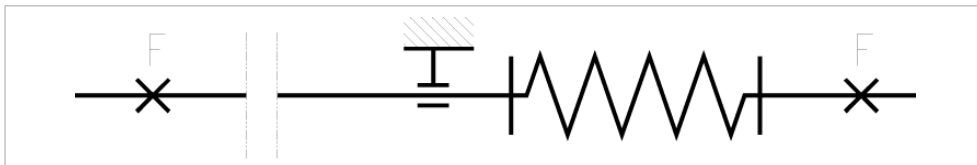
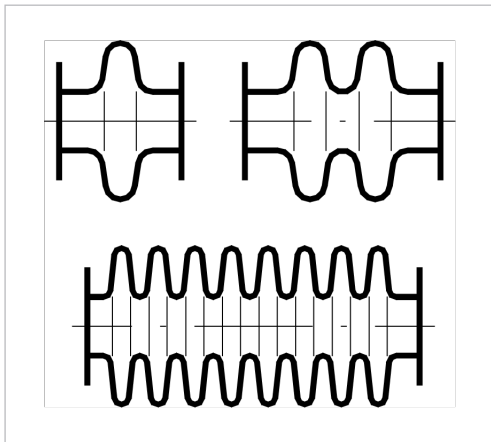


## 4.5.2 Installation of compensators

The low modulus of elasticity means that the reaction force of plastic pipe to thermal changes is low compared to metal pipe. This makes normal compensators designed for use with metal pipe unsuitable because of their high inherent resistance. Only freely moving compensators may be used in plastic pipe systems, i.e. those with a low resistance. The following compensators may be considered: rubber compensators, PTFE-corrugated compensators or suitably selected metal multi-disk compensators.

Carefully placed fixed points should be selected when fitting compensators for the regulation of the pipe in order to ensure their unhindered operation.

**⚠** When using compensators, additional longitudinal forces are implemented into the pipeline. These forces have to be carried by guiding the pipeline. For example, threaded rods are not suitable. To estimate the lateral forces it can be assumed that they can reach about 15 % of the axial forces. Please contact the manufacturers of compensators for further support designing such piping systems.



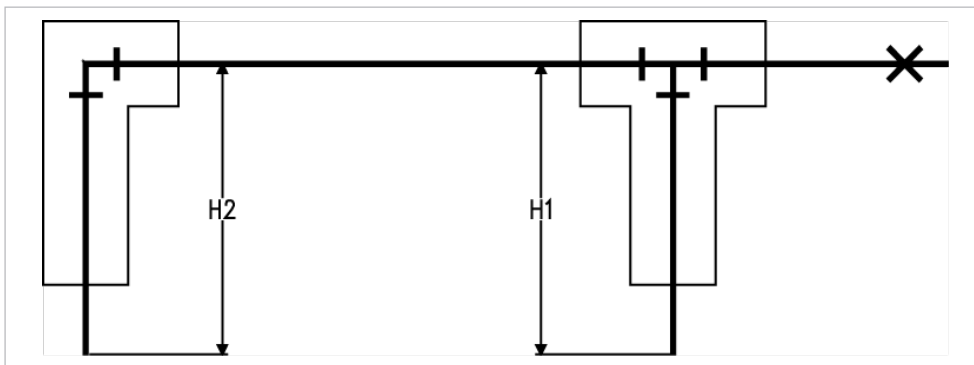


### 4.5.3 Installation of valves

Valves should be secured as directly as possible, e.g. to bracket or wall, so that the actuation forces are transmitted directly and not via the pipeline. Valve brackets or valves with integrated mounting device from GF Piping Systems are used for securely fastening plastic valves. The valve brackets are also used to accept loads from the valve and fill weight of the pipeline. Any changes in length which arise can be kept from the valve with the appropriate fixed points before or after the valve.

#### Installing pipework under plaster or embedding it in concrete padded piping systems

Where piping systems are installed under plaster or embedded into concrete, the flexible sections at bends and branches must be padded for the calculated distance H, as well as any branches and elbows included in the affected section.



The assigned tee or elbow pieces must be included in the cushioning. Only elastic materials, such as glass wool, rock wool, foamed plastic or similar may be used for cushioning.

#### Non-padded pipe

Plastic pipe can also be plastered or concreted in directly. Since the axial stress arising from internal pressure is half as great as the circumferential stress, piping systems can support limited additional axial stress without becoming overloaded. In these cases, the level of stress expected must be calculated. The same is true of any section of pipe between two fixed points where no allowance has been made for changes in length. The load at the fixed points must be calculated and considered when planning the fixed points. The distance between pipe brackets in such cases may have to be reduced from the normal values in order to prevent bowing in the pipeline.

Care must be taken to avoid creating cavities when plastering or concreting in the pipeline, because under unfavorable conditions these can become areas of stress concentration. A rich plaster mixture (1:3 to 1:4) should be used to allow the forces arising from temperature variations to be transmitted away without causing the plaster to crack.

## 4.6 Pipe bracket distances and installation of pipes

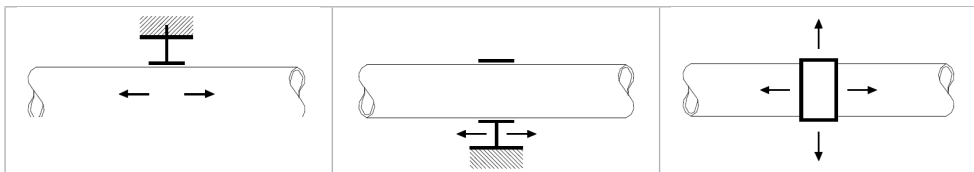
### 4.6.1 Overview

#### Installation of plastic pipe

Plastic pipe should be installed using supports designed for use with plastics and should then be installed taking care not to damage or overstress the pipe.

#### Arranging loose brackets

A loose bracket is a pipe bracket which allows axial movement of the pipe. This allows stress-free compensation of temperature changes and compensation of any other operating condition changes.

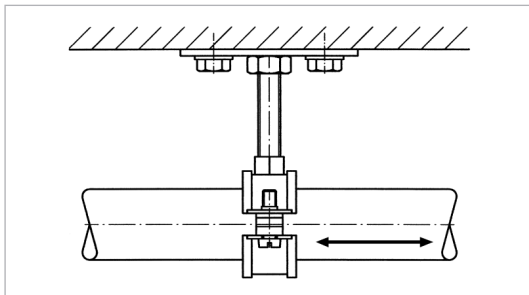


Movement of the pipe in the pipe bracket.

Pipe bracket firmly installed on the pipe, movement in the bracket suspension.

Movement of the pipe in 2 axes.

The inner diameter of the bracket should be larger than the outer diameter of the pipe to allow free movement of the pipe. The inner edges of the brackets should be free from any sharp contours to avoid damaging the pipe surface. Another method is to use brackets with spacers in the bolts which also avoids clamping the bracket on the pipe.



Spacers prevent clamping the pipe

The axial movement of the piping may not be hindered by fittings arranged next to the pipe bracket or other diameter changes.

Sliding brackets and hanging brackets permit the pipe to move in different directions. Attaching a sliding block to the base of the pipe bracket permits free movement of the pipe along a flat supporting surface. Sliding and hanging brackets are needed in situations where the pipeline changes direction and free movement of the pipe must be allowed.

## Arranging fixed points

A fixed pipe bracket is a bracket which prevents the pipe from moving in any direction. The purpose of a fixed point is to control system stresses caused by temperature changes.

### ⚠ Fixed point design

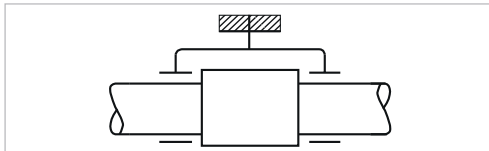
The pipe must not be fixed by clamping it in the pipe bracket. This can cause deformation and physical damage to the pipe, damage that sometimes does not appear until very much later.

If it is necessary to restrict the length change of the pipe at both ends – as it is usually the case – then the pipe bracket should be arranged between two fittings or designed as a double bracket (two-sided fixed point).

Placing a pipe bracket immediately adjacent to a fitting restricts movement due to changes in length to one direction (one-sided fixed point).



One-sided fixed point



Two-sided fixed point

⚠ Pipe brackets must be robust and mounted firmly to be able to take up the forces arising from changes in length in the pipeline. Hanging brackets or KLIP-IT pipe brackets are unsuitable for use as fixed points.

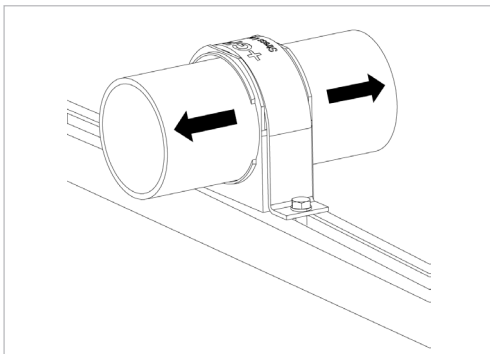
## 4.6.2 Stress Less® Pipe Support System

### Stress Less Overview

Stress Less is a pipe support system specifically designed to eliminate stress transfer to the pipe caused by thermal expansion and overtightening clamps onto the pipe. The patented design consists of a uniquely designed Polypropylene plastic insert that allows for pipe movement during thermal expansion and prevents severe pipe impact when seismic accelerations occur. The trivalent chrome-coated metal hoop meets pipe hanger and support standards and withstands a myriad of operating conditions, including seismic and corrosive environment.

### Loose Bracket

Stress Less pipe guides allows the pipe to have axial movement in the pipe bracket. This allows stress-free compensation of temperature changes and allows movement during other dynamic loading events, countering undesirable stress. The inner diameter of the smooth plastic insert is larger than the outer diameter of the pipe to allow free movement of the pipe.



### Stress Less Pipe Support System

Stress Less Pipe Support System includes pipe guides, vertical supports, clevis hangers, and valve supports allowing installers the flexibility of mount directly on any surface, on pipe support rail, horizontally as a hanger, or vertically.

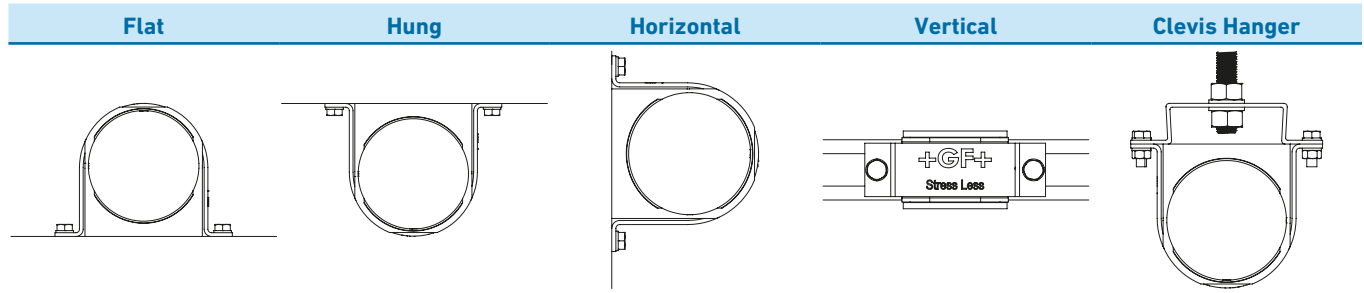
Pipe Guides	Vertical Supports	Clevis Hanger	Valve Supports
d20-d315 (Metric) 0.5" to 12" (IPS)	d20-d63 (Metric) 0.5" to 2" (IPS)	d20-d315 (Metric) 0.5" to 12" (IPS)	d20-d63 (Metric) 0.5" to 2" (IPS)

Other Stress Less pipe support types are available upon request:

- Linestop Clamp Kits
- Fixpoint Flange Restraint Kits
- Accessories

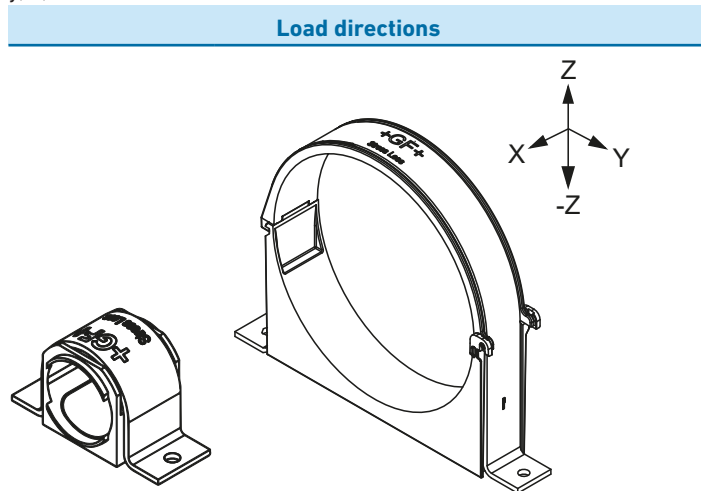
### Stress Less Install Configuration

Stress Less can be mounted to any flat surface or strut support in the different configurations shown below. Please see design load table for maximum recommended load in each configuration. With the addition of the clevis hanger kit, Stress Less guides can be installed as a clevis hanger hung from a threaded rod.



### Stress Less Pipe Supports Load Rating

F<sub>y</sub>, F<sub>z</sub>, and -F<sub>z</sub> are rated design loads, in lb-f (pounds-force) and N (Newtons), for respective y, z, and -z directions.



Pipe Size (OD)		Design Load			Bolt size*
Metric	Inch	F <sub>z</sub>	F <sub>-z</sub>	F <sub>y</sub>	
20mm	½"	150 lb-f / 660 N	180 lb-f / 800 N	150 lb-f / 660 N	M6 - ¼"
25mm	¾"	150 lb-f / 660 N	180 lb-f / 800 N	150 lb-f / 660 N	M6 - ¼"
32mm	1"	150 lb-f / 660 N	180 lb-f / 800 N	150 lb-f / 660 N	M6 - ¼"
40mm	1 ¼"	150 lb-f / 660 N	180 lb-f / 800 N	150 lb-f / 660 N	M6 - ¼"
50mm	1 ½"	150 lb-f / 660 N	180 lb-f / 800 N	150 lb-f / 660 N	M6 - ¼"
63mm	2"	200 lb-f / 800 N	240 lb-f / 880 N	200 lb-f / 800 N	M8 - 5/16"
75mm	2 ½"	300 lb-f / 1300 N	360 lb-f / 1600 N	300 lb-f / 1300 N	M8 - 5/16"
90mm	3"	450 lb-f / 2000 N	540 lb-f / 2400 N	450 lb-f / 2000 N	M8 - 5/16"
110mm	4"	650 lb-f / 2800 N	780 lb-f / 3400 N	600 lb-f / 2670 N	M8 - 5/16"
125mm		700 lb-f / 3100 N	840 lb-f / 3700 N	600 lb-f / 2670 N	M8 - 5/16"
140mm	5"	700 lb-f / 3100 N	840 lb-f / 3700 N	600 lb-f / 2670 N	M8 - 5/16"
160mm	6"	900 lb-f / 4000 N	1080 lb-f / 4800 N	600 lb-f / 2670 N	M8 - 3/8"
225mm	8"	1750 lb-f / 7700 N	2100 lb-f / 9300 N	800 lb-f / 3560 N	M8 - 3/8"
250mm	10"	1750 lb-f / 7700 N	2100 lb-f / 9300 N	800 lb-f / 3560 N	M12 - ½"
280mm		1750 lb-f / 7700 N	2100 lb-f / 9300 N	800 lb-f / 3560 N	M12 - ½"
315mm	12"	1750 lb-f / 7700 N	2100 lb-f / 9300 N	800 lb-f / 3560 N	M12 - ½"

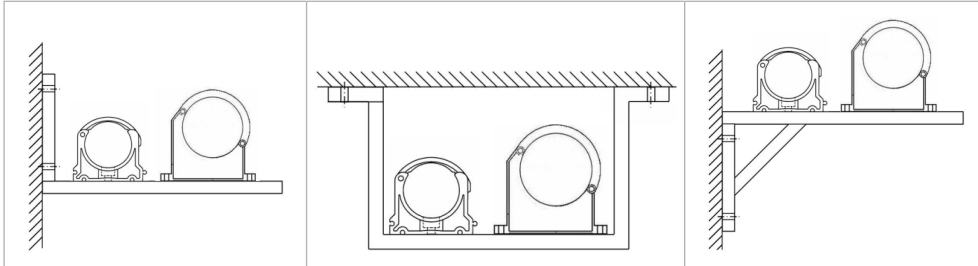
\*Bolts with a tensile strength of at least 70,000 Psi (482 Mpa) recommended.

### 4.6.3 KLIP-IT pipe brackets

These robust plastic pipe brackets can be used not only under rigorous operating conditions, but also where the pipework is subject to aggressive media or atmospheric conditions. Pipe brackets and pipe clamps from GF Piping Systems are suitable for all pipe materials used.

Do not use KLIP-IT pipe brackets as fixed points!

Starting from the dimension  $d_{90}$ , the KLIP-IT brackets must be installed standing, as shown in the following assembly examples. The support distances listed in sections starting with "Pipe bracket spacing for ABS pipes", specified for the KLIP-IT pipe clamps, apply only to this mounting method.



### 4.6.4 Pipe brackets for post-insulated piping systems

Special insulation clamps are offered for piping which is insulated after installation. These clamps shall be installed according to the clamp manufacturer's instructions.

### 4.6.5 Using the tables for pipe bracket spacing

Plastic piping systems need to be supported at certain intervals depending on several factors: the material, the average pipe wall temperature, the density of the medium transported and the size and wall thickness of the pipe. Determining the spacing between pipe brackets is based on the permissible deflection of the pipe between consecutive brackets.

Pipe which are fixed in the axial direction (fixed installation) must be checked for buckling. In most cases, this leads to a reduction of maximum inner pressure as well as shorter distances between the support brackets. Furthermore, the forces which act on the fixed points must be taken into consideration.



#### 4.6.6 Pipe bracket spacing for ABS pipes

##### Liquids with a density of 1 g/cm<sup>3</sup>

d (mm)	DN (Inch)	Pipe bracket spacing L for pipe PN10 / SDR17 / S8 or Class C (mm)				
		≤ 20 °C	30 °C	40 °C	50 °C	60 °C
16	3/8	700	650	600	550	450
20	1/2	800	700	650	600	500
25	3/4	850	800	750	650	600
32	1	1'000	900	850	750	650
40	1 1/4	1'100	1'000	950	850	750
50	1 1/2	1'150	1'100	1'000	900	800
63	2	1'300	1'200	1'100	1'000	850
75	2 1/2	1'500	1'350	1'200	1'100	950
90	3	1'600	1'450	1'350	1'200	1'050
110	4	1'800	1'650	1'550	1'350	1'200
140	5	2'050	1'800	1'700	1'400	1'250
160	6	2'200	1'850	1'750	1'450	1'300
200	7	2'300	2'050	1'850	1'550	1'350
225	8	2'400	2'200	1'900	1'600	1'450
250	9	2'500	2'300	2'000	1'650	1'500
280	10	2'650	2'400	2'100	1'700	1'600
315	12	2'800	2'500	2'200	1'800	1'650

For other SDR / PN values or classes, multiply the values given in the table by the following factor:

- SDR11 und PN16: 1.08
- Klasse B: 0.90
- Klasse D: 1.05
- Klasse E: 1.09

The pipe bracket spacing given in the table may be increased by 30 % in the case of vertical pipe runs, i.e., multiply the values given by 1.3.

##### Liquids with a density other than 1 g/cm<sup>3</sup>

If the liquid to be transported has a density other than 1 g/cm<sup>3</sup>, then the bracket spacings in the table above should be multiplied by the factor given in the following table to obtain different support spacings.

Density of medium (g/cm <sup>3</sup> )	Type of medium	Factors for bracket spacing
1.00	Water	1.00
1.25	Other media	0.96
1.50		0.92
1.75		0.88
2.00		0.84
≤ 0.01	Gaseous media	1.30

#### 4.6.7 Bracket spacing for PE pipe

##### Liquids with a density of 1 g/cm<sup>3</sup>

d (mm)	Bracket spacing L for SDR11 pipe (mm)				
	≤ 20 °C	30 °C	40 °C	50 °C	60 °C
16	500	450	450	400	350
20	575	550	500	450	400
25	650	600	550	550	500
32	750	750	650	650	550
40	900	850	750	750	650
50	1'050	1'000	900	850	750
63	1'200	1'150	1'050	1'000	900
75	1'350	1'300	1'200	1'100	1'000
90	1'500	1'450	1'350	1'250	1'150
110	1'650	1'600	1'500	1'450	1'300
125	1'750	1'700	1'600	1'550	1'400
140	1'900	1'850	1'750	1'650	1'500
160	2'050	1'950	1'850	1'750	1'600
180	2'150	2'050	1'950	1'850	1'750
200	2'300	2'200	2'100	2'000	1'900
225	2'450	2'350	2'250	2'150	2'050
250	2'600	2'500	2'400	2'300	2'100
280	2'750	2'650	2'550	2'400	2'200
315	2'900	2'800	2'700	2'550	2'350
355	3'100	3'000	2'900	2'750	2'550
400	3'300	3'150	3'050	2'900	2'700
450	3'550	3'400	3'300	3'100	2'900
500	3'900	3'650	3'500	3'350	3'100

For other SDR values, multiply the values by the following factors:

- SDR17 und SDR17.6: 0.91
- SDR7.4: 1.07

The pipe bracket spacing given in the table may be increased by 30 % in the case of vertical pipe runs, i.e., multiply the values given by 1.3.

##### Liquids with a density other than 1 g/cm<sup>3</sup>

If the liquid to be transported has a density other than 1 g/cm<sup>3</sup>, then the bracket spacings in the table above should be multiplied by the factor given in the following table to obtain different support spacings.

Density of medium (g/cm <sup>3</sup> )	Type of medium	Factors for bracket spacing
1.00	Water	1.00
1.25	Other media	0.96
1.50		0.92
1.75		0.88
2.00		0.84
≤ 0.01	Gaseous media	1.30 for SDR11
		1.21 for SDR7.4



#### 4.6.8 Bracket spacing for PP pipe

##### PP-H pipe for liquids with a density of 1 g/cm<sup>3</sup>

d (mm)	Bracket spacing L for SDR11 pipe (mm)						
	≤ 20 °C	30 °C	40 °C	50 °C	60 °C	70 °C	80 °C
16	650	625	600	575	550	525	500
20	700	675	650	625	600	575	550
25	800	775	750	725	700	675	650
32	950	925	900	875	850	800	750
40	1'100	1'075	1'050	1'000	950	925	875
50	1'250	1'225	1'200	1'150	1'100	1'050	1'000
63	1'450	1'425	1'400	1'350	1'300	1'250	1'200
75	1'550	1'500	1'450	1'400	1'350	1'300	1'250
90	1'650	1'600	1'550	1'500	1'450	1'400	1'350
110	1'850	1'800	1'750	1'700	1'600	1'500	1'400
125	2'000	1'950	1'900	1'800	1'700	1'600	1'500
140	2'100	2'050	2'000	1'900	1'800	1'700	1'600
160	2'250	2'200	2'100	2'000	1'900	1'800	1'700
180	2'350	2'300	2'200	2'100	2'000	1'900	1'800
200	2'500	2'400	2'300	2'200	2'100	2'000	1'900
225	2'650	2'550	2'450	2'350	2'250	2'150	2'000
250	2'800	2'700	2'600	2'500	2'400	2'300	2'150
280	2'950	2'850	2'750	2'650	2'550	2'450	2'300
315	3'150	3'050	2'950	2'850	2'700	2'600	2'450
355	3'350	3'250	3'150	3'000	2'850	2'750	2'600
400	3'550	3'450	3'350	3'200	3'050	2'900	2'750
450	3'800	3'700	3'600	3'450	3'300	3'100	2'950
500	4'100	4'000	3'850	3'700	3'500	3'350	3'150

For other SDRs, multiply the values given in the table by the following factor:

- SDR17 and SDR17.6: 0.91

The pipe bracket spacing given in the table may be increased by 30 % in the case of vertical pipe runs, i.e. multiply the values given by 1.3.

##### PP-H pipe for liquids with a density other than 1 g/cm<sup>3</sup>

If the liquid to be transported has a density not equal 1 g/cm<sup>3</sup>, then the bracket spacing in the table above should be multiplied by the factor given in the following table to obtain different support spacings.

Density of medium (g/cm <sup>3</sup> )	Type of medium	Type of medium
1.00	Water	1.00
1.25	Other media	0.96
1.50		0.92
1.75		0.88
2.00		0.84
≤ 0.01	Gaseous media	1.30 for SDR11
		1.47 for SDR17.6 and SDR17

### PP-R pipe for liquids with a density of 1 g/cm<sup>3</sup>

d (mm)	Bracket spacing L for SDR11 pipe (mm)						
	≤ 20 °C	30 °C	40 °C	50 °C	60 °C	70 °C	80 °C
16	500	475	450	425	425	400	375
20	525	500	500	475	450	425	425
25	600	575	575	550	525	500	500
32	725	700	675	650	650	600	575
40	825	800	800	750	725	700	650
50	950	925	900	875	825	775	750
63	1'100	1'075	1'050	1'025	975	925	900
75	1'150	1'150	1'100	1'050	1'000	975	950
90	1'250	1'200	1'150	1'150	1'100	1'050	1'000
110	1'400	1'350	1'300	1'300	1'200	1'125	1'050
125	1'500	1'450	1'450	1'350	1'300	1'200	1'150
140	1'600	1'550	1'500	1'450	1'350	1'275	1'200
160	1'700	1'650	1'600	1'500	1'450	1'350	1'300
180	1'750	1'750	1'650	1'600	1'500	1'425	1'350
200	1'900	1'800	1'750	1'650	1'600	1'500	1'450
225	2'000	1'900	1'850	1'750	1'700	1'600	1'500
250	2'100	2'050	1'950	1'900	1'800	1'700	1'600
280	2'950	2'850	2'750	2'650	2'550	2'450	2'300
315	2'350	2'300	2'200	2'150	2'050	1'950	1'850
355	2'500	2'425	2'350	2'250	2'125	2'050	1'950
400	2'650	2'575	2'500	2'400	2'275	2'175	2'050
450	2'850	2'775	2'700	2'575	2'475	2'325	2'200
500	3'075	3'000	2'875	2'775	2'625	2'500	2'350

For other SDRs, multiply the values given in the table by the following factor:

- SDR17 and SDR17.6: 0.91

The pipe bracket spacing given in the table may be increased by 30 % in the case of vertical pipe runs, i.e., multiply the values given by 1.3.

### PP-R pipe for liquids with a density other than 1 g/cm<sup>3</sup>

If the liquid to be transported has a density not equal 1 g/cm<sup>3</sup>, then the bracket spacing in the table above should be multiplied by the factor given in the following table to obtain different support spacings.

Density of medium (g/cm <sup>3</sup> )	Type of medium	Factors for bracket spacing
1.00	Water	1.00
1.25	Other media	0.96
1.50		0.92
1.75		0.88
2.00		0.84
≤ 0.01	Gaseous media	1.30 for SDR11
		1.47 for SDR17.6 and SDR17

#### 4.6.9 Bracket spacing for PVC pipe

##### PVC-U pipe for liquids with a density of 1 g/cm<sup>3</sup>

d (mm)	DN (Inch)	Bracket spacings L for pipe SDR21 / S10 / PN10 (mm)				
		≤ 20 °C	30 °C	40 °C	50 °C	60 °C
16	3/8	950	900	850	750	600
20	1/2	1'100	1'050	1'000	900	700
25	3/4	1'200	1'150	1'050	950	750
32	1	1'350	1'300	1'250	1'100	900
40	1 1/4	1'450	1'400	1'350	1'250	1'000
50	1 1/2	1'600	1'550	1'500	1'400	1'150
63	2	1'800	1'750	1'700	1'550	1'300
75	2 1/2	2'000	1'900	1'850	1'700	1'450
90	3	2'200	2'100	2'000	1'850	1'550
110	4	2'400	2'300	2'250	2'050	1'750
125		2'550	2'450	2'400	2'200	1'850
140	5	2'700	2'600	2'500	2'300	1'950
160	6	2'900	2'800	2'700	2'500	2'100
180		3'100	2'950	2'850	2'650	2'200
200		3'250	3'150	3'000	2'800	2'350
225	8	3'450	3'300	3'200	2'950	2'500
250		3'650	3'500	3'350	3'100	2'600
280	10	3'750	3'700	3'550	3'300	2'750
315	12	4'100	3'900	3'750	3'500	2'950
355	14	4'300	4'200	4'000	3'700	3'100
400	16	4'600	4'450	4'250	3'950	3'300

For other SDR and PN levels, the values must be multiplied with the following factors:

- SDR51 / S25 / PN4: 0.83
- SDR34.3 / S16.7 / PN6: 0.90
- SDR13.6 / S 6.3 / PN16: 1.08
- SDR11 / S 5 / PN20: 1.15

The pipe bracket spacing given in the table may be increased by 30 % in the case of vertical pipe runs, i.e. multiply the values given by 1.3.

##### PVC-U pipe for liquids with a density other than 1 g/cm<sup>3</sup>

If the liquid to be transported has a density other than 1 g/cm<sup>3</sup>, then the bracket spacings in the table above should be multiplied by the factor given in the following table to obtain different support spacings.

Type of medium	Type of medium	Factors for bracket spacing
1.00	Water	1.00
1.25	Other media	0.96
1.50		0.92
1.75		0.88
2.00		0.84
≤ 0.01	Gaseous media	1.42 für SDR21, S8 und PN10
		1.30 für SDR13.6, S6.3 und PN16
		1.20 für SDR11, S5 und PN20

### PVC-C pipe for liquids with a density of 1 g/cm<sup>3</sup>

d (mm)	Bracket spacing L for pipe SDR21 / S10 / PN10 (mm)						
	≤ 20 °C	30 °C	40 °C	50 °C	60 °C	70 °C	80 °C
16	1'000	950	900	850	750	675	600
20	1'150	1'100	1'025	950	875	775	700
25	1'200	1'150	1'100	1'000	900	800	700
32	1'350	1'250	1'200	1'100	1'000	900	800
40	1'500	1'400	1'300	1'250	1'150	1'050	900
50	1'650	1'600	1'500	1'400	1'300	1'200	1'100
63	1'850	1'750	1'650	1'600	1'500	1'350	1'250
75	2'050	1'950	1'850	1'750	1'650	1'500	1'350
90	2'250	2'100	2'000	1'900	1'800	1'650	1'500
110	2'500	2'350	2'200	2'100	1'950	1'800	1'650
125	2'650	2'500	2'350	2'250	2'100	1'950	1'750
140	2'800	2'650	2'500	2'350	2'200	2'050	1'850
160	3'000	2'850	2'700	2'550	2'400	2'200	2'000
180	3'150	3'000	2'850	2'700	2'500	2'300	2'100
200	3'350	3'150	3'000	2'850	2'650	2'450	2'200
225	3'550	3'350	3'200	3'000	2'800	2'600	2'350
250	3'750	3'550	3'350	3'150	3'000	2'750	2'500
280	3'950	3'750	3'550	3'350	3'150	2'900	2'650
315	4'200	4'000	3'750	3'550	3'350	3'050	2'800
350	4'450	4'250	4'000	3'800	3'550	3'250	2'950
400	4'750	4'500	4'250	4'000	3'750	3'450	3'150

For other SDR levels, the values must be multiplied by the following factor:

- SDR13.6 / S6.3 / PN16: 1.08
- SDR11 / S5 / PN20: 1.12

The pipe bracket spacing given in the table may be increased by 30 % in the case of vertical pipe runs, i.e., multiply the values given by 1.3.

### PVC-C pipe for liquids with a density other than 1 g/cm<sup>3</sup>

If the liquid to be transported has a density not equal 1 g/cm<sup>3</sup>, then the bracket spacing in the table above should be multiplied by the factor given in the following table to obtain different support spacings.

Density of medium (g/cm <sup>3</sup> )	Type of medium	Factors for bracket spacing
1.00	Water	1.00
1.25	Other media	0.96
1.50		0.92
1.75		0.88
2.00		0.84
≤ 0.01	Gaseous media	1.42 for SDR21, S8 and PN10
		1.30 for SDR13.6, S6.3 and PN16
		1.20 for SDR11, S5 and PN20

#### 4.6.10 Bracket spacing for PVDF pipes

##### Liquids with a density of 1 g/cm<sup>3</sup>

d (mm)	Bracket spacings L for pipe PN16 / SDR21 (mm)									
	≤ 20 °C	30 °C	40 °C	50 °C	60 °C	70 °C	80 °C	100 °C	120 °C	140 °C
16	725	700	650	600	575	550	500	450	400	300
20	850	800	750	750	700	650	600	500	450	400
25	950	900	850	800	750	700	675	600	500	450
32	1'100	1'050	1'000	950	900	850	800	700	600	500
40	1'200	1'150	1'100	1'050	1'000	950	900	750	650	550
50	1'400	1'350	1'300	1'200	1'150	1'100	1'000	900	750	600

d (mm)	Bracket spacings L for pipe PN10 / SDR33 (mm)									
	≤ 20 °C	30 °C	40 °C	50 °C	60 °C	70 °C	80 °C	100 °C	120 °C	140 °C
63	1'400	1'350	1'300	1'250	1'200	1'150	1'100	950	800	650
75	1'500	1'450	1'400	1'350	1'300	1'250	1'200	1'050	850	700
90	1'600	1'550	1'500	1'450	1'400	1'350	1'300	1'100	950	850
110	1'800	1'750	1'700	1'650	1'550	1'500	1'450	1'250	1'100	950
125	1'900	1'850	1'800	1'700	1'650	1'600	1'500	1'350	1'200	1'000
140	2'000	1'950	1'900	1'800	1'750	1'700	1'600	1'450	1'250	1'050
160	2'150	2'100	2'050	1'950	1'850	1'800	1'700	1'550	1'350	1'150
180	2'300	2'200	2'150	2'050	1'950	1'900	1'800	1'600	1'400	1'200
200	2'400	2'350	2'250	2'150	2'100	2'000	1'900	1'700	1'500	1'300
225	2'550	2'500	2'400	2'300	2'200	2'100	2'000	1'800	1'600	1'400
250	2'650	2'600	2'500	2'400	2'300	2'200	2'100	1'900	1'700	1'500
280	2'850	2'750	2'650	2'550	2'450	2'350	2'250	2'000	1'800	1'600
315	3'000	2'950	2'850	2'750	2'600	2'500	2'400	2'150	1'900	1'650
355	3'200	3'100	3'000	2'850	2'750	2'650	2'500	2'250	2'000	1'750
400	3'400	3'300	3'200	3'050	2'950	2'800	2'650	2'400	2'100	1'800
450	3'650	3'550	3'450	3'300	3'200	3'000	2'850	2'600	2'250	1'900

For other PN and SDR levels, the values in the table above (diameter ≥ d63) must be multiplied by the following factors:

- PN16 / SDR21: 1.08

Pipe bracket spacing for lines running vertically can be increased by 30 % with respect to the values in the table, i.e., table values multiplied by 1.3.

##### Liquids with a density other than 1 g/cm<sup>3</sup>

If the liquid to be transported has a density not equal 1 g/cm<sup>3</sup>, then the bracket spacing in the table above should be multiplied by the factor given in the following table to obtain different support spacings.

Density of medium (g/cm <sup>3</sup> )	Type of medium	Factors for bracket spacing
1.00	Water	1.00
1.25	Other media	0.96
1.50		0.92
1.75		0.88
2.00		0.84
≤ 0.01	Gaseous media	1.48 für SDR33 und PN10
		1.36 für SDR21 und PN16

#### 4.6.11 Bracket spacing for ECTFE pipes

##### Liquids with a density of 1 g/cm<sup>3</sup>

d (mm)	Bracket spacings L for pipe PN10 / SDR21 (mm)										
	≤ 20 °C	30 °C	40 °C	50 °C	60 °C	70 °C	80 °C	90 °C	100 °C	110 °C	120 °C
20	750	650	600	550	500	450	400	400	350	350	300
25	850	700	650	600	550	500	450	400	400	350	350
32	950	850	750	700	650	600	550	500	450	450	400
40	1'050	950	850	750	700	650	600	550	500	500	450
50	1'250	1'100	1'000	900	800	750	700	650	600	550	500
63	1'400	1'200	1'100	1'000	900	850	750	700	650	600	550
75	1'550	1'350	1'200	1'100	1'000	950	850	800	750	700	650
90	1'700	1'500	1'350	1'250	1'150	1'050	950	900	850	800	700
110	1'850	1'650	1'550	1'450	1'300	1'200	1'100	1'000	950	900	800

Pipe bracket spacing for lines running vertically can be increased by 30 % with respect to the values in the table, i.e. table values multiplied by 1.3.

##### Liquids with a density other than 1 g/cm<sup>3</sup>

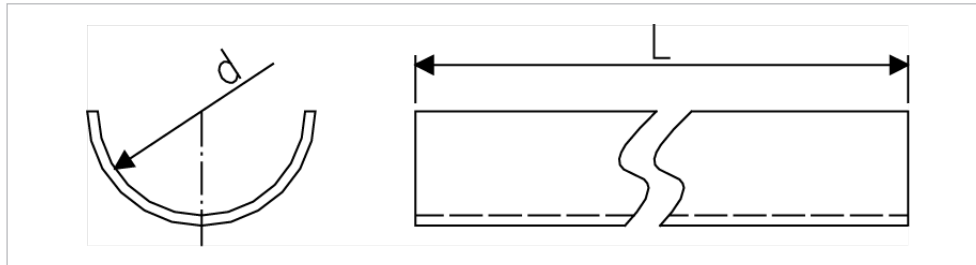
If the liquid to be transported has a density not equal 1 g/cm<sup>3</sup>, then the bracket spacing in the table above should be multiplied by the factor given in the following table to obtain different support spacings.

Density of medium (g/cm <sup>3</sup> )	Type of medium	Factors for bracket spacing
1.00	Water	1.00
1.25	Other media	0.96
1.50		0.92
1.75		0.88
2.00		0.84
≤ 0.01	Gaseous media	1.36 for SDR21 and PN10

#### 4.6.12 Bracket spacing for plastic pipe in carriers

Continuous support may be more economical and practicable than pipe brackets for horizontal or vertical piping systems, especially for small diameter pipe and in areas with high temperatures.

In order to avoid inadmissible loadings on the piping systems, ensure during installation that the carriers in the pipe brackets overlap.



Carriers, diameter (d) matched to pipe diameter, length (L) of carrier

The following table indicates the support spacings when using carriers. These values apply regardless of the type of pipe material or the temperature.

d (mm)	Support spacing when using carriers (mm)
16	1'600
20	1'750
25	1'900
32	2'000
40	2'150
50	2'300
63	2'500
75	2'600
90	2'750
110	2'900

## 4.7 Pressure and leak test

### 4.7.1 Introduction to pressure testing

#### Overview of the different testing methods

Testing method	Pressure test			Leak test	
Medium	Water	Gas <sup>1)</sup>	Compressed air <sup>1)</sup>	Gas/air (oil-free)	Gas/air (oil-free)
Type	Incompressible	Compressible	Compressible	Compressible	Compressible
Test pressure (overpressure)	$P_{p(perm)}$ or $0.85 \cdot P_{p(perm)}$	Operating pressure + 2 bar	Operating pressure + 2 bar	0.5 bar	1.5 bar
Hazard potential during pressure test	Low	High	High	Low	Medium
Material	All plastics	ABS, PE	PB, PE	All plastics	ABS
Informative value	High: Proof of resistance to pressure including tightness against test medium	High: Proof of resistance to pressure including tightness against test medium	High: Proof of resistance to pressure including tightness against test medium	Low	Medium

<sup>1)</sup> Observe the applicable safety precautions. More information is available in DVS 2210-1 addendum 2.

A number of international and national standards and guidelines are available for leak and pressure tests. Therefore, it is often not easy to find the applicable test procedure and for example the test pressure.

The purpose of a pressure test is:

- Ensure the resistance to pressure of the pipeline, and
- Show the leak-tightness against the test medium

Usually, the pressure test is done as a water pressure test and only in exceptional cases (under consideration of special safety precautions) as a gas pressure test with air or nitrogen.

The following comparison attempts to point out the difference between water and air as a test medium:



Water is an incompressible medium, i.e. setting a 1 m PVDF pipe with a diameter of d160 under a pressure of 3 bar results in an energy of approx. 1 joule. In contrast, air is a compressible medium. The same pipe with test pressure of 3 bar already stores an energy of 5,000 joule. If there were a failure during the pressure test, the water-filled pipe would jump up 0.02 m, the air-filled pipe 110 m.

#### Fracture behavior of plastics

In case of a failure, thermoplastic materials show different behaviors. Hence, PE and PB exhibit a ductile behavior (and ABS slightly lower), so that brittle fracture cannot occur.

Nevertheless, the following safety precautions must be taken into consideration during the pressure test. As mentioned before, the pressure test is the first loading placed on the pipeline and is intended to uncover any existing processing faults (e.g. insufficient fusioning).

Gas leak-tightness cannot be demonstrated by a water pressure test, not even with increased test pressure!



## 4.7.2 Pressure test with water or a similar incompressible test medium

### Overview

The pressure test is done when installation work has been completed and presupposes an operational pipeline or operational test sections. The test pressure load is intended to furnish experimental proof of operational safety. The test pressure is not based on the operating pressure, but rather on the internal pressure load capacity, based on the pipe wall thickness.

Addendum 2 of DVS 2210-1 forms the basis for the following information. This replaces the data in DVS 2210-1 entirely. The modifications became necessary because the reference value "nominal pressure (PN)" is being used less and less to determine the test pressure (1.5 x PN, or 1.3 x PN) and is being replaced by SDR. In addition, a short-term overload or even a reduction in the service life can occur if the pipe wall temperature  $T_R = 20\text{ °C}$  is exceeded by more than  $5\text{ °C}$  in the course of the pressure test based on the nominal pressure.

Test pressures are, therefore, determined in relation to SDR and the pipe wall temperature. The 100-h value from the long-term behavior diagram is used for the test pressure.

### Test parameters

The following table provides recommended methods for performing the pressure test.

Object	Pre-test	Main test
Test pressure $p_p$ (depends on the pipe wall temperature and the permissible test pressure of the built-in components, see the section "Determining the test pressure")	$\leq P_{p(\text{perm})}$	$\leq 0.85 P_{p(\text{perm})}$
Test duration (depends on the length of the pipeline sections)	$L \leq 100\text{ m}$ : 3 h $100\text{ m} < L \leq 500\text{ m}$ : 6 h	$L \leq 100\text{ m}$ : 3 h $100\text{ m} < L \leq 500\text{ m}$ : 6 h
Checks during the test (test pressure and temperature progression must be recorded)	At least 3 checks, distributed over the test duration with restoring the test pressure	At least 2 checks, distributed over the test duration without restoring the test pressure

### Pre-test

The pre-test serves to prepare the piping system for the actual test (main test). In the course of pre-testing, a tension-expansion equilibrium in relation to an increase in volume will develop in the piping system. A material-related drop in pressure will occur which will require repeated pumping to restore the test pressure and also frequently a re-tightening of the flange connection bolts.

The guidelines for an expansion-related pressure decrease in pipe are:

Material	Pressure drop (bar/h)
PVC-U	0.5
PVC-C	0.5
ABS	0.6
PP	0.8
PE	1.2
PB	1.4
PVDF	0.8
ECTFE	0.9
PA-U*	0.8

\*According to DVS 2210-1ff

## Main test

In the context of the main test, a much smaller drop in pressure can be expected at constant pipe wall temperatures so that it is not necessary to pump again. The checks can focus primarily on leak detection at the flange joints and any position changes of the pipe.

### Observe if using compensators

If the pipeline to be tested contains compensators, it has an influence on the expected axial forces on the fixed points of the pipeline. Because the test pressure is higher than the operating pressure, the axial forces on the fixed points increase proportionately. This has to be taken into account when designing the fixed points.

### Observe if using valves

When using a valve at the end of a pipeline (end or final valve), the valve and the pipe end should be closed by a dummy flange or cap. This prevents an inadvertent opening of the valve and exit of the medium or any pollution of the inside of the valve.

## 4.7.3 Filling the pipeline

Before starting with the pressure test, the following points must be checked:

- Was installation done according to the available plans?
- All pressure relief devices and flap traps mounted in the flow direction?
- All end valves shut?
- Valves in front of other devices are shut to protect against pressure?
- Visual inspection of all joints, pumps, measurement devices and tanks?
- Has the waiting period after the last fusion/cementing been observed?

Now the pipeline can be filled from the geodetic lowest point. Special attention should be given to the air vent. If possible, vents should be provided at all the high points of the pipeline and these should be open when filling the system. Flushing velocity should be at least 1 m/s.

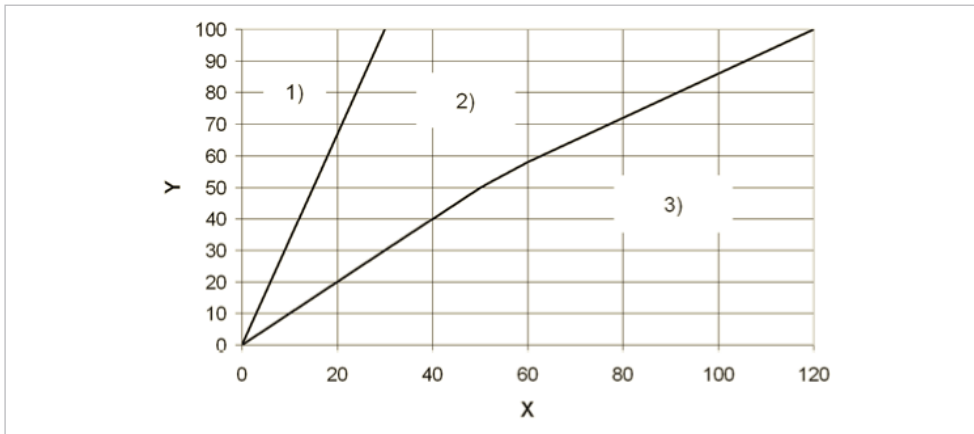
Reference values for the filling volume are given in the table below.

DN (mm)	V (l/s)	DN (mm)	V (l/s)
≤ 80	0.15	250	2.0
100	0.3	300	3.0
150	0.7	400	6.0
200	1.5	500	> 9.0

Adequate time should be allowed between filling and testing the pipeline, so that the air contained in the piping system can escape via the vents: approx. 6 - 12 h, depending on the nominal diameter.

### Applying the test pressure

The test pressure is applied according to the diagram. Here it is important that the pressure increase rate does not cause any water hammering!



- Y Test pressure (%)
- X Time for pressure increase (min)
- 1) Pressure increase rate up to DN100 mm
- 2) Range of pressure increase rates between DN100 and DN400 mm
- 3) Values for pressure increase rate DN500 and greater is: 500/DN (bar/10 min)

### Determining the test pressure

The permissible test pressure is calculated according to the following formula:

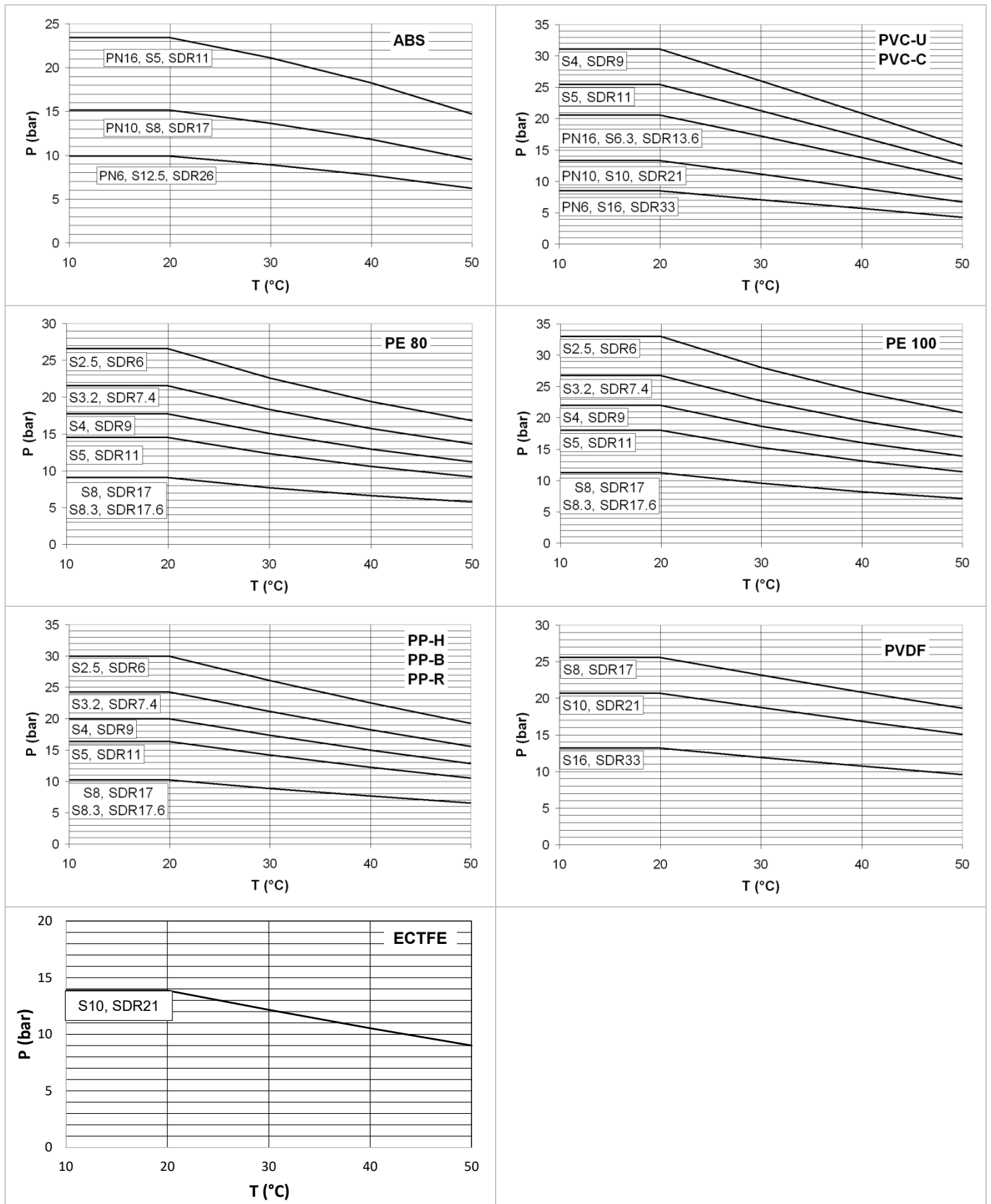
$$P_{p(zul)} = \frac{1}{SDR} \cdot \frac{20 \cdot \sigma_{v(T, 100 h)}}{S_p \cdot A_G}$$

- $\sigma_{v(T, 100 h)}$  Long-term creep strength for pipe wall temperature  $T_R$  (at  $t = 100 h$ )
- $S_p$  Minimum safety factor for long-term creep strength
- $A_G$  Processing or geometry-specific factor that reduces the allowable test pressure
- $T_R$  Pipe wall temperature: average value of test medium temperature and pipe surface temperature

**⚠** If the piping system contains valves, the maximum allowable test pressure is limited to the nominal pressure of the valves.  
 For the pressure test of valves in open position, the same instructions apply as for the piping system (max. 1.5 x PN, or max. PN + 5 bar), but the test pressure in closed valve position must not exceed max. 1.1 x PN.

Material	$S_p$ Minimum safety factor DVS 2210-1 Suppl.2
ABS	1.6
PE80, PE100	1.25
PP-H	1.8
PP-R	1.4
PVC-U, PVC-C	2.5
PVDF	1.4
ECTFE	1.6

To make things easier, the permissible test pressures can be taken directly from the following diagrams.



P Permissible test pressure (bar)  
 T Pipe wall temperature (°C)

## Checks during testing

The following measurement values must be recorded consistently during testing:

- Internal pressure at the absolute lowest point of the pipeline
- Medium and ambient temperature
- Water volume input
- Water volume output
- Pressure drop rates

### 4.7.4 Pressure test and leak-tightness test of ABS piping systems with gas/air as test medium (compressible medium)

#### Overview

Usually the pressure test is done as a water pressure test and only in exceptional cases (under consideration of special safety precautions) as a gas pressure test with air or nitrogen.

#### Compensators

If the pipeline to be tested contains compensators, it has an influence on the expected axial forces on the fixed points of the pipeline. Because the test pressure is higher than the operating pressure, the axial forces on the fixed points increase proportionately. This has to be taken into account when designing the fixed points.

#### Valves

When using a valve at the end of a pipeline (end or final valve), the valve and the pipe end should be closed by a dummy flange or cap. This prevents an inadvertent opening of the valve and exit of the medium or any pollution of the inside of the valve.

#### Minimum waiting times for the pressure test

Before carrying out the pressure test, observe the minimum waiting times according to the following table:

Ambient temperature	Waiting time
10 - 30 °C	Min. 48 hours


#### Performing the pressure test


The test pressure shall be least 2 bar higher than the operating pressure, but shall not exceed the nominal pressure PN of the installed piping system. Any components with a lower PN than the rest of the piping systems have to be taken into account. The test temperature shall be between 10 and 30 °C.

The piping systems must be free from any grease or paint.

Only oil-free air or inert gases such as nitrogen should be used as the test medium. No refrigerant gases, such as R22, may be used.

Once the pressure in the system has stabilized, hold the pipeline under the test pressure for at least 15 minutes. If a drop in pressure is observed, inspect all the joints, flanges, etc. for leaks using a foam-building agent. A soap solution which can be removed simply with water after the test is recommended.

 Commercial leak detection sprays can cause stress cracks in plastics. If these sprays are used, remove any residues after testing.

 The leak-tightness of valves against gases is not representative of the leak-tightness of valves against a liquid. Therefore, if a GF Piping Systems valve shows a leak during pressure testing with a gas, it is recommended to reduce the pressure to 1.5 bar and re-inspect the valves.

## Leak-tightness test with gas/air

To check the leak-tightness shortly after installation, a test pressure of up to 1.5 bar with a minimum waiting time of 3 hours after the last cementing applies.

### 4.7.5 Pressure test of compressed-air piping systems

#### Overview

For practical reasons, this testing is done with compressed air. The pressure test follows DVGW G 469. The pressure test for pipeline lengths less than 500 m using air A3 based on visual inspection is described below. More details are available in the DVGW guideline.



Compressible media like compressed air under internal pressure.

In case of failure: life-threatening danger during pressure testing due to explosive escape of the medium.

- The area around the pipeline under test pressure is to be clearly restricted for access only by persons assigned with the testing.
- Required control equipment is to be placed at a safe distance.
- The testing should be timed so that there are as few persons as possible in the immediate blocked-off area.
- Additional signs (e.g. Do Not Enter or Warning! Gas pressure tests!) should be placed particularly at the entrances to the hazard area. If necessary, persons in neighboring buildings should be informed.

#### Testing procedure

The test pressure shall be least 2 bar higher than the permissible operating pressure. If this is not possible because of insufficient compressor output, then the maximum compressor pressure shall be used.

The piping systems must be free from any grease or paint.

The test pressure is applied to the installed pipeline with a maximum increase in pressure of 3 bar/min (risk of water hammer!). Hold the pipeline under the test pressure until all connection parts of the pipeline like flanges, unions, valves, etc. are inspected for tightness using a foam-building agent. A soap solution, which can be removed simply with water after the test, is best. It is recommended to subsequently reduce the test pressure to 2 bar and repeat the test using a foam-building agent.

#### Leak test with gas as test medium (compressible medium) and maximum test pressure of 0.5 bar

If it is not possible to do an pressure test with water (e.g., pipeline must be kept dry), a leak test can be carried out with slight overpressure. For safety reasons, the test pressure must then be limited to maximum 0.5 bar overpressure. During the leak test, all joints must be sprayed with a foam-building agent and checked. A soap solution, which can be removed simply with water after the test, is best. Since the efficiency of the leak test is significantly limited due to the low load, it is recommended to use it preferably for systems with operating pressures below 0.5 bar.

## 4.8 Modifications, repairs, commissioning

### 4.8.1 Modifications and repairs

The following safety measures are to be observed when modifying or repairing piping systems:

- Wear protective clothing
- Drain the respective pipeline section completely
- Rinse the pipe section
- Protect against dripping
- Clean and dry the joints
- Perform the tasks by trained personnel

Modifications and repairs to the piping system must not cause mechanical weakening of the piping system.

To ensure the operational safety of the piping system following a modification or a repair, an pressure test should be done.

### 4.8.2 Commissioning

When putting a pipeline into operation for the first time, it is not only placed under internal pressure load, but also under temperature effect. The thermal stress or expansions were not simulated during testing.

We recommend an initial inspection at the earliest 3 days, at the latest 7 days, after commissioning and recording the results.

The checks during the inspection shall cover the following items:

- Visual inspection
- Flange joints, unions, valves (leak-proof)
- Condition and function of safety and leak detection equipment

The remaining inspections of the piping system, together with the general checks, shall be performed by the operating personnel according to the operating instructions.

# 5 Joining technology – Mechanical joints

## 5.1 Overview

Of the many diverse solutions offered by GF Piping Systems for mechanical joints, the following table offers information on the conventional methods used in industrial piping system construction:

Figure	Connection type	Gasket	Connection of plastic with
	Flange connection	O-ring Profile seal High Purity gasket	Plastic or metal
	Union	O-ring	Plastic (same or different materials)
	Adaptor union	O-ring	Metal
	Adaptor pipe fitting	PTFE tape Thread sealing cord	Plastic or metal
	Threaded fitting	PTFE tape Thread sealing cord	Plastic (same or different materials)
	Hose connection		Hose
	Victaulic® adaptor	Lip seal	Steel
	SYGEF Plus sanitary adaptor	Special seal	Stainless steel
	Universal coupling	Special seal	Plastic or metal

Overview of mechanical connections



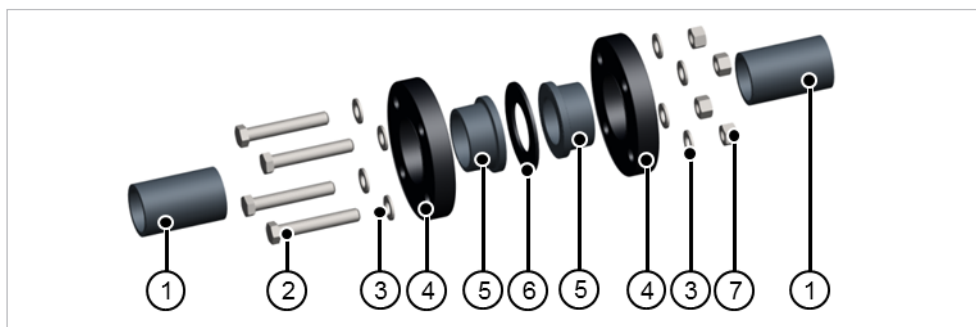
### Thread types

The following thread types are used:

Designation of the thread	Standard	Description	Application
Rp	ISO 7-1, EN 10226-1	Parallel internal thread, where pressure-tight joints are made on the threads	Transitional and threaded fittings, Malleable cast iron fittings
Rc	ISO 7-1, EN 10226-2	Tapered internal thread, where pressure-tight joints are made on the threads	JIS connections
R	ISO 7-1, EN 10226-1	Tapered male thread, where pressure-tight joints are made on the threads	Transitional and threaded fittings, Steel pipe
G	ISO 228-1	Parallel internal or male threads, where pressure-tight joints are not made on the threads, dimension up to and including 4"	Unions (with coupling nut)
NPT = National (American Standard) Pipe Taper	ASTM F 1498	Tapered internal or male threads, where pressure-tight joints are made on the threads	Transitional and threaded fittings
Acme thread	Special thread	Fastening thread for unions made of ABS, PVC-U and PVC-C d75, d90 and d110	Unions
Buttress thread	Special thread	Fastening thread for unions made of PE, PP and PVDF d75, d90 and d110	Unions

## 5.2 Flange connections

Flanges with sufficient thermal and mechanical stability must be used. The different flange types by GF Piping Systems fulfill these requirements. The gasket dimensions must match the outer and inner diameter of the flange adapter or valve end. Differences between the inner diameters of gasket and flange that are greater than 10 mm may result in malfunctioning flange connections.



- 1 Pipe
- 2 Bolt
- 3 Washer
- 4 Flange
- 5 Valve end/flange adapter
- 6 Flange seal
- 7 Nut

### Comparison of flange connections

Flange connection	Properties
PP-V flange	<ul style="list-style-type: none"> <li>• Corrosion-free all-plastic flange made of polypropylene PP-GF30 (fiber-glass reinforced)</li> <li>• High chemical resistance (hydrolysis-resistant)</li> <li>• Maximum possible break resistance due to elasticity (deforms if it is tightened too much)</li> <li>• Use for ambient temperatures up to 80 °C</li> <li>• The temperature of the medium is restricted by the material of the plastic piping system (ABS, PVC-U, PVC-C, PP or PE)</li> <li>• For PVDF up to 140 °C media temperature, the ambient temperature is limited to at most 40 °C</li> <li>• UV-stabilized</li> <li>• With integrated bolt-fixing</li> <li>• Self-centering aid for the flanges on the flange adapter</li> <li>• Symmetric design allows assembly on either side: A "reverse" installation is never possible. All important information is readable</li> <li>• V-groove (patented)</li> <li>• Even distribution of forces across the flange (preserves life expectancy of components)</li> <li>• Supports a longer-lasting torque for a safe joint</li> </ul>
PP steel flange	<ul style="list-style-type: none"> <li>• Very robust and stiff due to the steel inlay</li> <li>• Corrosion-free plastic flange made of polypropylene PP-GF30 (fiber-glass reinforced) with steel inlay</li> <li>• High chemical resistance (hydrolysis-resistant)</li> <li>• Maximum ambient temperature 80 °C</li> <li>• UV-stabilized</li> </ul>
PVC flange	<ul style="list-style-type: none"> <li>• PVC-U flanges may be used as long as the flow medium or the ambient temperature does not exceed a temperature of 45 °C.</li> <li>• At higher temperatures, the flanges could distort over time.</li> <li>• At temperatures above 45 °C, flanges with sufficient thermal and mechanical stability must be used. These requirements are met by the PP-V and PP steel flanges by GF Piping Systems.</li> </ul>
Blind flange	<ul style="list-style-type: none"> <li>• Combination of a backing flange and an end blank. The end blanks are available in PP-H and PE materials.</li> <li>• Combines end blanks in the dimensions d63 to d315 with the PP-V backing flange.</li> <li>• The dimensions d355 to d630 are combined with a backing flange made of PP with steel inlay.</li> <li>• With the blanking flange set, the piping system can be closed off using the same material.</li> <li>• If the piping system is extended, the backing flange can be used again, cutting down on additional costs.</li> <li>• Suitable for pressure piping</li> <li>• Easy assembly of the blank flange set: The end blank is centered on the inner diameter of the backing flange.</li> </ul>

### Creating flange connections

When making a flange connection, the following points have to be taken into account:

#### Usage information

Backing flanges are identified with the following pictograms of the usable flanges:



#### Orientation of bolts beyond the two main axes

- For horizontal piping systems, the orientation shown of the bolts beyond the main axes (see the following figure) is preferred since possible leaks at the flange connection do not cause the medium to run directly onto the bolts.



Flange with main axes (centered, crosswise)

- Flange adapter, valve end or fixed flange, gasket, as well as backing flange, must be aligned centered on the pipe axis.
- Before pre-tightening the bolts, the jointing faces must be flush with each other and must fit tightly against the gasket. Pulling badly aligned flanges together within the flange connection must be strictly avoided because of the resulting tensile stress.

#### Selecting and handling bolts

- The length of the bolts should be selected in such a way that the bolt thread does not protrude more than 2 to 3 turns of the thread at the nut. Washers must be used at the bolt head as well as the nut.
  - To ensure that the connecting bolts can be easily tightened and removed after a lengthy period of use, the thread should be lubricated, e.g. with molybdenum sulphide.
  - Tightening the bolts by using a torque wrench
- The bolts must be tightened diagonally and evenly: First, tighten the bolts by hand so that the gasket is evenly contacting the jointing faces. Then tighten all bolts diagonally to 50 % of the required torque, followed by 100 % of the required torque. The recommended bolt tightening torques are listed in the table "Bolt tightening torque guidelines for ISO flange connections". However, deviations may occur in practice, e.g. through the use of stiff bolts or pipe axes that are not aligned. The Shore hardness of the gasket can also influence the necessary tightening torque.
- We recommend checking the tightening torques 24 hours after assembly according to the specified values and, if necessary, retighten them. Always tighten diagonally here, as well.
- After the pressure test, the tightening torques must be checked in any case and, if necessary, retightened.

**i** For more information on flange connections, see DVS 2210-1 Supplement 3.

#### Tightening the bolts using a torque wrench

However, deviations may occur in practice, e.g. through the use of stiff bolts or pipe axes that are not aligned. The Shore hardness of the gasket can also influence the necessary tightening torque.

**i** In the area of flexible sections and expansion loops, no bolt connections or flange connections should be used since the bending stress may cause leaks.


**Bolt tightening torque guidelines for metric (ISO) flange connections with PP-V, PP- steel and PVC flanges**

The indicated torques are recommended by GF Piping Systems. These torques already ensure a sufficient tightness of the flange connection. They deviate from the data in the DVS 2210-1 Supplement 3, which are to be understood as upper limits. The individual components of the flange connection (valve ends, flange adapters, flanges) by GF Piping Systems are dimensioned for these upper limits.

Pipe outer diameter d (mm)	Nominal diameter DN (mm)	No. of bolts	For PROGEF PP, SYGEF PVDF, SYGEF ECTFE, ecoFIT PE, ABS, PVC-U/C metric systems, with PP-Steel, PP-V and PVC-U flanges (Nm)						
			Flat gasket, lubed	Flat gasket, unlubed	Profile gasket, lubed	Profile gasket, unlubed	O-ring, lubed	O-ring, unlubed	SYGEF HP gasket unlubed
d16	DN10	4	10	13	10	13	10	13	
d20	DN15	4	10	13	10	13	10	13	
d25	DN20	4	10	13	10	13	10	13	14
d32	DN 25	4	15	20	10	13	10	13	16
d40	DN 32	4	20	26	15	20	15	20	20
d50	DN 40	4	25	33	15	20	15	20	26
d63	DN 50	4	35	46	20	26	20	26	34
d75	DN 65	4	50	65	25	33	25	33	38
d90	DN 80	8	30	39	15	20	15	20	45
d110, 125	DN 100	8	35	46	20	26	20	26	30
d140	DN 125	8	45	59	25	33	25	33	
d160, 180	DN 150	8	60	78	35	46	30	39	49
d200, 225	DN 200	8	70	91	45	59	35	46	65
d250, 280	DN 250	12	65	85	35	46	30	39	65
d315	DN 300	12	90	117	50	65	40	52	76
d355	DN 350	16	90	117	50	65			223
d400	DN 400	16	100	130	60	78			176
d450, 500	DN 500	20	190	247	70	91			264
d560, 630	DN 600	20	220	286	90	117			

**Bolt tightening torque guidelines for ASME flange connections with PP-V, PP-steel and PVC flanges**

Flange size (inch)	Nominal diameter DN (mm)	No. of bolts	For PROGEF PP, SYGEF PVDF, SYGEF ECTFE and ecoFIT PE systems, with PP-Steel and PP-V flanges (ft-lb)				
			Flat gasket, lubed	Flat gasket, unlubed	SYGEF HP gasket, unlubed	Profile gasket, lubed	Profile gasket, unlubed
½"	DN15	4	7	9		5	7
¾"	DN20	4	9	12	10	7	9
1"	DN25	4	11	14	12	9	12
1¼"	DN32	4	14	18	15	10	13
1½"	DN40	4	16	21	19	13	17
2"	DN50	4	28	36	25	19	25
2½"	DN65	4	43	56	28	21	27
3"	DN80	4	47	61	33	25	33
4"	DN100	8	30	39	22	16	21
6"	DN150	8	45	59	36	25	33
8"	DN200	8	52	68	48	33	43
10"	DN250	12	56	73	48	31	40
12"	DN300	12	64	83	56	37	48
14"	DN350	16	66	75	165	49	64
16"	DN400	16	75	80	130	45	59
18"	(DN450)	16	120	132	195	56	73
20"	DN500	20	140	154		60	78

 Please observe the special bolt tightening torques listed for butterfly valves. See also the section "Planning fundamentals for butterfly valves, hand-operated".

**Installation recommendation:**

Either the bolt or the nut, and preferably both, should be zinc-plated to ensure minimal friction.

- zinc-on-zinc, with or without lube
- zinc-on-stainless-steel, with or without lube
- stainless-on-stainless, with lube only


Cadmium-plated fasteners are also acceptable with or without lubrication. Galvanized and carbon-steel fasteners are not recommended. Use a copper-graphite anti-seize lubricant to ensure smooth engagement and the ability to disassemble and reassemble the system easily.

**Length of bolts**

In practice, it is often difficult to specify the correct bolt length for flange connections. It can be derived from the following parameters:

- Thickness of the washer (2x)
- Thickness of the nut (1x)
- Thickness of the gasket (1x)
- Flange thickness (2x)
- Thickness of flange collar (valve end or flange adapter) (2x)
- Valve installation length, if applicable (1x)

The following tables are useful in determining the necessary bolt length. Due to the various combinations of the individual components, only thicknesses of the individual parts of flange connections can be provided. However, you simply add them together to determine the necessary bolt length.

 According to DVS 2210-1, you should dimension the necessary bolt length for flange connections so that 2-3 turns of the thread protrude beyond the nut.

■ Online tool "Bolt lengths and tightening torques" located at [www.gfps.com/tools](http://www.gfps.com/tools)



Washer (mm)	Thickness (mm)
DN10–DN25	3
DN32–DN600	4

Nuts (mm)	Pitch (mm)	Height of nut (thickness) (mm)
DN10–DN25 M12 WAF 19 (18)	1.7	10.4
DN32–DN125 M16 WAF 24	2.0	14.1
DN150–DN350 M20 WAF 30	2.5	20.2
DN400–DN500 M24 WAF 36	3.0	20.2
DN600 M27 WAF 41	3.0	23.8

Flat gasket (mm)	Thickness (mm)
DN10–DN80	Approx. 2
DN100–DN600	Approx. 3

Profile seal (mm)	Thickness (mm)
DN10–DN40	Approx. 3
DN50–DN80	Approx. 4
DN100–DN125	Approx. 5
DN150–DN300	Approx. 6
DN350–DN600	Approx. 7

Flange (hole circle PN10) (mm)	Thickness (mm)			
	PP-V	PP steel	PVC-U, PVC-C	Blind flange (PVC-U)
DN10			10	
DN15	16	12	11	12
DN20	17	12	12	13
DN25	18	16	14	15
DN32	20	20	15	16
DN40	22	20	16	17
DN50	24	20	18	20
DN65	26	20	19	21
DN80	27	20	20	22
DN100	28	20	22	24
DN125	30	24	26	28
DN150	32	24	28	30
DN200	34	27	32	36
DN250	38	30	36	36
DN300	42	34	36	36
DN350	46	40	38	38
DN400	50	40	42	42
DN500		54		
DN600		64		

Metric valve end for socket joints, flat or profile gasket (mm)	Thickness (mm)		
	ABS, PVC-C, PVC-U	PP, PE	PVDF
d16/DN10	6		
d20/DN15	6	7	6
d25/DN20	7	9	7
d32/DN25	7	10	7
d40/DN32	8	11	8
d50/DN40	8	12	8
d63/DN50	9	14	9
d75/DN65	10	16	
d90/DN80	11	17	
d110/DN100	12	18	
d125/DN100	13		
d140/DN125	14		
d160/DN150	16		
d200/DN200	24		
d225/DN200	25		
d250/DN250	23		
d280/DN250	23		
d315/DN300	27		
d355/DN350	32		
d400/DN400	34		

Metric valve end for socket joints, O-ring (mm)	Thickness (including gasket) (mm)		
	PVC-C, PVC-U	PP, PE	PVDF
d16/DN10	9		
d20/DN15	9	9	9
d25/DN20	10	10	10
d32/DN25	10	10	10
d40/DN32	13	13	13
d50/DN40	13	13	13
d63/DN50	14	14	14
d75/DN65	15	15	
d90/DN80	16	16	
d110/DN100	18	18	
d125/DN100	19		
d140/DN125	20		
d160/DN150	22		
d200/DN200	30		
d225/DN200	31		
d250/DN250	23		
d280/DN250	30		
d315/DN300	35		
d355/DN350			
d400/DN400			

Metric flange adapters for butt fusion joints, flat or profile gasket (mm)	Thickness (mm)		
	PP, PE, SDR11	PP, PE, SDR17	PVDF, SDR33, SDR21, ECTFE SDR21
d16/DN10			
d20/DN15	7		6
d25/DN20	9		7
d32/DN25	10		7
d40/DN32	11		8
d50/DN40	12	12	8
d63/DN50	14	14	9
d75/DN65	16	16	10
d90/DN80	17	17	12
d110/DN100	18	18	13
d125/DN100	25	25	14
d140/DN125	25	25	16
d160/DN150	25	25	17
d180/DN150	30	30	
d200/DN200	32	32	22
d225/DN200	32	32	22
d250/DN250	35	25	22
d280/DN250	35	25	22
d315/DN300	35	35	24
d355/DN350	40	30	30
d400/DN400	46	33	32
d450/DN500	60	60	
d500/DN500	60	60	
d560/DN600	60	60	
d630/DN600	60	60	

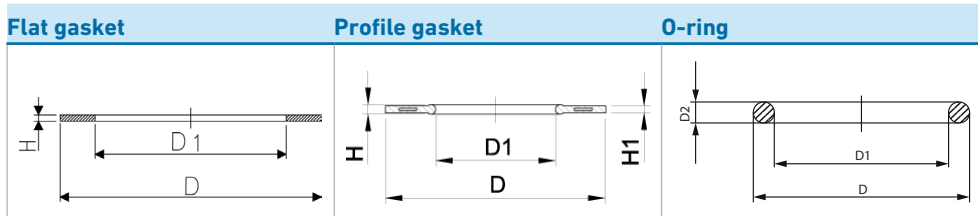
Valves installed in flange connection (mm)	Installation length (mm)		
	Butterfly valve Type 567/578	Butterfly valve Type 037/038	Wafer check type 369
DN32			15
DN40			16
DN50	45	43	18
DN65	46	46	20
DN80	49	46	20
DN100	56	52	23
DN125	64	56	23
DN150	72	56	26
DN200	73	60	35
DN250	113	68	40
DN300	113	78	45
DN350	129		
DN400	169		
DN450	179		
DN500	190		
DN600	209		

### Selection of gaskets for flange connections

When selecting suitable flange seals for thermoplastic piping systems, the following factors must be taken into account:

- Operating conditions
- Sealing forces
- Gasket form
- Dimension
- Material

#### Type of gasket



In applications with low operating pressures, the customary flat gasket, which is made of 2 to 5 mm thick sheet material (depending on the nominal width), is sufficient. Flange connections with flat gaskets require flanges with sufficient stiffness. All flanges by GF Piping Systems meet these requirements.

For higher operating and testing pressures, profile flange gaskets and O-rings have proven useful. Compared to flat gaskets, profile flange gaskets consist of two parts. One is the crowned flat gasket part, which is reinforced with steel, and the other is the profile gasket part (O-ring, lip seal) on the inner side of the gasket.

Stabilized profile flange gaskets, as well as O-ring gaskets, have the following advantages:

- Reliable seal with low bolt tightening torque
- Usable at higher internal pressures and internal vacuum
- Minor influence of flange or collar surface
- Safe operation when connecting pipe made of different materials



A suitable gasket form can be found by using the table below.

Gasket form	Recommended application limits	Flange or collar design
Flat gasket	p ≤ 10 bar, above DN200 only ≤ 6 bar T to 40 °C	With sealing grooves
Profile flange gasket	Vacuum p = 1 bar to 16 bar T = entire application range	With or without sealing grooves
O-ring	Vacuum p = 1 bar to 16 bar T = entire application range	One side with groove

**Gasket material**

The choice of a gasket material is based on the flow media. Details about the suitability of the gasket material, or specifically its chemical resistance, can be found in the GF Piping Systems resistance tables.

The use of gasket materials with a high degree of hardness, as in steel pipe, is not recommended for thermoplastic piping systems because the flange or the adaptor could become deformed due to the required high sealing forces. Elastomer materials, such as EPDM or FKM, with a Shore-A hardness of up to 75° are preferable.

**Gasket dimension**

The dimensions of the gaskets are set in the general standards for pipe joining components. Excessive dimensional deviations in the inside or outside diameter of the gasket compared to the flange adapter or valve end cause increased mechanical stress of the flange connection, accelerated wear of the inner side of the gasket, as well as deposits inside the pipe.


### 5.3 Unions joining plastic piping components

Wherever available, unions are the preferred choice over flange adapters for the mechanical connection of plastic pipe. With no metal parts, there is no corrosion and the weight of the connection is also reduced. In addition, the smaller outside diameter compared to a flange connection means that the distance from pipe axis to pipe axis is shorter. Furthermore, assembly is easier and faster. Unions are available in a wide variety of materials and material combinations.

**General notes on assembly**

Plastic unions are always sealed with an O-ring. The coupling nut may only be tightened manually. Pipe wrenches customarily used in steel pipe construction are not permissible. For bigger sizes, a pipe wrench with belt can be used. When using unions, care should be taken to obtain a low-stress assembly.

 In the area of flexible sections and expansion loops, unions cannot be used because the bending load can lead to leakages.

 To make assembly of large unions easier, "lubricate" the thread with some water.

**Assembly of unions made of PP, PE, PVDF with d75, d90 and d110**

The newest generation of plastic unions in the above mentioned materials and dimensions has been equipped with a modern, plastics-oriented buttress thread, resulting in a product with considerably increased nominal pressure and safety reserves. Several notable/ important points in this respect are listed below.

**Threads on coupling nut and union bush for PP, PVDF and PE**

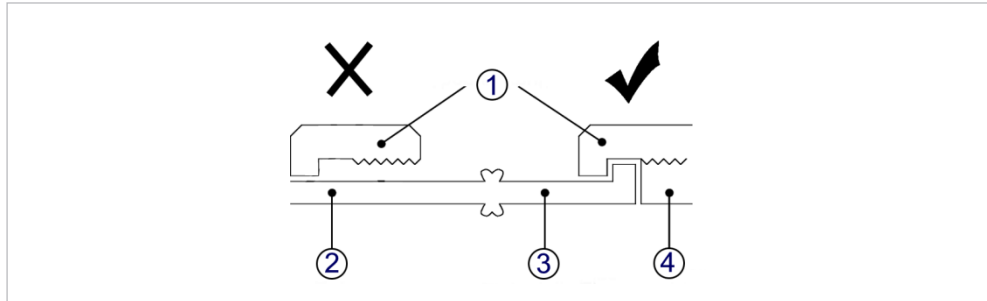
When using individual parts, check prior to the assembly whether the threads of the union bush and coupling nut are identical and can be bolted together:

- Coupling nut with trapezoidal thread on union bush with trapezoidal thread
- Coupling nut with buttress thread on union bush with buttress thread

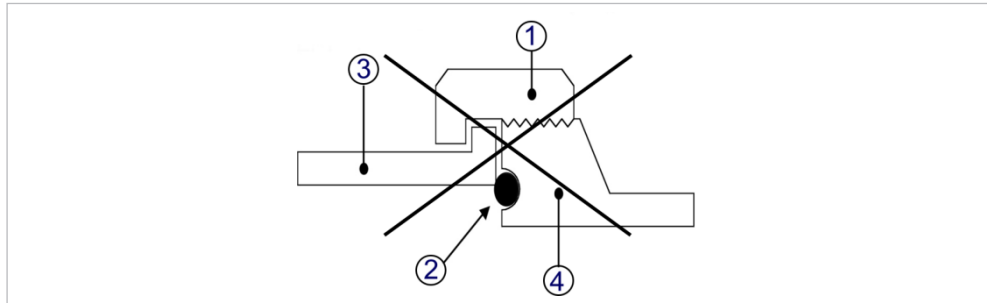
**Fusion bead at unions for butt fusion**

For the dimensions d90 and d110, we advise fusing the complete union to the pipe, if possible (or slide the coupling nut to the collar of the union end) because it may not be possible to slide the coupling nut over the fusion bead after the fusion.

**i** Only use union bushes and union ends with the same nominal diameter. A butt fusion union bush d75 may not be combined with a butt fusion union end d90 to form a reducer, because this can cause leakage, as illustrated below.



- 1 Coupling nut
- 2 Pipe
- 3 Union end
- 4 Union bush



- 1 Coupling nut d75
- 2 Insufficient seal
- 3 Butt fusion union end d90
- 4 Butt fusion union bush d75

**Unions as adaptor connections for different plastics**

The component parts of the unions d20 to d63 of different plastics can be combined. Each of the two components with thread, union bush and coupling nut must be made of the same material. The union end can be selected from another material. For larger dimensions (d75 to d110), the material transition is not generally possible, and should be looked at on a case by case basis.

**5.4 Adaptor unions for connections between plastic and metal pipe**

The GF Piping Systems line of fittings contains various adaptor and threaded fittings. For the connection of plastic piping components to metal pipe, fittings or valves made of metal (or vice versa) with threaded connections, adaptor unions with metal inlays are preferred.

The seal in the metal thread can either be made with hemp or a PTFE tape as long as the counterpart is not made of plastic.

**⚠** To prevent electrochemical corrosion, malleable iron connecting elements should preferably be used for steel transitions and brass connecting elements for transitions to non-ferrous metals.

## 5.5 Transitional and threaded fittings

### Combination G and R threads

The connection of an external parallel pipe thread G in accordance with EN ISO 228-1, with an internal parallel pipe thread Rp in accordance with ISO 7-1 is not intended according to standards. A tight connection is possible under favorable conditions, but cannot be reliably established.

### NPT (US-American standard)

A combination of R or G threads with NPT threads is not possible because of the different pitch.

Transitional and threaded fitting	Figure	Property
Adaptor fittings with parallel internal pipe thread Rp and rustproof reinforcement ring A2 (sockets)		Make it possible to connect both plastic and metal pipe, as well as plastic pipe with one another. <b>⚠ Metal pipe may only be bolted into adaptor pipe fittings with a reinforcement ring!</b>
Adaptor pipe fitting with tapered male thread R (nipple)		Nipples with tapered male pipe thread R with the exception of a double nipple can be bolted into plastic as well as metal sockets.
Threaded sockets with tapered internal pipe thread Rp without reinforcement ring		Threaded fittings (without reinforcement ring) with tapered internal pipe thread Rp allow the establishment of connections between plastic pipe.

### Installation tips for transition and threaded fittings

It is especially important that the pipe installation is low stress. Adaptor pipe or threaded fittings should be avoided at points in the piping system that are subjected to bending stress. If piping systems are subject to significant temperature changes, adaptor unions should be used because of the O-ring seal.

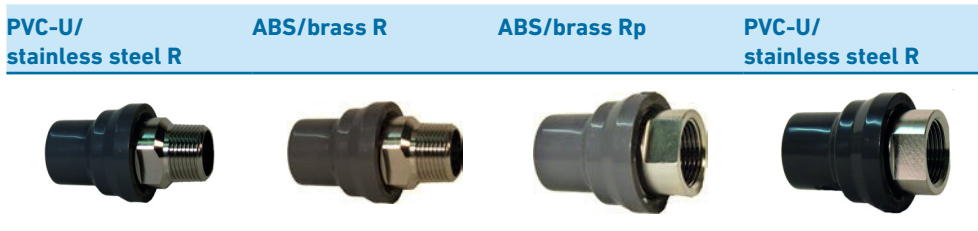
**⚠ To avoid damage to plastics fittings, remove any flash (if present) in the area of the metal thread before bolting in the fittings.**

Plastic transition and threaded fittings are initially bolted in by hand and without any force. Using a suitable tool, the fittings are subsequently bolted in until only approx. 1 to 2 turns of the thread are visible.

For plastic transition and threaded fittings, GF Piping Systems recommends using PTFE tape for sealing. As an alternative, thread sealing cord Henkel Tangit Uni-Lock or Loctite 55 and/or thread sealing paste Loctite 5331 can also be used. Please consider the appropriate installation guidelines from the manufacturer. If other sealing materials are used, compatibility with the plastics to be used must be established first.

**⚠ Do not use hemp! When using hemp, the plastic fittings may be overloaded when the hemp swells and may damage the thread. In addition, hemp is not resistant to chemicals depending on the medium used.**

## 5.6 Adaptor pipe fittings for connecting plastic piping systems and metal threads



The adaptor pipe fittings for connecting plastic piping systems and metal threading offer the greatest possible flexibility for assembly given the combined socket/spigot on the plastic end. The metal thread can be sealed with either hemp or PTFE-tape.

The adaptor pipe fitting is factory-sealed with an EPDM O-ring. The O-ring also serves as protection against damage to the plastic during assembly. Compared to the usual adaptor unions, the special connecting technology with circlip increases reliability, even at temperature changes and during vibration.

In addition to the classic transition to metal pipe, the fittings can also be used for connecting manometers.

**⚠ To avoid electrochemical corrosion in transitions to non-ferrous metals, brass connections must be used.**

## 5.7 Hose connections to plastic piping systems

GF Piping Systems has a wide range of products for hose connections to plastic piping systems.

**⚠ The hose must be fixed on the spigot by using a suitable hose clip.**



## 5.8 SYGEF Plus and PROGEF Natural sanitary adaptor for standard TriClamp connections

Clamp connections form part of the group of longitudinal interference-fit, detachable adapter connections and are primarily used for pure water and production piping systems in the pharmaceutical, biotechnology, food and cosmetic industries. A special characteristic of the TriClamp connection is simple, rapid and low-cost assembly.



SYGEF Plus sanitary adaptor

SYGEF Plus Sanitary Adaptor with clamp:  
plastic-stainless steel connection

Use of the SYGEF Plus or PROGEF Natural sanitary adaptor provides an aseptic plastic-stainless steel connection. The majority of connection standards are taken into account (inner diameter of stainless steel component). The adaptors can be combined with commercially available gaskets and clamps.

## 5.9 Universal coupling

The coupling made of stainless steel offers various advantages compared to similar connecting elements.



A patented gasket prevents leakage and the specially formed anchor ring ensures a reliable and permanent connection. It features a special helical tooth profile with ball tempering that ensures very good support on the piping, particularly for hard surfaces, such as thin-walled stainless steel and cast iron.

The simple design allows the coupling to be installed in no time. Thanks to the large variety of types, it can be used as connector between pipe made of different materials and with different outside diameters. Given the larger clamping range, one coupling can be used to connect up to three different pipe dimensions. The housing consists of corrosion-free stainless steel, the gasket of high-quality elastomers (EPDM or NBR).

The connection is made by slipping the coupling over the elements to be connected and tightening the bolts with the specified tightening torque.







## 6 Joining technology – Cementing



### 6.1 Solvent cement jointing using Tangit


#### 6.1.1 Overview


##### Material/cement

PVC-U	PVC-U PLUS	PVC-C PLUS	DTX	ABS	DYTEX
					
Standard PVC-U cement	THF free Drinking water approval	THF free Applications up to 80°C	For aggressive media	Applications from -50°C to +60°C	For sulfuric acid >93% Availability end Q1 2025

#### 6.1.2 Requirements and information

##### Safety information

 Solvent cement jointing calls for adequate technical know-how, which can be acquired in the appropriate training courses. Your authorized GF Piping Systems representative will be happy to provide information about training options.

 For the correct selection of the cement, observe the information on chemical resistance for the use of Tangit cement. For more information, see [www.gfps.com/tools](http://www.gfps.com/tools).

 The current safety data sheet from Henkel is available at [www.mysds.henkel.com](http://www.mysds.henkel.com)



##### Adequate ventilation of the workplace

Tangit cement and Tangit cleaner contain highly volatile solvents. This makes good ventilation or adequate fume extraction essential in closed spaces. Since the solvent fumes are heavier than air, extraction must occur at floor level, or at least below the working level. Place paper that has been used for cleaning or for the removal of surplus cement into closed containers to avoid of solvent fumes in the air.

**No open flames when cementing. No smoking.**

Cement and cleaner are flammable. Extinguish open flames before starting work. Switch off electric devices without explosion protection, electric heaters, etc. Avoid electrostatic charges. Discontinue any fusing operations. Furthermore, observe all instructions issued by the solvent cement manufacturer (e.g. label on the can and supplementary documentation).

**Protection against spilled liquids**

Pipe and fittings must be kept away from spilled cement, cleaner and used paper. Cement and cleaner that are no longer needed must be disposed of in an environmentally sound manner.

**Use of gloves and protective glasses**

The use of protective gloves is recommended to avoid cement or cleaner contact with the skin. If the cement or the cleaner come in contact with your eyes, rinse immediately with water. Consult a doctor! Immediately change clothes that have cement on them.

**i** Always observe the safety regulations issued by the responsible authorities, as well as information in the safety data sheet. The safety data sheet is available at [www.mysds.henkel.com](http://www.mysds.henkel.com)

### 6.1.3 Required tools and equipment



Nr.	Description	Dimensions
1	Pipe cutter	d10–d63 mm d50–d110 mm d110–d160 mm
2	Chamfer device	d16–d200 mm d63–d400 mm
3	Deburring device	Commercially available
4	Can lid	
5	Tangit cement	PVC-C PLUS 0.7 kg can PVC-U 0.125 kg tube 0.25 kg can 0.50 kg can 1.0 kg can ABS 0.65 kg can
6	Screwdriver or wooden spatula	Commercially available
7	Round brush ø 4 mm Round brush ø 8 mm Flat brush 1", 25 x 3 mm Flat brush 2", 50 x 5 mm Flat brush 3", 75 x 6 mm	Fitting 6–10 mm Fitting 12–32 mm Fitting 40–63 mm Fitting 75–225 mm Fitting 250–400 mm
8	Tangit PVC-U, PVC-C, ABS cleaner	1 liter can
9	Marking pen	
10	White, absorbent, lint-free paper	Commercially available
11	Folding ruler	Commercially available
12	Solvent-resistant safety gloves	Commercially available
13	Protective glasses	Commercially available



### 6.1.4 Dimensions and tolerances

The dimensions of pipe, fittings and valves made of PVC-U, PVC-C and ABS by GF Piping Systems generally conform to the standards EN ISO 15493 and EN ISO 1452-3. They can be connected with any fittings and valves made of the same material that have also been produced based on these standards.

### 6.1.5 Required amounts of Tangit cement

Diameter (d)	Tangit (kg/100 connections)	Amount (g/joint)
20	0.25	2.5
32	0.40	4.0
40	0.55	5.5
50	0.70	7.0
63	1.10	11.0
75	1.50	15.0
90	2.50	25.0
110	4.10	41.0
140	6.00	60.0
160	8.00	80.0
200	13.00	130.0
225	20.00	200.0
315	40.00	400.0

**i** The amount of cement used depends on a variety of factors. The table provides average values. It is generally not necessary to exceed these values.

### 6.1.6 Cementing with solvent-based adhesives

Cementing should be performed at an ambient temperature of 5 °C to 35 °C.

**1** Cutting the pipe to length

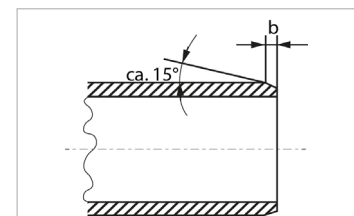
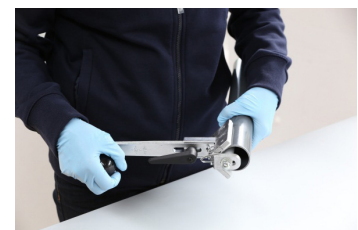
Cut off the pipe at a right angle by using a pipe cutter.



**2** Chamfering the pipe

Chamfer the end of the pipe with the chamfer device according to the following figure and table to enable a perfect cementing joint.

d (mm)	b (mm)
6 – 16	1 – 2
10 – 55	2 – 3
63 – 225	3 – 6
250 – 400	6 – 8



**i** Well-chamfered pipe ends prevent the layer of cement from being removed as the pipe is inserted into the fitting.

### 3 Deburring the pipe

Deburr the inside of the pipe with a deburring device.



### 4 Cleaning pipe and fitting

First, remove any coarse dirt from the cementing surfaces (outside of pipe, inside of fittings). Clean the cementing surfaces thoroughly with Tangit PVC-U/PVC-C/ABS cleaner/primer and paper. Always use a fresh piece of paper for each component. Remove any condensation that may have formed on the parts.

Pipe may have a waxy surface. To ensure proper jointing in such a case, the cleaning process must be repeated until the pipe surface becomes visibly matte.

Mechanical machining of the pipe surface may be necessary in individual cases. An indication of expected inadequate jointing quality is an absent or insufficient adhesion of the jointing parts following fine cleaning. The jointing surfaces should then be roughened evenly with emery cloth of grain 80 or finer, observing the maximum permitted gaps.



**⚠** The cementing surfaces must be dry and free from grease and dirt, and must not be touched after cleaning.

### 5 Marking the insertion depth

Mark the cementing length of the fitting on the pipe end using the folding ruler and marking pen; this allows for checking the required application of adhesive and whether the pipe has been completely inserted.

Calculating the insertion depth:



$$t = \frac{d}{2} + 6$$

t Insertion depth (mm)  
d Pipe diameter (mm)

**i** If the outside diameter of the pipe and the inside diameter of the socket are at opposite extremes of their tolerances, then the pipe cannot be inserted dry into the fitting socket. Insertion will only become possible once the cement has been applied.

### 6 Checking the cement

Tangit cement is supplied ready for use. Stir thoroughly with a screwdriver or wooden spatula prior to use! Cement of the correct consistency will run evenly from a wooden spatula held at a slant. Cement that no longer runs smoothly is unusable. The cement must not be thinned since thinning would falsify the mixing ratio.



**i** PVC-C Plus: The new consistency has a structure-viscous appearance, i.e. it may appear gelatinous/paste-like. However, when stirring, liquefaction occurs depending on the duration and intensity. Recommended stirring time = min. 2 minutes.

**7 Applying the cement**

Using firm brush pressure, apply an even, closed cement layer brushing in axial direction, first in the fitting, then on the pipe. Use a thin layer of cement in the fitting to avoid excessive bead formation inside the pipe, apply a generous amount on the pipe end.



**⚠ Starting at d75 (ABS/PVC-C) or d90 (PVC-U), two people are needed to apply the cement to the pipe end and fitting socket simultaneously in order to avoid exceeding the maximum opening time of the cement.**

**⚠ Starting at d250, the cement is poured directly from the can into the middle of the cementing surface and distributed first radially and then axially over the entire area with a flat brush until an even, closed layer is present. The minimum layer thickness in the fitting area is 1 mm, while a heavier coat is applied at the pipe end. Cementing in these dimension ranges must be performed by at least 2 people.**

**8 Connecting pipe and fitting**

Immediately push pipe and fitting together to the stop or the full length of the socket (check insertion depth on the pipe) without twisting or misalignment and hold in position for a few seconds until the cement has set.



**⚠ Starting at d250, push pipe and fitting together and align them by using 3 to 4 people. Hold the joint in this position for 1 minute.**

**9 Checking and removing surplus cement**

After jointing, a complete bead must be visible on the inside (smaller) and outside (larger). Immediately wipe off any surplus cement using clean, absorbent paper.



**⚠ Jointing faces must be kept clean.**

**⚠ Important note**

Store cement and cleaner in a cool, dry place (5 to 35°C). The optimum temperature is up to 20°C. Higher temperatures may affect the shelf life. Adhesive and cleaner are stable under these conditions according to the printed expiration date (DDMMYY batch). Cans not in use should be closed immediately to prevent solvent losses and thickening. The brush lid can be used, which allows for leaving the brush in the can of cement.



Since both cement and cleaner dissolve the material, pipe and fittings must not be laid on or allowed to come into contact with spilled cement or paper containing cement residues.

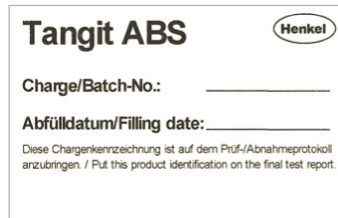
Scrape off thickened cement sticking to the brush using dry paper and then rinse the brush with cleaner. Cleaned brushes must be dry before reuse.

**Flushing before putting into operation**

After the drying process (see table in the section "Waiting time and pressure test") the piping systems can be filled. To remove remaining solvent vapor, the pipeline must be thoroughly flushed before putting it into operation. For pipe that are not put into operation immediately, we recommend filling them with water and flushing them regularly after careful cleaning. Do not use compressed air for flushing.

**Documenting Tangit batch for ABS cementing**

To ensure the traceability of the Tangit batch(es) used, if needed, document the batch identification attached to every shipped unit to the test/acceptance report. If several batches are used in one project, add one identification from each batch to the test report.



**6.1.7 Waiting time and pressure test**

The length of the drying period before the joint may be subjected to testing or operating pressure depends on the drying temperature, the dimension and the fit requirements, as well as ambient influences.

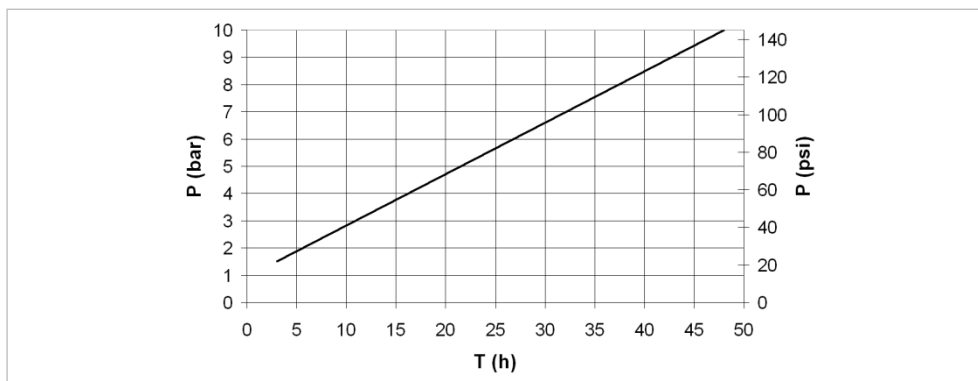
The following table shows the corresponding waiting times:

Materials and dimension	Temperature: 10 °C - 30 °C			Temperature: <10 °C / >30 °C		
	Between joints on the same component	Operating pressure after the last joint or a repair	Pressure test max. 1.5 x PN	Between joints on the same component	Operating pressure after the last joint or a repair	Pressure test max. 1.5 x PN
<b>PVC-U</b>						
< d250	5 Min	1h / bar	24h	15 min	2h / bar	48h
d250-400	15 Min	1h / bar	48h	30 min	2h / bar	72h
<b>PVC-C</b>						
All dim.	5 Min	1h / bar	24h	15 min	2h / bar	48h
<b>ABS</b>						
< d160	10 Min	1h / bar	24h	15 min	2h / bar	48h
d160-225	30 Min	2h / bar	24h	60 min	4h / bar	48h
d250-315	60 Min	4h / bar	48h	120 min	8h / bar	72h

Actual values at the construction site may deviate. These are empirical values.

**6.1.8 Pressure test or leak tightness test of ABS with gas/air**

Due to the risk of a pressure test with a compressible test medium, this pressure test should be carried out only in exceptional cases. The following diagram shows the required waiting times depending on the test pressure for ambient temperatures between 10 and 30 °C:



P Test pressure (bar, psi)  
 T Waiting time after last cementing (h)  
 Ambient temperature from 10 to 30°C

**⚠** In principle, PVC-U and PVC-C may not be pressure tested by using a compressible medium!

**6.1.9 Disposal**

Dried product residues can be added to household or industrial waste. Large quantities must be disposed of separately. The disposal key (EAC code) is available upon request. Empty packaging can be added to recycling.

### 6.1.10 Tangit DTX

Tangit DTX in conjunction with the PVC-U/PVC-C/ABS cleaner is a special cementing system for PVC-U/PVC-C piping systems that are exposed to the effects of highly aggressive chemicals, such as concentrated, inorganic acids.

#### Applications

- Cementing thermoplastic PVC-U/PVC-C piping systems in accordance with EN ISO 15493
- Suitable for critical media (see the list of chemical resistance at [www.gfps.com/tools](http://www.gfps.com/tools))

#### Properties

- Solvent cement based on tetrahydrofurane (THF-stabilized)
- Open time: 1 minute
- Gap-filling and thixotropic
- Diameter, pipe: max. 140 mm, gap: max. + 0.4 mm
- Maximum operating temperature limited to 60 °C
- Meets DIN EN 14814: Adhesives for thermoplastic piping systems for fluids under pressure
- CE marking and DoP (01011))

#### Resistance


The cementing joints are watertight. Their chemical resistance, especially to inorganic acids and strongly oxidizing materials, depends on the following factors:


- Diameter tolerances
- Curing times
- Pressure ratings
- Temperatures
- Acid type
- Acid concentration

For pressure piping systems made of PVC-C, special PVC-C cement is recommended for high temperatures (technical data sheet upon request).

Cemented PVC-U or PVC-C pipe connections, if they are installed following the Tangit cementing instructions, are just as stable as the installed pipe material. Exceptions are the media listed in the following table. When these media are used, the use of Tangit DTX special cement for laying piping made of PVC-U or PVC-C is recommended. Since these media can attack the pipe material, GF Piping Systems recommends the use of PN16 pipe. For all media not featured in the list of chemical resistance, or those with a lower concentration, Tangit PVC-U or Tangit PVC-C cement can be used, if the pipe and fitting material are suitable. When using Tangit DTX special cement for PVC-C piping and a critical medium featured in the list, the temperature and pressure recommendations for PVC-U material must definitely be followed.

Medium	Concentration	De-rating factor	Temperature
Sulfuric acid	> 70 - 93 % H <sub>2</sub> SO <sub>4</sub>	AF: 1.6 (> 70 - 78 %) AF = 2 (> 78 %)	max. 60 °C max. 40 °C
Hydrochloric acid	> 25 - 37 % HCl	AF: 1.6	max. 60 °C
Nitric acid	> 20 - 55 % HNO <sub>3</sub>	AF: 1.6	max. 60 °C (> 20 - 30 %) max. 40 °C (>30 %)
Sodium- / Potassium hypochlorite	> 6 - 15 % NaOCl / KOCl	AF: 1.6	max. 40 °C
Hydrogen peroxide	> 5 - 70 % H <sub>2</sub> O <sub>2</sub>	AF: 1.6	max. 40 °C
Hydrofluoric acid	</= 40% HF	AF: 1.6	max. 40 °C

 Tangit DTX solvent cement jointing calls for adequate technical know-how, which can be acquired in the appropriate training courses. Your authorized GF Piping Systems representative will be happy to provide you with information about training options.

 For the correct selection of the cement, observe the information on chemical resistance for the use of Tangit DTX cement. For more information, see [www.gfps.com/tools](http://www.gfps.com/tools)

### 6.1.11 GF Dytex

GF Dytex, in conjunction with the GF Dytex solvent, is a special adhesive for piping systems made of PVC-U/ PVC-C for aggressive media at higher concentrations (mainly sulfuric acid 93% - 98%). See chapter

„General information regarding chemical resistance“ for more details.

For general information see chapter “Jointing Technology” at “Solvent cementing joint Tangit”. In this chapter, only the GF Dytex specific topics are addressed.

#### Specifications for GF Dytex cement

Resource base	Post-chlorinated PVC dissolved in methylene chloride
Density	1,35 g/cm <sup>3</sup>
Temperature resistance	+40 °C
Processing temperature	+10 °C – +25 °C
Viscosity cement	200 – 300 mPas, DIN EN 12092, 20 °C
Operational strength	48 Hours
Full Strength	Corresponds to the strength of the bonded material
Dilution	GF Dytex must not be diluted.

#### Specifications for GF Dytex solvent

Resource base	Methylene chloride
Density	1,32 g/cm <sup>3</sup>
Viscosity	Runny

### Chemical compliance and future availability

The current European REACH regulation restricts the use of certain substances contained in our solvent-based adhesive GF Dytex. Dioctyltin, also known as "DOTE" meets the criteria for inclusion in Annex XIV (Authorization List) of Regulation (EC) No 1907/2006 concerning the Registration, Evaluation, Authorization and Restriction of Chemicals (REACH). Therefore, DOTE has been included in the REACH Authorization List and as of May 1, 2025, GF Dytex may only be manufactured, sold and used in the European Union if there is a positive authorization decision for DOTE from the European Commission.

GF DYTEX will therefore no longer be available after April 30, 2025.

### Area of application

Jointing of thermoplastic PVC-U/PVC-C piping systems acc. EN ISO 15493 for aggressive media at higher concentrations (mainly sulfuric acid 93% - 98%). See chapter „General information regarding chemical resistance“ for more details. Due to the influence of the aggressive media to the pipe material, it is recommended to use pipe with nominal pressure PN16. Regarding the expected service life and pressure rating, please contact our experts on [chem@georgfischer.com](mailto:chem@georgfischer.com).

GF Dytex is not suitable for use in drinking water applications. For the solvent cementing of PVC-U or PVC-C in use with other media, using Tangit PVC-U/PVC-C or Tangit DTX is recommended (for material and adhesive selection see list of chemical resistance [www.gfps.com/tools](http://www.gfps.com/tools)).

### Important features

- Cement is not gap filling, multiple cement application possibly necessary
- Maximum outer diameter (pipe) d140 mm, gap: max. +0.4 mm
- limited maximum operating temperature 40 °C

### Resistance

- The cemented joints are waterproof. Their chemical resistance depends on the following factors:
  - Diameter tolerances
  - Curing time
  - Pressure charges
  - Temperatures
  - Concentration of sulfuric acid
  - Quality of the jointing

### Processing

First, clean the cementing surfaces (outside of the pipe end, fitting inside) of coarse dirt. Potentially adhering ice must be removed by heating (lukewarm).

The pipe ends must be cut square, chamfered and deburred. If there is no or insufficient pipe chamfer, no permanent tight connection is achieved.

Due to the missing gap filling properties of GF Dytex, check the pipe / fitting fit when dry.



If the pipe end can slide in to the pipe stop without resistance, multiple application of cement is required. Gaps with a difference in diameter of >0.4 mm are not permitted! Pipe / fittings from dimension d110 mm have to be measured for admissible gap size.

Cleaning is done with GF Dytex solvent. For this, coat the surfaces with GF Dytex solvent with a brush until they are significantly dissolved (slimy test/ fingernail test).

Then mark the cementing length of the fitting on the pipe end, so that the necessary cement application and the complete insertion of the pipe can be checked.

Apply to still solvated surface, the GF Dytex with a brush in axial direction, and allow to dry at least 30 seconds. Repeat cement application several times, depending on the gap.

After the final adhesive application, apply GF Dytex solvent again to both surfaces until they are sufficiently wetted, then immediately push the parts to the full fitting depth without twisting / tilting and hold for a few seconds. Due to the rapid setting of the cement, the joining of the parts must be done within one minute after the last application of the GF Dytex solvent. At temperatures above 25 °C, the open time is reduced to less than one minute. When inserting, a definite resistance should be felt. The forming bead must be complete and even.

The excess adhesive should be wiped off immediately.



The production of GF Dytex cemented joints requires adequate expertise, which can be acquired in the appropriate training courses. The local branch of GF Piping Systems provides information on training opportunities and adhesive instructions.



For the correct choice of adhesive, observe the instructions for use of the chemical resistance of GF Dytex. More information on [www.gfps.com/tools](http://www.gfps.com/tools)

## 6.2 Solvent-free cement jointing Tangit RAPID (2-component cement)

### 6.2.1 Overview

Tangit RAPID is suitable for restraint-proof connections of pressure pipe in system installations with fittings and valves made of PVC-U or PVC-C

- Meets DIN EN 14814
- For piping systems in accordance with EN ISO 15493 (PVC-U and PVC-C)
- Also suitable for repairs
- Construction cementing with plate material (e.g. catch trays and housing boxes)

Technical data	
Raw material basis	Methacrylate
Density	0.99 and 1.01 g/cm <sup>3</sup>
Processing temperature	+5 °C to +35 °C
Viscosity	70,000 mPas components A/B, DIN EN 12092, 20 °C
Open time	Approx. 8 min.
Fitness for use: (20 °C)	For new installation 12 h, for repairs 4 bar/h (min. 1 h)
Final strength	Corresponds to the strength of the cemented material
Temperature resistance	PVC-U: 60 °C, PVC-C: 80 °C
Storage	Not below 5 °C
Minimum shelf life	At +20 °C, 12 months in unopened original package. Minimum shelf life date and batch number are located on the cartridge.

### 6.2.2 Requirements and information

#### Safety information

**i** Cement jointing calls for adequate technical know-how, which can be acquired in the appropriate training courses. Your authorized GF Piping Systems representative will be happy to provide information about training options.

**⚠** For the correct selection of the cement, observe the information on chemical resistance for the use of Tangit cement. For more information, see [www.gfps.com/tools](http://www.gfps.com/tools).

**■** For acids and heavily oxidative substances as flow media, Tangit solvent cements can be used. The current safety data sheet from Henkel is available at [www.mysds.henkel.com](http://www.mysds.henkel.com)



#### Protective measures before cementing

##### Adequate ventilation of the workplace

Tangit RAPID and Tangit PE/PP/PVDF/PB cleaning cloths and special cleaner are highly flammable. The solvent vapors are heavier than air, can collect at the floor and form explosive vapors. For this reason, ensure that sufficient ventilation and exhaustion is present during processing and drying, including after cementing. Prolonged inhalation of vapors poses health hazards.

Keep used cleaning paper in a closed container (e.g. bucket with a lid) to keep the exposure to solvent vapors low.

##### No open flames when cementing. No smoking.

In the work room and in adjacent rooms: No smoking! No fusion! Do not use open flame or fire, avoid creating sparks under any circumstances. Prior to fusion tasks, remove any collected solvent vapors and explosive mixtures. Thoroughly flush piping systems with water and blow them out. Do not close piping systems during the drying phase.



Avoid product accumulations! Fire hazard! Two-component products can generate high heat during hardening if they are applied in a block. Always spread product residues out over the surface.

**Protection against spilled liquids**

Pipe and fittings must be protected against spilled cement, cleaning agent and used paper. Do not pour cement or cleaner that is no longer needed into sewer lines.

**Use of gloves and protective glasses**

The use of protective gloves is recommended to avoid contact of cement or cleaner with the skin. If the cement or the cleaner comes in contact with your eyes, rinse immediately with water. Consult a doctor! Immediately change clothes that have cement on them.

**i** Always obey the safety regulations issued by the responsible authorities, as well as the information in the safety data sheet. The safety data sheet is available at [www.mysds.henkel.com](http://www.mysds.henkel.com).

**6.2.3 Required tools and equipment**



Nr.	Description	Dimensions
1	Pipe cutter	d10–63 mm d50–110 mm d110–160 mm
2	Chamfer device	d16–200 mm d32 –200 mm
3	Deburring device	Commercially available
4	Tangit RAPID cement	Kit with 50 ml cartridges Kit with 400 ml cartridges
5	Folding ruler	Commercially available
6	Marking pen	
7	Tangit cleaner PP/PE/PVDF/PB	1 liter can
8	White, absorbent, lint-free paper	Commercially available
9	Tangit cleaning cloths PP/PE/PVDF/PB	
10	Plastic brush	1" 2"
11	Safety gloves	Commercially available
12	Protective glasses	Commercially available
13	Cartridge gun	50 ml 400 ml

### 6.2.4 Dimensions and tolerances

The dimensions of pipe, fittings and valves by GF Piping Systems made of PVC-U and PVC-C conform to the standards EN ISO 15493 and EN ISO 1452-3. They can be connected with any pipe, fittings and valves made of the same material that have also been produced based on these standards.

### 6.2.5 Adhesive amount

Approximately the following quantities of adhesive and cleaner are required to produce an adhesive bond:

Pipe-dimension d mm	Tangit KS Cleaner ca. ml	Tangit RAPID approx. g
d20	3,5	1
d32	5	1,5
d50	9	3
d63	11	5
d75	13	7
d90	15	12
d110	17	20
d140	21	28
d160	25	38
d200	40	65
d225	45	100
d315	70	200

**i** The amount of adhesive consumed depends on a number of factors. The table indicates average values. Exceeding these values is usually not required.

### 6.2.6 Cementing

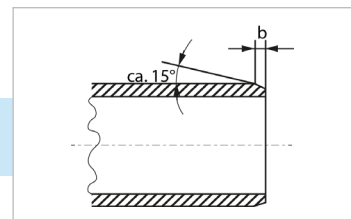
#### 1 Cutting the pipe to length

Cut off the pipe at a right angle by using a pipe cutter.



#### 2 Chamfering the pipe

Chamfer the pipe with a chamfer device according to the following figure and table to enable a perfect cementing joint.



**i** Well-chamfered pipe ends prevent the layer of cement from being removed as the pipe is inserted into the fitting.

#### 3 Deburring the pipe

Deburr the inside of the pipe with a deburring device.



#### 4 Cleaning pipe and fitting

Clean the pipe and fitting with Tangit PE/PP/PVDF/PB cleaning cloths or cleaner with paper. Replace the paper after every cleaning. The cleaned surfaces must be dry before applying the cement.



**⚠** Pipe end and fitting socket must be dry and free from grease and dirt, and must not be touched after cleaning.

#### 5 Marking the insertion depth

Mark the cementing length of the fitting on the pipe end using the folding ruler and marking pen; this allows for checking the required application of adhesive and whether the pipe has been completely inserted.

Calculating the insertion depth:

$$t = \frac{d}{2} + 6$$

t Insertion depth (mm)  
d Pipe diameter (mm)

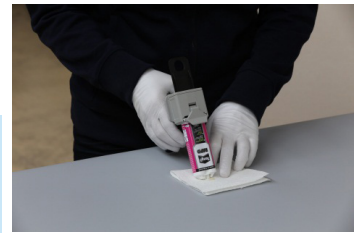


**i** If the outside diameter of the pipe and the inside diameter of the socket are at opposite extremes of their tolerances, then the pipe cannot be inserted dry into the fitting socket. Insertion will only become possible once the cement has been applied.

**6** Checking the cement

Tangit RAPID cement is supplied ready for use. Before its use, check whether both components can be evenly pushed out of the cartridge.

**⚠** Tangit RAPID should not be stored below +5 °C since this would cause an increase in viscosity and solidification of the structure, which would affect its processing ability. After bringing the cement to room temperature, the temperature-based increase in viscosity and structure is reduced again.



**7** Applying the cement

- Apply Tangit RAPID to the cementing surfaces from the cartridge by using a cartridge gun and static mixer. Apply the cement in the form of rings to ensure a sufficient amount of cement.
- First, evenly distribute the cement in axial direction in the socket and then on the pipe using a plastic brush.
- Apply a thin layer of Tangit RAPID in the socket. To avoid subsequent bead formation inside the pipe, apply a generous amount on the pipe end. Tangit RAPID can be used according to DIN EN 14814 to cover diameter tolerances up to +0.6 mm.



Depending on the processing temperature, the following approximate times are available:

Temperature (°C)	Estimated processing time (min)
10	10
20	8
30	6



**⚠** If there is series production, the static mixer can be used multiple times. However, after the processing time has been exceeded, a new static mixer is required. Immediately tightly close any cartridges that are not in use. (For short-term interruptions, the static mixer used can remain on the cartridge.)

**8** Connecting pipe and fitting

- Immediately push pipe and fitting together to the stop or the full length of the socket (check insertion depth on the pipe) without twisting or misalignment and hold in position for a few seconds until the cement has set.
- The joining parts must be pushed together during the open time of the cement (approx. 8 minutes from the start of the application of adhesive).
- Excess cement does not have to be removed. However, any flash that is created may have sharp edges and should be removed.
- Wipe off cement residues from the plastic brush. The dried cement film can be pulled off the plastic brush by using a slight rotation.



**⚠** For dimensions starting at d160, one person should apply the cement to the pipe and socket while the second person distributes the cement.

**9** Wiping off the cement bead

A cement bead must be visible on the inside and outside. Excess cement can remain at the cementing joint (quality assurance) or be wiped off (aesthetics).



### 6.2.7 Waiting time and pressure test

During the first 5 minutes after cementing, the pipe must not be moved. At temperatures below +10 °C, this time is extended to at least 15 minutes. Larger piping systems should be supported during the first 30 minutes due to their intrinsic weight.

Filling the pipeline as well as the pressure test up to the test pressure cannot be performed until 12 hours after the last cementing. If the line is to be stressed at the operating pressure, a minimum waiting time of 4 bar/h must be followed (min.1 hour). At 10 °C, the waiting times are doubled. For pipe that are not put into immediate operation, we recommended flushing them thoroughly.

### 6.2.8 Pressure test with water



In principle, PVC-U and PVC-C may not be pressure tested by using a compressible medium!

To remove remaining product vapors, thoroughly flush the pipeline before putting it into operation.

### 6.2.9 Disposal

Dried product residues can be added to household or industrial waste. Large quantities must be disposed of separately. The disposal key (EAC code) is available upon request. Empty packaging can be added to recycling.

## 6.3 Retrofit of branch fittings into an existing ABS, PVC-U or PVC-C piping system

### Existing situation

Occasionally it may be necessary to install measuring sensors, venting fittings or similar devices in an existing piping system without using additional installation fittings.

### Solution

A hole is drilled for the solvent cement spigot in the section of the piping system with the greatest wall thickness (in the center of the pipe-socket joint). A suitable branch fitting is then cemented into the hole.

### Detailed installation steps

1. The hole is drilled into a drained pipe section.
2. The hole is drilled at a right angle to the pipe axis.
3. The hole diameters and tolerances provided in the table below correspond to socket dimensions according to ISO 727-1 and are to be observed.
4. The dimension X in the table below indicates the distance from the entrance of the socket to the center of the hole to be drilled in order to place the hole in the center of the joint.
5. The edges of the hole are deburred using a deburring tool.
6. Shavings must be removed from the pipe.
7. Permissible combinations of pipe and branch fitting dimensions are indicated in the table below by the symbol ✓ Selection criteria were: the spigot of the branch fitting does not extend into the pipe by more than 1 mm and the socket joint with the hole is completely covered.
8. The branch fitting's spigot is cemented into the drilled hole according to the instructions for spigot jointing provided in the Planning Fundamentals of GF Piping Systems
9. The waiting times before reapplying pressure must be observed

**i** If properly installed, such a connection can be pressurized up to PN10 at 20 °C and water as the medium.

## Permissible combinations of pipe and outlet

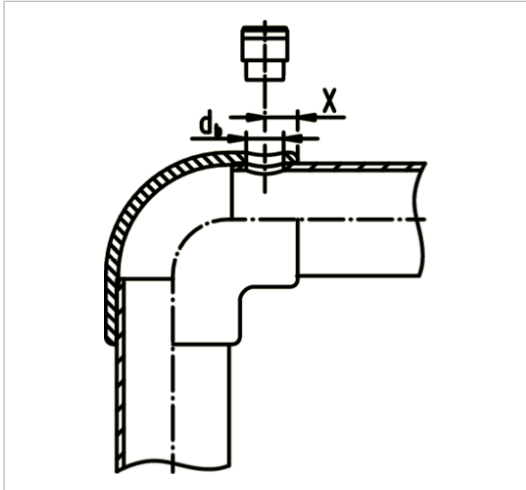
ABS PN10		Wall thickness e (mm)		Outlet dimension d (mm)	
Pipe dimension (mm)	S8, SDR17	20	25	32	40
75	4.5	✓	✓	x	x
90	5.4	✓	✓	x	x
110	6.6	✓	✓	x	x
125	7.4	✓	✓	x	x
140	8.3	✓	✓	x	x
160	9.5	✓	✓	x	x
180	10.7	✓	✓	✓	x
200	11.9	✓	✓	✓	x
225	13.4	✓	✓	✓	✓

ABS PN6		Wall thickness e (mm)		Outlet dimension d (mm)	
Pipe dimension (mm)	S12.5, SDR26	20	25	32	40
250	4.5	x	✓	✓	x
280	5.4	x	✓	✓	✓
315	6.6	x	x	✓	✓

PVC-U PN10		Wall thickness e (mm)		Outlet dimension d (mm)	
Pipe dimension (mm)	S10, SDR21	20	25	32	40
125	6.0	x	x	x	x
140	6.7	✓	x	x	x
160	7.7	✓	✓	x	x
180	8.6	✓	✓	x	x
200	9.6	✓	✓	✓	x
225	10.8	✓	✓	✓	✓
250	11.9	x	✓	✓	✓
280	13.4	x	✓	✓	✓
315	15.0	x	x	✓	✓
400	19.1	x	x	✓	✓

PVC-U PN16		Wall thickness e (mm)		Outlet dimension d (mm)	
Pipe dimension (mm)	S6.3, SDR13.6	20	25	32	40
125	9.2	✓	x	x	x
140	10.3	✓	✓	x	x
160	11.8	✓	✓	✓	x

### Drilling specifications



Outlet dimension d (mm)	Hole diameter, d <sub>b</sub> (mm)
20	20.2
25	25.2
32	32.2
40	40.2
<b>Tolerance</b>	<b>± 0.1 mm</b>

Pipe dimension d (mm)	Drilling position X (mm)
75	22
90	26
110	31
125	34
140	38
160	43
180	48
200	53
225	59
250	66
280	73
315	82
400	103
<b>Toleranz</b>	<b>± 1 mm</b>

## 6.4 Cementing different pipe materials

It is possible to cement the pipe materials ABS, PVC-U and PVC-C with one another; certain conditions must, however, be observed.

**i** If different pipe materials are to be cemented, please contact your authorized GF Piping Systems representative.



## 7 Joining technology – Welding

### 7.1 Infrared fusion jointing

#### 7.1.1 Overview

##### Material

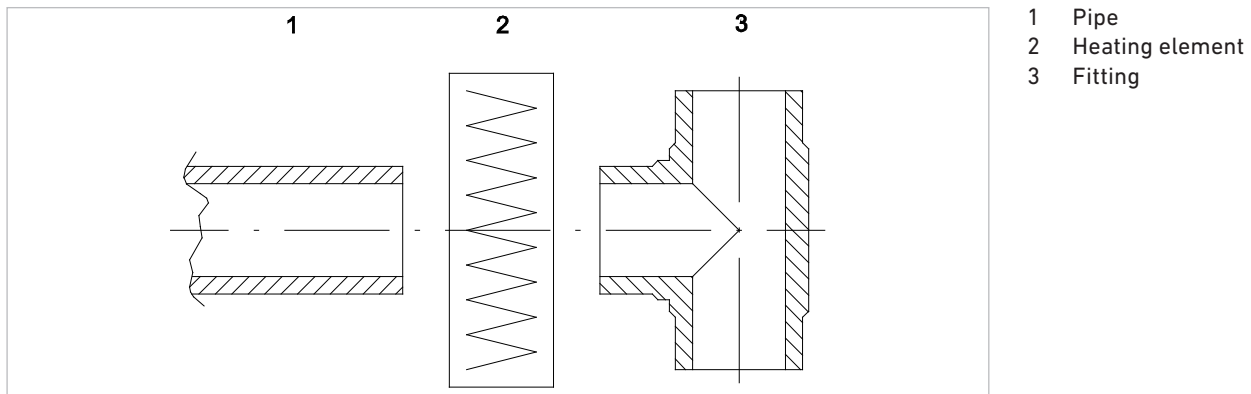
- PVDF
- ECTFE
- PP
- PP-n
- PE100
- IR PVC-U



#### 7.1.2 Fusion procedure

In infrared (IR) fusion the fusion areas of the components (pipe, fittings or valves) are heated to fusion temperature without contact to the heating element and fused by means of mechanical pressure or jointing pressure path without using additional materials.

##### Principle of the fusion procedure



The resulting fusion joints are homogeneous and display the following characteristics:

- Non-contact heating of the jointing components eliminates the risk of contamination and inhomogeneities
- Small fusion beads due to adjustment of jointing pressure path prior to the fusion process itself, i.e. elimination of the equalization process
- Low-stress fusion joints due to very uniform heating by using an IR radiator

### 7.1.3 Properties and advantages compared to conventional butt fusion

#### Non-contact heating

The components being jointed are heated to the ideal fusion temperature uniformly and without contact by using infrared radiation.

A defined gap between the infrared heater and the end faces minimizes the risk of contamination of the jointing surface. Contamination of the infrared heater by plastic particles is thus also eliminated.

#### Reduced bead formation

The fusion bead produced during fusion is considerably reduced without any loss of quality. Bead-forming equalization is eliminated by non-contact melting of the end faces. The minimal, defined bead is only formed during the jointing process. The fusion zone thus has improved flow dynamics, is nearly zero-static, and features a greater throughput area.

#### Reproducible jointing processes

The jointing path controls the jointing pressure and thus the fusion process. The high reproducibility of the joints is assured by the clearly defined and controlled process sequence.

#### Clear, simple operator guidance

Clear, straightforward operator guidance in different languages guides the user interactively through the fusion process in logical operating steps.

#### Fusion reports and traceability

Fusion reports with all relevant fusion parameters for the corresponding fusion operation can be printed out on a commercial printer via USB interfaces on the fusion device. For identification purposes, labels can be printed on a label printer that assigns the fusion to the corresponding protocol. In addition, the data can be exported (for example USB stick). Together with the signatures of fusion operator and inspector, this allows for meeting the most stringent quality assurance requirements.



For additional information about using the fusion procedure for corresponding materials, see [www.gfps.com](http://www.gfps.com)

## 7.2 Butt fusion jointing (heating element butt fusion conventional butt fusion)

### 7.2.1 Overview

#### Material

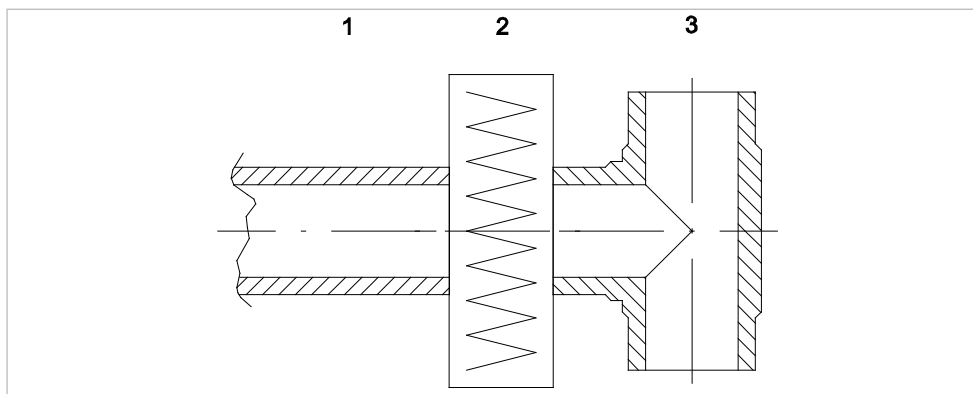
- PE
- PP
- PVDF



### 7.2.2 Fusion procedure

For heating element butt fusion (HB), the fusion areas of the parts to be joined (pipe, fittings or valves) are heated to fusion temperature and joined by means of mechanical pressure, without using additional materials. A homogeneous joint is the result. Butt fusion joints for pressure piping systems must only be created with a fusion device that allows the jointing pressure to be regulated. When building pressure piping systems, the components to be jointed must have the same wall thicknesses.

#### Principle of the fusion procedure



- 1 Pipe
- 2 Heating element
- 3 Fitting

### 7.2.3 Advantages and properties

Heating element butt fusion joints are inexpensive connections that can be made on corresponding systems up to large diameters (2,000 mm and more). Professionally prepared butt fusions meet the same requirements as the components. On specially equipped butt fusion devices, it is also possible to fuse parts at an angle so that segment-fused elbows or T-pieces can be made from pipe segments. A wide range of devices is available for conventional butt fusion; these are designed for workshops, pipe trenches or fitting fusion and can be operated manually, electrically or hydraulically.

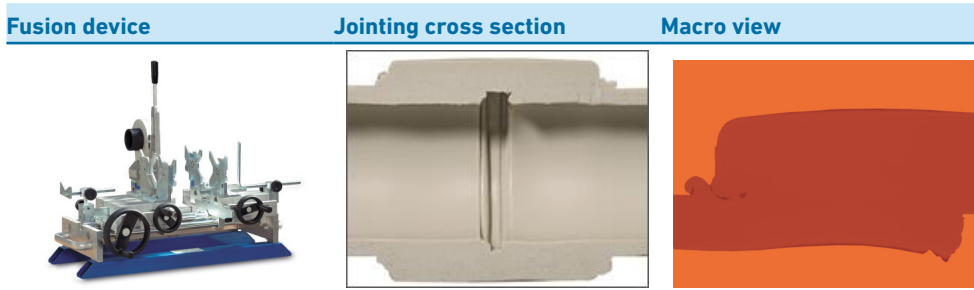
**i** For additional information about using the fusion procedure for corresponding materials, see [www.gfps.com](http://www.gfps.com)

## 7.3 Socket fusion jointing (heating element socket fusion)

### 7.3.1 Overview

#### Material

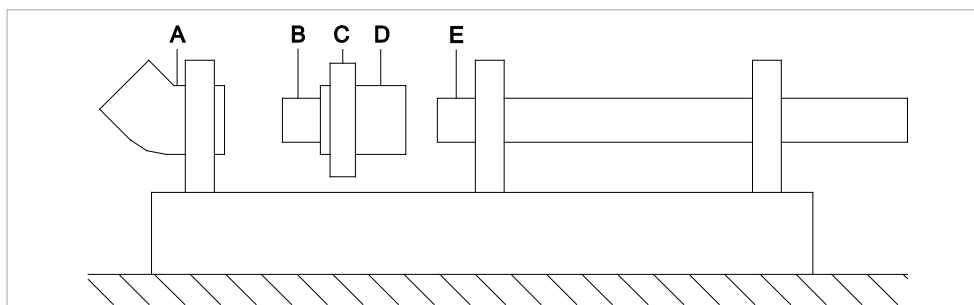
- PE
- PP
- PVDF



### 7.3.2 Fusion procedure

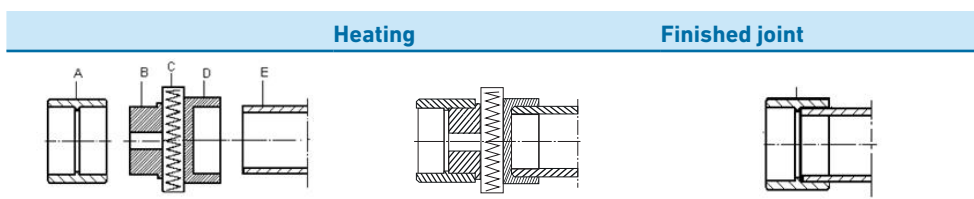
In heating element socket fusion, the pipe end and fusion socket overlap and are fused without using any additional material. The pipe end and fitting socket are heated to fusion temperature using a socket- or spigot-shaped heating element, and are then pushed into each other. The dimensions of the pipe end, fitting socket and heating element correlate in such a way that a fusion pressure is obtained during jointing, resulting in a homogeneous joint.

#### Fusion device



- A Fitting
- B Heating spigot
- C Heating element
- D Heating bush
- E Pipe

#### Principle of the fusion procedure



- A Fitting
- B Heating spigot
- C Heating element
- D Heating bush
- E Pipe

### 7.3.3 Advantages and properties

Heating element socket fusion joints up to a pipe diameter of approx. 50 mm can be created manually. That is, only a heating element with matching attachments is required, a fusion device with clamping elements is not needed. For larger diameters, a fusion device with movable clamping elements is required due to the higher jointing forces.

The rather larger fusion surface compared to butt fusion provides the socket fusion method with an unusually high fault tolerance.



For additional information about using the fusion procedure for corresponding materials, see [www.gfps.com](http://www.gfps.com)

## 7.4 Electrofusion (heating element fusion joints)

### 7.4.1 Overview

#### Material

- PE100

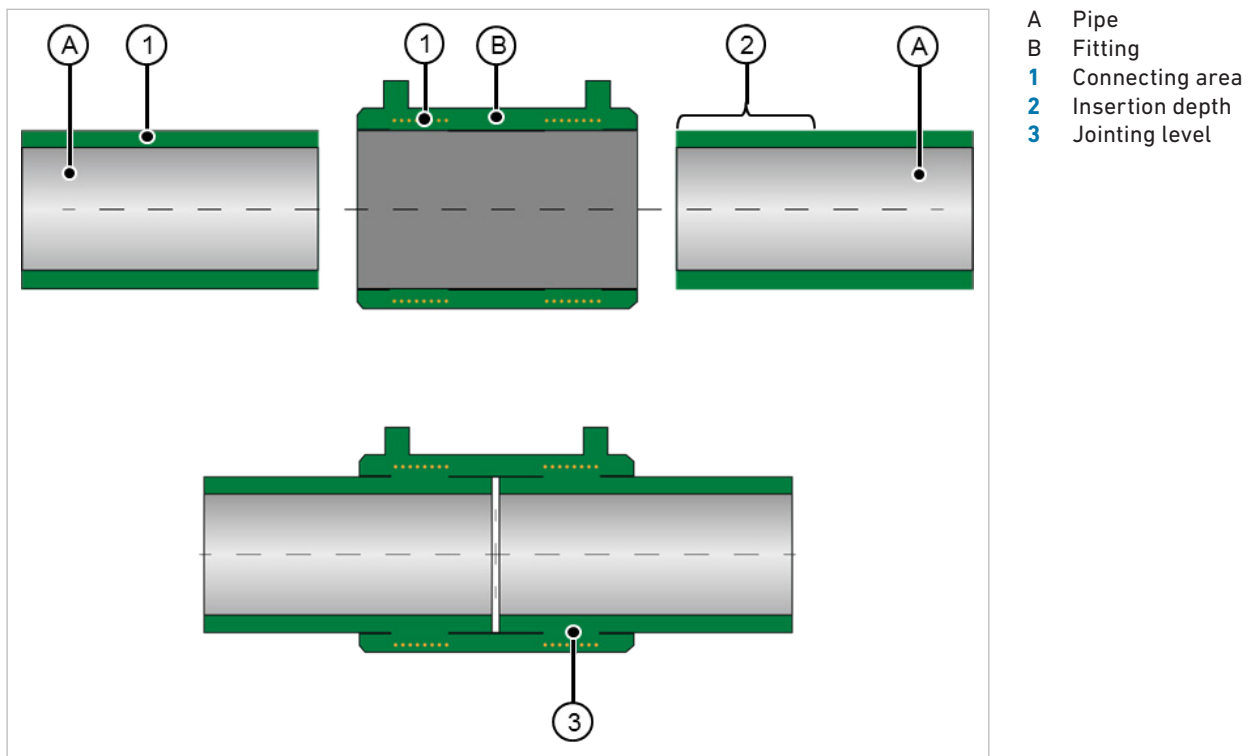


### 7.4.2 Fusion procedure

By electro fusion, plastic pipe and electrofusion fitting are permanently connected with each other by a restraint and homogenous joint s.

The electrofusion fittings are equipped with internal resistance wires to which electric current is applied during the fusion process. This heats the inside of the fittings and the outside of the pipe to the fusion temperature and melts them. The dimensions of the pipe end and fitting socket correlate in such a way that a fusion pressure is obtained during jointing, resulting in a homogeneous joint. The jointing force in the polymer melt required for the fusion is the result of the volume increase of the melt. After it cools off, the result is a permanent, homogenous joint.

#### Principle of the fusion procedure



### 7.4.3 Advantages and properties

The use of electrofusion to connect pipe and fittings allows safe, rational, economic and efficient installation of underground and aboveground PE piping systems.

#### Advantages

- No fusion bead on inside of the pipe
- Fast pipe-laying speed (compared to conventional butt fusion) because fusion device is barely fixed
- Connection of pipe made of PE80, PE100 as well as a combination of PE80 and PE100
- Low investment need because all dimensions are fused with one fusion device
- Small space requirement for execution because of lightweight and compact fusion devices
- Fully automatic fusion process (high process reliability)



For additional information about using the fusion procedure for corresponding materials, see [www.gfps.com](http://www.gfps.com)

## 7.5 BCF Plus fusion jointing (bead and crevice-free)

### 7.5.1 Overview

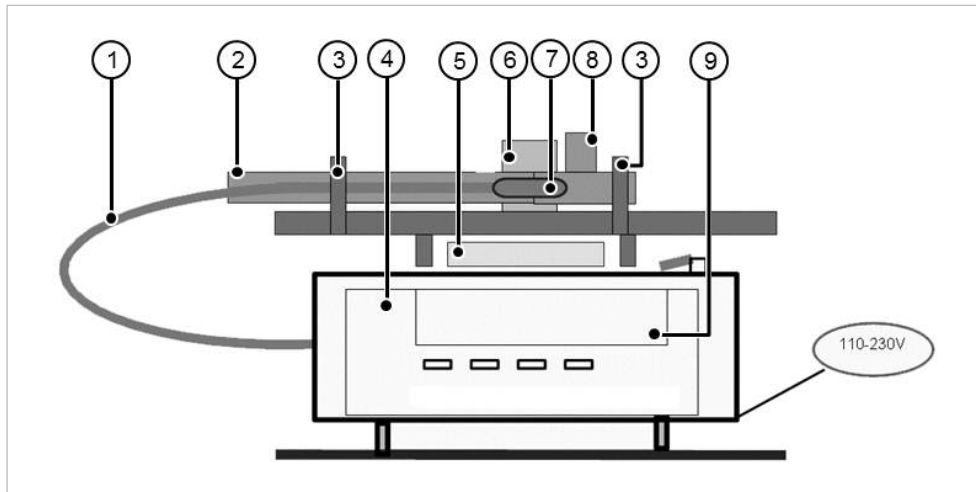
#### Material

- PVDF
- PP-n (PP Natural)

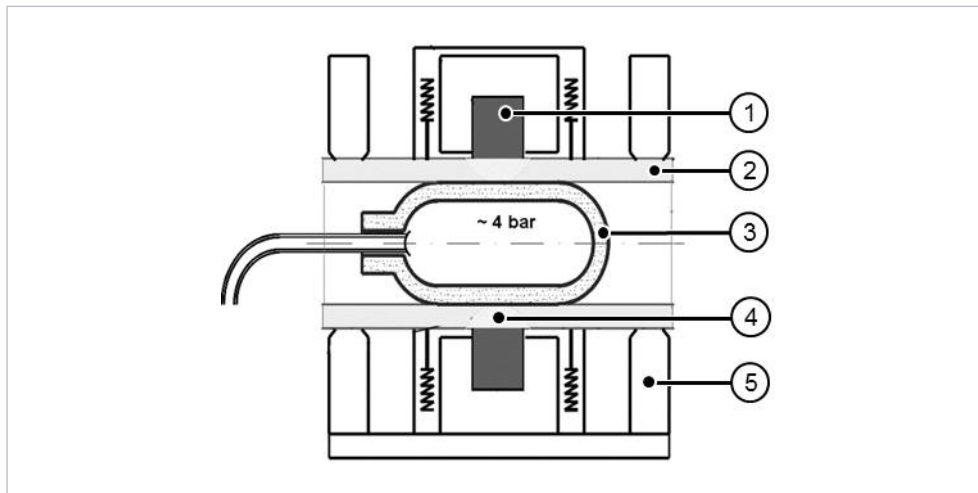


### 7.5.2 Fusion procedure

The fusion process consists of transmitting precisely defined thermal energy radially to the pipe and fitting ends being jointed by means of half-shell heating elements. At the same time an elastic, pressurized bladder supports the inside surface of the fusion zone in order to prevent the formation of a fusion bead. Keeping the melted thermoplastic at controlled pressure ensures ideal, homogeneous fusion of the plastic components. Fully automatic process control of the fusion process with a fusion device developed by GF Piping Systems permits extremely simple handling and reproducible fusion quality.



- 1 Compressed-air supply
- 2 Pipe
- 3 Clamping position
- 4 Compressor for bladder
- 5 Cooling air blower
- 6 Heating element with clamping device
- 7 Bladder (elastic pressure vessel)
- 8 Fitting
- 9 Control unit with control panel



- 1 Heating element
- 2 Pipe/fitting
- 3 Bladder (elastic pressure vessel)
- 4 Fusion zone
- 5 Clamping position

### 7.5.3 Advantages and properties

#### Bead and crevice-free fusion result

The result of the joining process is a surface similar to the actual piping system components without any beads or crevice. Hence, no dead spots are created. The surface roughness is within the range of the piping system components.

#### Reproducible joining processes

The high reproducibility of the fusions is assured by the clearly defined and controlled process sequence.

#### Clear, simple operator guidance

Clear, straightforward operator guidance in different languages leads the user interactively through the fusion process in logical operating steps.

#### Fusion reports and traceability

Fusion reports with all relevant fusion parameters for the corresponding fusion operation can be printed out on a commercial printer via USB interfaces on the fusion device. For identification purposes, labels can be printed on a label printer that assign the fusion to the corresponding protocol. In addition, the data can be exported to a USB stick and edited with special software. Together with the signatures of fusion operator and inspector, this allows for meeting the most stringent quality assurance requirements.

**i** For additional information about using the fusion procedure for corresponding materials, see [www.gfps.com](http://www.gfps.com)



# Double Containment Solutions

## CONTAIN-IT Plus

### Content

<b>1</b>	<b>CONTAIN-IT Plus .....</b>	<b>285</b>
1.1	Introduction – Double Containment System.....	285
1.2	Double containment system – CONTAIN-IT Plus.....	289
1.3	Planning instructions.....	300
1.4	Installation instructions.....	309
1.5	Pressure testing the inner and containment pipe.....	350
1.6	Operating and maintenance instructions .....	356
1.7	Double containment – CONTAIN-IT Plus - Valves and mechanical connections.....	358



# 1 CONTAIN-IT Plus

## 1.1 Introduction – Double Containment System

### EHSQ – Environment, Health, Safety, Quality

Double containment systems are used for the safe transport of hazardous liquids or gaseous media. They protect the environment, people, production plants and ensure the quality of the end product (EHSQ: Environment, Health, Safety, Quality).

### United Nations – Sustainable development goals

Georg Fischer Piping Systems addresses numerous sustainable development goals of the United Nations by providing the CONTAIN-IT Plus double containment system.



Responsible environmental awareness and an increased need for safety are becoming increasingly important in today's world. The transport of hazardous media can lead to personal injury in the event of unexpected leakage, property damage and environmental pollution. Corroded steel pipes, as well as unexpected leakages – especially creeping leakages from underground pipes – pose a serious risk for ensuring the good quality of our global water resources.

The goals of the United Nations are already reflected in various guidelines on environmental protection and personal safety. At European level, the Water Framework Directive 2000/60/EC (Environmental protection) and the Occupational Health and Safety Framework Directive 89/391/EEC (Employee protection) have already entered into force. Numerous EU member states already consider Double containment systems in their national legislation and define these as a measure for the safe transport of hazardous media (protection of the environment and of employees).

### Trend - Zero Pollution Action Plan (EU)

The Zero Pollution Action Plan was published in May 2021 and focuses on the implementation and enforcement of all EU pollution preventing legislation.

This approach will be increasingly reflected in national legislation, bringing the use of double containment piping systems into focus.

## Impacts – Uncontrolled leakages

The CONTAIN-IT Plus double containment system from Georg Fischer Piping Systems minimizes the expensive impacts of leakages to a minimum. Consequently, liquid and gaseous media escaping unexpectedly from medium-carrying inner pipe do no longer pose a risk to the surrounding and help planners and plant operators to comply with the principle of concern.

Costly consequences such as heavy fines, high process and decontamination costs, long-term image loss, as well as tiresome occupational accidents, can be minimized or even eliminated by conducting hazard assessments and defining measurements like double containment systems. Moreover, depending on local legislation, double containment systems may be mandatory for the legally compliant operation of a plant.

## Applications

### Collection points

Double containment systems are used to ensure the safe transport of hazardous media from the truck intake to the storage tanks.

### Distribution systems

Double containment systems are used to ensure the safe transport of hazardous media (pressure pipings) from storage tanks into the production process. The structural situation often requires an underground double containment system. Depending on the transported medium, a double containment system must be used even for the smallest amounts of hazardous substances, since creeping leakages can escape unnoticed for many years and thus have a massive impact on water quality.

### Wastewater systems

The safe transport of hazardous/contaminated pressureless wastewater mixtures is realized by using underground and overground double containment systems for the treatment of wastewater.

### Wastewater treatment

The treatment of wastewater requires environmentally hazardous chemicals. The safe transport of hazardous media - from the storage tanks to the wastewater treatment plant - is ensured by means of double containment pipes.

### Plant availability

There are also further applications that requires a high degree of process safety – to protect production-relevant equipment such as servers, machines, etc. – and where the piping system has to remain in operation, despite leakages.

A double containment system is likewise recommended for highly diffusing media such as HF, HCL, HNO<sub>3</sub>, as well as for valuable liquid media.

## Market segments

Double containment systems are used in all market segments where uncontrolled leakage of a media-carrying pipe can cause damage.

Main fields of application:

- Microelectronics
- Data centers
- Batteries
- Water treatment plants
- Chemical process industry
- Food and beverage industry
- Pharmaceutical
- Mining industry
- Hospitals
- Municipal wastewater
- etc.

## Legal provisions – Protection of the environment

### Germany

According to the German Water Management Act (Section 62 g WHG), the principle of concern applies to the storage, filling, production and treatment of substances hazardous to water, as well as for in-plant piping systems.

Facilities for handling substances hazardous to water must be designed, installed, maintained and operated in such a way that there is no reason to fear contamination of water bodies. In accordance with a verdict of the federal administrative court, the principle of concern implies that there must be no probability, however slight, of water contamination.

### Requirement of the German regulation on installations for handling substances that are hazardous to water (Section 17 AwSV)

- Plants must be planned, erected, constructed and operated in such a way that
  - substances that are hazardous to water cannot escape,
  - leakages on any parts of the installation coming into contact with substances that are hazardous to water can be identified quickly and reliably,
  - leaking substances hazardous to water are quickly and reliably detected and retained and properly disposed of; the same applies for splash and drip losses occurring during operation, and
  - in the event of a malfunction of the plant, any mixtures that may contain leaked substances hazardous to water are retained and properly disposed of as waste or disposed of as wastewater.
- Installations must be leak-tight, stable and adequately resistant to the expected mechanical, thermal and chemical influences.
- Single-walled, underground vessels for liquid substances that are hazardous to water are not permitted. Single-walled, underground vessels for gaseous substances that are hazardous to water are not permitted, if the gaseous substances which are hazardous to water emerge in a liquid state, are heavier than air or dissolve in existing moisture in the ground after escaping.
- When decommissioning a plant or parts of a plant, the operator must remove all substances hazardous to water contained in the plant or parts of the plant, as far as technically possible. He must secure the plant against misuse.

The above mentioned requirements for piping systems can be fulfilled by the existing containment room in-between inner and outer pipe of the double containment system.

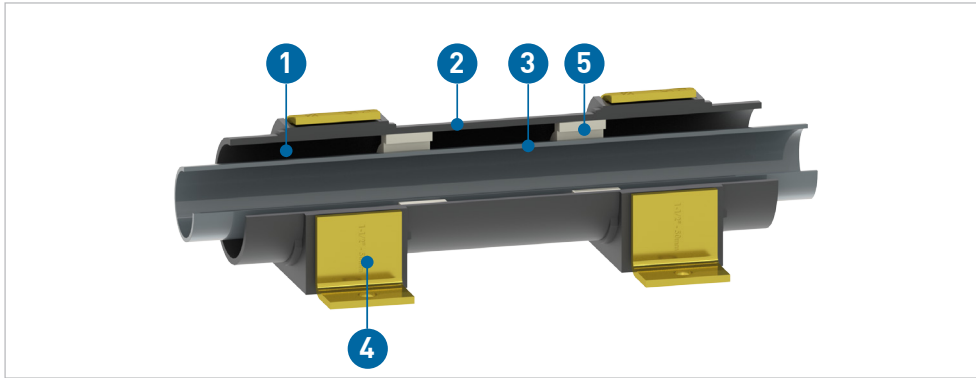
### Switzerland

The regulation on the protection against failures (Section 3, General safety measures) states that operators must take all suitable measures for reducing the risk into account. This includes measures to reduce the hazard potential, prevent incidents, and limit their environmental impact.

The federal law on the protection of waters (Section 22, General requirements) states, that operators of plants with water-hazardous substances must ensure, that the constructional and instrumental equipments for the protection of waters are regularly inspected, properly operated and maintained. Liquid losses must also be prevented in storage and handling areas, and escaping liquids must be contained.

## 1.2 Double containment system – CONTAIN-IT Plus

### 1.2.1 CONTAIN-IT Plus – General design information

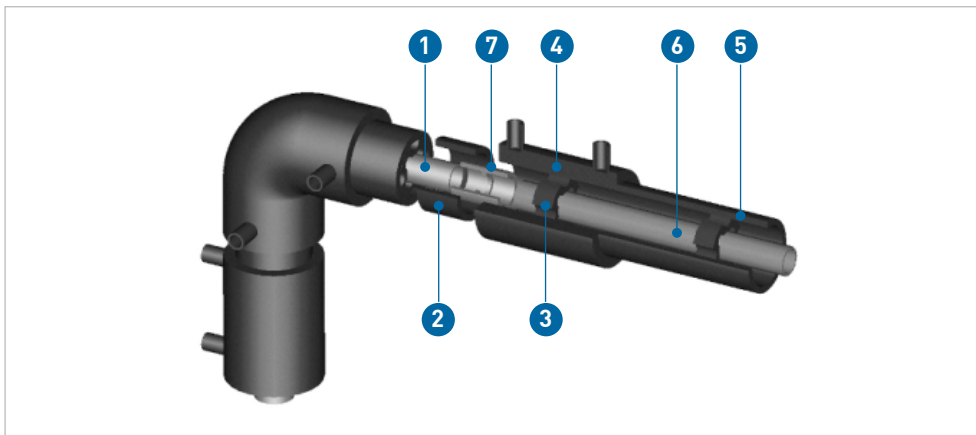


- 1 Monitoring room
- 2 Containment pipe
- 3 Inner pipe
- 4 Support clamps
- 5 Spacers

The CONTAIN-IT Plus system consists of a media-carrying inner pipe and an containment pipe, which provides protection for the environment, people and production facilities in the event of an unexpected leakage of the medium carrying inner pipe. The inner pipe is centralized in the containment pipe by the use of spacers to prevent buckling from the inner pipe in the containment pipe. Leakage detection devices have to be connected to the monitoring room so that operators can detect unexpected leakages after a maximum of 72 hours and initiate appropriate countermeasures.

### 1.2.2 CONTAIN-IT Plus – Basics connection technology

The patented double containment connection technology allows a double containment pipe to be connected in the same way as a single pipe using the familiar and proven joining techniques in accordance with DVS Directive 2210-2. In the CONTAIN-IT Plus system, the inner and containment pipes are joined after each other. This unique connection technology makes it possible to visually inspect every internal piping connection and to execute a pressure-test of the internal pipe before the external pipe is joined. So-called "last connections", which occur with other system in each change of direction and then usually have to be done blind, are thus eliminated.



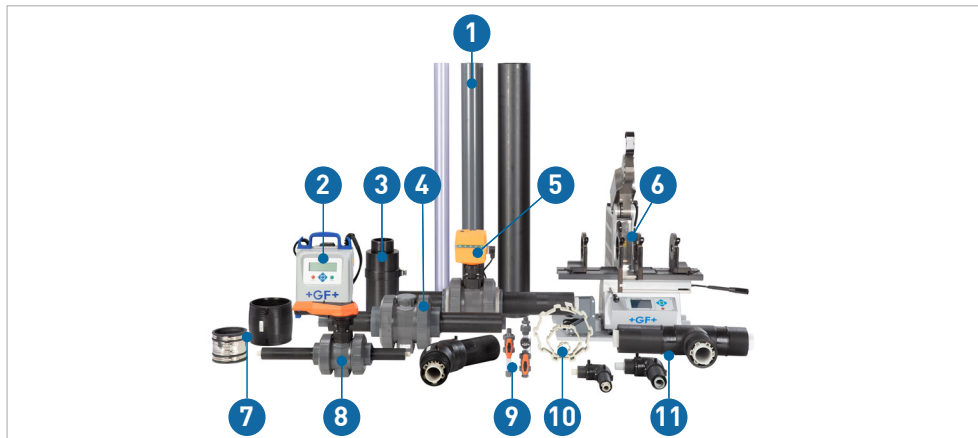
- 1 Fitting
- 2 Snap ring
- 3 Spacers
- 4 Electrofusion coupler
- 5 PE containment pipe
- 6 Inner pipe
- 7 Cementing/welding socket

Example: PE100 containment pipe

Further information relevant to planning and installation can be found in the chapters "Planning instructions" and "Installation instructions".

### 1.2.3 CONTAIN-IT Plus Product range

Georg Fischer Piping Systems offers a broad product portfolio of double containment fittings, ball valves, mechanical connections, leak detections solutions and numerous connection technologies, all the way through to expanded services.



- 1 Containment pipes
- 2 MSA Electro fusion machine
- 3 Termination fitting/End fitting
- 4 Double containment mechanical connection
- 5 Electrical/pneumatic double containment ball valve
- 6 Fusion machines
- 7 Couplers
- 8 Double containment ball valves
- 9 Leak detection solutions
- 10 Spacers
- 11 Double containment fittings

### 1.2.4 CONTAIN-IT Plus delivery program – Inner pipe

The selection of materials and connection technologies are crucial for operational safety and a long service life. The diverse choice of materials from various plastics for the inner pipe allows an optimal adaptation of the pipe material to the physical and chemical requirements: PVC-U, PVC-C, PP-H, PE, PVDF, ECTFE and PFA.

Georg Fischer Piping Systems provides comprehensive support in the selection of the materials and connection technologies based on your project-specific operation conditions in the "Questionnaire for static evidence and stress calculation".

The [online tool: Chemical resistance - Georg Fischer Piping Systems](http://www.gfps.com) (www.gfps.com) can be used as a general guidance for a rough material pre-selection.

Sulfuric Acid, > 78 - 93% solution

Formula: H<sub>2</sub>SO<sub>4</sub>  
 Synonyme:  
 Comments: Chemical de-rating factors apply only to metric DIN and not to ASTM SCH systems.

- not applicable ⓘ    
 0 individual evaluation, please contact GF ⓘ    
 + (AF) conditionally applicable ⓘ    
 ++ unconditionally applicable ⓘ

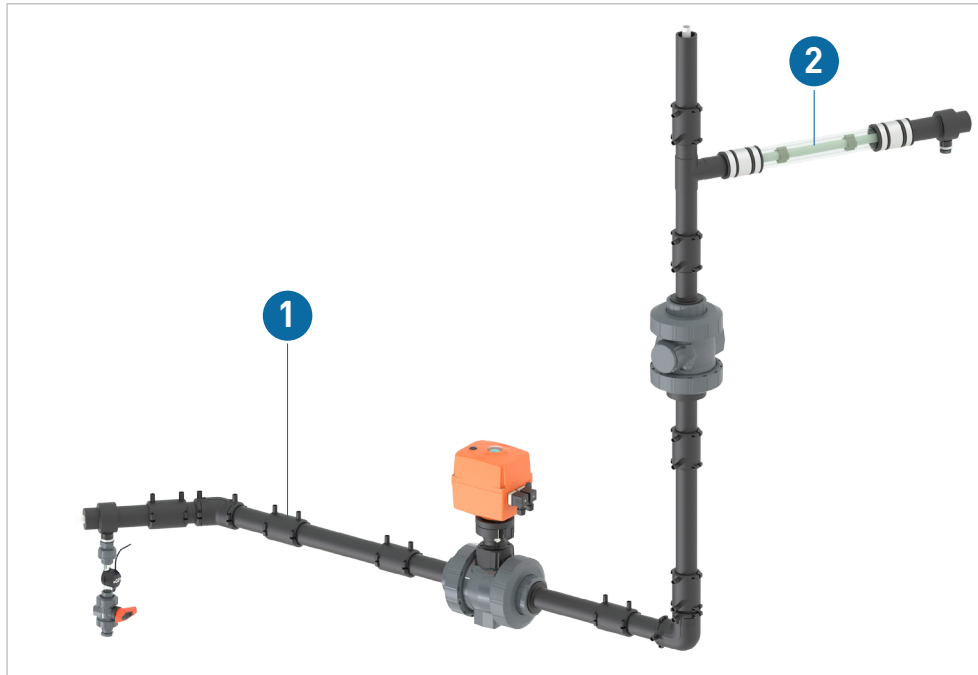
Piping Systems	20 °C	40 °C	60 °C	80 °C	100 °C	120 °C	140 °C
PVC-U	+ (1.1)	+ (1.1)	-				
PVC-C	++	++	0	-			
PE	-						
PP	-						
PVDF	+ (1.3)	+ (1.3)	0	-			
ECTFE	++	++	++	++	0	-	
EPDM	-						
FKM	++	++	++	0	0	-	
Jointing of PVC	20 °C	40 °C	60 °C	80 °C	100 °C	120 °C	140 °C
Tangit PVC-U	-						
Tangit PVC-C	-						



### 1.2.5 CONTAIN-IT Plus delivery program – Containment pipe

The containment pipe of the CONTAIN-IT Plus system can be designed with a pressure-resistant PE and a pressureless PVC-U (transparent) pipe from Georg Fischer Piping Systems. The outer fittings of the CONTAIN-IT Plus system are always made of PE100.

The prime considerations for selecting the containment pipe material are the installation and operating conditions like temperatures, pressures, impact, notch rupture strength, UV resistance, etc. The chemical resistance of both materials is sufficient, due to the fact that the containment pipe is just in contact with the medium under full load in case of leakage and hence only for a max. period of 72 h.



- 1 Variant 1: PE containment pipe**
  - Tensile-tight and pressure-resistant system
  - Installation underground/above ground/inside/outside of buildings
  - UV-resistant system
  - Good impact and notching resistance
- 2 Variant 2: PVC-U (transparent) containment pipe**
  - Non-tensile-tight and non-pressure-resistant system
  - Installation in buildings
  - Simple visual leakage detection

#### Containment pipe variants: System overview

	Variant 1: PE100	Variant 2: PVC-U (transparent)
Connection technology	Electrofusion coupler (ELGEF Plus)	EPDM couplers and cementing sockets
		
Tensile-tight connection	Yes	No
Containment pipe dimension	50mm – 315mm	50mm – 160mm
Nominal pressure	PN6*/PN10*/PN16*	PN1

\*The nominal pressure of the inner and containment pipe is based on the component with the lowest nominal pressure. Pressure decreasing containment pipe components are, among others, mechanical connections, as well as ball valves with a nominal pressure of PN6 (housing).

### Variant 1: Pressurized PE containment pipe

The containment pipe designed to encapsulate the medium-carrying inner pipe is made from polyethylene PE100. This material is characterized by good chemical resistance to acids, alkalis and salts, as well as numerous organic and inorganic solvents.

The advantages of PE100 are clear:

- High UV resistance thanks to black (stabilized with black carbon) polyethylene.
- Insusceptibility to notching
- Flexibility and impact strength even at temperatures down to -50°C.

Consequently, PE100 is ideally suited as a containment pipe material for installations indoor, outdoors and underground.



The code numbers and wall thicknesses of the containment pipes – PE100 – are provided in the CONTAIN-IT Plus product catalog.

#### Connection technology:

The containment pipe out of PE100 is welded pressure-tight with the ELGEF Plus electrofusion couplers.

Both the inner and the outer protective pipe are reliable, quality-controlled pressure piping systems, which are implemented without changes. The jointing techniques correspond without exception to the relevant guidelines for pressure piping system construction.

### Variant 2: Splash protection PVC-U (transparent) containment pipe

The external protective pipe designed to encapsulate the medium-carrying internal pipe is made from PVC-U (transparent). The splash protection system differs from the pressure-tight system in usage of an EPDM rubber collar with a V2A metal band for connecting the containment pipe. This connection is neither tensile-tight nor pressure-tight, and is therefore used almost exclusively inside buildings under constant operating and ambient conditions.



The code numbers and wall thicknesses of the containment pipes – PVC-U (transparent) – are provided in the CONTAIN-IT Plus product catalog.

#### Connection technology

EPDM sleeves are used at every transition from PVC-U (transparent) containment pipe to the PE molded parts. The containment pipe materials offered by Georg Fischer Piping Systems can be connected to one another quickly and easily using the EPDM sleeves. The procedure for connecting the fittings is the same as for the pressure-resistant system.

For pipe-to-pipe connections, standard cemented connections (socket cementing) are used.

## Containment pipe variants: wall thicknesses

Inner pipe	Containment pipe			
Dimension [mm]	Dimension [mm]	Variant 1	Variant 2*	
		PE100	PVC-U	PVC-U transparent
20	50	SDR 11	SDR 13.6	SDR 13.6
25	50	SDR 11	SDR 13.6	SDR 13.6
32	63	SDR 11	SDR 13.6	SDR 13.6
40	75	SDR 11	SDR 21	SDR 21
50	90	SDR 17.6	SDR 21	SDR 21
63	110	SDR 17.6	SDR 21	SDR 21
75	125	SDR 17.6	SDR 34.4	
90	140	SDR 17.6	On request	
110	160	SDR 17.6	On request	
125	180	SDR 17.6		
140	200	SDR 17.6		
160	225	SDR 17.6		
200	280	SDR 17.6		
225	315	SDR 17.6		

\*Spacer PVC-U (transparent): Spacers can be adjusted for thin-walled pipes (on request)!

### 1.2.6 CONTAIN-IT Plus product range – Fittings

The CONTAIN-IT Plus double containment system is available in a wide range of different materials, dimensions, connection technologies and components.

#### Materials, dimensions, connection technology

The choice of materials from various plastics for the inner pipe allows the pipe material to be optimally adapted to meet the physical and chemical requirements: PVC-U, PVC-C, PP-H, PE, PVDF, ECTFE and PFA.

The containment fittings are always out of PE100 and are therefore completely independent of the inner pipe material and the inner pipe connection technology.



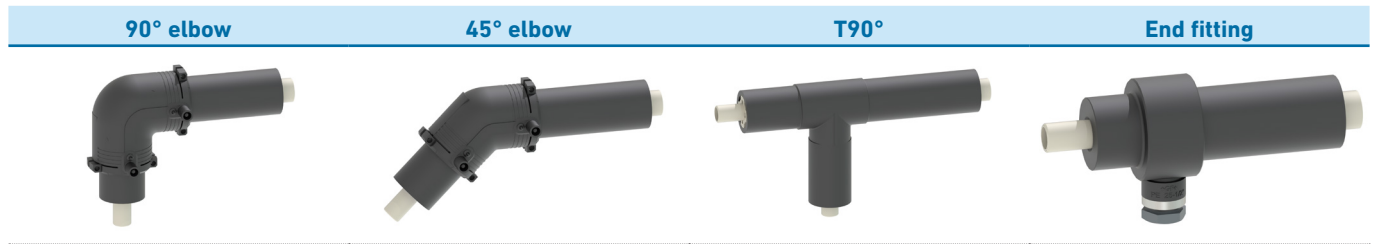
- Compatible with butt and infrared welding (IR)
- Other combinations such as WNF welding connection (free of beads and crevices) on request.

Dimension (mm)	Inner pipe				Socket fusion			Butt welding				IR welding
	Socket cementing				PP-H	PE80	PVDF	PP-H SDR11	PE100 SDR11	PVDF SDR21	PVDF SDR33	ECTFE SDR21
	PVC-U Tangit	PVC-U Dytex	PVC-C Tangit	PVC-C Dytex								
d20/D50	✓	✓	✓	✓	✓	✓	✓	•	•	•		✓
d25/D50	✓	✓	✓	✓	✓	✓	✓	•	•	•		✓
d32/D63	✓	✓	✓	✓	✓	✓	✓	•	•	•		✓
d40/D75	✓	✓	✓	✓	✓	✓	✓	•	•	•		✓
d50/D90	✓	✓	✓	✓	✓	✓	✓	•	•	•		✓
d63/D110	✓	✓	✓	✓	✓	✓	✓	•	•	•		✓
d75/D125	✓	✓	✓	✓	✓	✓		•	•	•		✓
d90/D140	✓	✓	✓	✓	✓	✓		•	•	•		✓
d110/D160	✓	✓	✓	✓	✓	✓		•	•	•		✓
d125/D180	✓							✓	✓		✓	
d140/D200	✓							✓	✓		✓	
d160/D225	✓							✓	✓		✓	
d200/D280	✓							✓	✓		✓	
d225/D315	✓							✓	✓		✓	

**i** The factory-welded connections on the fitting are made with infrared fusion wherever possible. The infrared fusions are logged internally (fusion log) and each connection is provided with a label.

## Components and their layout

The individual fittings for the inner and containment pipe are injection molded using the latest quality assured procedures. Fittings are factory-made and supplied ready to install. With the CONTAIN-IT Plus system, the containment fitting – consisting of polyethylene (PE100) – is loosely centered on the inner fitting at the factory.



Specially designed and patented termination fittings, with an Rp½ connection to the monitoring space, are installed at the start and end of the double containment system. End fittings have two EPDM O-rings or lip seals in series, which are required at the transition from double containment pipe to single pipe to seal the monitoring space in case of a leakage. Specially designed and patented termination fittings, with an Rp½ connection to the monitoring space, are installed at the start and end of the double containment system.

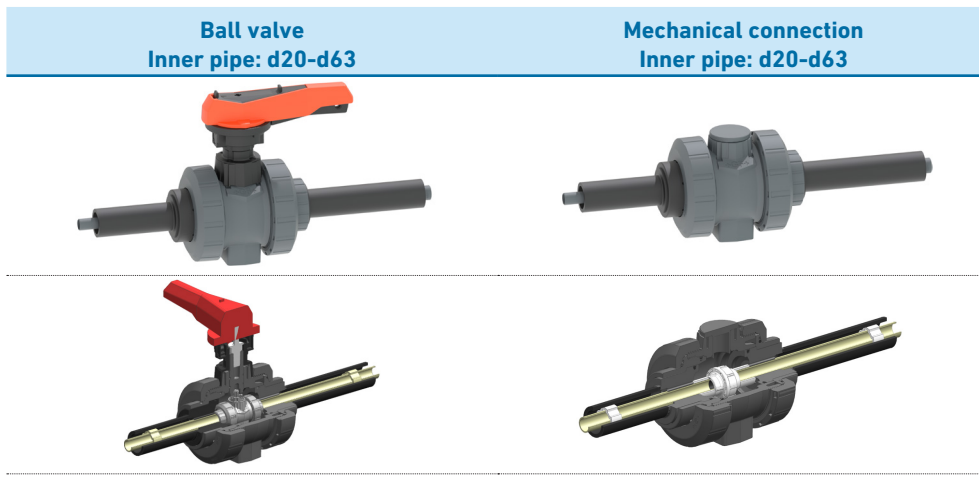
**i** Customized designs such as T45°, fixed point fittings inner and containment pipe (see chapter "Questionnaire for static evidence and stress calculation") are possible on request!

### 1.2.7 CONTAIN-IT Plus product range – Valves and mechanical connections

The CONTAIN-IT Plus Double Containment System is supplied in a wide range of different materials, dimensions, connection technologies and components.

#### Components and design

Double containment ball valves and mech. connections are factory-made and can be integrated into the double containment system in the same way as the fittings. Valves can be operated manually/automated from outside and can be opened radially for maintenance purposes and for pressure testing of the inner piping system. In addition, the monitoring room is continuous, so that leaks can spread easily. All fittings have Rp½ connections for the simple and flexible integration of leakage detection solutions into the monitoring room.



**i** Larger, pressure-resistant ball valves (d75, d90, d110) available on request!

**i** Seals: For the construction of the inner pipe, the sealing material must be selected according to the given operating conditions. EPDM, FKM and additionally FFKM (on request) are available for the ball valves (Valves with actuators on request).

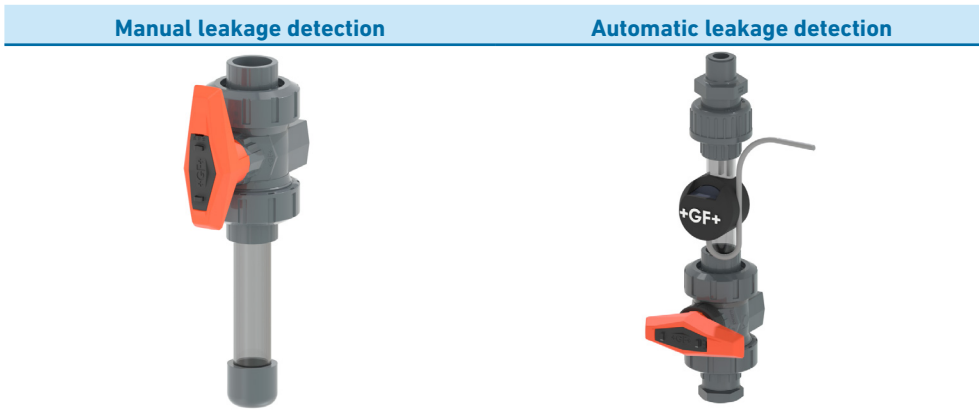
#### Automation

Thanks to their modular design, double containment ball valves can be supplied from the factory with electric or pneumatic actuators or retrofitted with an actuator by adding an adapter set. Please contact your local sales office.



### 1.2.8 CONTAIN-IT Plus delivery program – Leakage detection

For leakage detection, both manual and automatic solution are available. If further project-specific solutions are required (leakage location cables, vacuum or overpressure), Georg Fischer Piping Systems has the corresponding partner companies. Further information on leakage detection relevant to planning and installation can be found in the following chapters.



#### Connection clamps/saddles

Depending on the isometry and local conditions, connection clamps are required for leakage detection and must be selected on the basis of the selected containment pipe variant/ dimension.

<p><b>PP connection clamp with NBR seal</b> (PE/PVC-U containment pipe = d50) (Mechanical connection)</p>	<p><b>PE connection saddle</b> (PE containment pipe ≥ d63) (Electrofusion)</p>	<p><b>PE adapter for saddle connector</b> (For connecting the leakage detection system)</p>
---	--	---




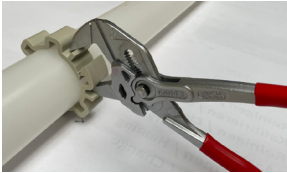
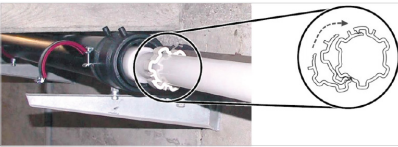
For d50 containment piping:  
753 211 610  
with reducer (63/50):  
753 901 658

**i** Connection clamps/saddles that can be retrofitted to the containment pipe enables flushing of the monitoring room, venting at the highest point of the pipeline, or can be used as a spigot for the pressure test of the containment pipe

### 1.2.9 CONTAIN-IT Plus product range – Spacers and snap rings

#### Spacers


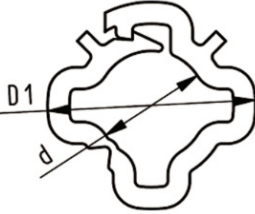
Spacers (PP-H) are a necessary component of a double containment system. Spacers prevent the inner pipeline from buckling in the outer pipeline due to thermal effects, for example, and contribute to an extended service life of the overall system. The number of spacers required or the distance between two spacers must be checked on the basis of the results of the "Questionnaire for static evidence and stress calculation".

Description	Spacers
<p>"Click system" spacers are clamped to the inner pipe, which is then pushed into the outer pipe – double containment pipes are not pre-fabricated. The pipes can also be used as standard single pipes.</p>	
	

Containment pipes with the appropriate wall thickness must be used so that the spacers fit as closely as possible to the containment pipe. This prevents the internal pipe from hanging through. With thin-walled PVC-U (transparent) pipes, the inner pipe may hang through in the containment pipe. Special spacers can be supplied on request.

#### Spacer dimensions

Inner pipe diameter d [mm]	Containment pipe diameter D1 [mm]
20	38
25	38
32	48
40	57
50	76
63	94
75	104
90	118
110	138
125	152
140	173
160	195
200	238
225	267



## Snap rings

The CONTAIN-IT Plus double containment system is characterized by a staggered connection between the inner and containment pipe. This connection technology ensures a 100% visual inspection of the inner pipe connection. The 30 mm wide control gap in the containment pipe, which is needed for the visual inspection, is closed by a snap ring once the internal pipe connection has been successfully inspected.



### 1.2.10 CONTAIN-IT Plus – Bill of material

The calculation table below provides an overview of the required sockets, snap rings, ELGEF Plus electrofusion coupler and EPDM collars.

#### Material requirement checklist

##### Inner piping connection: Socket fusion or cementing

Quantity required per item	Pressure-tight solution ELGEF Plus Socket	Splash protection solution EPDM collars	Socket Equal	Snap ring
Connection technology	Electrofusion	Mechanical		
Containment piping material	PE	PVC-U (Transparent)		
90° elbow	2	2	1	2
45° elbow	2	2	1	2
T-90° equivalent	3	3	2	3
End fitting	1	1	0	1
Segmentation fitting	2	2	1	2
Inner pipe	0	0	*	0
Containment pipe (PE)	*	0	0	*
Containment pipe (PVC-U)	0	0	**	0

##### Inner pipe connection: Butt fusion

Quantity required per item	Pressure-re-sistant solution ELGEF Plus Coupler	Splash protection solution EPDM collars	Socket Equal	Snap ring
Connection technology	Electrofusion	Mechanical		
Containment piping material	PE	PVC-U (Transparent)		
90° elbow	2	2	0	2
45° elbow	2	2	0	2
T-90° equivalent	3	3	0	3
End fitting	1	1	0	1
Segmentation fitting	2	2	0	2
Inner pipe	0	0	0	0
Containment pipe (PE)	*	0	0	*
Containment pipe (PVC-U)	0	0	**	0

\* For segmenting the monitoring room into monitoring sections

\*\* 1 item per pipe rod to be processed

## 1.3 Planning instructions

### 1.3.1 Criteria for a safe system

DVS Guideline 2210-2 (German Association of Welding Technology) must be taken into account for the project planning, design and installation of a double containment piping system.

This includes the following topics, among others, which contribute to safe operation:

#### Planning and installation

- **Inner pipe:** For safety reasons, the components of the media-conveying inner pipe should not be altered from their standard version. This ensures the consistent, tested quality of our DIBt-approved (German Institute for Building Technology) individual components of the fittings for the following materials: PVC-U Z-40.23-2; PE80 and PE100 Z-40.23-282; PP-H Z-40.23-264 and PVDF Z-40.23-262. The pipes have to be DIBt-approved.
- **Connections:** The DVS (German Association for Fusion Technology) fusion guidelines and KRV (Plastic Pipe Association) solvent cementing instructions are applicable without exception, especially to double containment piping systems.
- **Static evidence and installation:** Due to different operation conditions (temperatures, pressure ratings, etc.) between inner and containment pipe, as well as the use of different materials with different expansion coefficients for inner and containment pipe, high stresses can be caused by inhibited longitudinal expansion between inner and containment pipe, depending on the application. Georg Fischer Piping Systems calculates these stresses and other fundamental installation parameters, which are relevant to planning and installation for a straight pipe section (based on your project specific information in the "Questionnaire for static evidence and stress calculation") and provides the results to the planner and installer free of charge.
- **Staff training:** Only persons trained and authorized by Georg Fischer Piping Systems are allowed to install the CONTAIN-IT Plus double containment systems.
- **Quality control and assessment:** "Blind connections" cannot be tolerated in double containment systems. Especially the visual inspection of the inner pipe connection during the jointing process is an important quality feature. A successful pressure test of the inner pipe must be guaranteed before the containment pipe is sealed. A successful and recorded pressure test of the containment pipe represents the end of the installation work and is an integral part of the installation.
- **Leakage detection:** Manual or automated leakage detection solutions must be taken into account for double containment systems. These must be taken into account by the operator in the supervision and maintenance plan, among other things.
- **Advanced planning service:** Georg Fischer Piping Systems recommends the use of the advanced engineering service, especially in the case of complex isometrics. This service analyzes the entire isometry, which can then be used as a basis for cost optimization proposals to the customer (support clamp distances, etc.).

#### Operation

- **Maintenance:** For maintenance purposes, subsequent extensions, and for repair cases, the Georg Fischer Piping Systems product range includes mechanical and radially expandable separators.
- **Operators:** Operators of double containment systems must hold operating instructions, including all relevant documents such as a supervision and maintenance plan, an emergency plan and immediate measures to be taken into account in case of a leakage.

### 1.3.2 Selecting the material of the medium-carrying inner pipe

The choice of material and the pressure rating of the pipe components are important for both, operating safety and for attaining the specified minimum operational lifetime of the system.

The decisive factors are the following:

- Operating pressure
- Operating temperature
- Conveyed medium
- Time of operation

A preselection can be done by using the list of chemical resistances and the material-related pressure and temperature diagrams.



The ChemRes PLUS tool is available on <https://www.gfps.com/com/de/downloads-tools/online-tools/chemical-resistance.html>

### 1.3.3 Selecting the material of containment pipe

In case of a leak, both containment systems (PVC-U and PE100) provide sufficient chemical resistance to contain the escaping medium for at least 72 h in the monitoring room. However, it should be noted that the pressure rating of the containment piping system depends on the component with the lowest pressure rating

#### Variant 1: PE containment pipe

The pressure rating of the PE containment piping system (PN10/PN16, with fittings PN6) must be at least equal to the operating pressure rating of the inner piping system until the incident is fixed. The PE system is suitable for underground applications due to excellent impact resistance. Moreover, thanks to the wide temperature range (-50 ... +60°C) and excellent UV resistance, it can be used in harsh environments, especially for above-ground installations outside buildings. Due to its excellent properties, the PE system can be used in almost all applications.

#### Variant 2: PVC containment pipe (transparent)

The pressure rating of the PVC-U containment piping system (PN1) must be at least equal to the operating pressure of the inner piping system until the incident is fixed. In the event of a leak, no higher pressure (including static pressure) than PN1 is allowed in the containment pipe, including at the lowest point of the monitoring section. Due to the limited temperature range of PVC-U (0°C ... 60°C) and the mechanical connections (EPDM-Collars) of the outer pipe, which is not a tensile-tight connection, the PVC-U (transparent) system can only be installed indoors under constant operation conditions.

#### Combination of variants 1 and 2:

Depending on the isometric drawings, a combination of the two containment piping materials may also be suitable. At well-accessible short pipe sections (1-2m) - at the lowest point of the monitoring room - a PVC-U (transparent) containment piping system can be used for visual leak detection. However, when using a PVC-U (transparent) system, the limited pressure rating of the containment piping system to PN1 must be considered.



A leakage of the inner pipe usually does not require an immediate shutdown of the double containment system, which means that production processes may still be completed. However, Georg Fischer Piping Systems recommends that operators define appropriate immediate measures in the event of a leakage and carry out a risk assessment before commissioning the double containment system. Depending on the installation conditions, a short-term shutdown may be necessary to ensure that the containment pipe is undamaged and that the leakage only affects the medium-carrying inner pipe.

### 1.3.4 Inner pipe sizing

The pipe diameter is determined by calculating the pressure loss within the pipe. This depends not only on the diameter, length or pipe material but, also on the flow medium and the flow rate. A calculation can be done based on DVS 2210.

### 1.3.5 Isometric drawing

The 30° isometric drawing (see example of cutting length calculation) provides an accurate view of the piping layout. When the axis dimensions are entered, the cutting lengths can be calculated and the installation direction of the fittings determined. This can be used to represent the ventilation, rinsing and shut-off requirement, as well as the installation position of the end and sectional fittings.

### 1.3.6 Questionnaire for static evidence and stress calculation

The questionnaire for the static evidence is a mandatory document. The results and recommendations must be taken into account during planning and installation phase. Within the scope of the standard service provided free of charge by Georg Fischer Piping Systems, a straight double containment section is considered. The entire isometric drawing is not analyzed, but only one straight pipe section. This calculation is informative enough for a standard installation.

#### The static evidence offers the following advantages:

1. Material check: Based on the questionnaire for static evidence and stress calculation, Georg Fischer Piping Systems checks if the selected inner pipe material is suitable under the specified operating conditions.
2. Steel structure dimensioning: For fixed point installation - prevented linear expansion of the containment pipe - the resulting stresses and forces applied to the fittings are calculated. These stresses and forces must be absorbed by the fixed pipe clamps at every change of direction. Additional support clamps must be installed between the fixed points, due to the pipe deflection or due to a pipe routing that is not exactly aligned. The support clamps must be designed for lateral forces of approx. 10-15% of the axial forces applied to the fixed points. The support clamps are to be designed for lateral forces amounting to approx. 10-15% of the axial forces acting on the fixed points. The results of the static verification take into account the axial forces acting on the fixed points, the lateral forces acting on the support clamps, both in the operating case and in the leakage case, and the support clamps distances.

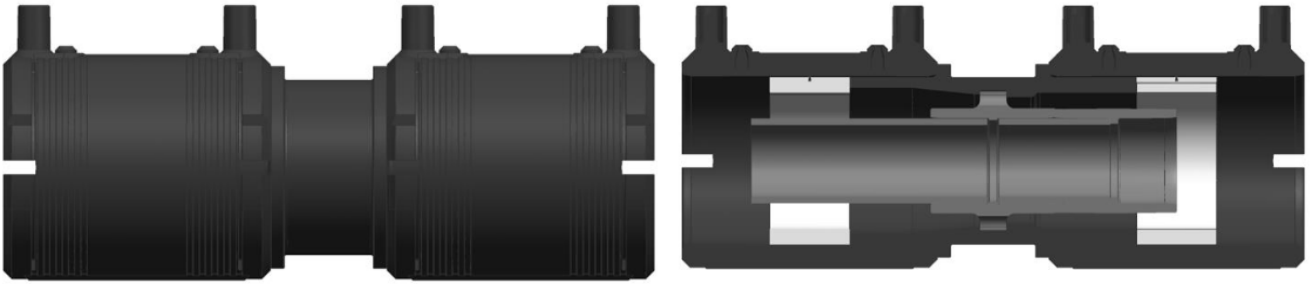
**i** The expansion of the containment pipe in the pipeline run does not have to be taken into account thanks to the fixed point installation, so that no additional expansion bends are necessary.

3. Expected system stresses: If the calculated stresses in the changes of direction become too large, the operating conditions or the material must be changed. Alternatively, an axial connection in the form of a fixed joint between the inner and outer piping ("fixed point fitting") must be considered to absorb the stresses before the change in direction. Experts at Georg Fischer Piping Systems will recommend a fixed point fitting based on your information in the "Questionnaire for Determination of Static Proof and Stress Calculation" if required.

In particular, straight pipe lengths of more than 10m and significant delta T need to be checked for the necessity of fixed point fittings.

In addition, there are various other options, such as trace heating cables with insulation, to overcome this behavior.

## Example of a fixed point: Cementing variant



The described fixed point design has a pass-through, so that leakage can spread easily.

4. Spacer distances: Spacer distances must be calculated individually for each application. Spacers prevent buckling and hence excessive expansion of the inner pipe (own weight) in the containment pipe. The calculation results of the static evidence also includes a calculation of the spacer distances based on the project specific information provided in the questionnaire.



GF Piping Systems

CONTAIN-IT Plus Systems

# Questionnaire for Static Evidence and Stress Calculation DVS 2210-2

**General project information**

Project name \_\_\_\_\_  
 Customer \_\_\_\_\_  
 CRM/Order number \_\_\_\_\_

**Flow media**

Flow media \_\_\_\_\_ %  
 Density (in g/cm<sup>3</sup>) \_\_\_\_\_  
 MSDS (Material Safety Data Sheet) attached?  Yes  No

**Operation conditions**

**Total load time**

Maximum working temperature	_____ °C	in percent	_____ %
Minimum working temperature	_____ °C	in percent	_____ %
Maximum working pressure	_____ bar	in percent	_____ %
Minimum working pressure	_____ bar	in percent	_____ %
Period w/o media/empty	_____	in percent	_____ %
Ambient temperature	Minimum _____ °C	Maximum	_____ °C
Required service life	<input type="checkbox"/> 10 years <input type="checkbox"/> 25 years		

**Parameter pipes**

**Inner pipe**

**Outer pipe**

Material	_____	<input type="checkbox"/> PE-100	<input type="checkbox"/> PVC-U (transparent)
Outer diameter d	_____		
Wall thickness e	_____		
Nominal pressure PN	_____		
Standard dimension ratio (SDR)	_____		
Expected connection technology	_____		

**Installation details**

**Installation detail 1**

**Installation detail 2**

Additional system data	<input type="checkbox"/> Above the ground	<input type="checkbox"/> In the ground (buried)	<input type="checkbox"/> In building	<input type="checkbox"/> Outdoor
	Longest straight pipe run >10m?		<input type="checkbox"/> Yes	<input type="checkbox"/> No
	Heat tracing?		<input type="checkbox"/> Yes	<input type="checkbox"/> No
	Insulation thickness		_____ mm	
Installation temperature	Minimum _____ °C		Maximum _____ °C	

**Leak detection information**

Leak detection information  Optical  Sensor  Detection cable  
 Overpressure difference \_\_\_\_\_ [mbar]  No pressure  
 Underpressure \_\_\_\_\_

**Comments**

Attachments  Isometric drawing  \_\_\_\_\_  \_\_\_\_\_

**Your contact**

Georg Fischer Piping Systems Ltd.  
 Ebnatstrasse 111, 8201 Schaffhausen / Switzerland  
 gss@georgfischer.com / www.gfps.com

**Disclaimer**  
 The scope of engineering services provided by Georg Fischer Piping Systems Ltd. is as follows: verification of above and below ground piping systems according to the given conditions. The static evidence provided complies with following criteria and is mainly based on DVS 2210-1: (static evidence and stress calculation for flexible and axially clamped sections with consideration of permissible change in length and deflection / generation of pipe support concept incl. support spacing, piping reactions and optimization / clear overview of load cases and assumptions / clarification of calculation / verifiability of calculation steps and non-generally accepted codes of practice / summary of results). GF makes its recommendations on the basis of information provided by the customer. GF does not check this information for completeness or correctness. Any liability due to incorrect or incomplete information provided by the customer is herewith excluded.

GFDO\_OP\_00037b\_EN (03.21)



### 1.3.7 Results of static evidence and stress calculation

Various materials and operating conditions require measures to ensure the expected service life time and safe operation of a double containment system.

#### Explanation

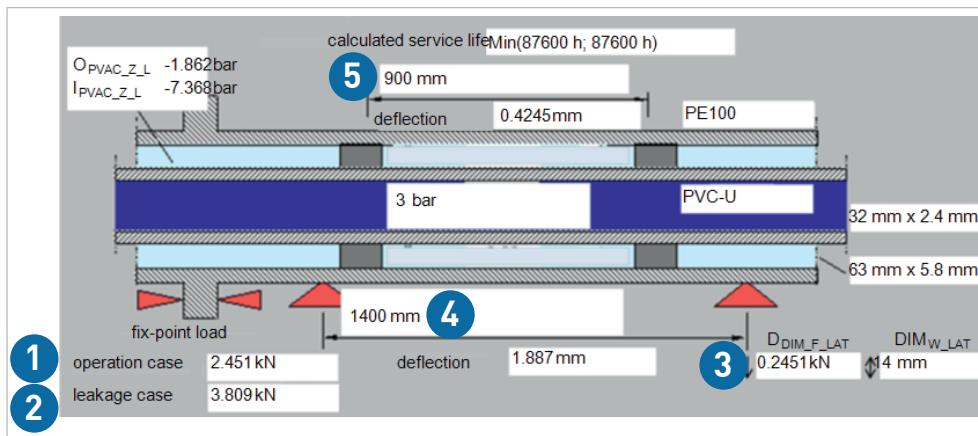
Double containment piping systems must be designed as fixed point installations due to diverse process conditions. The containment pipe must therefore be fixed to the steel structure at every change of direction to prevent thermal expansion/contraction. Inner piping materials such as PVC-C, PVC-U, ECTFE, PVDF, PP, PE, as well as outer piping materials such as PE, PVC-U (transparent) are exposed to different operating conditions. Depending on the combination, they have different expansion coefficients and thus, among other things, lead to different changes in length. Georg Fischer Piping Systems calculates the expected stress for a straight pipe section based on the project-specific information provided in the questionnaire. In this respect, it is also important, among other things, that filling lines in particular are taken into account in the questionnaire, as these are only occasionally operated under process conditions (temperature, etc.).

Material	Temperature range (°C)	$\alpha$ Expansion coefficient (mm/mxK)	L Pipe length (m)	$\Delta T$ Temperature change (K)	$\Delta L$ Length change (mm)
Steel		0.012	100	10	12
PVC-C	20...80	0.06...0.07	100	10	60...70
PVC-U	20...60	0.07...0.08	100	10	70...80
ECTFE	20...80	0.08...0.14	100	10	80...140
PVDF*	20...120	0.12...0.18	100	10	150...180
PP	20...80	0.16...0.18	100	10	160...180
PE	20...60	0.15...0.20	100	10	150...200

\*The linear expansion coefficient increases in line with temperature.

#### Steel structure forces

The expected forces on the steel construction can be extracted from the result of the static evidence and must be taken into account during planning and installation phase, in particular for the pipe routing and the selection of pipe clamps, see extract from an example project:



- 1 Axial load at fixed point during operation [kN]
- 2 Axial load at fixed point in case of a leak [kN]
- 3 Lateral load at guide bearings [kN]
- 4 Guide bearing distances [mm]
- 5 Spacer distances [mm]

## Determining the layout

The cable routing should be protected from mechanical and thermal effects. In addition, the required minimum distance from walls and ceilings must be observed.

In the case of high fixed point forces, the possibility of fastening to the building structure should be checked. If structural components cannot absorb the calculated fixed point force (e.g. trapezoidal sheet metal roofs), the forces must be absorbed by means of stable mounting rails that run with the structure.

## Fixed point installation

Double containment systems must be installed as a fixed point installation due to a wide range of process conditions. Thanks to this installation technique, among other things, a meaningful service life time of the double containment system can also be calculated (see result static evidence "calculated service life time").



- 1 Fixed point
- 2 Guide bearings

## Selecting the fixed point/support clamps

The appropriate load class must be taken into account when selecting the pipe supports.

Georg Fischer Piping Systems offers "Georg Fischer Stress Less" support types suitable for plastics in accordance with static proof.

<https://www.gfps.com/en-us/products-solutions/systems/stress-less.html>



### 1.3.8 Determining the leakage detection

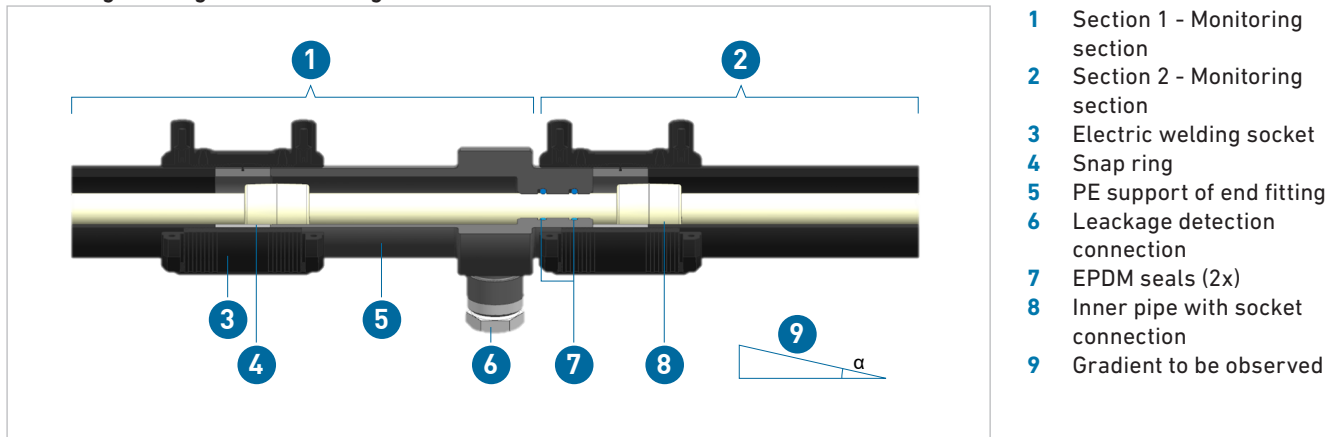
The design of the leakage monitoring is a central requirement of all double containment systems. Solutions for leakage monitoring must already be taken into account in the planning phase. In order to ensure that the double containment pipe does not become a single pipeline unnoticed in the event of a leak of the inner pipe, it must be ensured that leaks are detected within 72 hours. Various leakage monitoring solutions are available for monitoring the pipe or the monitoring room.

In addition, there are other possibilities in the design of the system available, which contribute to a fast leak localization and a quick recommissioning in case of a leak.

#### System segmentation: fast leakage localization and recommissioning

For rapid leakage localization and recommissioning of the double containment system in the event of a leakage, it is recommended to divide the interstitial space into smaller, freely selectable interstitial sections. This allows the leaking medium to spread only in a small monitoring section.

End fitting as a segmentation fitting:



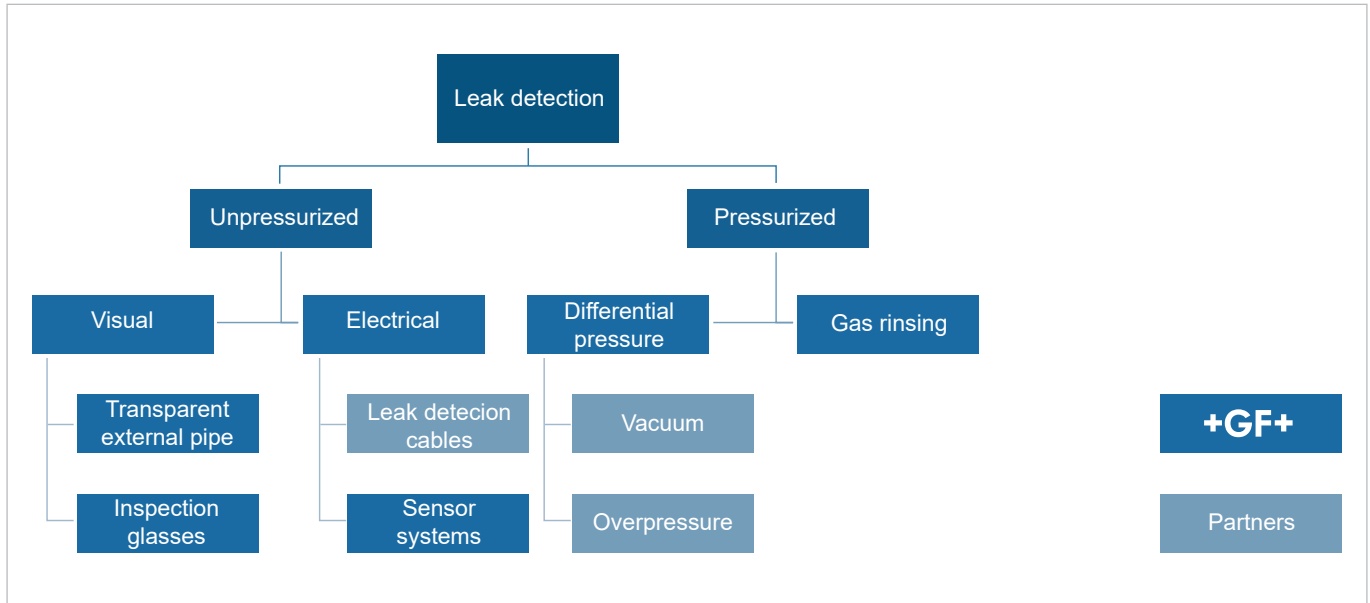
To ensure that the leakage can be reliably detected at the lowest point, it is very important to consider the installation position of the end fitting as a subdivision fitting (see illustration).

Standardized Georg Fischer Piping Systems end fittings can be used for the system segmentation (see illustration). The end fittings have two EPDM O-rings in series or a EPDM lip sealing, which ensure sufficient protection in case of a leakage and separate the monitoring rooms from each other. According to DVS- 2210-2 and based on internal experience, monitoring sections of 20m to 50m are well established.



### Leakage monitoring solutions

Georg Fischer Piping Systems provides three possibilities for pressureless leakage detection. A leakage monitoring solution is required for each monitoring system segmentation.



**i** Further information can be found in the chapter "Leakage detection and containment".

### Pipe routing: Low point leakage solutions

When using low-point solutions, such as inspection glasses and sensor systems, a slight slope of the containment pipe should be taken into account. As a result, even creeping leaks are detected at an early stage and are always led to the lowest point of the monitoring section.

### Monitoring room: Accessibility

Georg Fischer Piping Systems offers a wide range of flexible possibilities to get access into the monitoring room. Many standardized components such as end fittings, ball valves and mechanical connections are equipped with an Rp 1/2" connection to get access into the monitoring room in their standard version. In addition, it is possible to use connection clamps or saddles (PE and PP), which also allow access to the monitoring room after installation (see chapter "1.2.8 CONTAIN-IT Plus delivery program – Leakage detection").

## 1.4 Installation instructions

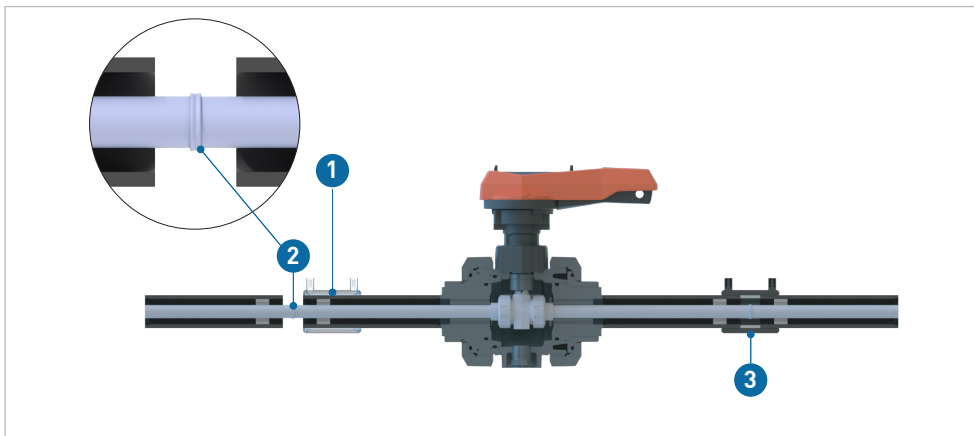
### 1.4.1 Authorization of installation personnel

Easy-to-learn technology, strict adherence to standards and regulations as well as many decades of experience in plastic piping system construction are the marks of distinction of the double containment piping system from Georg Fischer Piping Systems. Added to these essential requirements, in the interest of safety, is the careful training of the installers. Double containment systems may be installed only by persons who have been specifically trained and authorized by Georg Fischer Piping Systems.

### 1.4.2 Introduction – double containment connection technology

The patented double containment piping connection technology allows a double containment pipe to be connected in the same way as a single pipe by using the established and proven connection technologies in accordance with DVS guidelines 2210-2. In the CONTAIN-IT Plus system, the inner pipe and containment pipe sections are connected with a staggered connection. This unique connection technology allows a visual inspection of each inner pipe connection and pressure testing of the inner pipe before closing the containment pipe. So-called "last connections", which occur with every change of direction in other systems and then usually have to be executed "blindly", are thus eliminated.

#### Connection Plus – Highest quality



- 1 ELGEF electrofusion coupler; alternative: EPDM coupler
- 2 Visual inspection of inner pipe connection and pressure test of inner pipe
- 3 Centering of the snap ring in the ELGEF electrofusion coupler (gray) and closing of the containment pipe

#### Explanation on connection technology

1. Step: The inner pipe connection is realized by using proven and quality-assured connection technologies based on the selected material.
2. Step: A small gap in the containment pipe enables a visual inspection of the inner pipe connection.
3. Step: The initial pressure test of the inner pipe can be executed while the outer pipe is open, so that possible leaks in the inner pipe can be quickly located and repaired.
4. Step: After the pressure test of the inner piping system has been successfully completed, a PE snap ring (cutted PE pipe) is inserted to close the containment pipe.
5. Step: The electrofusion coupler (ELGEF Plus) is centered over the snap ring and afterwards welded.
6. Step: Pressure test of the containment pipe

### 1.4.3 Introduction – double containment installation steps

The essential processes for installing a double containment system are explained briefly below. Detailed explanations can be found in the corresponding sub-chapters.

#### Overview of the key installations steps

##### 1. Step: Cutting length calculation

The dimensions between axes (Z-dimension) for the 90° angle, the 45° angle and T-pieces are always identical and indicated on the bag labels of the fittings. The external pipe has a different length dimension to the internal pipe. The two pipes must be calculated separately and is based on the internal pipe connection technology (welding losses among others, etc.) and material. Detailed information on calculating the cutting length can be found in the chapter "Calculating the cutting length of the internal and external piping".

##### 2. Step: Preparation pipes

Before the internal pipe is joined, it is necessary to ensure that the spacers are mounted on the internal pipe according to the results of the static evidence (spacer distances) and that the protective pipe has been pulled over the internal pipe. The ELGEF sockets or EPDM sleeves must be pulled onto the external pipe or the long fitting side before the internal pipe is connected. Detailed information on preparing the pipes can be found in the chapter "Preparing the internal and external piping".

##### 3. Step: Connection inner pipe

Proven and well-known standard connections have been taken into account for the connections of the inner pipeline. Depending on the material and dimensions, the following are available: Solvent cementing, socket fusion, butt fusion and the infrared fusion. The selection is based on suitability based on operating conditions. PVDF BCF welded joints (bead- and crevice-free) can be performed on request.

###### **Cemented connection (PVC-U and PVC-C)**

A quick jointing method that is carried out without extensive use of tools or machinery.

###### **Heating element socket fusion (PP, PE and PVDF)**

Socket fusion is particularly suited for dimensions from d20/50 up to d110/160. Up to and including dimension d50/90, these joints can be easily made in the piping system route, using hand fusion equipment.

###### **Heating element butt fusion (PP, PE and PVDF)**

In pressurized pipe systems, all butt fusion joints must be executed with a butt fusion machine and not by hand.

###### **Infrared fusion (PP, PE100, PVDF and ECTFE)**

In IR fusion, the parts to be connected (pipe and fitting) are heated to fusion temperature in the fusion area and fused in a contact-free process. This low-stress welding process allows smaller weld beads and reduces the risk of contamination due to the non-contact process.

For detailed information on connecting the inner pipe, see chapter "Connecting the inner pipe".

##### 4. Step: Pressure test and visual inspection of the inner pipe

Once the inner pipe is connected, a 30 mm gap remains in the containment pipe.

This gap allows the inner pipe connection to be visually inspected and assessed. The pressure test of the inner pipe has to be performed before the containment pipe is closed so that leaking inner pipe connections can be quickly localized and rectified.

The pressure test of the inner pipe requires that the inner pipe sections are ready for operation. Georg Fischer Piping Systems recommends a section-by-section pressure test, especially for long double containment piping systems and in tight locations. For further information on how to carry out the pressure test, please refer to the chapter "Instructions for internal and external pressure testing".

**5. Step: Connecting containment pipe**

After successful verification of the inner piping system, the containment pipe can be closed (see chapter "Connection containment pipe").

A pressure-resistant version with electrofusion coupler (ELGEF Plus) and a splash protection version with EPDM sleeve is available. Before closing the containment pipe, make sure that the 30mm gap in the containment pipe is closed by the 30mm wide snap ring (cutted PE pipe). The insertion depth of the sleeve/collar must be determined precisely so that the snap ring is centered in the sleeve/collar.

After welding the ELGEF Plus electrofusion coupler or tightening the EPDM sleeve, the pressure test of the containment pipe can be carried out.

**6. Step: Pressure test containment pipe**

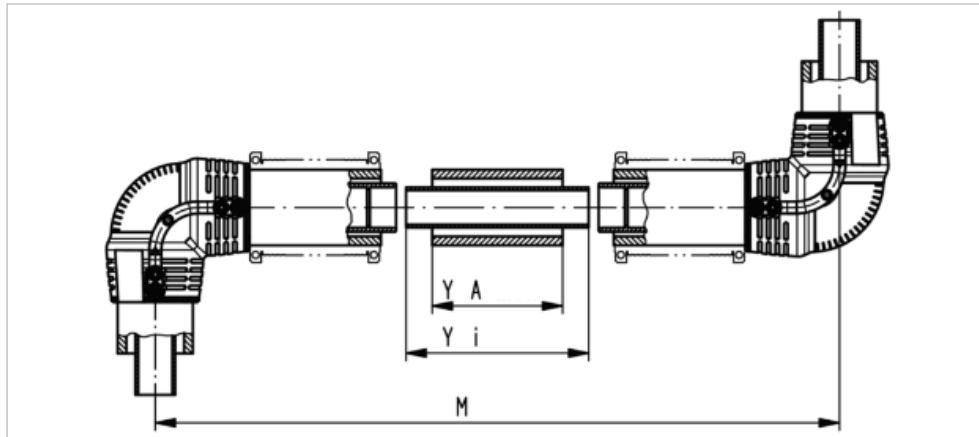
The containment pipe is pressure tested when the inner pipe is completely filled and under internal pressure (the internal pressure of the inner pipe should be at least equal to or higher than the internal pressure of the containment pipe) in order to prevent the inner pipe being exposed to external overpressure. Further information on performing the pressure test can be found in the chapter "Instructions for internal and external pressure test".

Once the pressure test of the outer pipe has been successfully completed and the connections to the interstitial space (flushing connections, pressure test connections, etc.) have finally been closed and the leakage detection units have been functionally tested, the double containment system is ready for operation from a technical point of view.

### 1.4.4 Cutting length calculation of internal and containment pipes

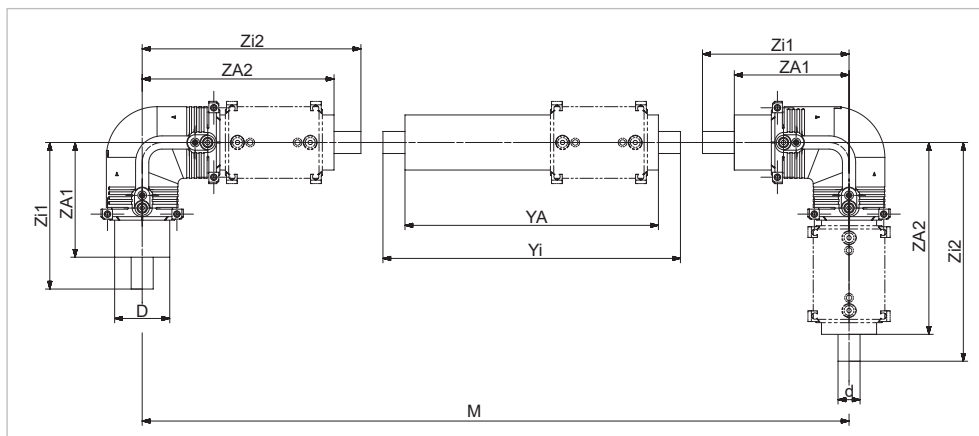
#### Definitions

The required axial measurement "M" can be taken from the isometric drawing or determined by precise measurement.



M ≈ Length between axes  
 YA ≈ cutting length  
     Containment pipe  
 Yi ≈ Cutting length  
     Inner pipe

For the cutting length calculation of the inner pipe "Yi" and the containment pipe "YA", the Z measures of the fittings must be taken into account in advance.



#### Z-dimensions of fittings

Every item of the double containment system is packaged in a bag in the factory and delivered with a bag label. The label includes all relevant Z-dimensions for calculating the cutting lengths of the inner and containment pipe.

1 Z-dimension

#### Labeling Packaging with label

**+GF+**  
**CONTAIN-IT Plus**  
 Winkel 90°  
 Coude 90°  
 Elbow 90°  
 Gomito a 90°  
**721104108**  
**d32-d63**  
**PVC-U**  
 PN16/16

**1x** ZA1 = 120 Zi1 = 160  
 ZA2 = 190 Zi2 = 183

1 Patch No

Georg Fischer Piping Systems Ltd., 8221 Schaffhausen/Schweiz  
 www.gfps.com

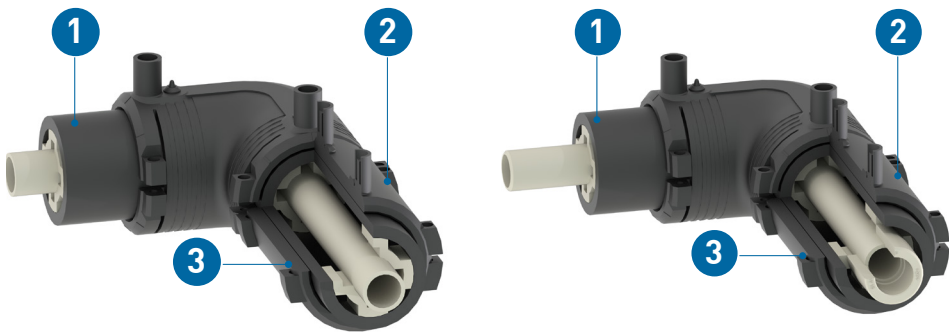


**i** The Z-dimensions for the 90° elbow, the 45° elbow and T-pieces are identical.

### Explanation of the Z-dimension

Each item of the double containment system has a short and a long side (see illustration). The shortest axial measurement can be achieved by combining the short fitting side with the long fitting side, in order to apply the ELGEF sleeve or the EPDM coupler.

Fitting-Butt Fusion	Fitting-Socket fusion/cementing
---------------------	---------------------------------

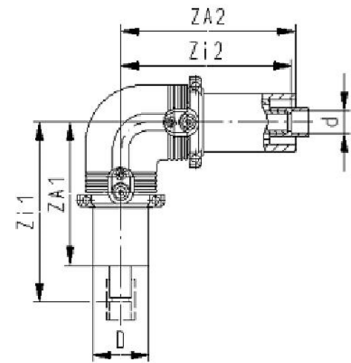


- 1 Short side (S)
- 2 Long side (L)
- 3 ELGEF electrofusion coupler or EPDM sleeve

CAD files (<https://bim.gfps.com>): AUTODESK REVIT, AVEVA

Designation	Explanation	Side
-------------	-------------	------

ZA1	Z-dimension of containment pipe	Short side
Zi1	Z-dimension of inner pipe	Short side
ZA2	Z-dimension of containment pipe	Long side
Zi2	Z-dimension of inner pipe	Long side



### Legend

Abbreviation	Designation	Symbol	Example of 90° elbow
S	Short fitting side		
L	Long fitting side		
E	End fitting		

### Case assessment

Before calculating the cutting lengths ( $Y_i$ ,  $Y_A$ ), it is mandatory to consider the isometry and the corresponding installation case. The cases differ depending on the arrangement of the fittings. The following case scenarios may occur (see table). GF strongly recommends to always consider the combination "Short fitting side - Pipe - Long fitting side" for the connection.

Abbreviation	Designation	Symbol
S – P – L	Short fitting side – Pipe – Long fitting side	
S – P – S	Short fitting side – Pipe – Short fitting side	
S – L	Short fitting side – Long fitting side	
L – P – L	Long fitting side – Pipe – Long fitting side	
S – E	Short fitting side – End fitting	
S – P – E	Short fitting side – Pipe – End fitting	
L – P – E	Long fitting side – Pipe – End fitting	

Depending on the isometry, the Z measures of the fittings must be selected accordingly, i.e. Zi1 and ZA1 or Zi2 and ZA2 or ZA and Zie.



**30° allowance sheet - Z-Measure method**

Before calculating the cutting length, the isometric drawing must be taken into account to define how the fittings should be installed in the most practical case. With the combination of "short fitting side" to "long fitting side", the shortest axial measurement M can be realized.



**GF Piping Systems**

**Double Containment system  
CONTAIN-IT Plus**

Date: \_\_\_\_\_  
Sheet No./Number: \_\_\_\_/\_\_\_\_

Client: \_\_\_\_\_  
Construction object: \_\_\_\_\_

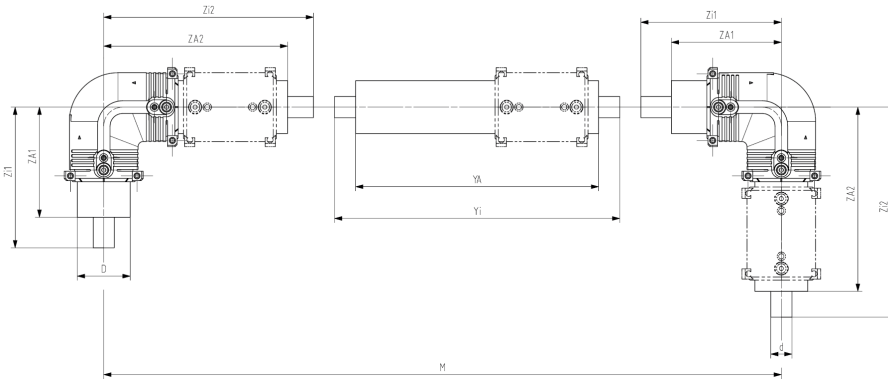
<b>Material of inner pipe:</b>		<b>Dimension of inner pipe:</b>	
<input type="checkbox"/> Cementing	<input type="checkbox"/> Sockets	<input type="checkbox"/> Conventional butt	<input type="checkbox"/> Infrared butt

<b>Legend</b>		
<b>Short fitting side (S)</b>	<b>Long fitting side (L)</b>	<b>Endfitting (E)</b>



**Z-Mass Method**

Case study: Long fitting side – Pipe – Short fitting side



Conventional butt & IR fusion joint

Z-Mass 90°/45°/T90°	
	Short fitting side:
	ZA1 : _____
	Zi1 : _____
	Long fitting side:
	ZA2 : _____
	Zi2 : _____
ZA : _____	
Zi : _____	

Calculation – "Short-Pipe-Long":

- **Yi Cutting length inner pipe**  
M - Fitting1 Zi1 - Fitting2 Zi2 + (material loss x (number of inner pipe connections))

- **YA Cutting length outer pipe**  
M - Fitting1 ZA1 - Fitting2 ZA2 - (30mm x number of snap rings)

Material loss butt/infrared fusion [mm]:  
\_\_\_\_\_

*The material losses must be taken into account in the cutting length calculation for pipe-to-pipe connections.*

Cementing & socket connections

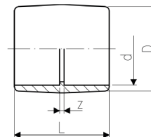
Z-Mass 90°/45°/T90°	
	Short fitting side:
	ZA1 : _____
	Zi1 : _____
	Long fitting side:
	ZA2 : _____
	Zi2 : _____
ZA : _____	
Zi : _____	

Calculation – "Short-Pipe-Long":

- **Yi Cutting length inner pipe**  
M - Fitting 1 Zi1 - Fitting2 Zi2 - (joint width z x number of pipe-to-pipe connections)

- **YA Cutting length outer pipe**  
M - Fitting1 ZA1 - Fitting2 ZA2 - (30mm x number of snap rings)

Z-Value of welding/solvent cement socket [mm]:  
\_\_\_\_\_



*The Z-Value must be taken into account when calculating the cutting length for pipe-to-pipe connections.*

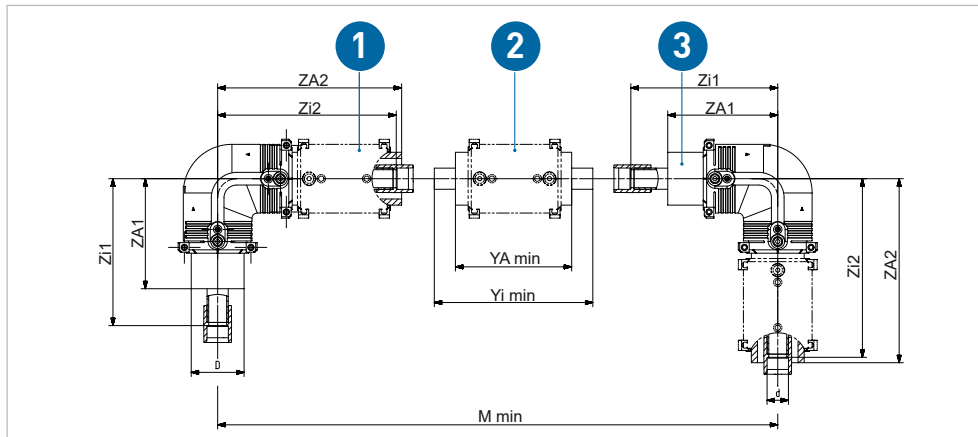
**Cutting length calculation**

Pipe Section No.: _____ Case: _____ M: _____ Yi: _____ YA: _____	Pipe Section No.: _____ Case: _____ M: _____ Yi: _____ YA: _____	Pipe Section No.: _____ Case: _____ M: _____ Yi: _____ YA: _____	Pipe Section No.: _____ Case: _____ M: _____ Yi: _____ YA: _____
Pipe Section No.: _____ Case: _____ M: _____ Yi: _____ YA: _____	Pipe Section No.: _____ Case: _____ M: _____ Yi: _____ YA: _____	Pipe Section No.: _____ Case: _____ M: _____ Yi: _____ YA: _____	Pipe Section No.: _____ Case: _____ M: _____ Yi: _____ YA: _____
Pipe Section No.: _____ Case: _____ M: _____ Yi: _____ YA: _____	Pipe Section No.: _____ Case: _____ M: _____ Yi: _____ YA: _____	Pipe Section No.: _____ Case: _____ M: _____ Yi: _____ YA: _____	Pipe Section No.: _____ Case: _____ M: _____ Yi: _____ YA: _____
Pipe Section No.: _____ Case: _____ M: _____ Yi: _____ YA: _____	Pipe Section No.: _____ Case: _____ M: _____ Yi: _____ YA: _____	Pipe Section No.: _____ Case: _____ M: _____ Yi: _____ YA: _____	Pipe Section No.: _____ Case: _____ M: _____ Yi: _____ YA: _____

**Minimum measures between axes M min. (Case: S – P - L)**

If a very short pipe is required between two fittings, the minimum measurement between the axes must be taken into account. The shortest possible axis measurement - except for the direct fitting-to-fitting connection - can be realized by combining "Short fitting side" to "Long fitting side" (see illustration).

A sleeve/coupler can still be pushed onto the long fitting side. The second sleeve/coupler, however, has to be pushed onto the containment pipe. This leads to the fact that the outer pipe must have at least the length of the sleeve/coupler.



- 1 Long side
- 2 Coupler on containment pipe
- 3 Short side

**General formula:**

$$M \text{ min} = 2 \times \text{snap ring width} + \text{fitting 1 ZA 1} + \text{fitting 2 ZA 2} + \text{coupler length}$$

**Explanation:**

- Snap rings: Two snap rings are always required, which leads to a control gap of 30 mm for each connection.
- Z-dimension ZA 1 or ZA 2: Case assessment must be taken into account, see isometry and bag label.
- Socket length: choice to be made between EPDM sleeves and ELGEF Plus electrofusion coupler

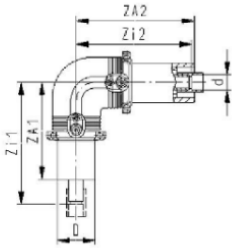
**Overview of socket lengths:**

Dimension of containment pipe d [mm]	ELGEF Plus coupler (SDR11) L [mm]	EPDM sleeve L [mm]
50	88 (SDR11)	90
63	96 (SDR11)	90
75	96 (SDR11)	110
90	113 (SDR11)	100
110	138 (SDR11)	120
125	154 (SDR11)	120
140	172 (SDR11)	120
160	180 (SDR17)	120
180	192 (SDR17)	
200	206 (SDR17)	
225	225 (SDR17)	
280	252 (SDR17)	
315	267 (SDR17)	

**i** Example for determining the minimum dimensions between axes M min:  
Long fitting side – Pipe – Short fitting side

## Labeling

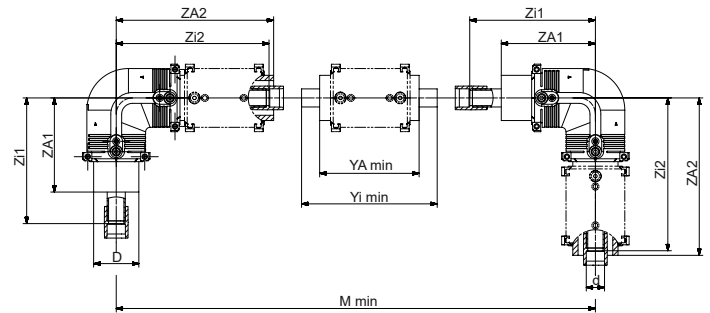
**+GF+**  
CONTAIN-IT Plus  
Winkel 90°  
Coude 90°  
Elbow 90°  
Gomito a 90°  
**721104108**  
**d32-d63**  
PVC-U  
PN16/16  
Georg Fischer Piping Systems Ltd., 8201 Schaffhausen/Switzerland  
www.gfps.com



**1x** ZA1 = 120 Zi1 = 160  
ZA2 = 190 Zi2 = 183

EAN 7 012988 060013  
Batch No

## Measures



$M \text{ min} = 2 \times 30 \text{ mm} + \text{Fitting 1 ZA1} + \text{Fitting 2 ZA2} + \text{coupler length (d63 ELGEF Plus electrofusion coupler)}$

$M \text{ min} = 60 \text{ mm} + 120 \text{ mm} + 190 \text{ mm} + (1 \times 96 \text{ mm}) = 466 \text{ mm}$

### Cutting length calculation – Cementing

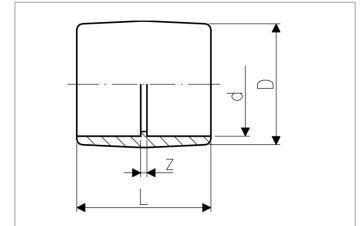
#### Relevant information before the calculation:

- **M dimension between axes:** This dimension either has to be measured on-site or taken from the isometric drawing.
- **Case assessment:** The case assessment is required to ensure that the correct Z-dimensions are considered for the calculation.
- **Z-dimension of double containment item:** The Z-dimensions must be gathered from the bag labels.

**i** To ensure a proper calculation, the use of the pipe layout chart 30° sheet is recommended.

#### Calculation with case example (short-pipe-long):

- **Yi** cutting length of inner pipe = M – Fitting 1 Zi1 – Fitting 2 Zi2 – (Z-Value z x number of pipe-to-pipe connections)  
The Z-dimensions have to be adapted in line with the isometry (case)!
- **YA** cutting length of containment pipe = M – Fitting 1 ZA1 – Fitting 2 ZA2 – (30mm x quantity of snap rings)  
The Z-dimensions have to be adapted in line with the isometry (case)!



**i** It is essential to consider the width of the ridge ("z") of the sockets for pipe-to-pipe connections (see illustration).

#### Example:

**Fitting labels** **Case assessment: Long side – Pipe – Short side**

**+GF+**  
**CONTAIN-IT Plus**  
 Winkel 90°  
 Coude 90°  
 Elbow 90°  
 Gomito a 90°

---

**721104108**

---

**d32-d63**

---

**PVC-U**

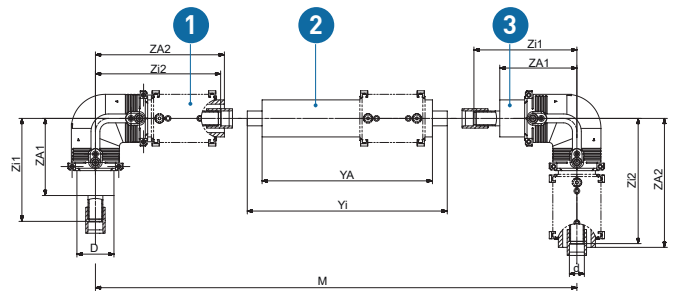
---

PN16/16

---

Georg Fischer Piping Systems Ltd., 8201 Schaffhausen/Schweiz  
 www.gfps.com

**1x** ZA1 = 120 Zi1 = 160  
 ZA2 = 190 Zi2 = 183



Case assessment: Long – Pipe – Short

M = Measure between axes = 1000 mm

Yi = M - Fitting 1 Zi1 - Fitting 2 Zi2 - (Z-Value x number of pipe-to-pipe connections) = (1000 - 160 - 183) - (3 x 0) x mm = 657 mm

YA = M - Fitting 1 ZA1 - Fitting 2 ZA2 - 30mm x 2 = (1000 - 120 - 190 - 30 x 2) x mm = 630 mm

- 1** Long side
- 2** Pipe
- 3** Short side

### Cutting length calculation – Socket fusion

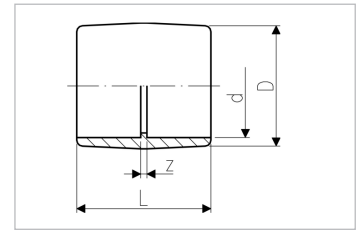
#### Relevant information before the calculation:

- **M dimensions between axes:** This dimension either has to be measured on-site or taken from the isometric drawing.
- **Case assessment:** The case assessment is required to ensure that the correct Z-dimensions are considered for the calculation.
- **Z-dimension of double containment item:** The Z-dimensions must be gathered from the bag labels.

**i** To ensure a clear calculation, the use of the 30° allowance sheet containing all the required information is recommended.

**Calculation with case example (short-pipe-long):**

- **Yi** cutting length of inner pipe = M – Fitting 1 Zi1 – Fitting 2 Zi2 – (Z-Value x number of pipe-to-pipe connections)  
The Z-dimensions have to be adapted in line with the isometry (case)!
- **YA** cutting length of containment pipe = M – Fitting 1 ZA1 – Fitting 2 ZA2 – (30mm x quantity of snap rings)  
The Z-dimensions have to be adapted in line with the isometry (case)!



**i** It is essential to consider the Z-Value of the sockets for pipe-to-pipe connections, see illustration.

**Example:**

**Fitting labels**

**Case assessment: Long side – Pipe – Short side**

**+GF+**  
**CONTAIN-IT Plus**  
 Winkel 90°  
 Coude 90°  
 Elbow 90°  
 Gomito a 90°

---

**727104108**

---

**d32-d63**

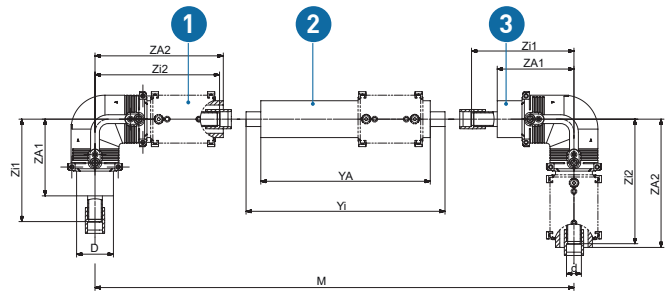
---

**PP-H**  
 PN10/16 PE

---

Georg Fischer Piping Systems Ltd., 8201 Schaffhausen/Switzerland [www.gfps.com](http://www.gfps.com)

1x    ZA1 = 120 Zi1 = 156  
 ZA2 = 190 Zi2 = 185



Case: Long – Pipe – Short

M = Measure between axes = 1000 mm

**Yi** = M – Fitting 1 Zi1 – Fitting 2 Zi2 – (Z-Value x number of pipe-to-pipe connections)

= (1000 – 156 – 185 – 3 x 0) x mm = 659mm

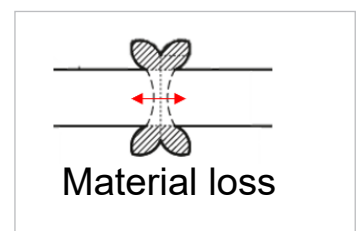
**YA** = M - Fitting 1 ZA1 - Fitting 2 ZA2 - 30mm x 2 = (1000 – 120 – 190 – 30 x 2) x mm = 630 mm

- 1** Long side
- 2** Pipe
- 3** Short side

**Cutting length calculation – conventional butt fusion**

**Relevant information before the calculation:**

- **M dimensions between axes:** This dimension either has to be measured on-site or taken from the isometric drawing.
- **Case assessment:** The case assessment is required to ensure that the correct Z-dimensions are considered for the calculation.
- **Z-dimensions of double containment item:** The Z-dimensions must be gathered from the bag labels.
- **Material loss, planing loss and welding loss:** Test welds per installer are suitable for determining the material loss, since the material loss depends on the variable planing dimension.



**i** To ensure a proper calculation, the use of the pipe layout chart 30° is recommended.

**Calculation with case example (Short-Pipe-Long):**

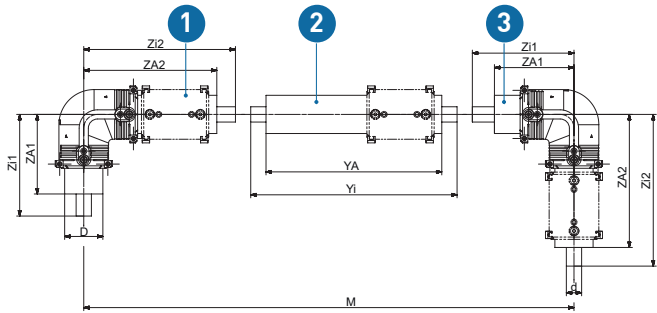
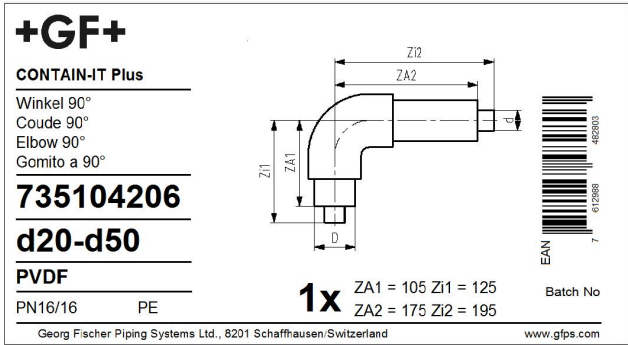
- **Yi** cutting length of inner pipe = M – Fitting 1 Zi1 – Fitting 2 Zi2 + (material loss x (number of inner pipe connections))
- **YA** cutting length of containment pipe = M – Fitting 1 ZA1 – Fitting 2 ZA2 – (30mm x quantity of snap rings)

**i** The nozzles of the double containment components are already shipped from the factory somewhat longer and take into account approximately the material losses.

**i** Material losses must be taken into account for pipe-to-pipe connections.

**Example:**

**Fitting labels** **Case assessment: Long side – Pipe – Short side**



Case: Long – Pipe – Short , material PVDF

M = Measure between axes = 1000 mm

Material loss of test weld = 4.5 mm

**Yi** = M - Fitting 1 Zi1 - Fitting 2 Zi2 + (material loss x ( number of inner pipe connections)) = (1000 – 125 – 195 + 2 x 4.5) x mm = 689 mm

**YA** = M - Fitting 1 ZA1 - Fitting 2 ZA2 - (30mm x number of snap rings) = (1000 – 105 – 175 – 30 x 2) x mm = 660 mm

- 1** Long side
- 2** Pipe
- 3** Short side

**Cutting length calculation – infrared fusion**

**Relevant information before the calculation:**

- **M dimensions between axes:** This dimension either has to be measured on-site or taken from the isometric drawing.
- **Case assessment:** The case assessment is required to ensure that the correct Z-dimensions are considered for the calculation.
- **Z-dimension of double containment item:** The Z-dimensions must be gathered from the bag labels.
- **Material losses, planing loss and welding loss:** With IR fusion, the material losses depend on the machine, material and dimensions. The expected material losses are shown in the tables below.



## Infrared fusion machine IR-63 Plus - material losses



d (mm)	PE100 (SDR11) (mm)	PP-H (SDR11) (mm)	PVDF (mm)	ECTFE (mm)	PFA (mm)
20	5.5	5.0	4.5	4.5	4.5
25	5.5	5.0	4.5	4.5	4.5
32	5.5	5.0	4.5	4.5	4.5
40	6.0	5.0	4.5	4.5	4.5

## Infrared fusion IR-110 Plus - material losses



d (mm)	PE100 (SDR11) (mm)	PP-H (SDR11) (mm)	PVDF (mm)	ECTFE (mm)	PFA (mm)
20	5.5	5.0	4.5	5.0	4.5
25	5.5	5.0	4.5	5.0	4.5
32	5.5	5.0	4.5	5.0	4.5
40	5.5	5.0	4.5	5.0	4.5
50	5.5	5.0	5.0	5.0	4.5

## Infrared fusion IR-225 Plus - material losses



d (mm)	PE100 (SDR11) (mm)	PP-H (SDR11) (mm)	PVDF (mm)
63	6.5	6.0	4.5
75	6.5	6.0	4.5
90	6.5	6.0	5.0
110	6.5	6.0	5.0
125	6.5	6.0	5.0

**i** To ensure a proper calculation, the use of the pipe layout chart 30° sheet is recommended.

## Calculation with case example (Short-Pipe-Long):

## Cutting length calculation – infrared fusion

- **Yi** cutting length of inner pipe = M – Fitting 1 Zi1 – Fitting 2 Zi2 + (material loss x (number of inner pipe connections))
- **YA** cutting length of containment pipe = M – Fitting 1 ZA1 – Fitting 2 ZA2 – (30mm x number of snap rings)

**i** Material losses must be taken into account for pipe-to-pipe connections.

Example:

Fitting labels

Case assessment: Long side – Pipe – Short side

**+GF+**

**CONTAIN-IT Plus**

Winkel 90°  
Coude 90°  
Elbow 90°  
Gomito a 90°

---

**737104206**

**d20-d50**

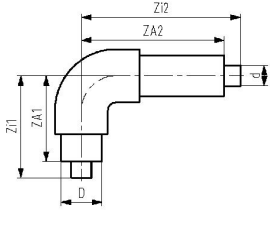
---

**ECTFE**

PN10 PE

---

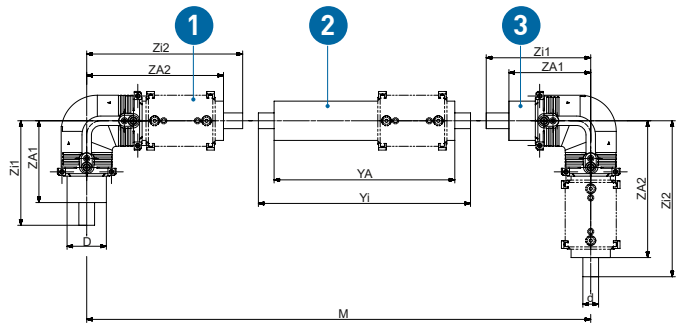
Georg Fischer Piping Systems Ltd., 8201 Schaffhausen/Switzerland [www.gfps.com](http://www.gfps.com)



**1x** ZA1 = 105 ZI1 = 125  
ZA2 = 175 ZI2 = 195

Batch No

EAN 4 617186 737104



Case: Long – Pipe – Short , material ECTFE

M = Measures between axes = 1000 mm

$Y_i = M - \text{Fitting 1 } Z_{i1} - \text{Fitting 2 } Z_{i2} + (\text{material loss } \times (\text{number of inner pipe connections}))$

$= 1000 - 125 - 195 + (2 \times 4.5) \times \text{mm}$

$= 689 \text{ mm}$

$Y_A = M - \text{Fitting 1 } Z_{A1} - \text{Fitting 2 } Z_{A2} - 30\text{mm} \times 2 - (30\text{mm} \times \text{number of snap rings}) = (1000 - 105 - 175 - (30 \times 2)) \times \text{mm} = 660 \text{ mm}$

- 1 Long side
- 2 Pipe
- 3 Short side

**i** The spigots of the double containment components are supplied slightly longer and more or less consider the material losses of a mandatory weld (welder-dependent)

### 1.4.5 Preparations for inner piping system and containment piping system

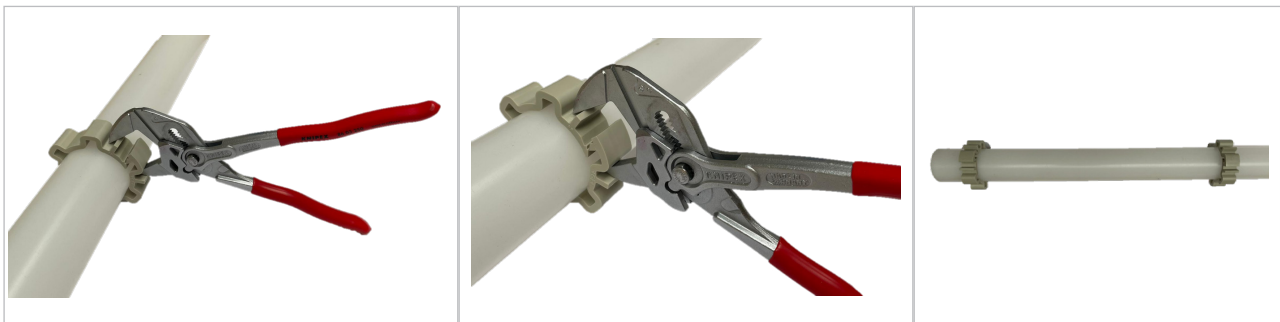
#### Cutting the pipes

After calculating the cutting lengths, the inner and containment pipes must be cutted precisely and in a right angle according to the calculation. In addition, the pipes must be cleaned from coarse dirt to prepare them for the fusion process. It is recommended to number the cuttled pipes.



#### Spacers on inner pipe

The spacers must be carefully mounted/clipped onto the inner pipe by hand or with a pipe wrench. The spacer distances are specified in the results of the static evidence and stress calculation provided by Georg Fischer Piping Systems.



### Variant 1: Preparing PE containment pipe

The PE containment pipe must be peeled with a rotary peeler. The peeling length on the pipe must be determined according to the type of the ELGEF Plus electrofusion coupler, half or full socket length. New fittings, which are taken out of the packaging just before processing do not have to be peeled. The pipe ends should be cleaned/degreased with TANGIT KS Cleaner and absorbent, clean paper.



d (mm)	Min. chip thickness (mm)	Permissible minimum pipe outer diameter (mm)
50	0.20	49.5
63	0.20	62.5
75	0.20	74.4
90	0.20	89.4
110	0.20	109.4
125	0.20	124.4
140	0.20	139.4
160	0.20	159.4
180	0.20	179.4
200	0.20	199.4
225	0.20	224.4
280	0.20	279.3

### Variant 2: Preparing PVC-U containment pipe

The PVC-U (transparent) containment pipe must be chamfered and deburred for pipe-to-pipe connections. This allows the pipe to be easily centered in the socket and does not shift the adhesive. Chamfering and deburring has also proven effective for pipe-fitting connections for easy sliding on of the EPDM sleeve and prevents surface damage to the sealing material.

	d (mm)	b (mm)
	6-16	1-2
	10-55	2-3
	63-160	3-6

**Overview**

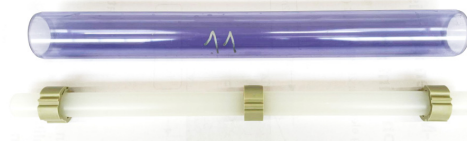
Variant 1: PE Containment pipe	Variant 2: PVC-U (transparent) Containment pipe
--------------------------------	---

1. The cleaned containment pipe has a different length compared to the inner pipe (gray/white, with clipped-on spacers).

Peeled and cleaned welding surfaces



Chamfered and deburred pipe ends



2. The inner pipe is pushed into the containment pipe. Thanks to the spacer, the inner pipe is centered in the outer pipe.

3. ELGEF Plus couplers or EPDM couplers must be mounted on the containment pipes or the long fitting sides before the connection of the inner pipe.

Immediately before use, remove the ELGEF Plus electrofusion coupler from the bag without contaminating it. The center stop must be removed and the coupler must be pushed completely over the peeled pipe end. Especially in the case of outdoor installations, a PE stretch foil is strongly recommended to protect the welding areas from contamination or moisture.

The pipe ends and long fitting sides must be cleaned/degreased with TANGIT KS Cleaner and absorbent paper. Finally the EPDM sleeves must be pushed on it.



In the next step, the inner pipe connection can be realized.

### 1.4.6 Connection the inner pipe

The welding directives of the DVS (German Welding Society) and the cementing instructions of the KRV (Kunststoffrohrverband e.V.) are applicable without restriction to both the containment and inner pipe connections. The following chapter deals with the special features of the double containment pipe system. Detailed information on the connection technology of the inner- and containment pipes are provided in the relevant chapters of the Planning Fundamentals.

#### Overview of the inner pipe connection technologies

Dimension (mm)	Inner pipe				Socket fusion			Butt welding				IR fusion
	Socket cementing				PP-H	PE80	PVDF	PP-H	PE100	PVDF	PVDF	ECTFE
	Tangit	Dytex	Tangit	Dytex	SDR11	SDR11	SDR21	SDR11	SDR11	SDR21	SDR33	SDR21
d20/D50	✓	✓	✓	✓	✓	✓	✓	•	•	•		✓
d25/D50	✓	✓	✓	✓	✓	✓	✓	•	•	•		✓
d32/D63	✓	✓	✓	✓	✓	✓	✓	•	•	•		✓
d40/D75	✓	✓	✓	✓	✓	✓	✓	•	•	•		✓
d50/D90	✓	✓	✓	✓	✓	✓	✓	•	•	•		✓
d63/D110	✓	✓	✓	✓	✓	✓	✓	•	•	•		✓
d75/D125	✓	✓	✓	✓	✓	✓		•	•	•		✓
d90/D140	✓	✓	✓	✓	✓	✓		•	•	•		✓
d110/D160	✓	✓	✓	✓	✓	✓		•	•	•		✓
d125/D180	✓							✓	✓		✓	
d140/D200	✓							✓	✓		✓	
d160/D225	✓							✓	✓		✓	
d200/D280	✓							✓	✓		✓	
d225/D315	✓							✓	✓		✓	

- Compatible with butt and infrared fusion (IR)

### 1.4.7 Inner pipe – Socket cementing

Detailed information on the connection technology for the inner pipe is provided in the Planning Fundamentals and/or the cementing instructions (KRV) and are valid without any limitation.

#### Fitting design

Since the axial dimension (Z-dimension) is the same for 90° angle, 45° angle and T-piece, only the 90° angles are listed here. However, this only applies to fittings made of the same material and using the same jointing method.

Double containment fittings are provided with a socket on the long fitting side at the factory. This allows direct "fitting to fitting" connections with the shortest possible axial dimension, ("fitting side long" directly to "fitting side short"). The Z-dimensions are noted on the bag label, (see illustration).

#### Fittings - PVC-U/PVC-C (cementing)

**+GF+**

**CONTAIN-IT Plus**

Winkel 90°  
Coude 90°  
Elbow 90°  
Gomito a 90°

---

**721104106**

---

**d20-d50**

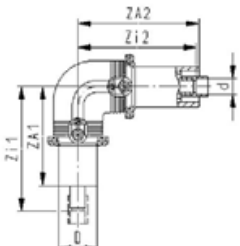
---

**PVC-U**


PN16/16

---


Georg Fischer Piping Systems Ltd., 8201 Schaffhausen-Switzerland      www.gfps.com



**1x**    ZA1 = 105    Zi1 = 139  
              ZA2 = 175    Zi2 = 174



EAN    7 612988 004528    Batch No



**i** ELGEF Plus sockets and EPDM couplers must be ordered separately.

#### Final inspection before cementing

ELGEF Plus sockets or EPDM couplers must be pushed onto the containment pipe ends or the long fitting sides before the inner pipe connection is done.

### 1.4.8 Inner pipe – Socket fusion

Due to the fact that the axis dimensions (Z-dimensions) are the same for angle 90°, angle 45° and T-piece, only the 90° angles are listed here. This applies only to fittings made of the same material and the same connection method.

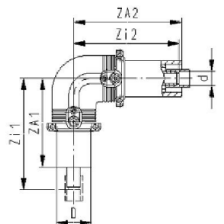
#### Fitting design

Since the axial dimension (Z-dimension) is the same for 90° angle, 45° angle and T-piece, only the 90° angles are listed here. However, this only applies to fittings made of the same material and using the same jointing method.

Double containment fittings are provided with a socket on the long fitting side at the factory. This allows direct "fitting to fitting" connections with the shortest possible axial dimension, "fitting side long" directly to "fitting side short". The Z-dimensions are noted on the bag label (see illustration).

#### Fittings - PP-H (Socket fusion)

<b>+GF+</b>	
CONTAIN-IT Plus	
Winkel 90° Coude 90° Elbow 90° Gomito a 90°	
<b>727104108</b>	
<b>d32-d63</b>	
PP-H	
PN10/16	PE
Georg Fischer Piping Systems Ltd., 8201 Schaffhausen Switzerland	
www.gfps.com	



**1x** ZA1 = 120 ZI1 = 156  
ZA2 = 190 ZI2 = 185

EAN 7 672888 001082  
Batch No



**i** ELGEF Plus sockets and EPDM couplers must be ordered separately.

#### Final inspection before welding

ELGEF Plus couplers or EPDM couplers must be pushed onto the containment pipe ends or the long fitting sides before the inner pipe connection is done.

### Fusion machines – Overview

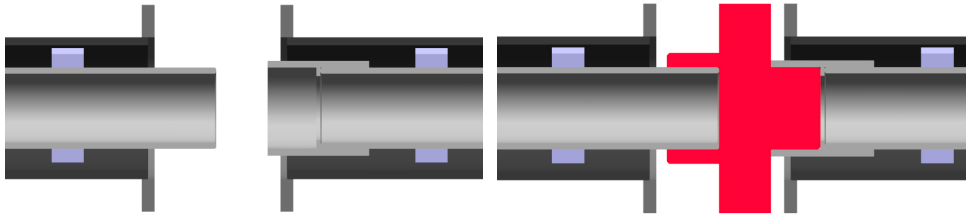
Dimension	SG 160		
-----------	--------	--	--



Inner pipe	Containment pipe	Fitting – Fitting	Fitting – Pipe
d20	D50	✓ (*)	✓
d25	D50	✓ (*)	✓
d32	D63	✓ (*)	✓
d40	D75	✓ (*)	✓
d50	D90	✓ (*)	✓
d63	D110	✓ (*)	✓
d75	D125	✓ (*)	✓
d90	D140	✓ (*)	✓
d110	D160	✓ (*)	✓ (*)
d125	D180		
d140	D200		
d160	D225		
d200	D280		
d225	D315		
*Notes:		Adjusting the machine stop (pipe dependent)!	Unscrew the sheet metal of the prism!



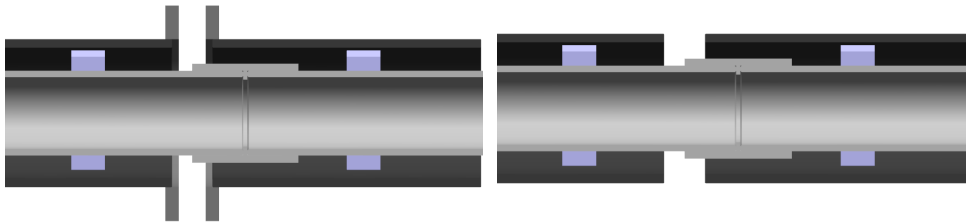
## Socket fusion – Procedure

**1. Clamping:**

Clamping collars shell inner pipe and/or socket

**2. Standard Heating element socket fusion:**

Inner pipe and socket are heated up simultaneously

**3. Fusion:**

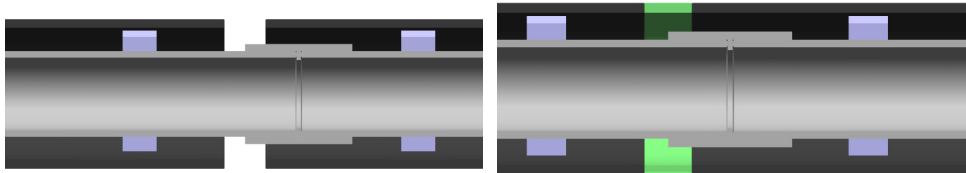
Inner pipe and socket are overlapped together

**4. Cooling time and unclamping:**

Waiting for cooling time, unclamping, control gap remains in outer tube (30mm)

## Next steps

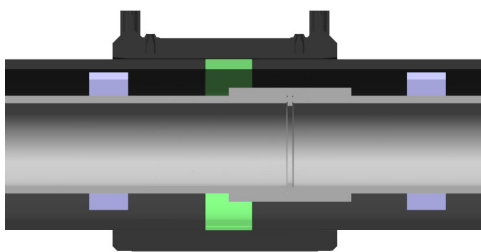
For a detailed description, see chapters "Pressure test and visual inspection of the inner pipe", "Sealing the containment pipe" and "Instructions for internal and external pressure test"

**5. Visual inspection of inner pipe connection:**

Visual inspection and evaluation of the inner pipe connection, followed by a pressure test

**6. Snap ring in control gap:**

Place a snap ring (30 mm) between the ends of the containment pipe

**7. Sealing containment pipe and pressure test:**

ELGEF Plus electrofusion coupler creates a pressure-resistant seal on the containment pipe or the EPDM coupler provides splash protection, followed by a pressure test of the containment pipe

### 1.4.9 Inner pipe – conventional butt welding

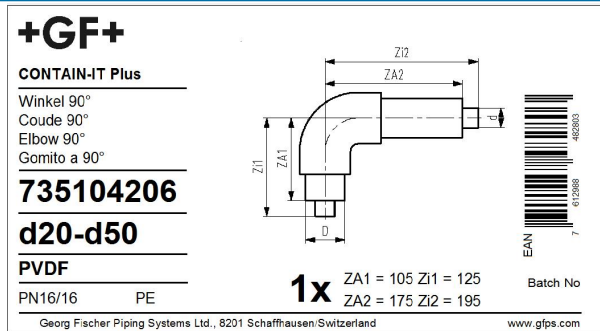
Detailed information on the connection technology for the inner pipe is provided in the Planning Fundamentals and/or the cementing instructions issued by the DVS and are valid without any limitation.

#### Fitting design

From the central axis to the leading edge/spigot end, all fitting types have the same Z-dimensions (i.e. same axis mass). This only applies to fittings made of the same material and using the same joining method!

The Z-dimensions are noted on the bag label, see illustration.

#### Fitting - PVDF (Butt Fusion)













**i** ELGEF Plus sockets and EPDM couplers must be ordered separately.

#### Final inspection before welding

ELGEF Plus couplers or EPDM couplers must be pushed onto the containment pipe ends or the long fitting sides before the inner pipe connection is done.

## Welding machines – Overview

Dimension		SG 160		TM 160		TM 250		TM 315 RU 315	
									
Inner pipe	Containment pipe	Fitting – Fitting	Fitting – Pipe	Fitting – Fitting	Fitting – Pipe	Fitting – Fitting	Fitting – Pipe	Fitting – Fitting	Fitting – Pipe
d20	D50								
d25	D50								
d32	D63	✓	✓						
d40	D75	✓	✓	- (*)	✓ (*)				
d50	D90	✓	✓	- (*)	✓ (*)				
d63	D110	✓	✓	- (*)	✓ (*)				
d75	D125	✓	✓	- (*)	✓ (*)	- (*)	✓ (*)		
d90	D140	✓	✓	- (*)	✓ (*)	- (*)	✓ (*)	- (*)	✓ (*)
d110	D160	✓	✓			- (*)	✓ (*)	- (*)	✓ (*)
d125	D180					- (*)	✓ (*)	- (*)	✓ (*)
d140	D200					- (*)	✓ (*)	- (*)	✓ (*)
d160	D225							- (*)	✓ (*)
d200	D280							- (*)	✓ (*)
d225	D315								
*Notes:			Rake from machine	Finger protection!	Rake off machine!	Finger protection	Rake off machine!	Finger protection!	

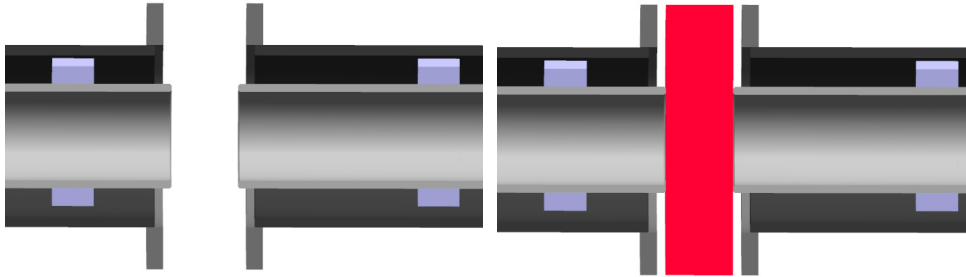
Dimension		GF 400		IM 160		IM 315		MC 110	
									
Inner pipe	Containment pipe	Fitting – Fitting	Fitting – Pipe	Fitting – Fitting	Fitting – Pipe	Fitting – Fitting	Fitting – Pipe	Fitting – Fitting	Fitting – Pipe
d20	D50		Tested Q2/22					✓ (*)	✓ (*)
d25	D50		Tested Q2/22					✓ (*)	✓ (*)
d32	D63		Tested Q2/22	✓	✓			✓	✓
d40	D75		Tested Q2/22	✓	✓			✓	✓
d50	D90		Tested Q2/22	✓	✓			✓	✓
d63	D110		Tested Q2/22	✓	✓				✓
d75	D125		Tested Q2/22	✓	✓				
d90	D140		Tested Q2/22	✓	✓	✓	✓		
d110	D160		Tested Q2/22	✓	✓	✓	✓		
d125	D180		Tested Q2/22			✓	✓		
d140	D200		Tested Q2/22			✓	✓		
d160	D225		Tested Q2/22			✓	✓		
d200	D280		Tested Q2/22			✓	✓		
d225	D315		Tested Q2/22			✓	✓		
*Notes:		Finger protection!						IR Plus preferred due to weld bead size	

Dimension	MD 160
-----------	--------



Inner pipe	Containment pipe	Fitting – Fitting	Fitting – Pipe
d20	D50		
d25	D50		
d32	D63		
d40	D75		
d50	D90	✓	✓
d63	D110	✓	✓
d75	D125	✓	✓
d90	D140	✓	✓
d110	D160	✓	✓
d125	D180		
d140	D200		
d160	D225		
d200	D280		
d225	D315		
*Notes:			

**Conventional butt weld – procedure**

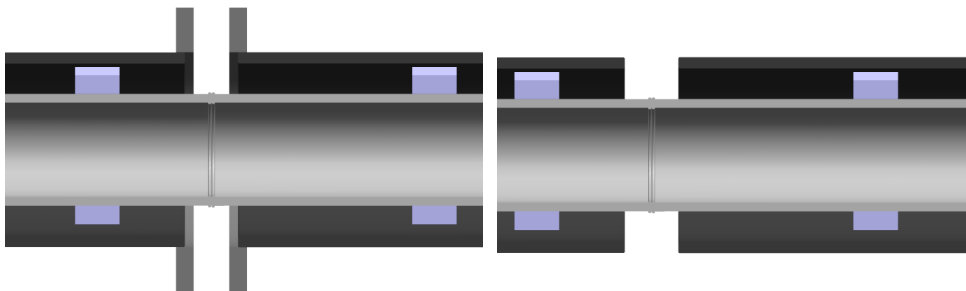


**1. Clamping:**

Clamping collars hold inner pipe and/or internal fitting

**2. Heating element butt welding:**

Inner pipe and fitting are heated up at the same time



**3. Joining:**

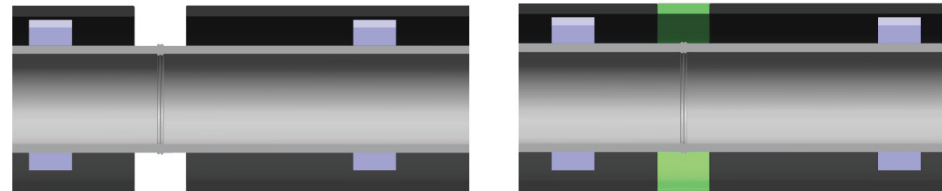
Inner pipe and fitting are welded together

**4. Cooling down time and unclamping:**

Wait for the cooling down time to end before unclamping, safety gap remains in containment pipe (30 mm)

**Next steps**

For a detailed description, see chapters "Pressure test and visual inspection of the inner pipe", "Sealing the containment pipe" and "Instructions for internal and external pressure test"

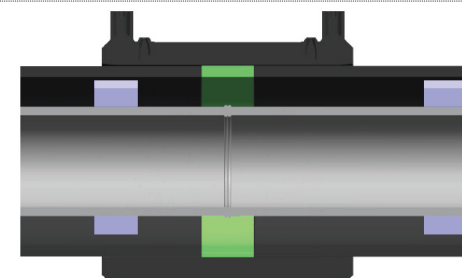


**5. Visual inspection of inner pipe connection:**

Visual inspection and assessment of the inner pipe connection, followed by a pressure test

**6. Snap ring in safety gap:**

Place a snap ring (30 mm) between the ends of the containment pipe



**7. Sealing containment pipe and pressure test:**

ELGEF Plus electrofusion coupler creates a pressure-resistant seal on the containment pipe or the EPDM coupler provides splash protection, followed by a pressure test of the containment pipe

### 1.4.10 Inner pipe – infrared butt fusion

Detailed information on the connection technology for the inner pipe is provided in the Planning Fundamentals and/or the cementing instructions issued by the DVS and are valid without any limitation.

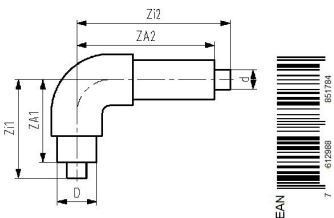
#### Fitting design

From the center axis to the front edge/spigot end, all fitting types have the same Z-dimensions (i.e. same dimension between axes). This applies only to fittings made from the same material using the same jointing method.

The Z-dimensions are noted on the bag label (see figure).

#### Fitting - ECTFE (IR-Fusion)

<b>+GF+</b>	
<b>CONTAIN-IT Plus</b>	
Winkel 90° Coude 90° Elbow 90° Gomito a 90°	
<b>737104206</b>	
<b>d20-d50</b>	
<b>ECTFE</b>	
PN10	PE
<b>1x</b>	
Z <sub>A1</sub> = 105    Z <sub>I1</sub> = 125 Z <sub>A2</sub> = 175    Z <sub>I2</sub> = 195	
Georg Fischer Piping Systems Ltd., 8201 Schaffhausen Switzerland    www.gfps.com	








**i** ELGEF Plus sockets and EPDM couplers must be ordered separately.

#### Final inspection before welding

Before the inner pipe connection is made, ELGEF Plus couplers or EPDM couplers must be pushed onto the containment pipe ends or onto the long fitting sides.

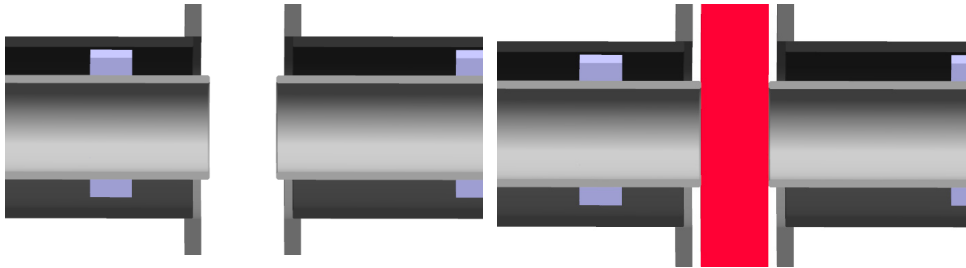
## Fusion machines - overview

Dimension		IR-63 Plus			IR-110 Plus			IR-225 Plus		
										
Inner pipe	Containment pipe	Fitting – fitting	Fitting – pipe	Special half shell	Fitting – fitting	Fitting – pipe	Special half shell	Fitting – fitting	Fitting – pipe	Special half shell
d20	D50	✓	✓	790 131 090	✓	✓	790 132 190			
d25	D50	✓	✓	790 131 091	✓	✓	790 132 191			
d32	D63	✓	✓	790 131 092	✓	✓	790 132 192			
d40	D75	✓	✓	790 131 093	✓	✓	790 132 193			
d50	D90				✓	✓	790 132 194			
d63	D110							✓	✓	790 133 090
d75	D125							✓	✓	790 133 091
d90	D140							✓	✓	790 133 092
d110	D160							✓	✓	790 133 093
d125	D180							✓	✓	790 133 094
d140	D200									
d160	D225									
d200	D280									
d225	D315									

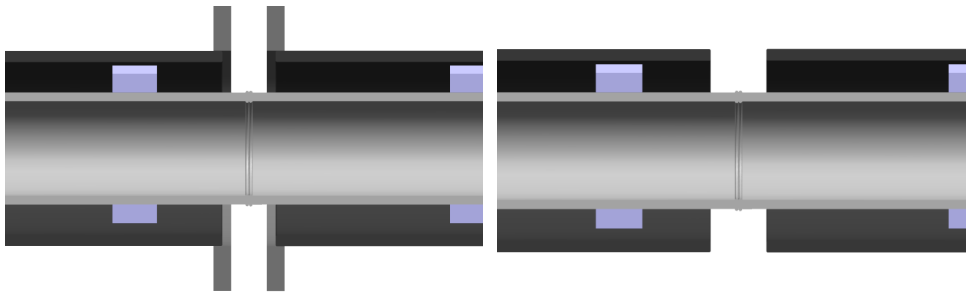
**i** Automated infrared fusion machines cannot be used for the CONTAIN-IT Plus system.

**i** If standard half shells are used, a gap of circa 25 mm instead of the required circa 30 mm appears in the containment pipe after welding.  
Consequently, Georg Fischer Piping Systems recommends the use of CONTAIN-IT Plus special half shells (4x per dimension).  
Note: Although it is possible in principle to achieve the required gap width of 30 mm using standard half shells, particular caution is required.

**Infrared butt weld – procedure**

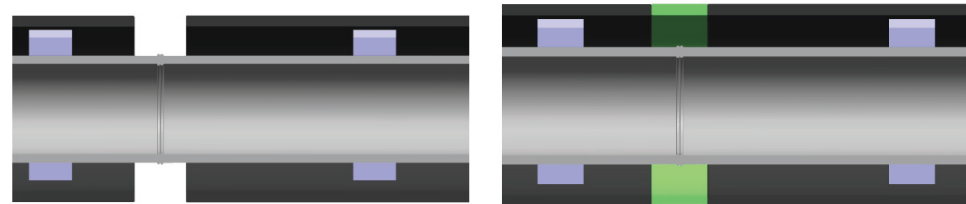


- 1. Clamping:**  
Clamping collars hold inner pipe and/or internal fitting
- 2. Heating element butt welding:**  
Pipe and fitting are heated up at the same time

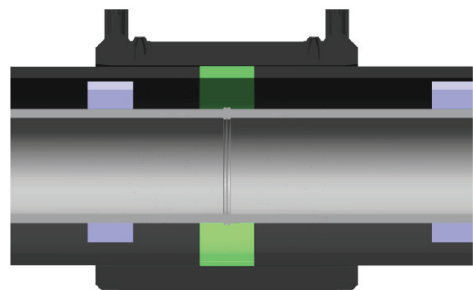


- 3. Joining:**  
Inner pipe and fitting are welded together
- 4. Cooling down time and unclamping:**  
Wait for the cooling down time to end before unclamping, safety gap remains in containment pipe [30 mm]

Next steps  
For a detailed description, see chapters "Pressure test and visual inspection of the inner pipe", "Sealing the containment pipe" and "Instructions for internal and external pressure test"



- 5. Visual inspection of inner pipe connection:**  
Visual inspection and assessment of the inner pipe connection, followed by a pressure test
- 6. Snap ring in safety gap:**  
Place a snap ring [30 mm] between the ends of the containment pipe



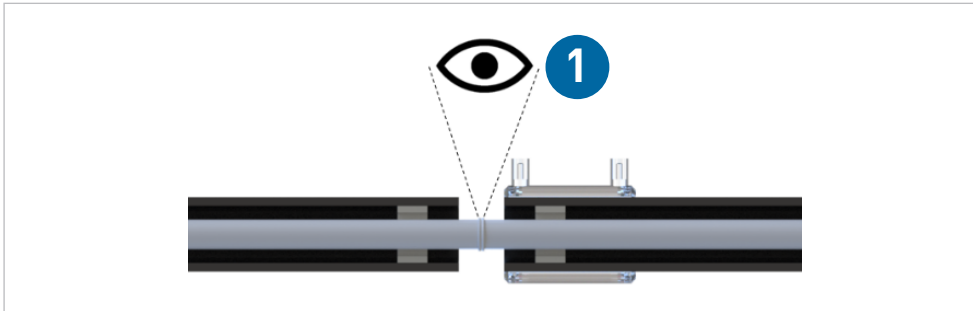
- 7. Sealing containment pipe and pressure test:**  
ELGEF Plus electrofusion coupler creates a pressure-resistant seal on the containment pipe or the EPDM coupler provides splash protection, followed by a pressure test of the containment pipe



### 1.4.11 Visual inspection of the inner pipe and pressure test

#### Visual inspection of the inner pipe

Thanks to the innovative connection technology, a gap of 30 mm appears in the containment pipe and this allows a visual inspection and assessment of the inner pipe connection in accordance with DVS 2210-2 among others. As a result of this technology, there are no blind connections anywhere in the piping system.



- 1 Visual inspection and pressure test of the inner pipe!

#### Pressure test

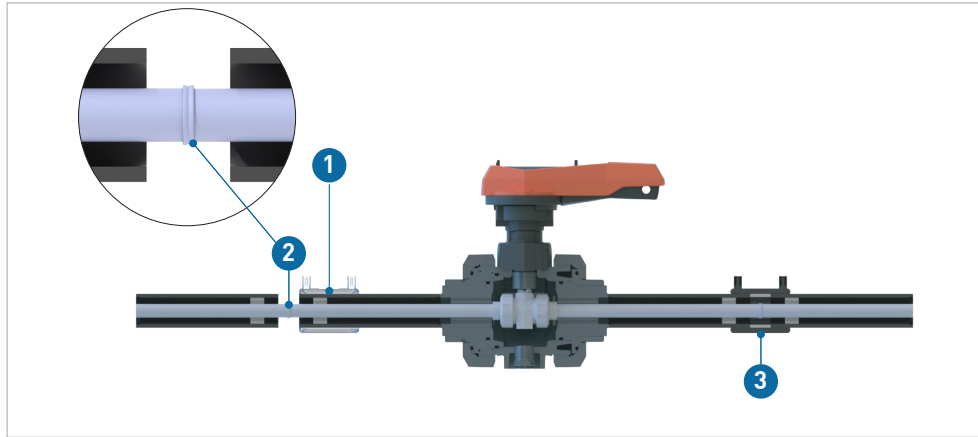
The pressure test of the inner pipe requires the pipe or pipe sections to be operational. A section-by-section pressure test is the suitable method, depending on the accessibility and length of the pipe (in-situ welding, etc.). The test pressure load ought to furnish experimental proof of operational safety. The precise procedure for the internal pressure test is described in the chapter "Pressure test of inner pipe".

### 1.4.12 Sealing the containment pipe

After a successful visual inspection of the inner pipe connection and a successful pressure test of the inner pipe, the containment pipe is sealed.

Various procedures are followed, depending on the containment pipe material:

- Variant 1 with PE100 System: ELGEF Plus electrofusion couplers
- Variant 2 with PVC-U (transparent) system: EPDM couplers and cementing



- 1 ELGEF electrofusion coupler; alternative: EPDM coupler
- 2 Visual inspection of inner pipe connection and pressure test of inner pipe
- 3 Centering of the snap ring in the ELGEF electrofusion coupler (gray) and closing of the containment pipe

#### Variant 1 – containment pipe material PE100

The connections in the containment pipe system are made by means of pressure-resistant and tight ELGEF Plus electrofusion couplers. The instructions for the electrofusion of sockets must be followed (clean welding zone, etc.). Holding devices are to be used wherever possible to ensure a stress-relieved welding process.



#### Calculating the insertion depth:

The 30 mm long gap in the containment pipe must be sealed by a PE snap ring prior to welding. This gap of 30 mm should be included in the calculation of the insertion depth and reduces the insertion depth by 15 mm on each side, see calculation.



$$\text{Insertion depth} = \frac{1}{2} \text{ socket length} - \text{snap ring(mm)}$$

$$\text{Snap ring width} = \frac{30 \text{ mm}}{2} = 15 \text{ mm}$$

$$\text{Insertion depth} = \frac{1}{2} \text{ socket length} - 15 \text{ mm}$$

Length: ELGEF Plus electrofusion couplers

d (mm)	SDR	L (mm)	Insertion depth $\frac{1}{2}L - 15$ (mm)	SDR pipe
50	11	88	29.0	9.0 - 11.0
63	11	96	33.0	9.0 - 17.6
75	11	110	40.0	9.0 - 17.6
90	11	125	47.5	9.0 - 17.6
110	11	145	57.5	9.0 - 17.6
125	11	156	63.0	9.0 - 17.6
140	11	166	68.0	9.0 - 17.6
160	17	180	75.0	9.0 - 26.0
180	17	192	81.0	9.0 - 26.0
200	17	206	88.0	9.0 - 26.0
225	17	225	97.5	9.0 - 26.0
280	17	252	111.0	9.0 - 26.0
315	17	267	118.5	9.0 - 26.0

## Marking

The calculated insertion depth has to be marked on both sides (pipe-pipe, pipe-fitting, etc.) two markings per connection.

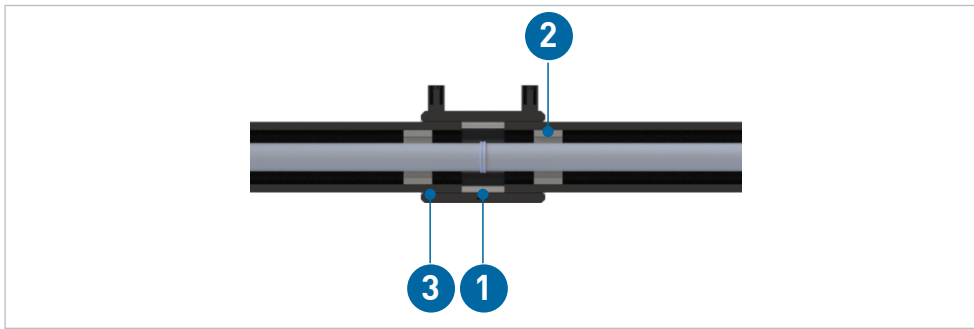
## Snap ring

Next, the snap ring has to be pushed over the 30 mm wide safety gap. The containment pipe ends must be in contact with the snap ring without any gap. Generally, distances of <2mm (up to d110) per side from snap ring to pipe ends are within tolerance. This calls for a highly precise measurement and the containment pipe to be cut at right angles.



## Welding process

The PE stretch foil has to be removed from the ELGEF Plus socket immediately before the containment pipe is sealed. The ELGEF Plus socket must then be pulled over the safety gap/ snap ring and closed flush with the markings on both sides. If the electrofusion coupler is pulled over without a snap ring, the containment pipe can move and a reliable sealing is then no longer guaranteed. The snap ring must be located in the middle of the ELGEF Plus socket (cold zone).



- 1 Snap ring
- 2 Spacer
- 3 ELGEF electrofusion coupler; alternative: EPDM coupler

### Welding machine and connection

Next, stress-relieved welding must be carried out using a MSA welding tool and a holding device.

#### Snap ring 30 mm

#### MSA welding tool for ELGEF Plus socket with GPS function



### Variant 2 - containment pipe material PVC-U (transparent)

The pipes to fitting connections in the containment pipe systems are made using non-tensile-tight and splash protection EPDM couplers (PN1). The straight pipe connections (pipe-pipe) are made as a cemented connection (Tangit).

#### EPDM coupler



#### Mechanical connections: fitting to pipe or fitting to fitting

EPDM couplers are used for the transition between PVC-U pipe (transparent) and the CONTAIN-IT Plus fitting (PE).

#### Cemented connection: pipe to pipe

Since the EPDM coupler does not offer tensile strength itself, Georg Fischer Piping Systems recommends cemented connections (PVC-U cementing sockets) for straight pipe runs. Information on the cementing process is provided in the chapter PVC-U (transparent) in the "Georg Fischer Planning Fundamentals" and is valid without any limitation.

**Calculating the insertion depth: EPDM coupler**

The 30 mm wide gap between PVC-U pipe and PE fitting needs to be sealed using a PE snap ring. The gap of 30mm must be taken into account when calculating the insertion depth and reduces the insertion depth by 15mm per side (see calculation).

$$\text{Insertion depth} = \frac{1}{2} \text{ socket length} - \text{snap ring (mm)}$$

$$\text{Snap ring width} = \frac{30 \text{ mm}}{2} = 15 \text{ mm}$$

$$\text{Insertion depth} = \frac{1}{2} \text{ socket length} - 15 \text{ mm}$$

Length: EPDM couplers

d (mm)	EPDM coupler L (mm)	Insertion depth $\frac{1}{2}L - 15$ (mm)
50	90	30
63	90	30
75	110	40
90	100	35
110	120	45
125	120	45
140	120	45
160	120	45

**Calculating the insertion depth: cementing sleeve**

$$t = \frac{d}{2} + 6 \text{ mm}$$

t = insertion depth for pipes (mm)

d = pipe external diameter (mm)

**Marking**

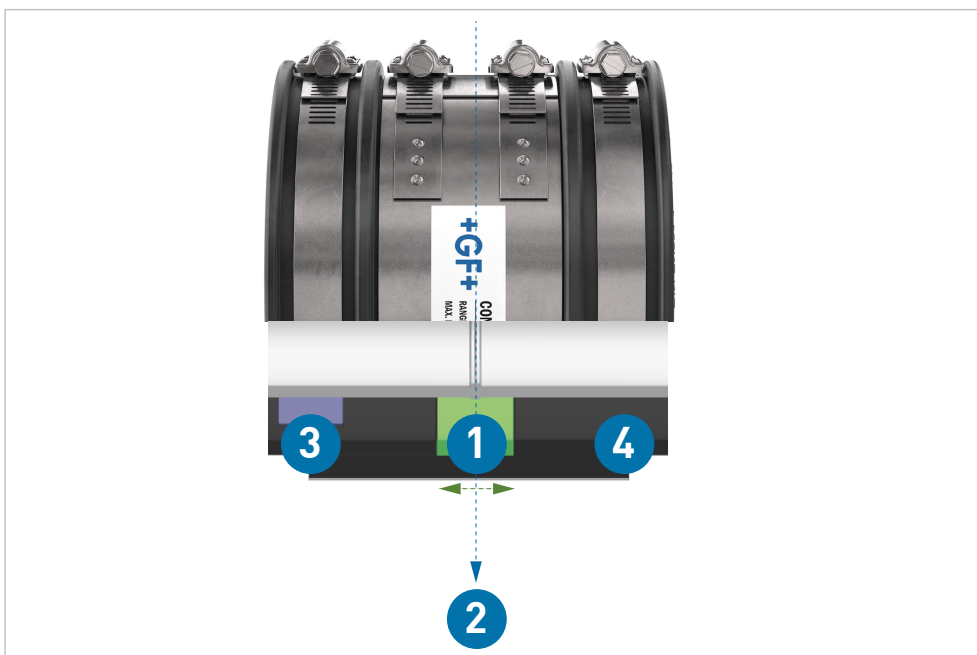
The calculated insertion depth is marked on the pipe ends, as well as on the fitting supports. Therefore, each connection has two markings.

**Snap ring**

The snap ring must be located in the middle of the EPDM coupler. The containment pipe ends must be in contact with the snap ring without any gap. Snap rings must not be used for cementing sockets.

## Connection

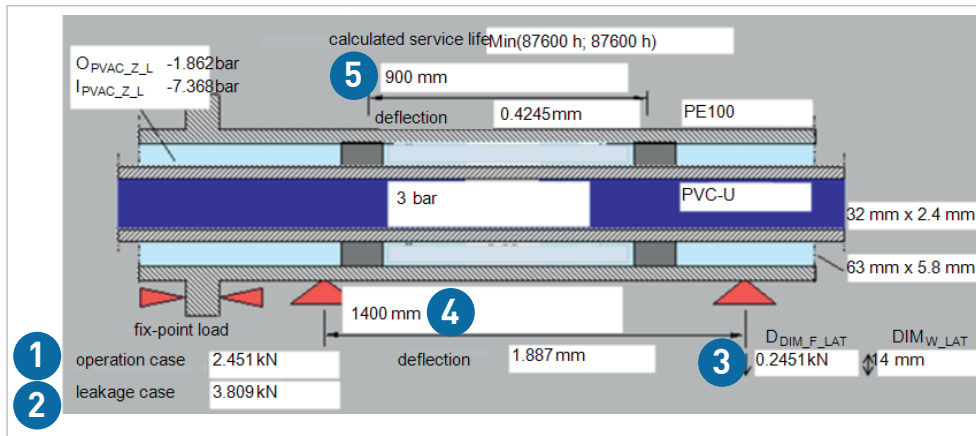
Clean the right angle cut containment pipe with a clean cloth and slide the sleeve over the safety gap/snap ring. The snap ring must be centered in the rubber sleeve. Tighten the rubber sleeve according to the torque on the label.



- 1 Snap ring: 30 mm
- 2 Inner pipe connection
- 3 PVC-U (transparent) pipe
- 4 CONTAIN-IT Plus components (PE containment pipe)

### 1.4.13 Fixed point installation

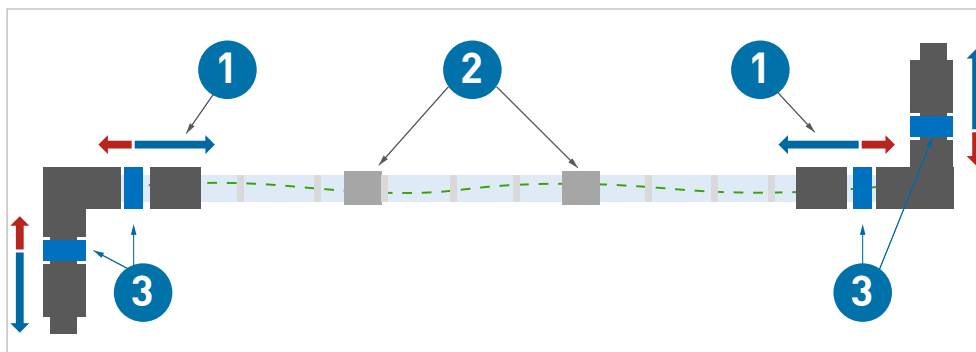
A central component of a safe installation is the result of the "Questionnaire for Static Proof and Stress Calculation". Based on this information, the steel structure (pipe clamps, guide bearing distances, etc.) must be designed.



- 1 Axial load at fixed point during operation [kN]
- 2 Axial load at fixed point in case of a leakage [kN]
- 3 Lateral load at support clamps [kN]
- 4 Support clamp distances [mm]
- 5 Spacer distances [mm]

### Installation technology data

Due to a variety of process conditions, double containment systems must be installed as a fixed point installation. To prevent thermal expansion/contraction, the containment pipe must be fixed to the steel structure at every change of direction.



- 1 Connection with EPDM coupler
- 2 Connection with cementing sockets
- 3 Fixed point to steel structure

**i** Thanks to this connection technology, no additional expansion loops or compensators are required.

### Installation example of a fixed point installation:



### 1.4.14 Leakage detection and containment

For the operation of a double containment system, devices for the control, indication or permanent monitoring of a leakage must be provided.

When dividing the interstitial space into monitoring sections by means of end fittings, it must be ensured that each section is equipped with a monitoring device.

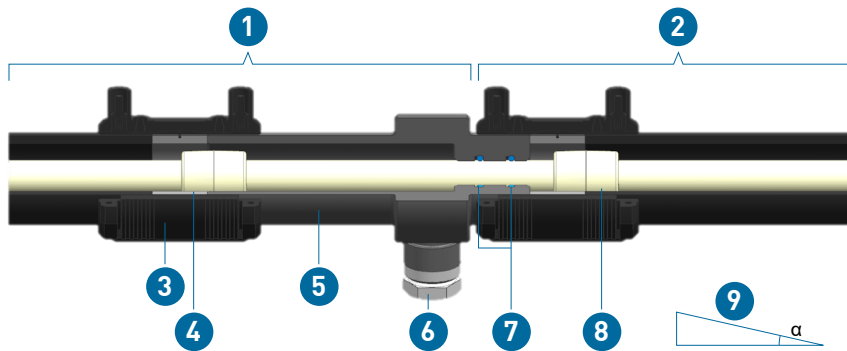
#### Leakage containment: Segmentation into monitoring sections

When dividing a large interstitial space into leakage monitoring sections using end fittings, the leaking medium can only spread in the pipe section or interstitial space between the installed end fittings (EPDM seals).

For more information on planning, see chapter "Determining leakage detection".

#### Advantages

- Fast and reliable leakage detection
- Only the identified section of the containment pipe has to be purged and cleaned
- Length of the leakage detection sections is freely selectable



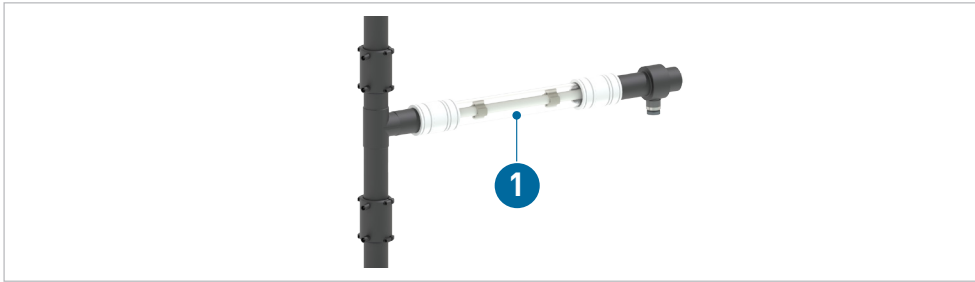
- 1 Section 1 - Monitoring section
- 2 Section 2 - Monitoring section
- 3 Electrofusion coupler
- 4 Snap ring
- 5 PE support of end fitting
- 6 Connection for leakage detection
- 7 EPDM seals (2x)
- 8 Inner pipe with socket connection
- 9 Gradient to be considered

**i** Attention! If end fittings are used to connect a low point leakage detection solution, the installation direction of the end fittings should be taken into account since there is only one connection per end fitting in an monitoring room (section). In addition, the pipe should be installed on a gradient (min. 2-3°) so that creeping leakages can be detected as quickly as possible at the lowest point of the monitoring section. Further information can be found in the chapter "Defining the leakage detection solution".



## Leakage detection solutions

### 1. Visual solution: transparent containment pipe

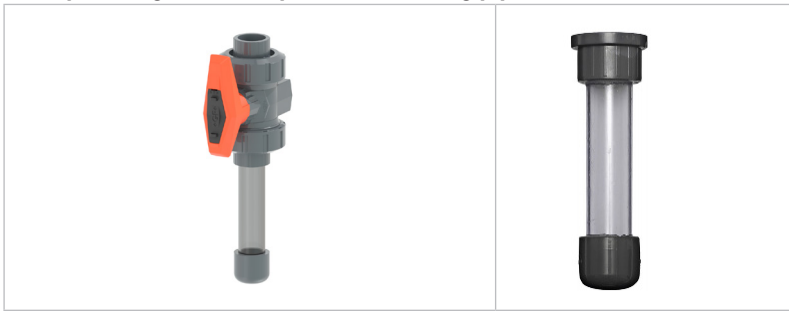


- 1 PVC-U: Transparent containment pipe

The PVC-U Transparent Splash Protection System (PN1) is an ideal solution for quick leakage localization. Due to the transparent containment pipe system, leaks on straight pipe sections can be quickly detected and repaired.

Routine checks need to be determined by the operator according to the risk assessment and are mandatory for safe operation!

### 2. Inspection glass: transparent monitoring pipe

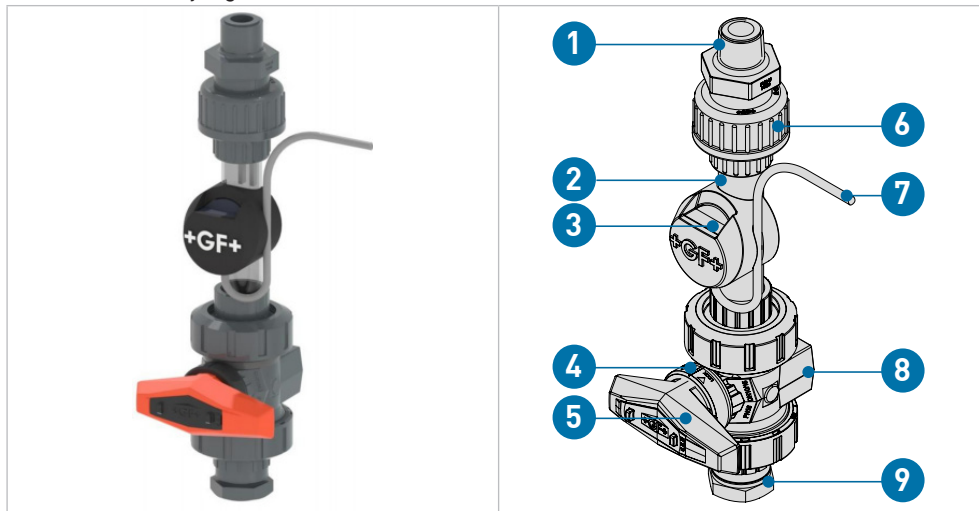


For optical leakage monitoring by means of an inspection glass, a 546 Pro ball valve (d20) with a transparent monitoring tube made of PVC-U is attached to the Rp ½" connection of the end fitting or to the connection clamp. Alternatively, the standard fittings also offer a connection option.

To ensure that even a small amount of the escaping medium covers the measuring point in the event of a leak, the inspection glass must be mounted at the lowest point of the interstitial space. Routine checks need to be determined by the operator according to the risk assessment and are mandatory for safe operation!

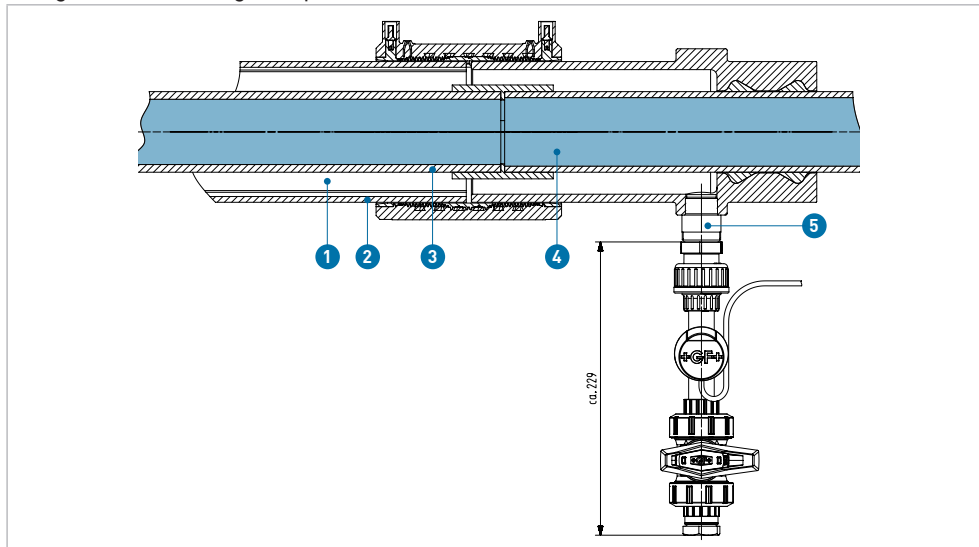
**3. Electrical solutions: capacitive sensor**

The double containment leakage detection sensor detects escaping fluids (dielectric constant  $\epsilon_r > 4.0$ ) in the monitoring room of Georg Fischer Piping Systems double containment system and emits a binary signal (PNP sensor).



- 1 Monitoring room connection R $\frac{1}{2}$ "
- 2 Transparent monitoring tube
- 3 Type 2286 sensor with LED indicator (green/yellow)
- 4 Locking mechanism
- 5 Ball valve handle (closed)
- 6 Union nut
- 7 Connection cable 5 m (3x 0.14 mm<sup>2</sup>)
- 8 Ball valve type 546 Pro
- 9 Flushing connection (Rp  $\frac{1}{2}$ " with plug (R $\frac{1}{2}$ "

To ensure that in the event of a leakage even a small amount of the escaping medium covers the measuring point, which thus leads to a change in the dielectric permittivity, the double containment detection sensor must be mounted at the lowest point of the interstitial space. Access to the interstitial space can be realized by means of the Rp  $\frac{1}{2}$ " connections of the end fittings or a connecting clamp.



Detailed information can be found in the operating instructions of the Type 2286 Leakage Sensor.

**4. Leakage detection cable**

Alternatively, a cable can be installed in the space between the inner and containment pipe, which reacts either to conductive liquids or to chemicals, and triggers an alarm. The installation of a leak detection cable requires special attention and represents an additional effort in production, planning and installation. The installation of a leak detection cable in Georg Fischer Piping Systems standard double containment fittings is not possible and requires a detailed consultation with the local Georg Fischer Piping Systems branch. Custom solutions may be possible on request.

Advantages	Disadvantages
<ul style="list-style-type: none"> <li>Leaking point is indicated with an accuracy of 1 m</li> <li>Automatic alarm triggering</li> </ul>	<ul style="list-style-type: none"> <li>Containment pipe is not monitored</li> <li>Relatively expensive</li> <li>Retrofits not possible</li> <li>Containment pipe may need to have a larger external diameter, depending on the system</li> <li>Susceptible to condensate</li> </ul>

**5. Differential pressure monitoring**

	Overpressure monitoring	Vacuum monitoring (underpressure monitoring)
<b>General</b>	In differential pressure monitoring with overpressure, the interstitial space between the inner and containment pipe is pressurized with nitrogen. In the event of a pressure drop in the interstitial space, the associated alarm switchgear indicates the leakage.	In differential pressure monitoring with vacuum, a vacuum in the range of 600 to 700 mbar is generated in the space between the inner and containment pipe with the aid of a pump. In the event of a possible leak, the vacuum pump is switched on via a vacuum switch (PU). At the same time, the alarm is triggered visually by an indicator light and acoustically by a buzzer.
<b>Advantages</b>	<ul style="list-style-type: none"> <li>Inner and containment pipe are monitored for leak-tightness</li> <li>Retrofit installation is possible</li> <li>TÜV test certificate</li> <li>Automatic alarm</li> </ul>	<ul style="list-style-type: none"> <li>No pressure loading on the inner pipe</li> <li>Inner and containment pipe are monitored for leak-tightness</li> <li>Retrofit installation is possible</li> <li>TÜV test certificate</li> <li>Automatic alarm</li> </ul>
<b>Disadvantages</b>	The injected nitrogen must have a higher pressure than the medium-carrying inner pipe, thus the inner pipe must be checked for collapse, taking into account the operating conditions (please refer to the questionnaire for the "static evidence").	<ul style="list-style-type: none"> <li>Pumping head of the vacuum pump must be at least 750 mbar with clear intake</li> <li>If the volume of the space between the inner and outer pipe is large, the vacuum pump must be dimensioned accordingly or divided into leakage sections, each with a vacuum pump (division with end fitting, refer to chapter "End fittings - Tools for leakage localization").</li> </ul>
<b>Leak locating</b>	<ul style="list-style-type: none"> <li>Containment pipe direct</li> <li>Inner pipe through exploratory borehole in the containment pipe</li> </ul>	<ul style="list-style-type: none"> <li>Containment pipe direct</li> <li>Inner pipe through exploratory borehole in the containment pipe</li> </ul>

**Suppliers of differential pressure monitoring systems**

SGB Sicherungsgerätebau GmbH  
 Hofstrasse 10  
 57076 Siegen, Germany  
 Ph.: +49 271 48 964-0  
 Fax: +49 271 48 964-6  
 www.sgb.de

## 1.5 Pressure testing the inner and containment pipe

### 1.5.1 Pressure test of the inner pipe

#### General

The internal pressure test forms the conclusion of the installation work and requires a ready-to-operate pipeline or ready-to-operate test sections. The stress caused by the test pressure is intended to provide experimental proof of operational safety. The test pressure is not based on the operating pressure, but on the internal pressure load capacity, starting from the pipe wall thickness.

The following information is based on supplement 2 to DVS 2210-1. This completely replaces the information in DVS 2210-1. The reasons for these adaptations are listed below:

- The reference value "nominal pressure (PN)" for determining the test pressure (1.5 x PN or 1.3 x PN) is increasingly being dropped and replaced by SDR.
- Possible short-term overstressing up to shortening of the service life if the pipe wall temperature  $TR = 20\text{ °C}$  is exceeded by more than  $5\text{ °C}$  during the nominal pressure-dependent internal pressure test.

Therefore, the test pressures are determined depending on the SDR and the pipe wall temperature. The value of 100 hours from the creep diagram is taken as the test stress.

#### Test parameters

The following table provides recommended methods for performing the internal pressure test.

Object	Pre-test	Main test
Test pressure $P_p$ (depends on the pipe wall temperature or the permissible test pressure of the installed components, see section "Determination of the test pressure")	$\leq P_p$ (perm)	$\leq 0.85 P_p$ (perm)
Test duration (depends on the length of the piping system or the piping system sections)	$L \leq 100\text{ m}$ : 3 h $100\text{ m} < L \leq 500\text{ m}$ : 6 h	$L \leq 100\text{ m}$ : 3 h $100\text{ m} < L \leq 500\text{ m}$ : 6 h
Checks during the test (test pressure and temperature progression must be recorded)	At least 3 checks, distributed over the test duration with restoring the test pressure	At least 2 checks, distributed over the test duration without restoring the test pressure

#### Pre-test

The purpose of the pre-test is to prepare the piping system for the actual test (main test). During the pre-test, a stress-strain equilibrium is established in the piping system in conjunction with an increase in volume. This results in a material-dependent pressure drop, which necessitates repeated re-pumping to restore the test pressure and often retightening of the flange connection bolts.

The guidelines for an expansion-related pressure decrease in pipe are:

Material	Pressure drop (bar/h)
PVC-U	0.5
PVC-C	0.5
PP	0.8
PE	1.2
PVDF	0.8
ECTFE	0.9

## Main test

During the main inspection, a much lower pressure drop can be expected if the pipe wall temperatures remain approximately constant, so that there is no need for re-pumping. The checks can concentrate on the tightness of the flange connections and possible changes in the position of the pipeline.



If a valve is located at the end of a pipeline (end or shut-off valve), the valve, and thus the end of the pipeline, must be closed off by means of a blind flange or cap. This prevents medium from escaping or the inside of the valve from being contaminated by unintentional actuation of the valve.

## Filling the piping system

Before starting with the internal pressure test, the following points must be checked:

- Was installation done according to the available plans?
- All pressure relief devices and flap traps mounted in the flow direction?
- All end valves shut?
- Valves of devices are shut to protect against pressure?
- Visual inspections of all joints, pumps, measurement devices and tanks?
- Waiting time after last fusion/cementing observed?

Now the piping system can be filled from the geodetic lowest point. Special attention must be paid to the venting. For this purpose, vents must be provided at all high points of the pipeline, if possible, and must be open when filling the system. The flushing speed must be at least 1 m/s.

Reference values for the filling volume are given in the following table:

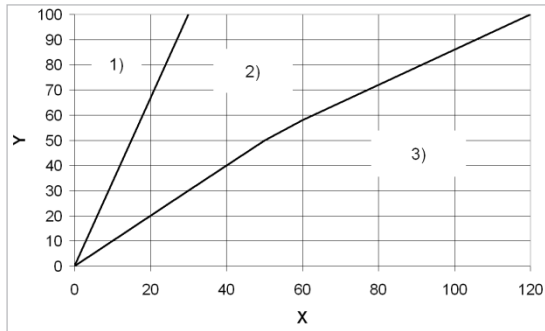
DN (mm)	V (l/s)	DN (mm)	V (l/s)
≤ 80	0.15	250	2.0
100	0.3	300	3.0
150	0.7	400	6.0
200	1.5	500	>9.0



Between filling and testing the pipeline, allow sufficient time for the air in the pipeline system to escape via the vents: approx. 6 to 12 hours, depending on the pipe diameter.

### 1.5.2 Applying the test pressure

**⚠** The test pressure is applied according to the diagram. Make sure that the pressure increase rate does not cause any impact stop!



- Y Test pressure (%)
- X Time for pressure increase (min)
- 1) Pressure increase rate up to DN100
- 2) Range of pressure increase rates between DN100 and DN400
- 3) Values for pressure increase rate DN500 and higher is: 500/DN (bar/10 min)

### Determining the test pressure

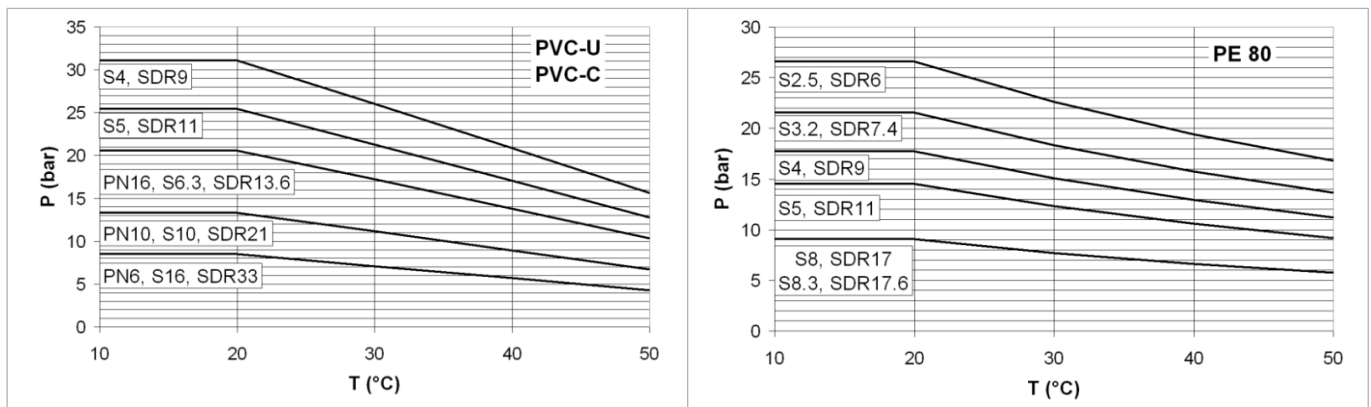
The permissible test pressure is calculated according to the following formula:

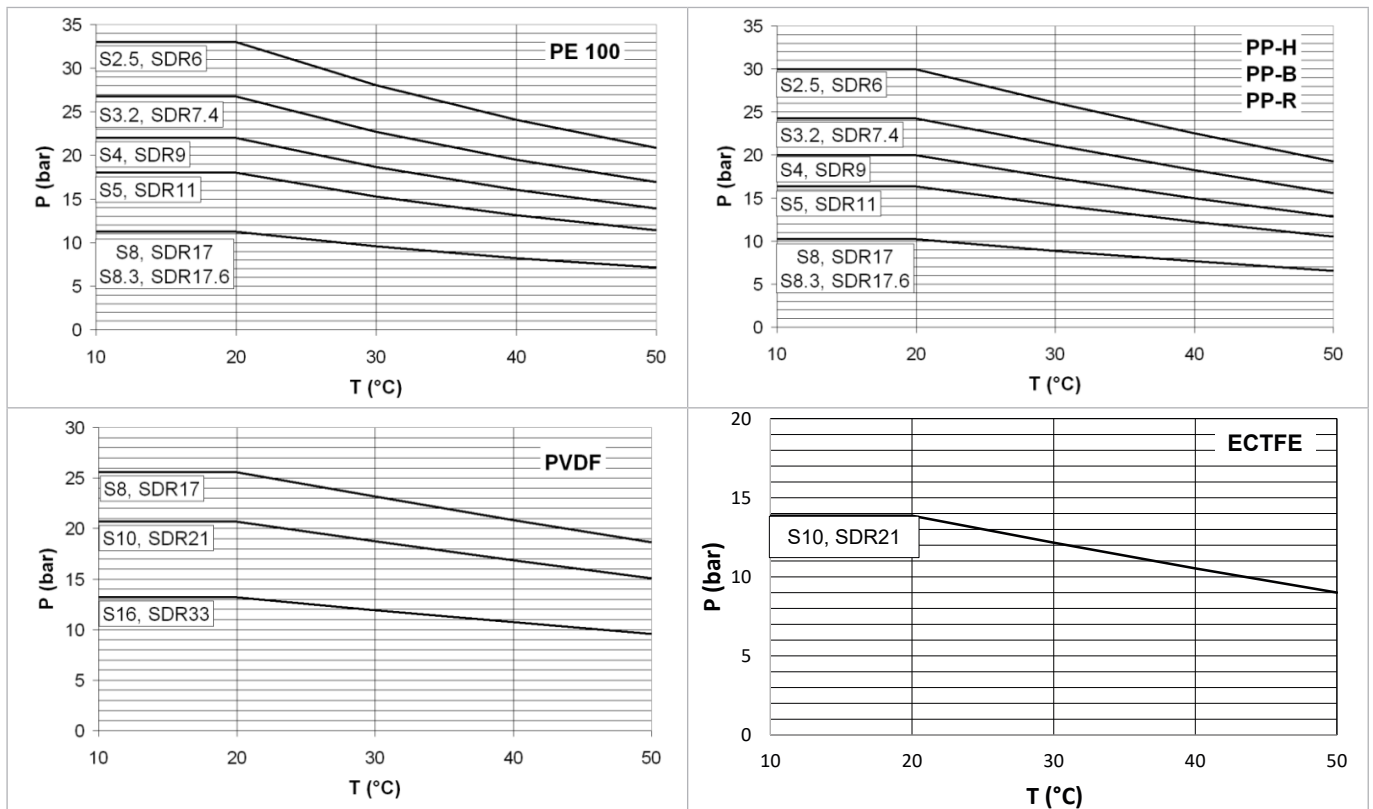
$$P_{p(zul)} = \frac{1}{SDR} \cdot \frac{20 \cdot \sigma_{v(T, 100 h)}}{S_p \cdot A_G}$$

- $\sigma_{v(T, 100 h)}$  Long-term creep strength for pipe wall temperature TP (at t = 100 h)
- $S_p$  Minimum safety factor for long-term creep strength
- $A_G$  Processing or geometry-specific factor that reduces the permissible test pressure (if the AG factor is less than zero, you need to use the reciprocal (1/AG))
- $T_R$  Pipe wall temperature: average value of test medium temperature and pipe surface temperature

**⚠** If the piping system contains diaphragm valves, the maximum permissible test pressure is limited to the nominal pressure of the diaphragm valves.

To make things easier, the permissible test pressures can be taken directly from the following diagrams.





P Permissible test pressure (bar)

T Pipe wall temperature (°C)

## Checks during testing

The following measurement values must be recorded consistently during testing:

- Internal pressure at the absolute lowest point of the piping system
- Medium and ambient temperature
- Water volume input
- Water volume output
- Pressure drop rates

## Leak test

If an internal pressure test with water is not possible (e.g. keeping pipelines dry), a leak test can be carried out with slight overpressure. For safety reasons, the test pressure must then be limited to a maximum of 0.5 bar (gauge pressure).


During the leak test, all connection points must be sprayed with a foam-forming agent and checked. Since the efficiency of the leak test is significantly limited due to the slight load, it should preferably be used for systems with operating pressures of less than 0.5 bar.

### 1.5.3 Pressure test of the containment pipe

#### General

The test of the containment pipe is carried out with the inner pipe completely filled and under internal pressure (internal pressure of the inner pipe should be at least equal to or greater than the internal pressure of the containment pipe), in order to avoid loading of the inner pipe by external overpressure. Suitable filling and venting facilities must be provided on the containment pipe for carrying out the pressure test.

After the installation of the double containment piping system has been completed, the pressure connection (pressure joint) for the leakage indicator, or a test union to monitor the proper operation of the leakage indicator, is installed as near as possible to (no further than 1 m from) or directly inside the termination fitting and at the end of each length of piping. The leak test of the space between the pipe is carried out at room temperature (20 °C).

 Thin-walled inner pipes in particular can collapse due to the overpressure in the annular space. The maximum permissible test or overpressure in the annular space depends on the load capacity of the medium-carrying inner pipe, whereby it must be ensured that the internal pipe pressure load (PN stage) does not correspond to the external pipe pressure load.

Water is the preferred test medium. However, complete draining must be ensured. In many cases, air or inert gas are also suitable test media.

The following points should be noted:


- Compressor oils can contain damaging elements for the pipe.
- Depending on the temperature, various materials tend to splinter when subjected to mechanical action and internal pressure from compressed media.
- Appropriate safety precautions must be taken against the effects of a splintering break in the containment pipe, especially in the case of transparent PVC-U.
- The maximum gas pressure depends on the material and should not exceed the values in the following table.

#### CONTAIN-IT Plus test parameters

Test medium for piping systems	PE100 containment pipe, pressure-resistant welded with ELGEF Plus coupler		PVC-U containment pipe, spray protection with EPDM rubber collar (not to be applied when there are axial forces)	
	SDR11, SDR17, SDR17.6			
	Pre-test	Main test	Pre-test	Main test
Water	≤ Pp (perm)	≤ 0.85 Pp (perm)	1 bar	1 bar
Inert gas	0.5 bar	0.5 bar	0.3 bar	0.3 bar

#### Testing time

The piping system is kept under test pressure until all connection parts, valves, flanges, etc. have been tested for leaks using a foaming agent. It is best to use soap solution, which can be easily removed with water.

 Commercially available leak detection sprays can trigger stress cracks in plastics. If these sprays are used, residue-free removal is required after testing.



### No overloading of the components

The adjustment of the test pressure at the corresponding components must be taken into account. In the case of installed valves, for example, the protective line in the flameproof system may only be pressurized to less than or equal to 6 bar.

Test medium for double containment valves	PE100 containment pipe, pressure-resistant welded with ELGEF Plus coupler		Containment pipe PVC-U splash guard with EPDM rubber sleeve (not tension-proof)	
	SDR11, SDR17, SDR17.6			
	Pre-test	Main test	Pre-test	Main test
Water	6 bar	6 bar	1 bar	1 bar
Inert gas	0.5 bar	0.5 bar	0.3 bar	0.3 bar

## 1.6 Operating and maintenance instructions

### General information

In case of maintenance (sealing of ball valve, diaphragm valve, mechanical separation, etc.), leakage, or system expansion, please contact your local safety representative before opening the containment and inner pipes. Operators must maintain an operating manual with a monitoring plan, maintenance plan, emergency plan and specified immediate measures in the event of a leak.

### Operation

- If the system consists of several double containment piping systems or several leakage monitoring sections, all these interstitial spaces must be equipped with leakage detection devices (manual/automatic). Leakages must be detected within 72 hours and defined countermeasures must be initiated to ensure the safe condition of the system.
- Routine checks are mandatory when using a visual leak detection solution for rapid leak detection and for initiating the defined countermeasures. When using electrical monitoring systems, regular functional checks are mandatory. These routine checks and functional tests are to be defined by the operator in accordance with a risk assessment and taking into account the existing local legislation and the operating instructions.
- Double containment piping systems must be protected against uncontrolled thermal and mechanical influences.
- In the event of a leakage, the double containment piping system becomes a single pipe. The safety measures according to section Repair must be observed.

### Maintenance

- To carry out maintenance work, it is mandatory to contact the safety officer in advance.
- Before performing maintenance, appropriate precautions such as checking the leakage warning system, complete draining of the inner and containment pipe, etc. must be taken into account.

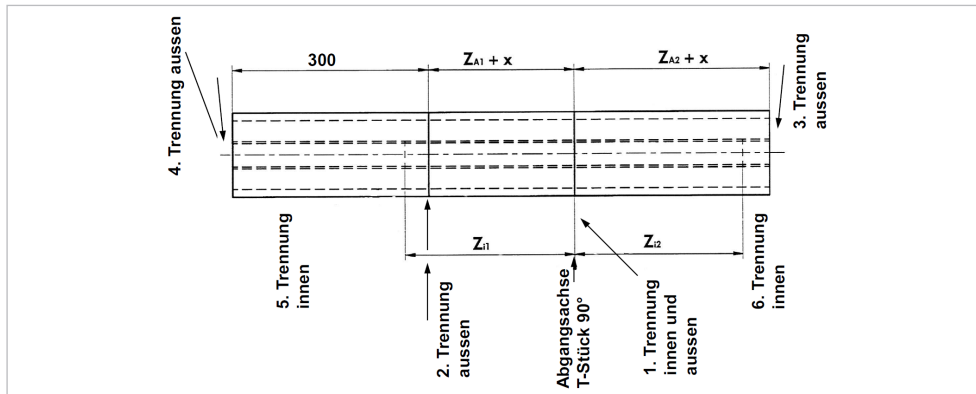
### Repair – Case of a Leakage:

- The safety officer must be contacted in advance before carrying out any repair work!
- If a leakage occurs, the procedure defined in advance by the operator of the double containment system must be followed.
- Before starting any repair work, comply with the precautionary measures such as complete draining, flushing of the inner and outer pipe, prevention of dripping, protective clothing, etc... If a leak cannot be located precisely, it is helpful to proceed in sections.
- Leakage detection may only be carried out with water to protect employees, the environment and equipment.
- In order to roughly locate/limit the leakage, test holes can be carefully drilled on the underside of the containment pipe using the mechanically fixed tapping clamp with half outlet. When drilling out containment pipe, make sure that the medium-carrying inner pipe is not damaged. The clamp is later closed again with a PVC plug.
- Georg Fischer Piping Systems recommends dividing the pipeline into leakage detection sections by means of end fittings already during new construction.
- The pipeline must be replaced in compliance with the Georg Fischer Piping Systems installation instructions.

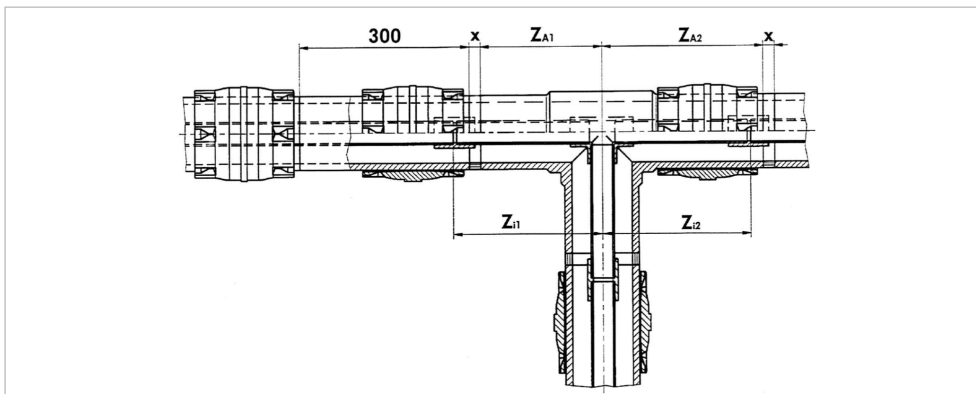
## Extension of the existing piping system and subsequent installation of a T-piece

- The safety officer must be contacted in advance if extensions are to be carried out.
- Before any extension begins, appropriate precautions must be taken, such as complete draining, flushing of the inner and containment pipe, prevention of dripping, protective clothing, etc.
- The pipeline must be extended in accordance with the Georg Fischer Piping Systems installation instructions.

Explanation:



$x = 30 \text{ mm}$



### Pressure test - recommissioning

- A pressure test of the inner and containment pipe is mandatory as soon as a new connection has been made. See chapter "Pressure test for inner and containment pipe".

### Safety and fire prevention measures

- Georg Fischer Piping Systems refers to the relevant safety datasheets of the plastic materials used.

### Firestop collars

- Approved firestop collars for double containment pipe are available on the market.

### Laying pipe in the ground

- If the pipe is laid in the ground, it must be ensured that the regulations regarding the creation of the trench, embedding of the double containment pipe and filling of the trench, as well as the relevant guidelines of professional associations and state authorities, are observed.

## 1.7 Double containment – CONTAIN-IT Plus - Valves and mechanical connections

### 1.7.1 CONTAIN-IT Plus - Valves and mechanical connections


The CONTAIN-IT Plus mechanical connections are delivered as ready-to-install system units with a PVC-U PN6 protective housing.

#### Application

The mechanical separation finds its application primarily in hard-to-reach areas, where the use of welding machines is difficult. In addition, mechanical separation is often used for subsequent removal or repair.

#### Connection technology

The connection technology used is analogous to the one used for double containment fittings. The double containment connection technology from Georg Fischer Piping Systems is based on the principle that the inner pipe is connected first according to the relevant connection technology. For details, see chapter "CONTAIN-IT Plus - principles of connection technology".



**+GF+**

**CONTAIN-IT Plus**

Mechanische Trennung  
Déconnexion mécanique  
Mechanical disconnection  
Scolligamento meccanico

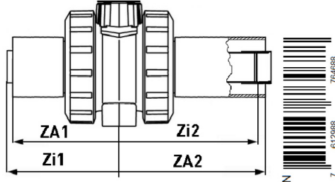
**721240108**

**d32-d63**

**PVC-U**

PN16/6

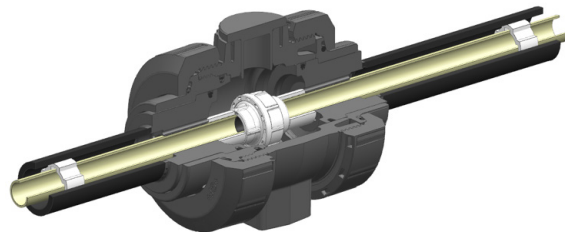
Georg Fischer Piping Systems Ltd., 8201 Schaffhausen/Switzerland www.gfps.com



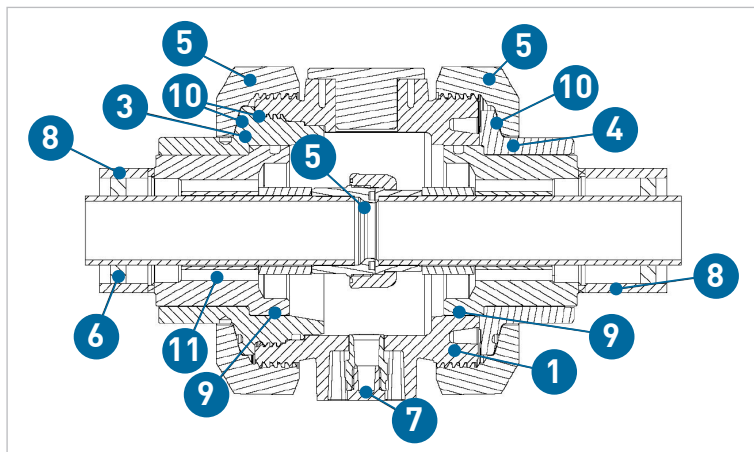
EAN 721240108  
Batch No

1x

ZA1 = 275 Zi1 = 315  
ZA2 = 355 Zi2 = 348



#### Design



- 1 Protective housing
- 2 Union
- 3 Union bush
- 4 Union end
- 5 Union nut of protective housing
- 6 Spacer
- 7 Adaptor for 1/2" leak detection or PVC-U 1/2" plug
- 8 PE support pieces
- 9 O-ring PE connecting element
- 10 O-rings for union bush/ union end
- 11 Bore-hole for leak detection of inner pipe

## Connection technologies inner pipe

Dimension (mm)	Socket cementing		Socket fusion		Butt fusion IR fusion				
	PVC-U Tangit/ Dytex	PVC-C Tangit/ Dytex	PP-H	PE	PVDF	PP-H	PE	PVDF	ECTFE
d20/D50	✓	✓	✓	✓	✓	✓	✓	✓	✓
d25/D50	✓	✓	✓	✓	✓	✓	✓	✓	✓
d32/D63	✓	✓	✓	✓	✓	✓	✓	✓	✓
d40/D75	✓	✓	✓	✓	✓	✓	✓	✓	✓
d50/D90	✓	✓	✓	✓	✓	✓	✓	✓	✓
d63/D110	✓	✓	✓	✓	✓	✓	✓	✓	✓

**i** Installation, pressure test and maintenance must be performed according to the corresponding installation manual. The installation manual is part of the product (see also the online product catalog at [www.gfps.com](http://www.gfps.com)).

## Maintenance

Thanks to the possibility of a radial installation and removal, the inner pipe union can be easily maintained/replaced (O-Rings, etc.)



### 1.7.2 CONTAIN-IT Plus – Double containment ball valve

Double containment valves in their standard version have a PVC-U PN6 protective housing with an anti-overwinding handle.

Double containment valves from Georg Fischer Piping Systems are delivered as ready-to-install system units with a PVC-U PN6 protective housing.

Double containment ball valves are also available in the following versions on request:

- Pneumatic actuator
- Electric actuator

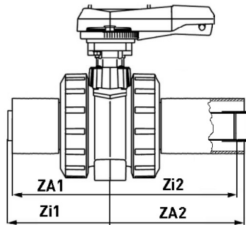

**i** A manual CONTAIN-IT Plus ball valve can be upgraded at any time by using an adapter set.

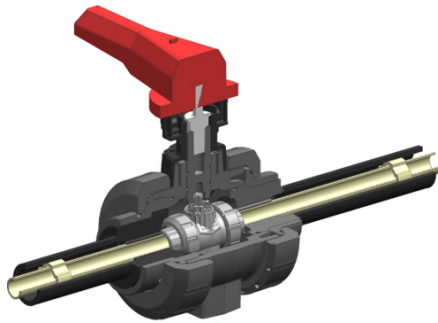
#### Connection technology

The connection technology used is analogous to the one used for double containment fittings. The principle of the double containment connection technology of Georg Fischer Piping Systems is based on the fact that first the inner pipe is connected according to the respective connection technology. For details, see chapter "CONTAIN-IT Plus - Principles of connection technology".

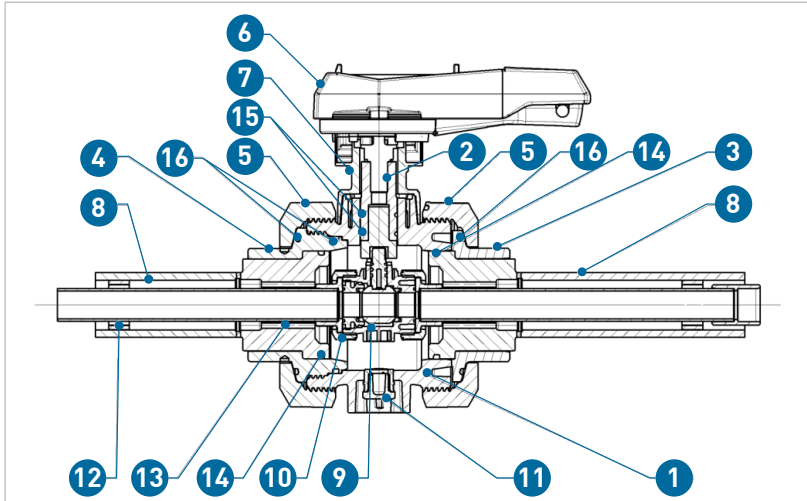


<b>+GF+</b>	
<b>CONTAIN-IT Plus</b>	
Kugelhahn Robinet à bille Ball Valve Valvola a Sfera	
<b>721239110</b>	
<b>d50-d90</b>	
<b>PVC-U</b>	
PN16/6	
<b>1x</b>	ZA1 = 340 Zi1 = 389 ZA2 = 425 Zi2 = 409
<small>Georg Fischer Piping Systems Ltd., 8201 Schaffhausen Switzerland www.gfps.com</small>	



Design

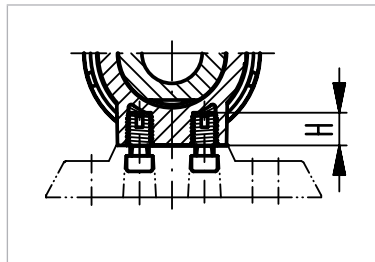


- 1 Protective housing
- 2 Stem
- 3 Union end
- 4 Union bush
- 5 Union nut of protective housing
- 6 Hand lever
- 7 Nuts and screws (to fix the hand lever)
- 8 PE supports
- 9 Ball valve type 546 (central part)
- 10 Ball valve type 546 coupling nut
- 11 Adaptor for 1/2" leak detection or PVC-U 1/2" plug
- 12 Spacer
- 13 Bore-hole for leak detection of inner pipe
- 14 O-ring PE connecting element
- 15 O-rings for stern
- 16 O-rings for union bush/ union end

Ball valve installation notes

Maximum insertion depth of the screws into the ball valve:

Dimension (mm)	Screw	Insertion depth H (mm)
d10/DN15	M6	12
d20/DN25	M6	12
d32/DN40	M8	15
d50	M8	15



**i** Installation, pressure test and maintenance must be performed according to the corresponding installation manual. The installation manual is part of the product, see also the online product catalog at [www.gfps.com](http://www.gfps.com)

**i** Replacement of the inner ball valve: When replacing an inner ball valve in the dimension d63/D110, it is mandatory to contact the Georg Fischer Piping Systems Global Service and Support Team. In this case, a slightly modified inner ball valve must be used!

## Maintenance

Thanks to the option of radial installation and removal, the inner pipe ball valve is easy to maintain/replace (O-rings, etc.).



## Inner pipe connection

Dimension (mm)	Socket cementing		Socket fusion			Butt welding & IR fusion		
	PVC-U Tangit/ Dytex	PVC-C Tangit/ Dytex	PP-H	PE	PVDF	PP-H	PE	PVDF
d20/D50	✓	✓	✓	✓	✓	✓	✓	✓
d25/D50	✓	✓	✓	✓	✓	✓	✓	✓
d32/D63	✓	✓	✓	✓	✓	✓	✓	✓
d40/D75	✓	✓	✓	✓	✓	✓	✓	✓
d50/D90	✓	✓	✓	✓	✓	✓	✓	✓
d63/D110	✓	✓	✓	✓	✓	✓	✓	✓

**i** The installation, pressure test and maintenance work must be carried out as described in the relevant installation instructions. The installation instructions are delivered with the product, see also the online product catalog at [www.gfps.com](http://www.gfps.com).

## Customizing

Larger dimensions are available on request. Please contact your local Georg Fischer Piping Systems branch.

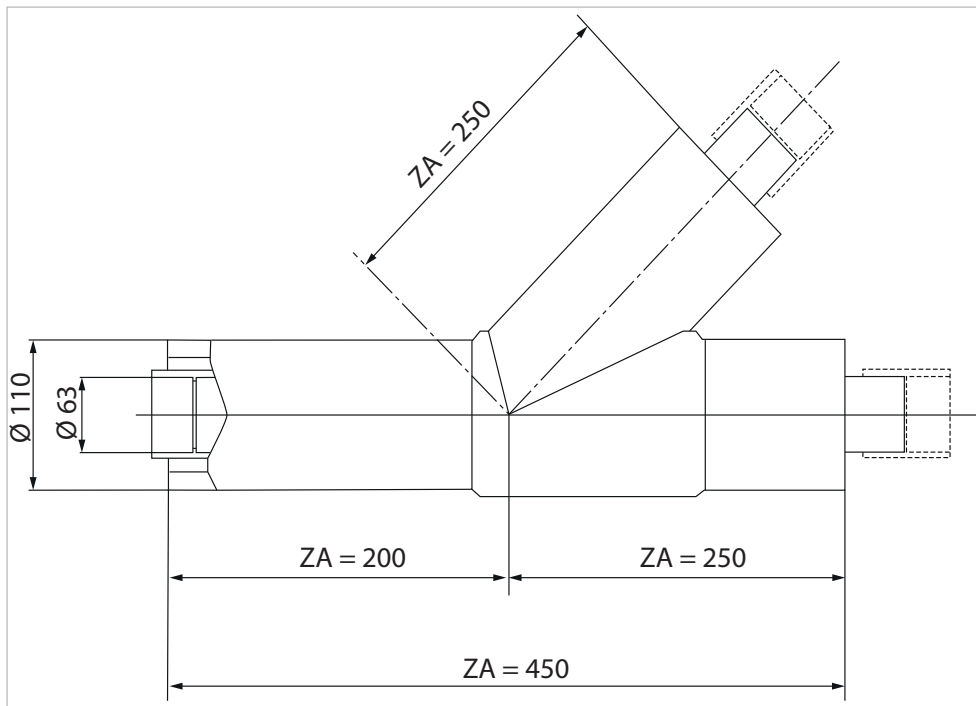


### 1.7.3 Special components

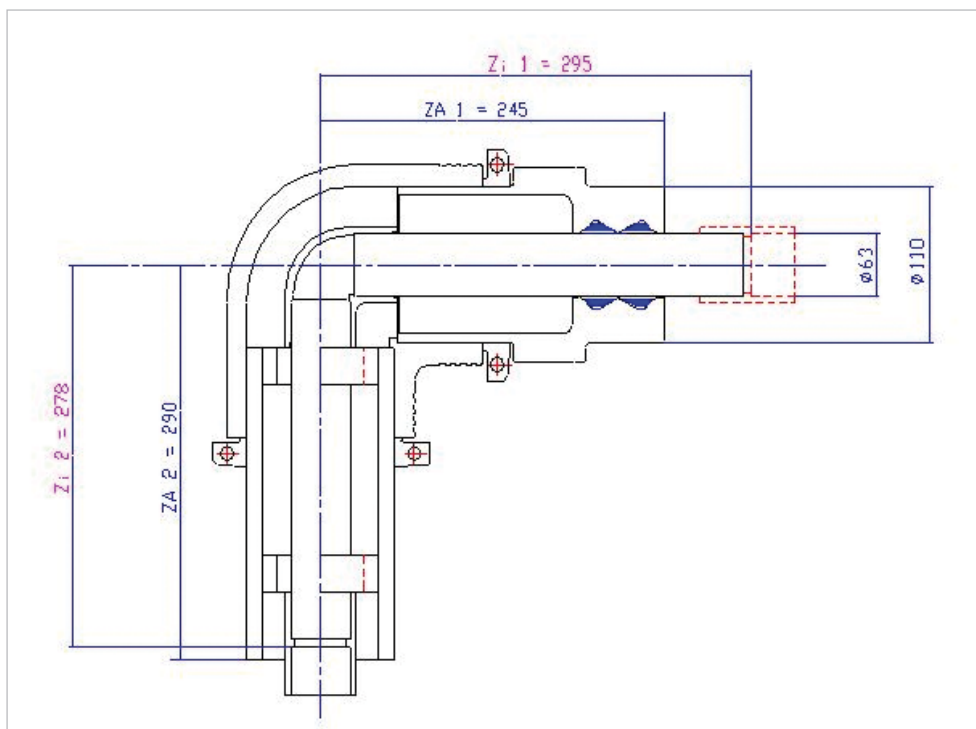
In the double containment product range, many components are manufactured according to customer requirements. Prefabricated tapping pieces, reducing T-pieces, end pieces integrated in the fitting or the prefabrication of entire assemblies can facilitate assembly on the construction site.

**⚠** Customized fittings may require the inclusion of a reduction factor.  
Contact your Georg Fischer Piping Systems representative for additional information.

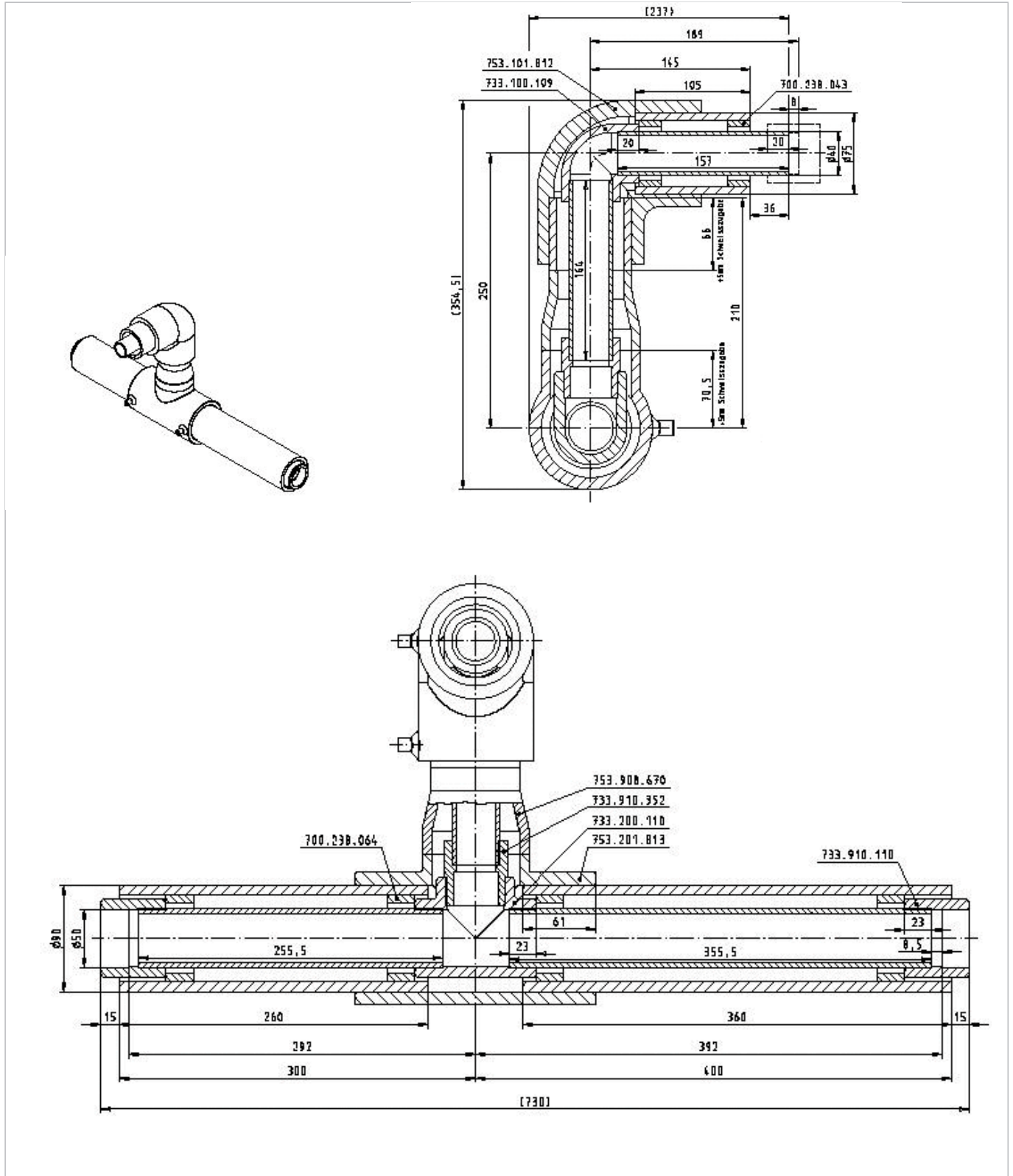
#### T-piece with 45° tapping point



#### 90° elbow including termination fitting



Double containment T 90° reduced with elbow



**i** Installation, pressure test and maintenance must be performed according to the corresponding installation manual. The installation manual is part of the product, see also the online product catalog at [www.gfps.com](http://www.gfps.com)

# Pre-Insulated Solutions

## COOL-FIT 2.0 / COOL-FIT 4.0

### Content

<b>1</b>	<b>COOL-FIT 2.0</b> .....	<b>367</b>
1.1	General Information .....	367
1.2	System Specification .....	368
1.3	Technical Details .....	370
1.4	Dimensioning and Design .....	383
1.5	Jointing and Installation .....	430
1.6	Transport, Handling and Storage .....	450
1.7	Environment .....	450
<b>2</b>	<b>COOL-FIT 4.0</b> .....	<b>451</b>
2.1	General Information .....	451
2.2	System Specification .....	452
2.3	Technical Details .....	454
2.4	Dimensioning and Design .....	468
2.5	Jointing and Installation .....	507
2.6	Transport, Handling and Storage .....	525
2.7	Environment .....	525



# 1 COOL-FIT 2.0

## 1.1 General Information

COOL-FIT 2.0 is a pre-insulated piping system for the delivery of secondary refrigerants. Thanks to its insulation thickness of 20 mm, the system can be used in air-conditioning systems with secondary refrigerant temperatures above 0 °C. COOL-FIT 2.0 is based on established, impact resistant and corrosion free PE pipe and fittings. The smooth inner surface of the fluid pipe provides minimal losses of pressure. The low thermal conductivity and high quality insulation guarantee low operating cost over the entire lifespan of the system. Thanks to the 3 in 1 design – Fluid pipe / Insulation / Jacket tube – installation time is kept very short.

The system consists of pipe, fittings, valves, flexible hoses and transition fittings. All components are pre-insulated or supplied with mountable insulation shells. The COOL-FIT 2.0 tools allow for fast and safe installation of the system.



The COOL-FIT 2.0 system is a completely pre-insulated plastic piping system for secondary refrigerant circuits run with water, brine, or Glycol based solutions.

The COOL-FIT 2.0 system is suitable for use in applications like:

### Comfort Cooling

- Air conditioning
- Airports
- Apartments
- Hospitals
- Industrial buildings

### Safe Cooling

- Data centers
- Hotels
- Shopping centers
- Sports center / leisure center
- Universities
- Bank / public institutions

## 1.2 System Specification

Specification		COOL-FIT 2.0	COOL-FIT 2.0F	COOL-FIT 2.0 Push System
				
Materials <sup>1)</sup>	Pipe	PE100	PE100	Multilayer composite pipe PE-RT/Al/PE-RT
	Insulation	GF-HE foam, halogen free, closed-cell	GF-HE foam, halogen free, closed-cell	Pipe: EPDM foam Fitting: EPP foam
	Outer jacket	Pipe HDPE Fitting GF-HE	Flame retardant - GF-FR	Stainless steel polyester fabric TPE
Size <sup>2)</sup>	d32DN25 – d140DN125 mm	d32DN25 – d140DN125 mm	d16DN12 - d32DN25	
Connection technology	Electrofusion	Electrofusion	Push-in connector	
Nominal pressure <sup>3)</sup>	16 bar, SDR11	16 bar, SDR11	16 bar	
Temperature	Medium	0 °C bis +60 °C	0 °C bis +60 °C	+5 °C bis +60 °C
	Environment	0 °C bis +55 °C	0 °C bis +55 °C	+0 °C bis +55 °C
Insulation	Thermal conductivity $\lambda_{20^\circ\text{C}}$			
	PE Inner pipe	0.38 W/mK	0.38 W/mK	
	HE Foam	0.022 W/mK	0.026 W/mK	
	PE jacket	0.38 W/mK		
	GF-FR jacket		0.15 W/mK	
	Multilayer composite pipe			0.43 W/mK
	Thermal conductivity $\lambda_{0^\circ\text{C}}$			0.036 W/mK
	Thermal conductivity $\lambda_{10^\circ\text{C}}$			0.037 W/mK
	Thermal conductivity $\lambda_{40^\circ\text{C}}$			0.038 W/mK
	Density	$\geq 70 \text{ kg/m}^3$	$\geq 70 \text{ kg/m}^3$	50-60 kg/m <sup>3</sup>
Foam cell size	max. $\varnothing$ 0.5 mm	max. $\varnothing$ 0.5 mm		
Nominal thickness	22 mm	22 mm	13 mm	
Mechanical strength (from insulation)	Axial shear strength	$\geq 0.12 \text{ N/mm}^2$	$> 0.12 \text{ N/mm}^2$	
	Compressive strength	$\geq 0.3 \text{ N/mm}^2$	$\geq 0.3 \text{ N/mm}^2$	
Colour	Outer jacket	Black	Black	Black
Weight (without medium)	Pipe d32	1.12 kg/m	1.06 kg/m	0.62 kg/m
	Pipe d110	5.5 kg/m	5.39 kg/m	
Oxygen diffusion at $\leq 5^\circ\text{C}$	ISO 17455	$\leq 0.083 \text{ mg}/(\text{m}^2 \text{ d})$	$\leq 0.083 \text{ mg}/(\text{m}^2 \text{ d})$	According to DIN 4726
Fire classification <sup>4)</sup>	EN 13501-1 <sup>4)</sup>	E	B - s2, d0	C - s2, d0
Environment	Stability	Moisture and vapor-tight	Moisture and vapor-tight	Moisture and vapor-tight
	Weather/UV resistance	For indoor use	For indoor use	For indoor use
	Ozone Depletion Potential	Zero	Zero	Zero

Standards and Guidelines	DIN EN 12201-2	Plastics piping systems for water supply, and for drainage and sewerage under pressure - Polyethylene (PE)	
	ISO 7	Threaded Joints	
	EN ISO 16135	Industrial valves ...	
	EN ISO 16136	– Ball valves made of thermoplastics	
	EN ISO 16137	– Butterfly valves made of thermoplastics	
	EN ISO 16138	– Backflow protection made of thermoplastics	
Product declarations Green buildings	EN ISO 16871	Plastic piping and ducting systems – Plastic pipe and fittings – Method for exposure to direct (natural) weathering	
	EN ISO 13501-1	Fire classification of construction products and building elements	
		BNB BN 2015 BREEAM Int 2016 DGNB 2015 DGNB 2018 LEED V3 LEED V4 WELL V1 2019	
GEG	COOL-FIT 2.0 meets the requirements of system 8 of the GEG (Building Energy Act of August 8, 2020) for thermal insulation of cold distribution and cold water pipes and fittings in the cases of §70.		
eco-bau	(BKP 240, 244, 250)	201710.1516	201908.5715

- <sup>1)</sup> All three materials are firmly bonded together.
- <sup>2)</sup> Bigger dimensions available via COOL-FIT 4.0 and COOL-FIT 4.0F product range
- <sup>3)</sup> At 20 ° C, medium water, the specified value is valid for all system components, with the exception of the butterfly valves, PN10 applies to the nominal pressure and for flexible hoses with maximum pressure according product datasheet.
- <sup>4)</sup> Additional information in chapter "Fire behavior and fire prevention measures".

### 1.3 Technical Details

#### 1.3.1 COOL-FIT 2.0

##### COOL-FIT 2.0 pipe

COOL-FIT 2.0 pipes are made from PE 100. The high efficiency GF-HE hard foam insulation exhibits a thermal conductivity  $\lambda$  of 0.022 W/mK. The pipes are protected by a impact resistant PE jacket.

All three materials are firmly bonded in order to ensure good insulation properties and low thermal expansion or contraction for the system.

The pipes are available in 5 m lengths.



Pipe size (mm)	Inner Pipe d x e (mm)	Inner Pipe d <sub>i</sub> (mm)	Outer jacket D x e1 (mm)	Weight empty (kg/m)	Weight with water (kg/m)	Volume (l/m)	Insulation thickness (mm)	Heat transfer coefficient (U) (W/m K)	Fire load (kWh/m)
d32/75	32 x 2.9	26.2	75 x 3	1.12	1.66	0.54	18.5	0.16	12.41
d40/90	40 x 3.7	32.6	90 x 3	1.50	2.34	0.83	22.0	0.17	16.55
d50/90	50 x 4.6	40.8	90 x 3	1.67	2.98	1.31	17.0	0.24	18.91
d63/110	63 x 5.8	51.4	110 x 3.4	2.47	4.54	2.07	20.1	0.25	27.91
d75/125	75 x 6.8	61.4	125 x 3.8	3.24	6.20	2.96	21.2	0.28	36.88
d90/140	90 x 8.2	73.6	140 x 4	4.17	8.43	4.25	21.0	0.32	47.91
d110/160	110 x 10	90.0	160 x 4	5.50	11.86	6.36	21.0	0.38	63.47
d140/200	140 x 12.7	114.6	200 x 5	8.71	19.02	10.31	25.0	0.47	100.88

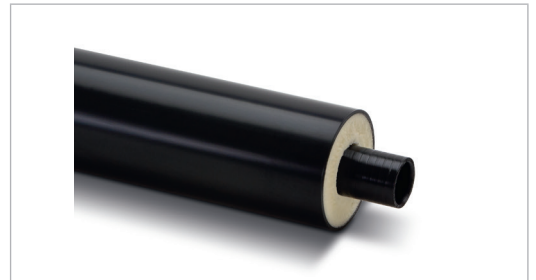
d Nominal outer diameter of the PE pipe  
 d<sub>i</sub> Nominal inside diameter of the pipe  
 D Nominal outside diameter of the outer PE jacket  
 e, e1 Nominal wall thickness

##### COOL-FIT 2.0F pipe

COOL-FIT 2.0F inner pipe is made from PE100. The insulation made of highly efficient GF HE rigid foam has a thermal conductivity  $\lambda$  of 0.022 W/mK. The pipe is protected by the GF-FR fire retardant jacket.

All three materials are firmly bonded in order to ensure good insulation properties and low thermal expansion or contraction for the system.

The pipes are available in 5m lengths and can be connected with all fittings from COOL-FIT 2.0.



Pipe size (mm)	Inner Pipe d x e (mm)	Inner Pipe d <sub>i</sub> (mm)	Outer jacket D x e1 (mm)	Weight empty (kg/m)	Weight with water (kg/m)	Volume (l/m)	Insulation thickness (mm)	Heat transfer coefficient (U) (W/m K)	Fire load (kWh/m)
d32/75	32 x 2.9	26.2	75 x 1.8	1.06	1.60	0.54	19.7	0.16	7.54
d40/90	40 x 3.7	32.6	90 x 1.8	1.43	2.27	0.83	23.2	0.17	10.65
d50/90	50 x 4.6	40.8	90 x 1.8	1.60	2.91	1.31	18.2	0.23	13.01
d63/110	63 x 5.8	51.4	110 x 1.8	2.27	4.34	2.07	21.7	0.24	19.20
d75/125	75 x 6.8	61.4	125 x 1.8	2.88	5.84	2.96	23.2	0.26	25.29
d90/140	90 x 8.2	73.6	140 x 2.5	4.09	8.34	4.25	22.5	0.30	35.87
d110/160	110 x 10	90.0	160 x 2.5	5.39	11.76	6.36	22.5	0.36	49.65
d140/200	140 x 12.7	114.6	200 x 2.5	8.05	18.37	10.31	27.5	0.44	76.84

d Nominal outer diameter of the PE pipe  
 d<sub>i</sub> Nominal inside diameter of the pipe  
 D Nominal outside diameter of the outer PE jacket  
 e, e1 Nominal wall thickness



## COOL-FIT 2.0 fittings

### General

The media fitting and insulation used for COOL-FIT 2.0 fittings fulfill the same specifications as the COOL-FIT 2.0 pipe. The COOL-FIT 2.0 fittings are based on ELGEF electrofusion fittings, which have been in use successfully for years. They provide an easy and safe connection.

The pre-insulated COOL-FIT 2.0 fittings are available in two types:

#### Type A:

Electrofusion fitting with integrated resistance wires for direct electrofusion pipe-to-fitting connections.



90° elbow as an example

#### Type B:

Spigot fitting with free ends for pipe-to-fitting electrofusion with COOL-FIT 2.0 electrofusion fittings.



90° elbow as an example

### Useful functions - Fittings type A:

#### Fusion indicators

After welding, check whether there is wear to the fusion indicators. After the welding process, the indicator pin shows clearly that energy has been applied to the welding zone.



#### Sealing lip

The sealing lip can be used to check whether the insulation has been properly sealed. If they bulge after the fitting has been pushed up to the end stop on the pipe, the installation is correct. By labelling the lip end on the pipe any changes in position of the fitting can be monitored.

For direct fitting-to-fitting or fitting-to-valve connections, the sealing lip can be removed beforehand during electrofusion fitting.



**Label**

The fittings have abrasion-resistant marking.



**Trace code**

Relevant product data can be traced back to production via traceability codes.



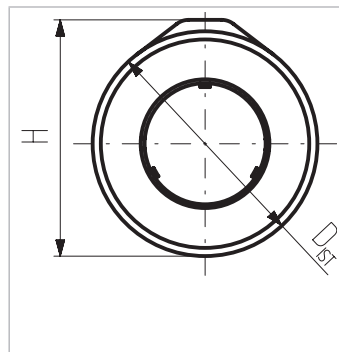
**Angle marking**

By marking the ends of the fittings, connections between pipe and fittings can be optimally aligned.



All Type A fittings feature a dome surrounding the welding connectors. It tops the outer diameter of a fitting, thus increases the total height (H) of a fitting in this specific section. The outer diameter of a fitting ( $D_{ist}$ ) is slightly larger than the nominal outer diameter (D) of the system. See dimension table for Type A fittings:

d/D (mm)	$D_{ist}$ (mm)	H (mm)
32/75	82	87
40/90	97	99
50/90	97	105
63/110	117	123
75/125	132	139
90/140	147	154
110/160	168	177
140/200	208	208



d/D Nominal inner- / outer diameter COOL-FIT 2.0 System  
 $D_{ist}$  Effective outer diameter fitting Type A  
 H Fitting height at welding connector section

**Joining**

**Pipe and Fitting**

Type A fittings have integrated resistance wires, which are put under electric current during the welding operation through welding contacts on the fittings. This heats up the inside of the fitting and bonds the melting zone with the pipe.

Type B fittings feature non-insulated spigot ends. They are connected with electrofusion coupler to a pipe (see chapter below "components").

**Fitting-to-fitting**

Two COOL-FIT 2.0 fittings are usually connected by using a piece of COOL-FIT 2.0 pipe with free ends or a short piece of ecoFIT PE pipe and an insulation ring (e.g. ring removed with the foam removal tool). The shortest connection between two COOL-FIT 2.0 Type A fittings can be achieved by cutting off the sealing lips and using a barrel nipple and an adhesive ring for the vapor seal (see components).

Two COOL-FIT 2.0 Type B fittings can be joined using an electrofusion coupler (see components).

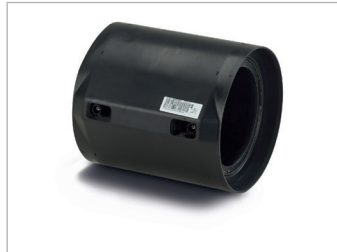
The connection of a COOL-FIT 2.0 fitting Type A and Type B is also possible.

## Components

Fittings can be connected to either pipe or other fittings using the parts described below:

### COOL-FIT 2.0 Electrofusion coupler

COOL-FIT 2.0 electrofusion couplers are used to connect pipe and components with free ends like type B fittings, valves and transition fittings.



### COOL-FIT 2.0 Elbows 45° and 90°

(Refer to „General“ chapter above)



### COOL-FIT 2.0 T90° equal and COOL-FIT T90° reduced

The equal and reduced type A 90° tees have, like the coupler, resistance wires for electrofusion. The central outlets can be connected to the type A fitting, so all combinations are possible.

The type B fittings with free fusion spigots can be connected to all type A fittings.



### COOL-FIT 2.0 reducer

The COOL-FIT 2.0 reducer can be used to reduce the flow of the starting size by up to three to four sizes (e.g. from d140 up to d63 or from d75 up to d32).



### Combination of T90° and Reducer

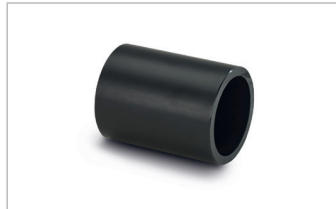
If a reduction step should be done after the branch of a T90°, either a COOL-FIT 2.0 T90° reduced, or a COOL-FIT 2.0 T90° reduced/ equal connected to a reducer should be used.

- X T90°- equal + reducer
- O T90°- reduced + reducer
- Δ T90°- reduced

Run Branch	40	50	63	75	90	110	140
32	Δ	Δ	Δ	Δ	Δ	Δ	0
40		X	X	0	0	0	0
50			X	0	0	0	0
63				Δ	Δ	Δ	Δ
75					Δ	Δ	Δ
90						Δ	Δ
110							Δ

**COOL-FIT 2.0 barrel nipple**

COOL-FIT 2.0 barrel nipple serves as a compact direct connector for type A fittings.



**COOL-FIT 2.0 Sliding coupler kit**

The sliding coupler kit is a radially insertable element for connecting two fixed pipe spigots.



**COOL-FIT 2.0 Fixed point for high forces**

The fixpoint placed on the media pipe allows the transmission of higher forces. The fixed point is placed between two electrofusion fittings.



**Accessories**

**Insulation for fusion contacts**

Supplied with each fitting. Prevent formation of a cold bridge at the fusion contacts. Insulation parts can also serve as an indicator that a connection has been welded (Install insulation after welding to show that the welding has been completed).



**Adhesive ring**

With a compact connection with a barrel nipple (fitting-to-fitting), this adhesive ring is used to ensure that the connection is water and vapor tight after the removal of the sealing lip.



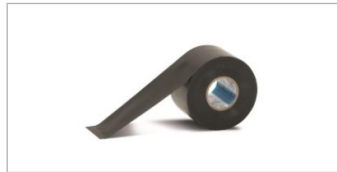
**Cement**

For frontal bonding of the insulations of transition fittings and flexible hoses



**Adhesive tape**

Optional for covering hand-cut faces.

**Sealant**

The silicone-free sealant is used to join the EPDM insulation of Weld-in ports to the COOL-FIT pipes.

**Y-Cable kit for COOL-FIT Fixpoints**

Cuts the welding time by 50% and includes the required welding adapters.

Article no.: 790 156 032.

**Tangit Rapid cement**

Cement and cement gun for attaching the COOL-FIT 2.0F fixed point sets to the outer casing of the pipe.

**COOL-FIT 2.0 valves**

COOL-FIT 2.0 valves are based on GF Standard plastic valves. The valves are supplied including GF-HE insulation shells with a protective PE jacket. The sealing faces between the shells and the valve are vapor tight by their design. No additional tape or sealant is required.



Releasable plastic bands for sizes d32DN25 – d63DN50 and metal straps with tension locks for sizes d75DN65 – d140DN125 permit the pre-insulated shells to be fitted to and removed from the valves easily, allowing easy maintenance.



The insulated ball valve in PVC-U is available in sizes d32DN25 – d90DN80, and the butterfly valve in sizes d110DN100 – d140DN125. Manual versions or such ISO 5211 interface are available. The interface is suitable for electric actuators from GF as well as for 3<sup>rd</sup> party actuators.

**Interfaces:**

F03 and F05 for ball valves d32DN25 – d63DN50

F07 for all ball- and butterfly valves d75DN65 – d90DN80

**COOL-FIT 2.0 transition fittings, flange connectors**

Transition fittings and flange connectors enable connections to different systems in either metal or plastic, such as the Georg Fischer systems iFIT or Sanipex MT. All listed components are supplied with insulation in NBR foam:



- \* NBR foam insulation
- \*\* Insulation half shells similar to valve insulations

Thread type/connector/ pitch circle	Size	Material	Thread type/connector/ pitch circle
Transition fittings for metal*	d32 – d63 ½" – 2 ¾"	PE – stainless steel PE – brass	Male thread (R), Female thread (Rp), Loose union nut (G)
Transition fittings to iFIT or Sanipex MT*	d32 1"	Stainless steel Brass	iFIT, Sanipex MT
Union plastic - plastic*	d32 – d110 1" – 4 "	PE – PE, PE – ABS	Welding spigots Cementing socket
Adaptor union to metal*	d32 – d63 1" – 2 "	PE – stainless Steel	Internal thread (Rp), External thread (R)
Flange joints**	d32 – d140	PE	Bolt circle PN 10/16

**COOL-FIT 2.0 flex hoses**

The flexible hose in EPDM with stainless steel protection permit mobile access to devices such as fancoils, compensating for expansion or contraction within the system. The tear-resistant protective tissue jacket and NBR insulation (19mm,  $\lambda_{10^\circ\text{C}} \leq 0.036 \text{ W/mK}$ ) ensure the temperature of the cooling medium remains unchanged. Versatile connectivity options mean that system connection is ensured:  
G thread (external thread + loose nut)



d (mm)	DN (mm)	Thread	Length (mm)	Max. compen- sation ΔL (mm)	R <sub>min</sub> (min. bending radius) (mm)
20	15	½"	1'000	276	119
25	20	¾"	1'000	161	156
32	25	1"	1'000	68	192
40	32	1 ¼"	1'500	233	252
50	40	1 ½"	2'000	396	312
63	50	2"	2'000	233	372

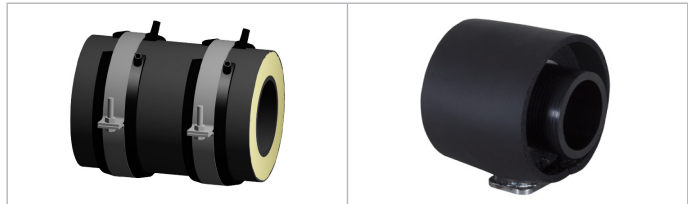
### COOL-FIT 2.0 Installation fittings type 313

Installation fittings are used to install various types of sensors to the system. Pressure or temperature sensors can be connected using the ½" or ¾" Rp female thread. The insulation is comprised of highly efficient GF-HE foam with excellent insulating capabilities.



### COOL-FIT 2.0 Fixed point

The fixed point is used to direct pipe movement or retain forces from pipe weight at risers. The electrofusion welding tapes allow a permanent connection and transmit occurring forces between pipe and clamp.



### COOL-FIT 2.0 Weld-In Port

The COOL-FIT Weld-in port significantly increases the flexibility by enabling the branching-off on already laid, unfilled and dry COOL-FIT pipes in dimensions d63-d225.

The product range of fittings includes Weld-in ports with transitions to female threads, as well as Weld-in ports that allow transitions within the GF piping portfolio.

The EPDM soft foam insulation supplied with the Weld-in ports is designed to ensure a condensation-free connection to the COOL-FIT pipe, and to insulate the nipples up to the corresponding interface.



Connection type, material	Size	Purpose
Female thread Rp, PE/Brass	½", ¾", 1"	Installation of instruments, probes, sensors as well as transition to other piping systems
iFIT, PE/Brass	16/20, 25/32	Transition from COOL-FIT 2.0 and COOL-FIT 4.0 to COOL-FIT 2.0 Push System
Sanipex MT, PE/Brass	32	Transition from COOL-FIT 2.0 and COOL-FIT 4.0 to GF Sanipex MT
PE spigot SDR11	32, 40, 50	Connection within COOL-FIT 2.0 and COOL-FIT 4.0

The Weld-in ports can be used with COOL-FIT 2.0 and COOL-FIT 2.0F pipes.

### Joining

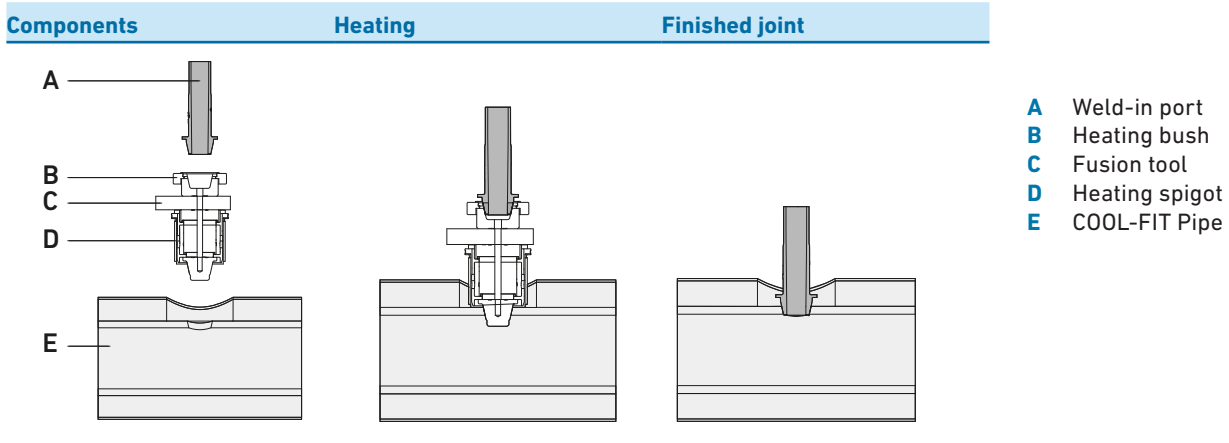
After the controlled local tapping of jacket and inner pipe of the respective COOL-FIT pipe, the welded joint is made.

In the cone welding process used here, a modified version of heating element socket welding, the inner pipe of the COOL-FIT pipe and the Weld-in port are welded in an overlapping material-to-material bond without the use of additional filler materials.

The welding surfaces of the pipe and the fitting are heated to welding temperature on a conical socket- or spigot-shaped heating element and then joined together.

The dimensionally matched geometry of the components ensures the welding pressure during joining and a homogeneous joint.

Jointing principle



After the fusion process, the EPDM insulation is mounted to the Weld-in port. Bonding of insulation the COOL-FIT pipe is done using the COOL-FIT sealant.

Distance of COOL-FIT Weld-in ports and pressure de-rating of main pipes

On positioning the Weld-in ports on the COOL-FIT pipe, the following distances must be taken into account:

- Distances between Weld-in ports along the pipe axis.
- Arrangement around the circumference of the pipe.

	Ports with metal insert	Ports with PE spigot
<b>Distances along pipe axis*</b>	<p><math>x \geq 120\text{mm}</math></p> <p><math>x \geq 120\text{ mm}</math>                      ► no pressure de-rating of main pipe</p>	<p><math>x \geq 2 * d</math> main pipe                      ► no pressure de-rating of main pipe</p> <p>or</p> <p><math>x &lt; 2 * d</math> main pipe                      ► pressure de-rating factor of main pipe of 0.8</p>
<b>Arrangement around circumference</b>	<p><math>\alpha \geq 60^\circ</math></p> <p><math>x \geq 0\text{ mm}</math> (along pipe axis), <math>\alpha \geq 60^\circ</math>                      ► no pressure de-rating of main pipe</p>	

\* The minimum distance due to the tool dimensions is 120 mm.

Height of Weld-in ports 1/2"-1" towards the pipe axis

Height h1 [mm]/d [mm]	d63	d75	d90	d110	d140	d160	d225
1/2" Rp	117	123	130	140	155	165	198
3/4" RP	117	123	130	140	155	165	198
1" Rp	118	124	131	141	156	166	199



### 1.3.2 COOL-FIT 2.0 Push System

#### COOL-FIT 2.0 Push System pipe

Inside the multilayer composite pipes of the COOL-FIT 2.0 push system is a medium-bearing layer made of polyethylene (PE-RT). The outer layer, which protects the pipe from mechanical loads, is also made of PE-RT. In between is a longitudinally butt-welded aluminum carrier pipe, which is permanently bonded to the other two layers by means of bonding agents - also PE-based.

The EPDM insulation has a thermal conductivity of 0.037W/mK at 10°C and is covered with an additional polyester/stainless steel mesh, which prevents wrinkling and protects the pipe from mechanical stress.

The pipes are available in 5m rod and 25m roll.

Pipe size (mm)	Inner Pipe d x e (mm)	Inner Pipe d <sub>i</sub> (mm)	Outer jacket D x e <sub>1</sub> (mm)	Weight empty (kg/m)	Weight with water (kg/m)	Volume (l/m)	Insu- lation thick- ness (mm)	Heat transfer coeffi- cient (U) (W/m K)	Fire load (kWh/m)	Bending radius R with spring tool 5x d (mm)	Bending radius R with spring tool 3,5 x d (mm)
d16/44	16 x 2	12	44 x 1	0.299	0.412	0.113	13	0.20	0.93	80	56
d20/48	20 x 2	16	48 x 1	0.354	0.556	0.201	13	0.23	1.13	100	70
d25/54	25 x 2.5	20	54 x 1	0.521	0.836	0.314	13.5	0.26	1.60	200	98
d32/61	32 x 3	26	61 x 1	0.621	1.152	0.523	13.5	0.31	2.28		112

d Nominal outer diameter of the PE pipe  
d<sub>i</sub> Nominal inside diameter of the pipe  
D Nominal outside diameter of the outer jacket  
e, e<sub>1</sub> Nominal wall thickness

#### COOL-FIT 2.0 Push System Fittings

##### General

The Push System fittings are made of high-performance polyphenylsulfone (PPSU) plastic. This material has proven itself for fittings in building services and is characterized above all by excellent corrosion resistance and low incrustation. The Push System fittings have a high degree of robustness, i.e. special impact strength and impact resistance.

To further increase mechanical strength, the iFIT adapters are additionally protected by a glass-fiber-reinforced polyamide (PA-GF30).

The insulation half-shells supplied fit onto the Push System fittings and can be closed quickly and easily with integrated tabs and hooks.



##### Connection

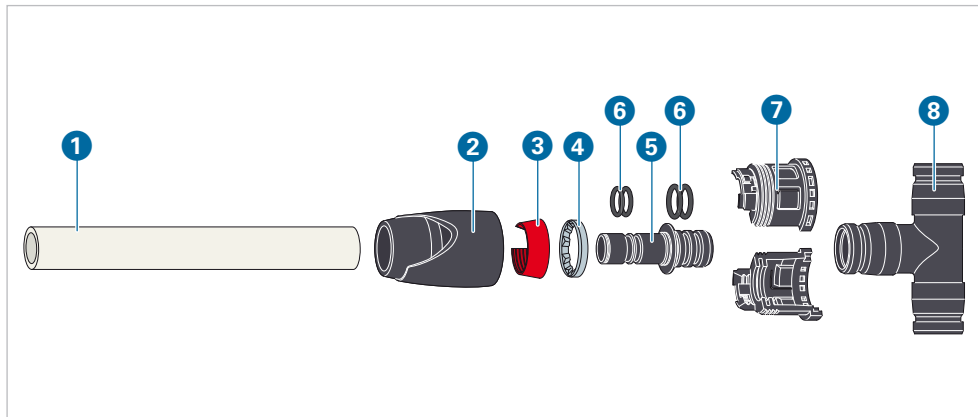
The connection is made using adapter module technology, a push system that requires few tools and no electrical power. It is possible to work across dimensions via the module.

The adapters are pushed onto the tube and module. A viewing window and "click" sounds allow the correct assembly to be checked during the installation process.

**Push-fit**

An iFIT tool is used for the processing and it is done manually. The iFIT push-fit guarantees a secure, fast and detachable connection. The modules are reusable. The adaptors can only be used once. This also applies to adaptors if the clicking action was not completed.

An iFIT push-fit consists of several components:



**iFIT push-fit**

**1** Pipe (PB or multilayer composite pipe)

**Adaptor**

**2** Adaptor housing

**3** Clamping ring

**4** Toothed ring

**5** Insert

**6** O-rings (EPDM)

**7** Half shells

**8** Module made of PPSU or low-lead, dezincification-resistant brass

The iFIT adaptor is plugged into a chamfered pipe end. The push-fit is then closed by clicking the module into the adaptor.

**Inadmissible system connections**

**!** **NOTE! Damage due to inadmissible system connections!**

- Do not connect iFIT system components with non-system components. Also, do not connect iFIT system components with INSTAFLEX-HWS components (e.g. HWS sleeves).
- Do not penetrate iFIT system components through walls.

PB pipes from the INSTAFLEX assortment are not compatible.

- When using the COOL-FIT 2.0 Push System, use only multilayer composite pipes from the COOL-FIT 2.0 Push System or iFIT assortment.

**Components**

**COOL-FIT-2.0 Push System, socket**

The sockets are used for straight connection of pipes.



**COOL-FIT 2.0 Push System, 90° angle**

The 90° elbows can be used to change the direction of the pipe when space is limited and it is not possible to bend the pipe.



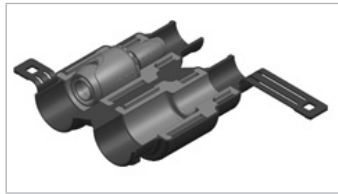
**COOL-FIT 2.0 Push System, T90° equal and T90° reduced**

The T-pieces 90° equal and 90° reduced are supplied with two adapters and tolerance rings in only. At the outlet, a choice can be made between two dimensions in each case. Additional adapters and rings must be ordered here.

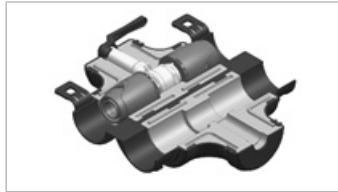


**COOL-FIT 2.0 Push System, Reduktion**

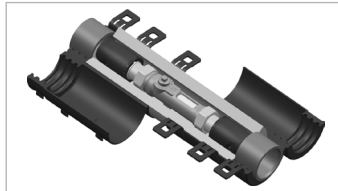
By means of the COOL-FIT 2.0 Push System reduction, the flow of the output dimension can be reduced by up to 2 dimensional sizes.

**COOL-FIT 2.0 Push System, Ball Valve**

The ball valves suitable for the COOL-FIT 2.0 Push System can be connected directly to the pipe via the adapters thanks to their plug-in contour. They also have a sealing shell.

**COOL-FIT 2.0 Push System, volume flow controller**

The COOL-FIT 2.0 Push System volume flow controller, based on the TacoSetter, can be used to balance or shut off a wide variety of systems such as recirculating air coolers.

**COOL-FIT 2.0 Transition Fitting PE/iFIT**

The COOL-FIT 2.0 transition fitting PE/iFIT provides a direct connection option from COOL-FIT 2.0 to the COOL-FIT 2.0 Push System.



### 1.3.3 COOL-FIT tools

#### Electrofusion Machines

Electrofusion machines are required to join COOL-FIT 2.0 components. The range includes dedicated and multipurpose electrofusion machines which are reliable and easy to use.

GF recommends: MSA-Series electrofusion machines.



#### Foam removal tool and peeling tool – manually operated

The foam removal tool is used to prepare shortened COOL-FIT 2.0 / 2.0F pipe for electrofusion. The tool removes the foam and cuts outer jacket, and also peels the surface of the inner pipe. Any oxide layer present is removed when the welding zone is treated. The tool is available in two versions:

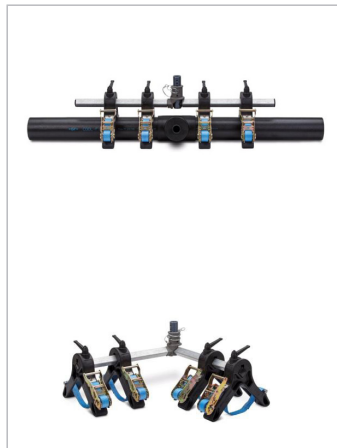
1. for sizes d32 – d90,
2. for sizes d110 – d140.



#### Clamping tool

The fusion process gives rise to forces that can pull the pipe out of the coupler. Therefore it is recommended that the assembly should be fitted with COOL-FIT installation clamps. This prevents movement during the welding- and cool-down process.

The central hinge allows the use of the clamps on elbows and reducers. Depending on the length of the pipe, 2 or 4 of the glass-reinforced plastic holders can be used. The linkage is made of galvanized steel. Tension bands are included and a T-adaptor is optional available.



#### Weld-In Port installation tool

Using the installation tool, the different COOL-FIT Weld-in ports can be installed safe, reliable, reproducible and quick.

Drilling of jacket, drilling of inner pipe as well as the subsequent welding joint is supported in a clever way.

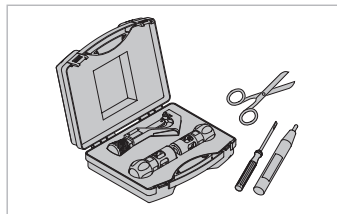
Depending on the need in Weld-in ports to be installed, the tool is available in 230V as well as in 110V in different equipment variants.



#### iFIT assembly case

The tools needed to make a correct and secure iFIT push-fit for the COOL-FIT 2.0 Push System are available in an iFIT assembly case.

Additional: scissors for insulation, screwdriver for closing the shell.



## 1.4 Dimensioning and Design

The following section describes only the COOL-FIT specific planning fundamentals. For prevailing information see general GF planning fundamentals.

### 1.4.1 General information about the dimensioning and installation of plastic piping

Plastics have different physical characteristics to metals. When designing and installing thermoplastic piping systems, this needs to be taken into account. Although PE and COOL-FIT 2.0 are very robust systems, care should be taken to avoid damage during handling and transportation.

For over 50 years, GF Piping Systems has developed and sold a variety of plastic piping systems which are subjected to very rigorous demands, such as optimized insulation properties in cooling applications. Experience has shown that plastic provides an economical and reliable alternative to metal when designers and installers take account of the recommendations in the technical documentation. In the professional production of plastic piping systems, for example, piping systems must be able to move to accommodate changes in length caused by temperature and pressure changes. To allow for these changes in length, the use of pipe holders that permit this movement is vital.

The following technical information contains the basic information needed to ensure an economical and trouble-free installation. However, this chapter does not contain all of the details. For more information, or if you have specific questions, please call your local GF Piping Systems representative. Additional information is available on the official GF Piping Systems website.

### 1.4.2 COOL-FIT 2.0 pressure-temperature diagram

The pressure resistance for thermoplastic pipe for water is always specified at +20 °C. At higher temperatures allowance must be made for a lower maximum operating pressure.

The graph shows the maximum permissible pressure for COOL-FIT 2.0 pipe, fittings and valves at various temperatures, up to the maximum permissible media temperature of +60 °C. The table is based on an ambient temperature of +20 °C. A safety factor of 1.6 and a minimum lifespan of 25 years have been allowed for in all calculations.

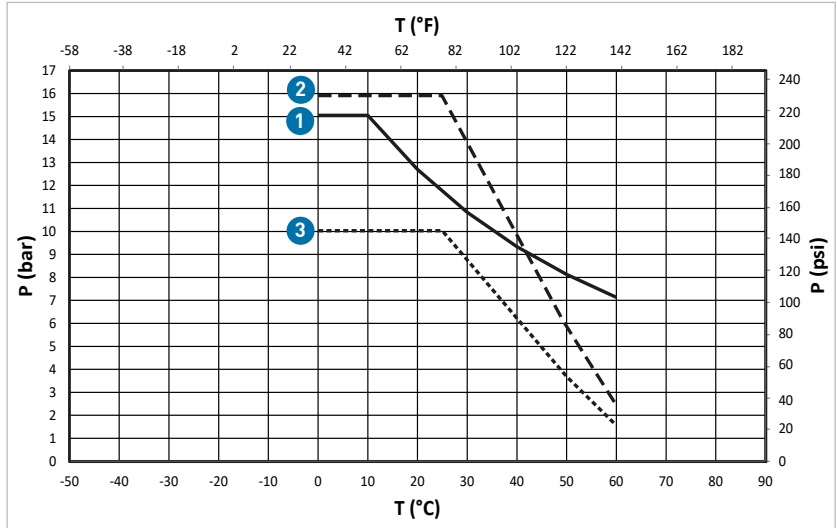
The values given in this chapter apply to both COOL-FIT 2.0 and COOL-FIT 2.0F.

For the COOL-FIT 2.0 Push System, the values are applicable in chapter „Pressure/temperature limits for COOL-FIT 2.0 Push System fittings, pipe, valves – water coolant“ on page 384.

### Pressure/temperature limits for COOL-FIT 2.0 fittings, pipe, valves – water coolant

Limits for COOL-FIT 2.0: 25-year values allowing for the safety factor (with water as the coolant).

**i** In case of long-term operating pressure at temperatures above 47 °C, please contact your authorized GF Piping Systems representative.

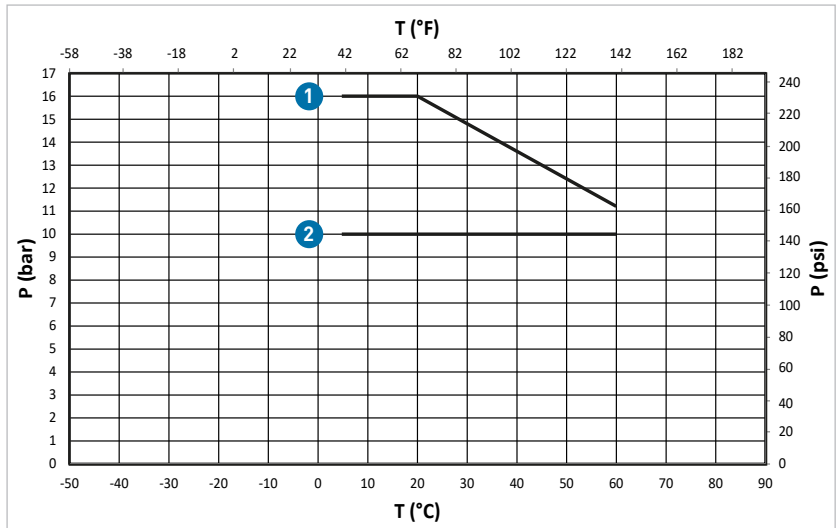


- P Allowable pressure (bar, psi)
- T Temperature (°C, °F)
- C Safety factor
- 1** COOL-FIT pipe and fitting  
C=1.6, SDR11
- 2** COOL-FIT 2.0 ball valve  
PN16
- 3** COOL-FIT butterfly valve  
PN10

The butterfly valves used for the COOL-FIT 2.0 system exhibit lower pressure-temperature ratings than the rest of the components. If valves are used, it is necessary to refer to the data in the diagram above.

### Pressure/temperature limits for COOL-FIT 2.0 Push System fittings, pipe, valves – water coolant

Limits for COOL-FIT 2.0: 25-year values allowing for the safety factor (with water as the coolant).



- P Allowable pressure (bar, psi)
- T Temperature (°C, °F)
- 1** COOL-FIT Push System  
pipe, fitting and ball valve
- 2** COOL-FIT 2.0 Push System  
Flow control valve

## Influence of secondary refrigerants with antifreeze additives

At ambient temperatures below 0 °C, antifreeze must be used in the water to prevent it from freezing during a plant shut-down.

COOL-FIT 2.0 is generally resistant to secondary coolants such as glycol and brines. For some secondary coolants a reduction factor is necessary depending on the type and mixing ratio. The permissible operating pressure is corrected downwards from the pressure-temperature curve for water.

### Reduction factors<sup>1</sup>

Inorganic salt solutions	F = 1
Organic salt solutions	F = 1
Glycol solutions (max. 50 %)	F = 1.1

For the calculation, the following formula is used:

<sup>1</sup> Valid for materials HD-PE, EPDM, PVC-U, metals

$$P_{AF} = \frac{P_w}{AF}$$

$P_{AF}$	Permissible pressure with reduction factor
$P_w$	Permissible pressure for water
AF	Reduction factor

## Glycol solutions

COOL-FIT 2.0 / 2.0F can be used with glycol solutions with concentrations up to 50%. The chemical resistance of COOL-FIT 2.0 systems is suitable for the following antifreeze types:

Brand name	Hersteller	Typ
Antifrogen N	Clariant	Ethylene glycol
Antifrogen L	Clariant	Propylene glycol
Showbrine Blue Showa standard EG brine	Showa Brine	Ethylene glycol
Showbrine Blue Showa trial EC brine	Showa Brine	Ethylene glycol
Tyfocor L	Tyfo	Propylene glycol
Tyfocor	Tyfo	Ethylene glycol
DOWFROST	DOW	Propylene glycol
Zytrec FC	Arteco	Propylene glycol
Zytrec LC	Arteco	Propylene glycol
Zytrec MC	Arteco	Propylene glycol
Neutrogel Neo	Climalife Dehon	Ethylene glycol
Friogel Neo	Climalife Dehon	Propylene glycol
DOWTHERM SR-1	DOW	Ethylene glycol

When using other coolants, compatibility with COOL-FIT 2.0 should be clarified with GF Piping Systems.



### Example – glycol dissolved in water

For water-glycol mixture ≤ 50%, the reduction factor for the pressure-temperature diagram is 1.1. Thus, at +10 °C, with a minimum life of 25 years, the maximum allowable working pressure is reduced as follows:

$$P_{AF} = \frac{15 \text{ bar}}{1.1} = 13.6 \text{ bar}$$

## Organic salt solutions

These media are usually potassium formates or potassium acetates: aqueous solutions with low viscosity at low temperatures. COOL-FIT 2.0 can be used with the media below. The manufacturer's instructions must be followed.

Brand name	Manufacturer	Type
Antifrogen KF	Clariant	Brine
Zytrec S-55	Frigol	Brine
Temper	Temper	Brine
Hycool	Addcon	Brine

**i** For detailed information on resistance and reduction factors, see Planning Fundamentals "Material selection – Chemical resistance".

### 1.4.3 Polyethylene (PE)

The dominant material for the COOL-FIT 2.0 / 2.0F system is polyethylene (PE). As the inner pipe which comes into contact with the media is made of PE-100, its properties are of particularly high relevance.

#### Properties of PE (approximate)

Property	PE 100-value <sup>1</sup>	Unit	Testing standard
Density	0.95	g/cm <sup>3</sup>	EN ISO 1183-1
Yield stress at 23 ° C	25	N/mm <sup>2</sup>	EN ISO 527-1
Tensile modulus at 23 ° C	900	N/mm <sup>2</sup>	EN ISO 527-1
Charpy notched impact strength at 23 ° C	83	kJ/m <sup>2</sup>	EN ISO 179-1/1eA
Charpy notched impact strength at -40 ° C	13	kJ/m <sup>2</sup>	EN ISO 179-1/1eA
Crystallite melting point	130	°C	DIN 51007
Thermal conductivity at 23 ° C	0.38	W/m K	EN 12664
Water absorption at 23 ° C	0.01 - 0.04	%	EN ISO 62
Color	9,005		RAL
Oxygen Index (LOI)	17.4	%	4589-1

<sup>1</sup> Typical, measured on material characteristics, should not be used for calculations.

#### General information

All polymers made from hydrocarbons of the formula C<sub>n</sub>H<sub>2n</sub> are constructed with a double bond (ethylene, propylene, butene-1, isobutene) are referred to collectively as polyolefins. Among them is polyethylene (PE). It is a semi-crystalline thermoplastic. Polyethylene is probably the best known plastic. The chemical formula is: -(CH<sub>2</sub>-CH<sub>2</sub>)<sub>n</sub>. Polyethylene is an environmentally friendly hydrocarbon product. PE, like (PP), is a non-polar material. Therefore, it is insoluble and scarcely swellable in conventional solvents. PE pipe cannot therefore be adhesively bonded to fittings. Welding is the appropriate connection method for the material.

In industrial piping, high molecular weight types have resulted in medium to high density. The types are classified by their creep rupture strength into PE80 (MRS 8 MPa) and PE100 (MRS 10 MPa). The latter are also called 3rd generation types of PE, while PE80 types are primarily associated with the 2nd generation. There are barely any first generation PE types – PE63 under the modern classification – remaining on the market. Creep rupture strength has been tested by long-term tests as per ISO 1167, and calculated in accordance with ISO 9080. The most widespread in piping system construction is PE for use in underground gas and water pipe. In this area polyethylene has become the dominant material in many countries. However, the advantages of this material mean that it is also used in domestic installations and industrial piping.



## Advantages of PE

- Light weight
- Excellent flexibility
- Good wear resistance (abrasion resistance)
- Corrosion resistance
- Ductile fracture properties
- High impact strength even at very low temperatures
- Very good chemical resistance
- Weldable

## Mechanical properties, chemicals, weathering and abrasion resistance

### Chemical resistance

Polyethylene exhibits good resistance to a wide range of media. For detailed information, please see the detailed chemical resistance list from GF Piping Systems, or contact the person responsible at GF Piping Systems directly.



### Abrasion resistance

PE has excellent resistance to abrasive wear. You can therefore find PE piping systems in use in numerous applications for transporting solids and media containing solids. For many applications, PE has proven especially advantageous with metals.



## Thermal properties and electrical properties

### Operating limits

The application limits of the material depend on both embrittlement and softening temperatures and on the manner and method of application. Details are provided in the relevant pressure-temperature charts.



### Electrical properties

Polyethylene, like most thermoplastics, is non-conductive. This means that systems in PE do not suffer from electrolytic corrosion. However, the non-conductive properties must be taken into consideration, as electrostatic charges can build up in the pipe. Polyethylene has good electrical insulation properties. The volume resistance is  $3.5 \times 10^{16} \Omega\text{cm}$ , the surface resistance  $10^{13} \Omega$ . This must be taken into account in applications where there is danger of fire or explosion.



### 1.4.4 Fire behavior and fire prevention measures

#### Firestop classes

##### Classification of fire behavior

Construction materials are classified into different firestop classes depending on their fire behavior. The classification is decisive for whether specific materials may be legally used for construction in certain areas of construction projects.

##### European classification according to EN 13501-1

In the year 2001, the EN 13501-1 was introduced, a European classification system for construction materials. EN 13501-1 defines 6 construction material classes from A to F:

A	No contribution to the development of a fire (A1, A2)
B	Very little contribution to the development of a fire
C	Limited contribution to the development of a fire
D	Acceptable contribution to the development of a fire
E	Acceptable fire behavior
F	No performance criteria detected

In addition to the fire behavior, the European standard also rates fire side effects: smoke release (s1, s2, s3) and burning droplets (d0, d1, d2).

Smoke release:

s1	limited smoke release
s2	average smoke release
s3	high smoke release, or smoke release not tested

Burning droplets:

d0	no burning droplets/fall off within 600 seconds
d1	no burning droplets/fall off with an afterglow time of more than 10 seconds within 600 seconds
d2	No performance criteria detected

#### Fire prevention classes EN13501-1, VKF and British building codes

	COOL-FIT 2.0	COOL-FIT 2.0F	COOL-FIT 2.0 Push System	COOL-FIT 2.0/ mineral wool <sup>2</sup>
				
EN 13501-1	E	B – s2, d0	C – s2, d0	A2 <sub>L</sub>
BS 5422:2009 <sup>1</sup>	National Class 3			National Class 0

<sup>1</sup> Test method according to BS 476-6 and BS 476-7  
<sup>2</sup> Type: Rockwool 800

## Thermal load

The thermal load corresponds to a thermal potential (energy release) related to a specific base area, fire section area in m<sup>2</sup>, for example an escape route. The physical unit for the thermal load is energy per surface area kWh/m<sup>2</sup>. The calculative thermal load is equivalent to the sum of the different thermal potentials of all used combustible used elements, such as pipelines. When the energy released per running meter of the pipe (kWh/m) is known, the thermal load of the pipe is calculated from the used pipe length.

d/D (mm)	32/75	40/90	50/90	63/110	75/125	90/140	110/160	140/200
Thermal load COOL-FIT 2.0 pipes (kWh/m)	12.02	15.97	18.43	29.38	36.84	46.93	62.32	99.14

d/D (mm)	32/75	40/90	50/90	63/110	75/125	90/140	110/160	140/200
Thermal load COOL-FIT 2.0F pipes (kWh/m)	7.54	10.65	13.01	19.20	25.29	35.87	49.65	76.84

d/D (mm)	16/44	20/48	25/54	32/61
Thermal load COOL-FIT Push System pipes (kWh/m)	0.93	1.13	1.60	2.28

## Fire resistance of components

While the fire behavior characterizes individual materials, the fire resistance must be considered for entire assemblies, for example a solid wall with pipe penetrations. The fire resistance is equivalent to the amount of time in which a component maintains its function during a standard fire.

The European system allows classification according to different criteria, stating the respective fire resistance duration in minutes.

## Fire resistance and classification according to the European standards

Pipe insulation systems are exposed to a standard fire according to EN 1363-3. Classification is according to EN 13501-2 and generally includes the criteria integrity (E, Étanchéité) and thermal insulation (I, Insulation).

Abbreviation	Criterion	Rating
E – Étanchéité	Flame protection or integrity	Measurement of an element's capacity of preventing the passage of gases and flames in case of fire.
I – Insulation	Insulation or thermal insulation	Measurement of the insulation capacity of an element, i.e. the duration in which the side of the element facing away from the fire does not exceed 180° C + the ambient temperature.

## Firestop collars/Fire sealing

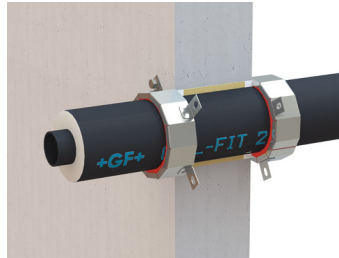
When pipes are installed through fire-rated assemblies, whose reliable functioning must not be affected, firestop collars that comply with local requirements and legislation must be used.

### Hilti firestop

#### System description

The firestop collar (incl. fastening hook) is made of galvanized steel sheet into which strips of intumescent material (i.e. that swells in case of fire) are inserted.

The fire retardation sealing with straight pipes is regulated in conjunction with the following products in the individual countries:



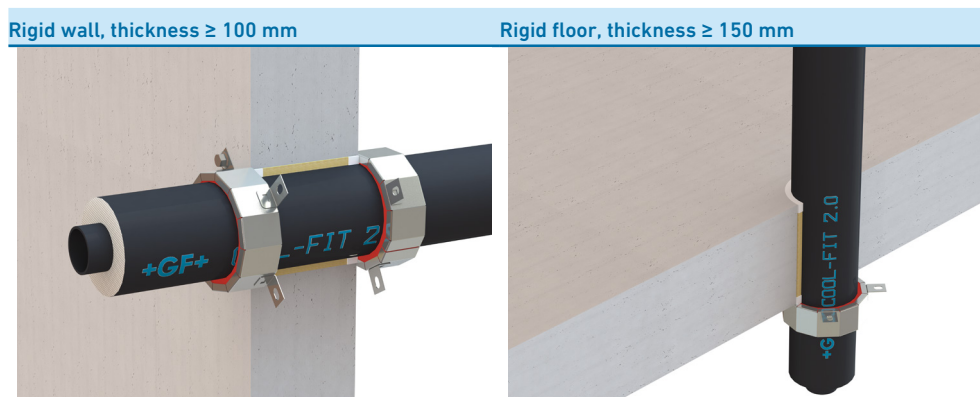
Product	Proof of applicability	Countries
Hilti firestop collar CP 644	Allgemeine Bauartgenehmigung (aBg) Z-19.53-2330	DE
Hilti firestop collar CP 644	VKF Technische Auskunft 14108	CH
Hilti firestop collar CFS-C P	ETA-10/0404	EU

The respective details of the proofs of application must be taken into account.

Additional information is available at Hilti online or from your Hilti contact person.

Hilti CP 644	Hilti CFS-C P
Info   Shop	Info   Shop
	
<a href="https://qr.hilti.com/r3069">qr.hilti.com/r3069</a>	<a href="https://qr.hilti.com/r4831">qr.hilti.com/r4831</a>

The following applications are regulated via the above proofs of application:



## Fire-retarding sealing

COOL-FIT 2.0 pipes up to and including an outside diameter D of 200mm, can be sealed in rigid walls and rigid floors by a Hilti firestop collar.

Rigid wall ≥ 100mm solid		Product DE, CH	Product EU	Fire resistance	Mounting
d (mm)	D (mm)	CP 644	CFS-C P		Number of hooks
32	75	CP 644-75/2.5"	CFS-C P 75/2.5"	EI 120-U/C	3
40	90	CP 644-90/3"	CFS-C P 90/3"	EI 120-U/C	3
50	90	CP 644-90/3"	CFS-C P 90/3"	EI 120-U/C	3
63	110	CP 644-110/4"	CFS-C P 110/4"	EI 120-U/C	4
75	125	CP 644-125/5"	CFS-C P 125/5"	EI 120-U/C	4
90	140	CP 644-160/6"	CFS-C P 160/6"	EI 120-U/C	6
110	160	CP 644-160/6"	CFS-C P 160/6"	EI 90-U/C	6
140	200	CP 644-200/8"	CFS-C P 200/8"	EI 120-U/C*	8

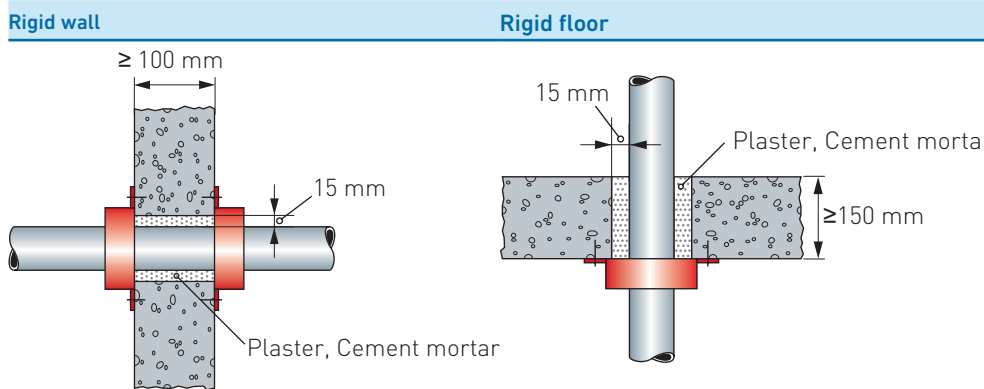
Rigid floor ≥ 150mm solid		Product DE, CH	Product EU	Fire resistance	Mounting
d (mm)	D (mm)	CP 644	CFS-C P		Number of hooks
32	75	CP 644-75/2.5"	CFS-C P 75/2.5"	EI 120-U/C	3
40	90	CP 644-90/3"	CFS-C P 90/3"	EI 120-U/C	3
50	90	CP 644-90/3"	CFS-C P 90/3"	EI 120-U/C	3
63	110	CP 644-110/4"	CFS-C P 110/4"	EI 120-U/C	4
75	125	CP 644-125/5"	CFS-C P 125/5"	EI 90-U/C	4
90	140	CP 644-160/6"	CFS-C P 160/6"	EI 120-U/C	6
110	160	CP 644-160/6"	CFS-C P 160/6"	EI 120-U/C	6
140	200	CP 644-200/8"	CFS-C P 200/8"	EI 60-U/C*	8

\* here exclusively gap sealing with non-combustible construction materials

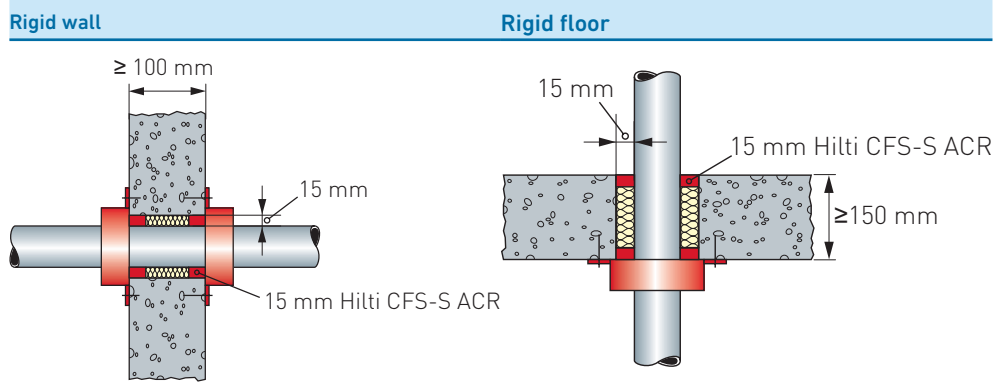
## Annular gap sealing

For the installation situations there are several options for sealing gaps against smoke gas.

Gap sealing with non-combustible construction materials:



Joint closure with Hilti firestop sealant CFS-S ACR and mineral wool backfill up to 15mm annular gap width for Hilti firestop collar CP 644 and CFS-C P.



### Distance regulations

The distance of the component openings to be closed to other openings or installed elements must comply with the data provided in the following table.

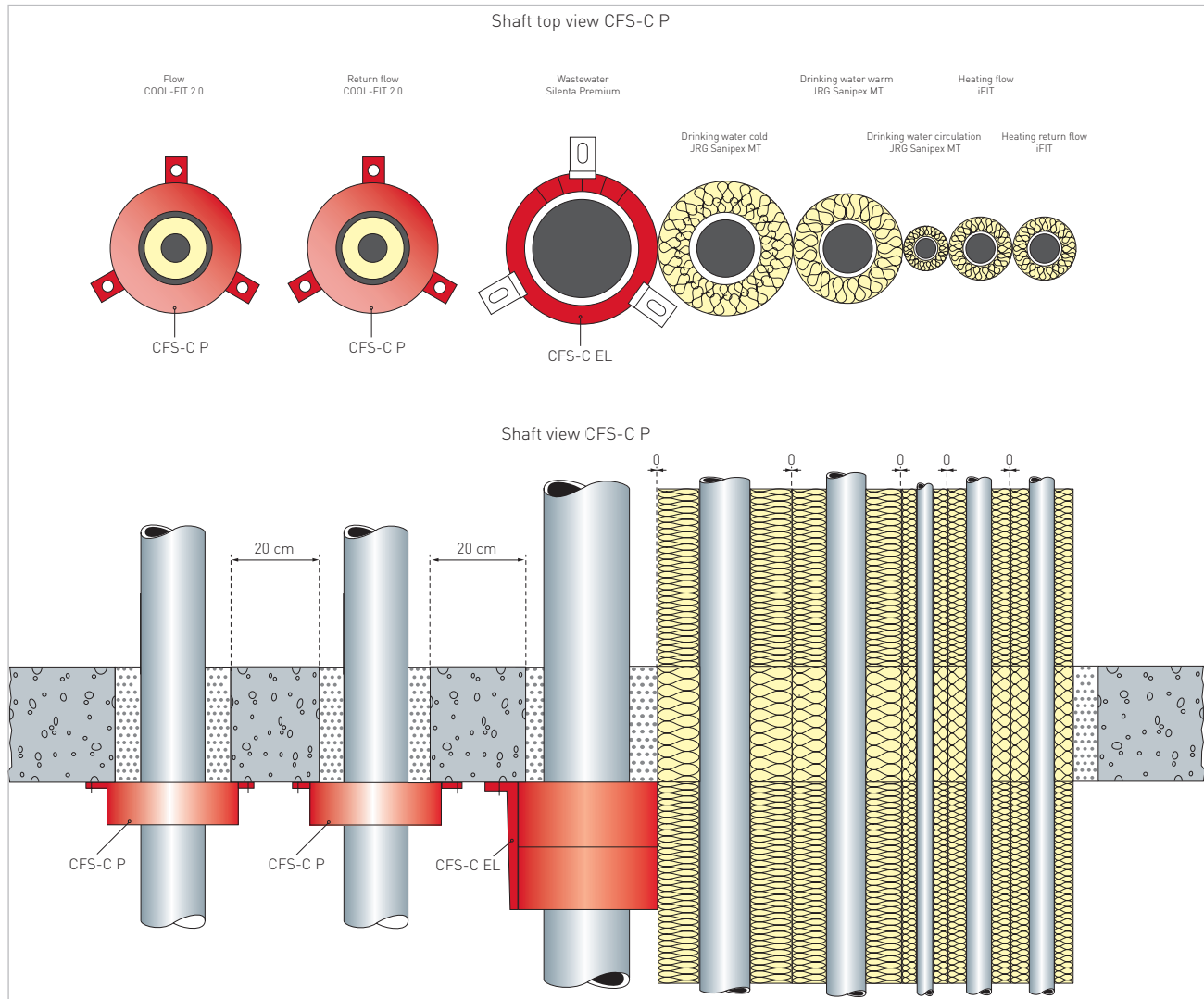
Distance of the pipe sealing to	Size of the adjacent openings	Distance between the openings DE, CH	Distance between the openings EU
Other cable or pipe sealing	one/both openings > 40cm x 40cm	≥ 20cm	≥ 20cm
	Both openings ≤ 40cm	≥ 10cm	
Other openings or installed elements	one/both openings > 20cm x 20cm	≥ 20cm	≥ 20cm
	Both openings ≤ 20cm	≥ 10cm	

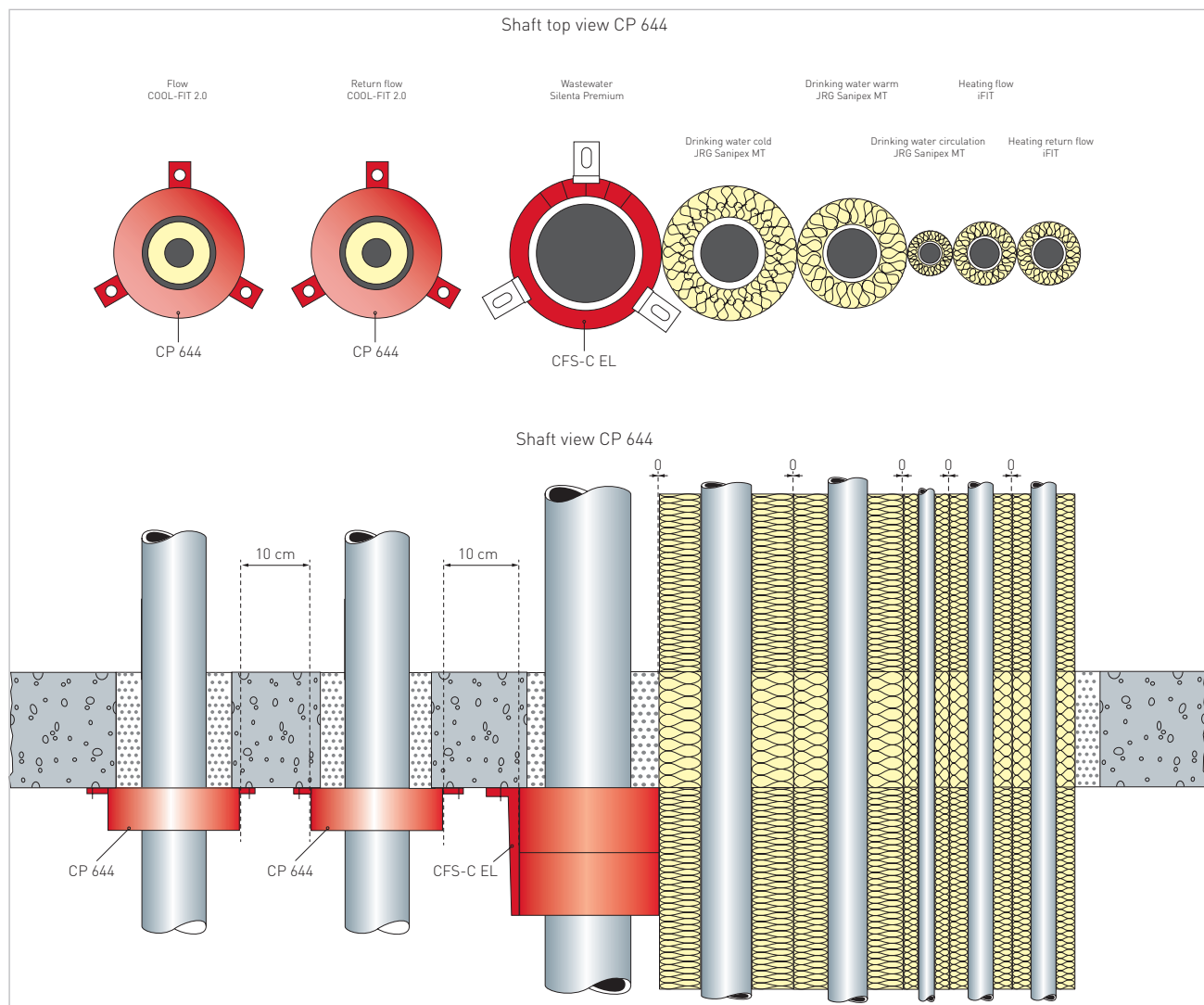
The following pipe distances between the openings of the pipe lead through are derived from this for pipe sealing with the Hilti firestop collar for COOL-FIT 2.0:



### Shaft installation

A shaft installation with additional pipelines, for example for heating and drinking water, may look as follows:





### Additional tested fire-retarding sealing

The following firestop collars were tested with COOL-FIT 2.0/2.0F pipes.

Fire-retarding sealing	Manufacturer	Approval
ROKU® AWM II	Rolf Kuhn GmbH	ETA 17/0753
BIS Pacifyre® AWM II	Walraven	ETA 17/0753

The firestop system ROKU® R – type AWM II carries the European technical approval ETA 17/0753. COOL-FIT 2.0/2.0F was tested with AWM II firestop collars.

For detailed product information on AWM II see [www.svt-global.com](http://www.svt-global.com).



## ROKU® System AWM II

### System description

The ROKU® system AWM II consists of a firestop collar housing, which is equipped on the inside with several layers of the highly effective intumescent material "ROKU® Strip." In case of fire, the foaming material reacts with a strong foaming pressure and permanently seals the construction component opening against fire and smoke. On walls, one collar should be fitted on each side, and on ceilings only one collar underneath the ceiling.

### Application areas

- Sealing of plastic pipes up to Ø 400 mm in solid walls, light partition walls, and solid ceilings
- For plastic pipes, mineral fiber-reinforced plastics, plastic composite pipes
- Suitable for insulated and non-insulated plastic pipes and acoustically insulating sewage pipes

## Solutions for emergency corridors

Within emergency corridors the use of only non-combustible materials is allowed. The supplier Rockwool offers with Rockwool 800 a protection sleeve, made of mineral wool, which allows the use of normal combustible pipe within emergency areas. This solution is approved on pipe outer diameters of up to 160 mm.

For detailed information about Rockwool 800 see:

[www.rockwool.de](http://www.rockwool.de)



## Roxtec RS PPS seal

### System description

The Roxtec RS PPS is a sealing for pipes through steel decks and bulkheads in vessels. The intumescent-based sealing strips that wrap around the plastic pipe ensure blocking of smoke, flames and water in case of fire.

Fire-retarding sealing	Manufacturer	Approval
Roxtec RS PPS und RS PPS/S	Roxtec International AB	MEDB000036A LR2090258SF

For detailed information about Roxtec see [www.roxtec.com](http://www.roxtec.com)

## 1.4.5 Hydraulic design

### Determination of pipe diameter based on flow rate (l/s)

As a first approximation, the required pipe cross-section for a certain flow rate can be calculated using the following formula

$$d_i = 18.8 \cdot \sqrt{\frac{Q_1}{v}} \quad \text{or} \quad d_i = 35.7 \cdot \sqrt{\frac{Q_2}{v}}$$

v	flow velocity (m/s)
d <sub>i</sub>	Pipe internal diameter (mm)
Q <sub>1</sub>	Flow rate (m <sup>3</sup> /h)
Q <sub>2</sub>	Flow rate (l/s)
18.8	Conversion factor for units Q <sub>1</sub> (m <sup>3</sup> /h)
35.7	Conversion factor for units Q <sub>2</sub> (l/s)

#### √ Example calculation of an internal diameter d<sub>i</sub>

COOL-FIT 2.0 pipe	SDR11
Flow rate Q <sub>2</sub>	8 l/s
Usual flow velocity v	1.5 m/s

$$d_i = 35.7 \cdot \sqrt{\frac{8}{1.5}} = 82.4 \text{ mm}$$

A pipe with d90/d140 is used. After the internal diameter has been determined that way, the actual flow rate is determined with the following formula:

$$v = 354 \cdot \frac{Q_1}{d_i^2} = 1.9 \frac{\text{m}}{\text{s}} \quad \text{or} \quad v = 1275 \cdot \frac{Q_2}{d_i^2} = 1.9 \frac{\text{m}}{\text{s}}$$

v	Flow velocity v (m/s)
d <sub>i</sub>	Pipe internal diameter (mm)
Q <sub>1</sub>	Flow rate (m <sup>3</sup> /h)
Q <sub>2</sub>	Flow rate (l/s)
354	Conversion factor for units Q <sub>1</sub> (m <sup>3</sup> /h)
1275	Conversion factor for units Q <sub>2</sub> (l/s)

### Determination of pipe diameter based on cooling capacity (kW)

As a first approximation, the required pipe cross section for a certain cooling capacity can be calculated using the following formula.

$$d_i = 18.8 \cdot \sqrt{\frac{Q_L \cdot 3600}{\Delta T \cdot c \cdot \rho \cdot v}}$$

d <sub>i</sub>	Pipe inner diameter (mm)
Q <sub>L</sub>	Cooling capacity in kW
ΔT	Temperature difference supply - return (K)
c	Specific heat capacity (kW*s/(kg*K))
ρ	Density of the medium (kg/m <sup>3</sup> )
v	Flow velocity (m/s)

√ Example for calculating the inner diameter  $d_i$  based on cooling capacity with water medium water

Cooling capacity $Q_L$	200 kW
Specific heat capacity (20 °C) $c$	4.187 kJ/(kg·K)
Water density (20 °C) $\rho$	998.2 kg/m <sup>3</sup>
Temperature difference $\Delta T$	10 K
Flow velocity $v$	1.5 m/s

$$d_i = 18.8 \cdot \sqrt{\frac{\left(\frac{200 \cdot 3600}{10 \cdot 4.187 \cdot 998.2}\right)}{1.5}} = 18.8 \cdot \sqrt{\frac{17.227}{1.5}} = 63.71 \text{ mm}$$

The flow rate should be estimated on the basis of the intended purpose of the pipe. As a guide for the flow rate, the following specifications apply.

#### Liquids

$v = 0.5 - 1.0$  m/s for the suction side

$v = 1.0 - 3.0$  m/s for the pressure side

#### Gases

$v = 10 - 30$  m/s

This method of calculation of pipe diameter does not allow for hydraulic losses. They must be calculated separately. The following sections serve that purpose.

(m <sup>3</sup> /h)	(l/min)	(l/s)	(m <sup>3</sup> /s)
1.0	16.67	0.278	$2.78 \times 10^{-4}$
0.06	1.0	0.017	$1.67 \times 10^{-5}$
3.6	60	1.0	$1.00 \times 10^{-3}$
3'600	60'000	1'000	1.0

Conversion table with units of flow rate.

#### Correlation of outer diameter - inner diameter

To determine the outer diameter based on the internal diameter and SDR, the following formula can be used:

$$d = d_i \cdot \frac{\text{SDR}}{\text{SDR} - 2}$$

#### Correlation between pipe external and internal diameter

$d_i$ (mm)	16	20	26	33	41	52	61	74	90	102	115
$d$ (mm)	20	25	32	40	50	63	75	90	110	125	140

### 1.4.6 Nomogram for easy calculation of diameter and pressure loss

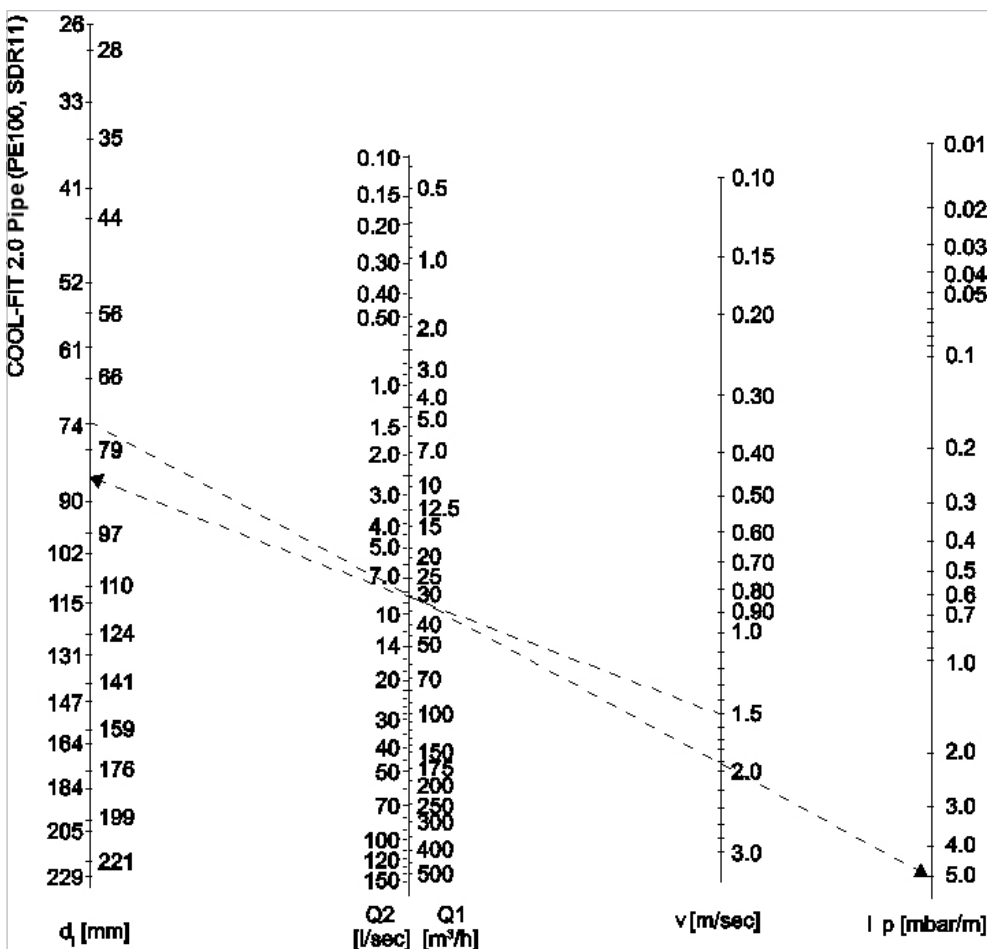
The nomogram below can be used to simplify the determination of the diameter required. The pressure loss in the pipe can be read off per meter of the pipe length.

**⚠** The pressure loss calculated using the nomogram only applies to flows of substances with density 1000 kg/m<sup>3</sup>, i.e. water. Further pressure losses from fittings, valves, etc. also need to be considered using the instructions that follow.

#### Using the nomogram

Based on a flow velocity of 1.5 m/s, a line is drawn through the desired flow rate (i.e. 30 m<sup>3</sup>/h) to the axis which shows an internal diameter  $d_i$  ( $\approx$  84 mm). Here, a closely matching diameter (74 mm for SDR11) and a second line is drawn back through the desired flow rate to the pressure drop axis  $\Delta p$  (5 mbar per meter of pipe).

Nomogram for COOL-FIT 2.0 pipe (PE, SDR11) using the metric system.



**i** For detailed information on the determination of diameter and pressure loss, see Planning Fundamentals "Hydraulic calculation and pressure losses of metric industrial piping systems".

## 1.4.7 Pressure loss

### Pressure loss in straight pipe

In determining pressure losses in straight pipe sections, a distinction is made between laminar and turbulent flows. The Reynolds number (Re) determines this. The change from laminar to turbulent occurs at the critical Reynolds number  $Re_{crit} = 2320$ .

In practice laminar flows occur particularly for the movement of viscous liquids such as lubricating oils. In most applications, thus including flows of aqueous materials, there is turbulent flow with a substantially more uniform velocity distribution over the pipe cross-section than in laminar flow.

The pressure loss in a straight pipe section is inversely proportional to the pipe diameter and is calculated as follows:

$$\Delta p_R = \lambda \cdot \frac{L}{d_i} \cdot \frac{\rho}{2 \cdot 10^2} \cdot v^2$$

$\Delta p_R$	Pressure loss in the straight pipe run (bar)
$\lambda$	Pipe friction factor = 0.02
L	Length of the straight pipe section (m)
$d_i$	Inner diameter of the pipe (mm)
$\rho$	Density of the flow material ( $\text{kg/m}^3$ ) ( $1 \text{ g/cm}^3 = 1000 \text{ kg/m}^3$ ) for water $20^\circ\text{C} = 998.2 \text{ kg/m}^3$
v	Flow velocity v (m/s)



In practice, when making a rough calculation (i.e. smooth plastic pipe and turbulent flow) it is enough to use the value  $\lambda = 0.02$  to represent the hydraulic pressure loss.

### Pressure losses COOL-FIT 2.0 fittings

#### Coefficient of resistance

The pressure losses depend upon the type of fitting as well as on the flow in the fitting. The so-called coefficient of resistance ( $\zeta$ -value) is used for calculations.

Fitting type	Coefficient of resistance $\zeta$	
Elbow $90^\circ$	1.2	
Elbow $45^\circ$	0.3	
T- $90^\circ$ <sup>1)</sup>	1.3	
Reducer (contraction)	0.5	
Reducer (enlargement)	1.0	
Connections (couplers, unions, flanges)	d20: 1.0 d25: 0.9 d32: 0.8 d40: 0.7	d50: 0.6 d63: 0.4 d75: 0.3 d90: 0.1 >d90: 0.1
Flexible hoses	$\frac{1}{2}$ " : 2.0 $\frac{3}{4}$ " : 1.8 1" : 1.4	$1 \frac{1}{4}$ " : 1.1 $1 \frac{1}{2}$ " : 1.0 2" : 0.8

<sup>1)</sup> For a more detailed view, differentiate between coalescence and separation. Values for  $\zeta$  up to a maximum of 1.3 can be found in the respective literature. Usually the part of a tee in the overall pressure loss is very small, therefore in most cases  $\zeta = 1.3$  can be used.

### Calculation of the pressure loss

To calculate the total pressure loss in all fittings in a piping system, take the sum of the individual losses, i. e. the sum of

all the  $\zeta$ -values. The pressure loss can then be calculated according to the following formula:

$$\Delta p_{Fi} = \sum \zeta \cdot \frac{v^2}{2 \cdot 10^5} \cdot \rho$$

$\Delta p_{Fi}$     Pressure loss of all fittings (bar)  
 $\sum \zeta$         Sum of all individual losses  
 $v$             Flow velocity  $v$  (m/s)  
 $\rho$             Density of the medium in  $\text{kg/m}^3$  ( $1 \text{ g/cm}^3 = 1000 \text{ kg/m}^3$ )

### Pressure losses in valves

The  $k_v$  factor is a convenient means of calculating the hydraulic flow rates for valves. It allows for all internal resistances and for practical purposes is regarded as reliable. It is defined as the flow rate of water in liters per minute with a pressure drop of 1 bar across the valve. The technical data of the Georg Fischer Piping Systems valves contains the  $k_v$  values as well as pressure loss charts. The latter make it possible to read off the pressure loss directly. But the pressure loss can also be calculated from the  $k_v$  value according to the following formula:

$$\Delta p_{Ar} = \left( \frac{Q}{k_v} \right)^2 \cdot \frac{\rho}{1000}$$

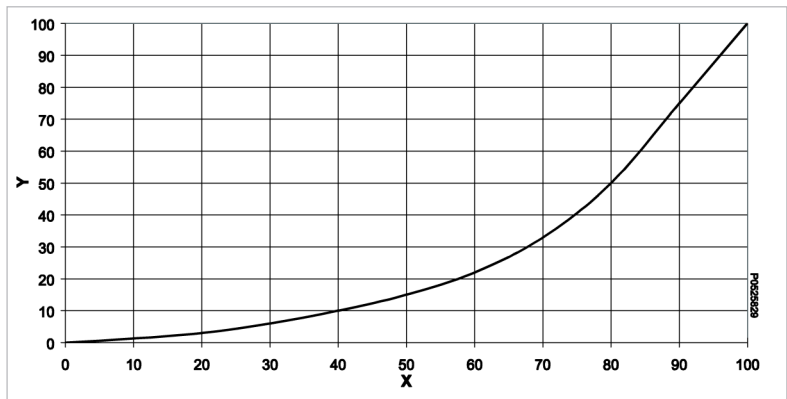
$\Delta p_{Ar}$     Pressure loss for the valve (bar)  
 $Q$          Flow rate ( $\text{m}^3/\text{h}$ )  
 $\rho$          Density of the conveyed medium ( $\text{kg/m}^3$ ) ( $1 \text{ g/cc} = 1000 \text{ kg/m}^3$ )  
 $k_v$         Valve characteristic value ( $\text{m}^3/\text{h}$ )

#### $k_v$ 100-Werte

DN (mm)	Zoll (inch)	d (mm)	$k_v$ 100 (l/min)	$C_v$ 100 (gal/min)	$k_v$ 100 ( $\text{m}^3/\text{h}$ )
25 <sup>1</sup>	1	32	700	49.0	42
32 <sup>1</sup>	1 ¼	40	1'000	70.0	60
40 <sup>1</sup>	1 ½	50	1'600	112.0	96
50 <sup>1</sup>	2	63	3'100	217.1	186
65 <sup>1</sup>	2 ½	75	5'000	350.0	300
80 <sup>1</sup>	3	90	7'000	490.0	420
100 <sup>2</sup>	4	110	3'800	455	390
125 <sup>2</sup>	5	140	8'600	602	516

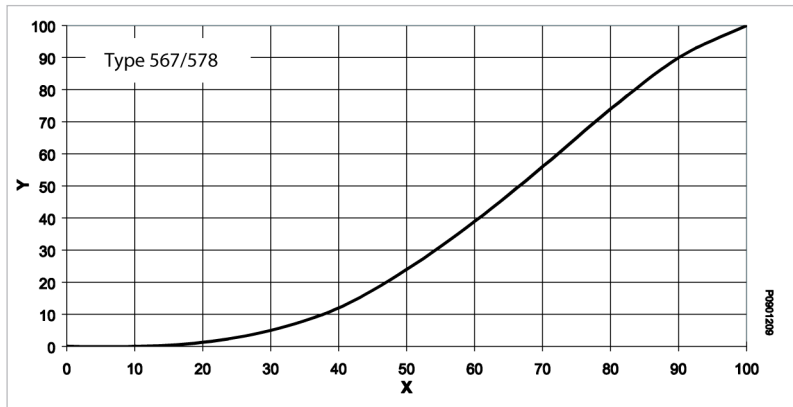
- <sup>1</sup> COOL-FIT 2.0 Ball valve
- <sup>2</sup> COOL-FIT 2.0 Butterfly valve

#### Flow characteristic Ball valve



- X Opening angle (%)
- Y  $k_v$ ,  $C_v$  value (%)

## Flow characteristic butterfly valve



X Opening angle (%)  
Y  $k_v$ ,  $C_v$  value (%)

## Pressure difference between the static pressure

If the piping system is installed vertically, then a geodetic pressure difference must be calculated for it. This pressure difference is calculated as follows:

$$\Delta p_{\text{geod}} = \Delta H_{\text{geod}} \cdot \rho \cdot 10^{-4}$$

$\Delta p_{\text{geod}}$  Geodetic pressure difference (bar)

$\Delta H_{\text{geod}}$  Difference in elevation of the piping system (m)

$\rho$  Density of the medium ( $\text{kg}/\text{m}^3$ ) ( $1 \text{ g}/\text{cm}^3 = 1000 \text{ kg}/\text{m}^3$ )



At closed systems, the geodetic pressure difference does not need to be considered

## Sum of pressure losses

The sum of all pressure drops for a piping system is calculated as follows:

$$\Sigma \Delta p = \Delta p_R + \Delta p_{Fi} + \Delta p_{Ar} + \Delta p_{\text{geo}}$$



## Example for pressure drop calculations

The following example illustrates the calculation process for determining the pressure loss of a piping system.

		Number of Fittings
COOL-FIT 2.0 pipe	d40 mm	12 x 90° angle
SDR11 – flow rate	1.5 l/s	4 x 45° angle
Medium	Wasser	3 x T-piece
Density of the medium	1.0 $\text{g}/\text{cm}^3$	3 x screws
Length straight pipe	15 m	2 x flange connections
Height difference	2.0 m	1 x ball valve, 80 % opened

The wall thickness of the piping system can be calculated as follows with the SDR:

$$e = \frac{d}{\text{SDR}} = \frac{40 \text{ mm}}{11} = 3.6 \text{ mm}$$

The inner diameter of the piping system is as follows:

$$d_i = d - 2 \cdot e = d - \frac{2 \cdot d}{\text{SDR}} = 32.8 \text{ mm}$$

With the desired flow rate of 1.5 l/s, the flow velocity is as follows:

$$v = 1275 \cdot \frac{Q_2}{d_i^2} = 1275 \cdot \frac{1.5}{32.8^2} \frac{\text{m}}{\text{sec}} = 1.78 \frac{\text{m}}{\text{sec}}$$

Pressure loss	Formula
Pressure loss for straight pipe sections	$\Delta p_R = 0.02 \cdot \frac{15}{32.8} \cdot \frac{1000}{2 \cdot 10^2} \cdot 1.78^2 = 0.14 \text{ bar}$
Pressure loss for fittings incl. connections	$\Sigma \zeta = (12 \cdot 1.2) + (4 \cdot 0.3) + (3 \cdot 1.3) + (5 \cdot 0.7) = 23$ $\Delta p_{Fi} = 23 \cdot \frac{1.78^2}{2 \cdot 10^5} \cdot 1000 = 0.36 \text{ bar}$
Pressure loss for the valve 80 % opened. With the flow characteristics diagram for ball valves type 546, from an 80% open angle a percentile kv value of 50 % can be read out, that means 50 % of the kv value 100: 0.5 * 60 m <sup>3</sup> /h (flow rate 1.5 l/s = 5.4 m <sup>3</sup> /h)	$\Delta p_{Ar} = \left( \frac{5.4}{0.5 \cdot 60} \right)^2 \cdot \frac{1000}{1000} = 0.03 \text{ bar}$
Pressure loss of height difference	$\Delta p_{geod} = 2.0 \cdot 1000 \cdot 10^{-4} = 0.2 \text{ bar}$
Whole pressure loss of the piping	$\Sigma \Delta p = 0.14 \text{ bar} + 0.36 \text{ bar} + 0.03 \text{ bar} + 0.2 \text{ bar} = 0.73 \text{ bar}$

Formulas for calculating pressure losses

### Pressure losses for pipes – The basics

Designation	Value [m/s]	
	SVGW W3*	EN 806-3:2006**
Discharge pipeline	max. 4.0	4.0
Groups of equipment	max. 3.0	–
Pipelines on individual floor levels	max. 3.0	2.0
Distribution pipelines	max. 2.0	2.0

Flow velocities

\* recommended (acc. to SVGW - Swiss Gas and Wate Industry Association Guideline W3/2013)

\*\* The values given are based on the following flow velocities:

Collective feed lines, risers, floor lines: max. 2.0 m/s

Single feeders: max. 4.0 m/s

### Pressure losses COOL-FIT 2.0 Push System

**i** A loading unit LU is equal to a flow of 0.1 l/s.

Pipe, Dimension	Pressure loss [hPa/m pipe (= mbar/m)]					
	LU [l/s]	1	2	3	4	5
d16		13.3	44.5	91.0	150.5	–
d20		3.8	12.5	26.0	42.5	63.0
d25		–	–	6.6	11.0	16.0
d32		–	–	–	–	4.6



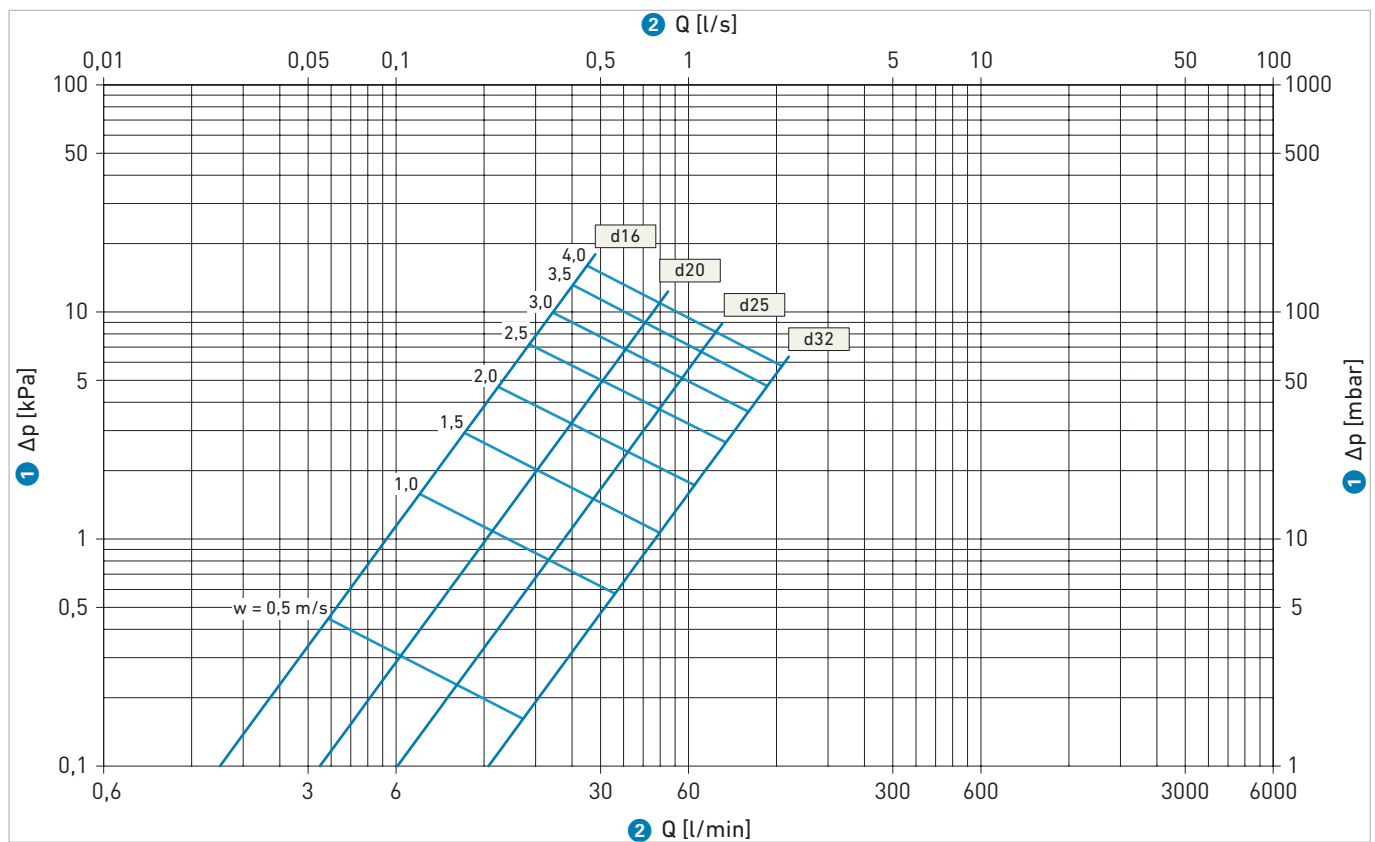
## Pressure losses at 10°C

### The basics

Designation	Value
Dimension	d16 – d32
Density $\rho$ (water)	999.70 kg/m <sup>3</sup>
Water temperature	10°C
Surface roughness k (inner pipe)	0.007 mm
Viscosity	0.00131 Pa · s

### Pipe friction pressure drop as a function of the volumetric flow

The diagram and the tables show the pipe friction pressure drop  $R$  and the calculated flow velocity  $v$  as a function of the volumetric flow  $Q$ .



## T5.2 Pipe friction pressure drop, flow velocity, peak flow

d	16		20		25		32	
DN	12		15		20		25	
Q	v	R	v	R	v	R	v	R
[l/s]	[m/s]	[hPa/m]	[m/s]	[hPa/m]	[m/s]	[hPa/m]	[m/s]	[hPa/m]
0.01	0.1	0.2	0.0	0.1	–	–	–	–
0.02	0.2	0.7	0.1	0.2	–	–	–	–
0.03	0.3	1.4	0.1	0.3	0.1	0.1	–	–
0.04	0.4	2.3	0.2	0.6	0.1	0.2	–	–
0.05	0.4	3.4	0.2	0.8	0.2	0.3	–	–
0.06	0.5	4.7	0.3	1.2	0.2	0.4	–	–
0.07	0.6	6.1	0.3	1.5	0.2	0.5	0.1	0.1
0.08	0.7	7.7	0.4	1.9	0.3	0.7	0.2	0.2
0.09	0.8	9.5	0.4	2.4	0.3	0.8	0.2	0.2
0.10	0.9	11.4	0.5	2.9	0.3	1.0	0.2	0.3
0.15	1.3	23.3	0.7	5.8	0.5	2.0	0.3	0.6
0.20	1.8	38.5	1.0	9.7	0.6	3.3	0.4	0.9
0.25	2.2	57.0	1.2	14.3	0.8	4.9	0.5	1.4
0.30	2.7	78.5	1.5	19.7	1.0	6.8	0.6	1.9
0.35	3.1	102.9	1.7	25.9	1.1	8.9	0.7	2.5
0.40	3.5	130.1	2.0	32.7	1.3	11.2	0.8	3.2
0.45	4.0	160.0	2.2	40.2	1.4	13.8	0.8	3.9
0.50	–	–	2.5	48.4	1.6	16.6	0.9	4.7
0.55	–	–	2.7	57.2	1.8	19.6	1.0	5.6
0.60	–	–	3.0	66.6	1.9	22.8	1.1	6.5
0.65	–	–	3.2	76.7	2.1	26.3	1.2	7.5
0.70	–	–	3.5	87.4	2.2	29.9	1.3	8.5
0.75	–	–	3.7	98.6	2.4	33.8	1.4	9.6
0.80	–	–	4.0	110.4	2.5	37.8	1.5	10.7
0.85	–	–	–	–	2.7	42.1	1.6	11.9
0.90	–	–	–	–	2.9	46.5	1.7	13.2
0.95	–	–	–	–	3.0	51.2	1.8	14.5
1.00	–	–	–	–	3.2	56.0	1.9	15.9
1.05	–	–	–	–	3.3	61.0	2.0	17.3
1.10	–	–	–	–	3.5	66.2	2.1	18.8
1.15	–	–	–	–	3.7	71.5	2.2	20.3
1.20	–	–	–	–	3.8	77.1	2.3	21.9
1.25	–	–	–	–	4.0	82.8	2.4	23.5
1.30	–	–	–	–	–	–	2.4	25.2
1.35	–	–	–	–	–	–	2.5	26.9
1.40	–	–	–	–	–	–	2.6	28.7
1.45	–	–	–	–	–	–	2.7	30.5
1.50	–	–	–	–	–	–	2.8	32.4
1.55	–	–	–	–	–	–	2.9	34.3
1.60	–	–	–	–	–	–	3.0	36.3
1.65	–	–	–	–	–	–	3.1	38.3
1.70	–	–	–	–	–	–	3.2	40.3
1.75	–	–	–	–	–	–	3.3	42.4
1.80	–	–	–	–	–	–	3.4	44.6
1.85	–	–	–	–	–	–	3.5	46.8
1.90	–	–	–	–	–	–	3.6	49.0
1.95	–	–	–	–	–	–	3.7	51.3
2.00	–	–	–	–	–	–	3.8	53.6
2.10	–	–	–	–	–	–	4.0	58.4

## Pressure losses for system parts

The  $\zeta$  values and the equivalent lengths of the pipelines were determined in accordance with the specifications of the SVGW (SV EN 1267).

### i Loading unit and $\zeta$ value

A loading unit LU is equal to a flow of 0.1 l/s.

The  $\zeta$  value for  $w = 2$  m/s, as shown in the table.

## Simplified representation for 1 loading unit (LU)

### T5.3 Pressure losses in iFIT system parts

Designation	Symbol	Dimension	$\zeta$ value	Equivalent length of pipeline [m]	
90° angle		d16	6.3	2.98	
		d20	8.7	5.81	
		d25	5.2	4.88	
		d32	11.0	12.57	
Pipe bend 90°, bent manually		d16	0.1	0.05	
		d20	0.1	0.06	
		d25	0.1	0.09	
		d32	0.1	0.10	
Pipe bend 45°, bent manually		d16	0.1	0.05	
		d20	0.1	0.06	
		d25	0.1	0.09	
		d32	0.1	0.10	
Tees	Flow rate		d16	3.8	1.80
			d20	4.8	3.21
			d25	2.8	2.36
			d32	6.4	7.32
Tee, reduced	Flow rate		d20-d16	3.1	1.47
			d25-d16	2.5	1.18
			d25-d20	3.4	2.27
			d32-d16	2.5	1.18
			d32-d20	3.4	2.27
Tees	Pipe branch		d32-d25	2.6	2.44
			d16	6.4	3.03
			d20	9.5	6.34
			d25	5.5	5.16
			d32	12.4	14.17
Tee, reduced	Pipe branch		d20-d16	4.6	2.18
			d25-d16	3.1	1.47
			d25-d20	5.0	3.34
			d32-d16	3.2	1.52
			d32-d20	4.7	3.14
Coupling			d32-d25	4.9	4.60
			d16	3.7	1.75
			d20	4.7	3.14
			d25	2.8	2.63
			d32	6.7	7.66
Reduction			d20-d16	3.1	1.47
			d25-d16	2.5	1.18
			d25-d20	3.4	2.27
			d32-d16	2.5	1.18
			d32-d20	3.3	2.20
			d32-d25	2.7	2.53

### 1.4.8 Dimension comparison COOL-FIT 2.0 / 2.0F vs metal

COOL-FIT 2.0 / 2.0F			Stainless steel		Copper pipe
d (mm)	d <sub>i</sub> (mm)	DN	Inch	d <sub>a</sub> (mm)	d <sub>a</sub> (mm)
32	26.3	25	1	33.4	28
40	32.6	32	1¼	42.2	35
50	40.8	40	1½	48.3	42
63	51.4	50	2	60.3	54
75	61.4	65	2½	73.0	76.1
90	73.6	80	3	88.9	88.9
110	90.0	100	4	114.3	108
140	114.6	125	5	141.3	

d Nominal external diameter of PE pipe  
 d<sub>i</sub> Nominal internal diameter of pipe

### 1.4.9 Z-dimension method

#### Overview

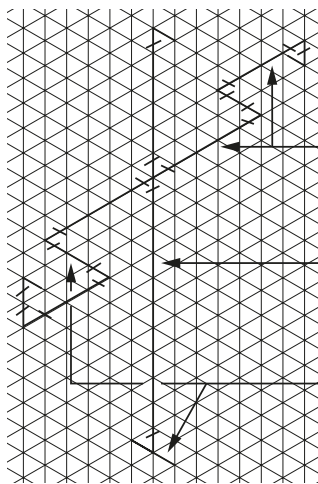
The pressure of competition and high costs on site makes it essential to install piping system systems efficiently. The GF Piping

Systems method of assembly is highly suited to this task. It replaces the tedious and time-consuming cutting to size of one pipe at a time by a fast and precise way of preparing whole groups of pipe according to plans or jigs.

The respective pipe group with the corresponding design dimensions and cut lengths can be entered in the isometric paper of GF Piping Systems.

Please adhere to the following guidelines for drawing:

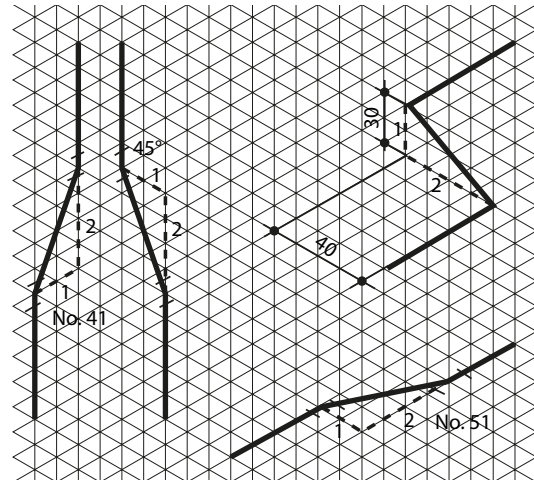
Pipe running perpendicular to one another	Pipe running diagonally
---	-------------------------



Horizontally:  
left and right

Vertical

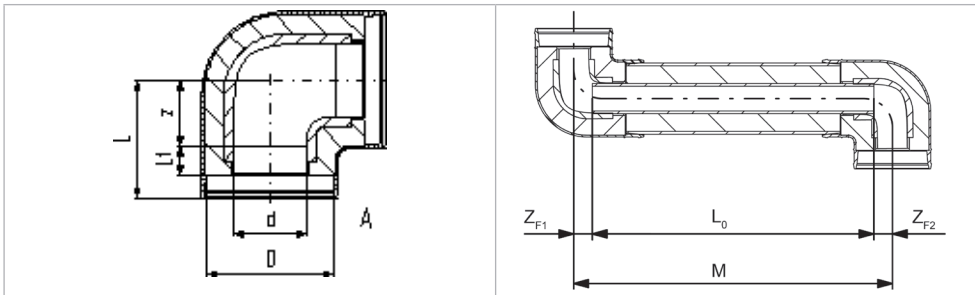
Horizontally:  
front and rear



The z-dimensions of the fittings are needed for determining the actual cutting lengths of the pipe. The tables in our product ranges and in the online catalogues contain all the relevant data for the fittings. The length of pipe to be cut is given as in the following diagram by the distance between the center of adjoining fittings less the sum of the z-dimension of the fittings.

## Procedure

### Electrofusion



L laid pipe length

### Formula for determining the required pipe length

$$L_0 = M - Z_{F1} - Z_{F2}$$

$L_0$  Pipe length to be cut

$M$  Center to center distance between fittings

$Z_{F1}$  z-measurement for fitting 1

$Z_{F2}$  z-measurement for fitting 2

### √ Example

Dimension	d32/D75
Center to center distance M	1'000 mm
z measurement for 90° elbow $Z_{F1}$	20 mm
z measurement for 90° elbow $Z_{F2}$	20 mm
M = 1000 mm; $L_0 = ?$	
$L_0 = 1000 \text{ mm} - 20 \text{ mm} - 20 \text{ mm} = 960 \text{ mm}$	

Measuring sheet

<b>+GF+</b>	<b>GEORG FISCHER</b> PIPING SYSTEMS	Firma _____ Firme _____ Ditta _____	Dat. _____	Ø	L cm	-cm	M-M	Pos.
		Unterteilungsblatt 30° Feuille de mesurage 30° Foglio per misura 30°	Blatt Nr. _____ Feuille No. _____ Foglio No. _____					
		Baobjekt _____ Bâtiment _____ Edificio _____						

### 1.4.10 Length changes and flexible sections

#### Overview

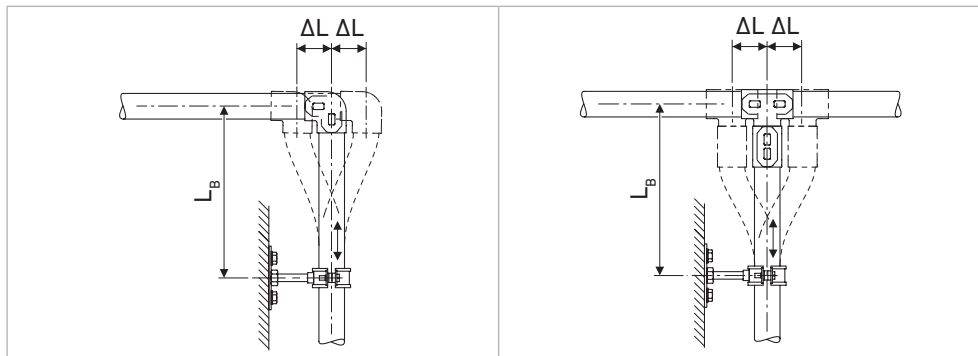
##### Length changes $\Delta L$ and expansion bend $L_B$ - General

Thermoplastics are subject to higher thermal expansion and contraction than metallic materials. Pipe installed above ground, against walls or in ducts, require changes in length to be taken up in order to prevent any superimposed extra strain on the pipe. This applies especially to pipe exposed to operating temperature variations.

To accommodate a change in length, the following options can be considered:

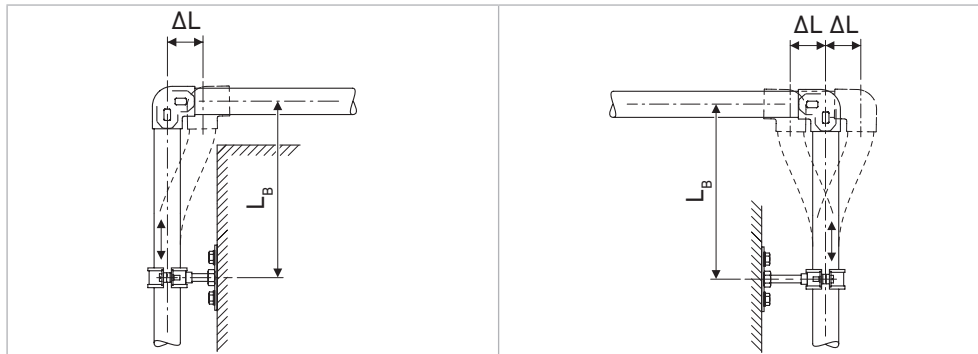
- A Flexible sections
- B Flexible hoses
- C Compensators

Flexible sections are the most common, the simplest and the most economical solution. The calculations for and the positioning of flexible sections are therefore described in detail.



#### Fundamentals

The low elasticity of thermoplastics allows changes in length to be taken up by special pipe sections, where pipe supports are positioned so that they can take advantage of the natural flexibility of the material. The length of such sections is determined by the diameter of the piping system and the extent of the thermal expansion to be compensated.



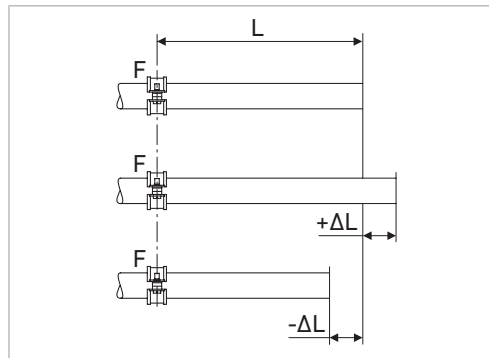
Flexible sections arise naturally at any branching or change in direction of the piping system. The movement  $L_B$  of the flexible section as a result of a change  $\Delta L$  in the length must not be restrained by fixed pipe brackets, wall protrusions, girders or the like.

**Calculation of length changes**

To determine the change in length due to temperature  $\Delta L$  (mm) of COOL-FIT 2.0 / 2.0F pipe, the following temperatures must be known:

**1. Installation temperature**

- Minimum flow temperature
- Maximum flow temperature
- Minimum ambient temperature
- Maximum ambient temperature



F Fixpoint  
L Length of pipe section

■ The following tables show changes in length at different media temperatures for certain conditions. To determine the change in length for other conditions, the Cooling Calculation Tool can be used. Contact your GF Piping Systems representative or visit [www.gfps.com](http://www.gfps.com)



**Example of use:**

Installation temperature	25 °C
Max. flow temperature	25 °C
Min. flow temperature	See table
Max. ambient temperature	25 °C
Min. ambient temperature	25 °C

Length change $\Delta L$ (mm) at 20° C flow temperature					Length change $\Delta L$ (mm) at 15° C flow temperature				
L (m)	25	50	100	150	L (m)	25	50	100	150
d32	-5	-10	-21	-31	d32	-11	-21	-42	-63
d40	-6	-12	-24	-36	d40	-12	-25	-49	-74
d50	-8	-16	-32	-48	d50	-16	-32	-65	-97
d63	-8	-17	-34	-51	d63	-17	-35	-69	-104
d75	-9	-18	-36	-54	d75	-18	-36	-73	-109
d90	-10	-20	-40	-59	d90	-20	-40	-80	-120
d110	-11	-22	-44	-66	d110	-22	-45	-90	-134
d140	-11	-23	-45	-68	d140	-23	-46	-91	-137

L laid pipe length

Length change $\Delta L$ (mm) at 10° C flow temperature					Length change $\Delta L$ (mm) at 5° C flow temperature				
L (m)	25	50	100	150	L (m)	25	50	100	150
d32	-16	-32	-65	-97	d32	-22	-44	-88	-132
d40	-19	-38	-75	-113	d40	-26	-51	-102	-154
d50	-25	-49	-99	-148	d50	-33	-67	-133	-200
d63	-26	-53	-105	-158	d63	-36	-71	-142	-213
d75	-28	-55	-111	-166	d75	-37	-75	-149	-224
d90	-30	-61	-122	-183	d90	-41	-82	-164	-246
d110	-34	-68	-136	-203	d110	-46	-91	-182	-273
d140	-34	-69	-138	-207	d140	-46	-93	-185	-278

L laid pipe length



## COOL-FIT 2.0F

Length change $\Delta L$ (mm) at 20° C flow temperature					Length change $\Delta L$ (mm) at 15° C flow temperature				
L (m)	25	50	100	150	L (m)	25	50	100	150
d32	-3	-6	-12	-17	d32	-6	-12	-24	-36
d40	-4	-7	-14	-21	d40	-7	-15	-29	-44
d50	-5	-10	-20	-29	d50	-10	-20	-40	-60
d63	-6	-12	-23	-35	d63	-12	-24	-47	-71
d75	-7	-13	-26	-39	d75	-13	-27	-54	-80
d90	-6	-13	-25	-38	d90	-13	-26	-52	-78
d110	-7	-15	-30	-45	d110	-15	-31	-61	-92
d140	-9	-17	-34	-51	d140	-17	-35	-70	-104

L laid pipe length

Length change $\Delta L$ (mm) at 10° C flow temperature					Length change $\Delta L$ (mm) at 5° C flow temperature				
L (m)	25	50	100	150	L (m)	25	50	100	150
d32	-9	-18	-37	-55	d32	-13	-25	-51	-76
d40	-11	-23	-45	-68	d40	-15	-31	-62	-92
d50	-15	-31	-62	-93	d50	-21	-42	-84	-126
d63	-18	-36	-73	-109	d63	-25	-49	-99	-148
d75	-20	-41	-82	-123	d75	-28	-56	-111	-167
d90	-20	-40	-80	-120	d90	-27	-54	-109	-163
d110	-23	-47	-93	-140	d110	-32	-63	-127	-190
d140	-26	-53	-106	-159	d140	-36	-72	-143	-215

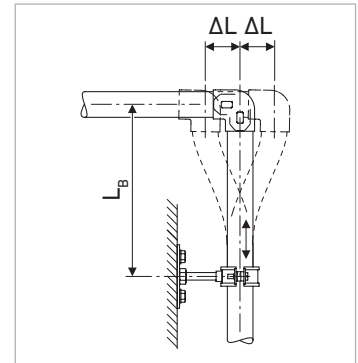
L laid pipe length

## Flexible sections for COOL-FIT 2.0 and COOL-FIT 2.0F

## Flexible section for COOL-FIT 2.0

The values for  $L_B$  (cm) from this table can be used for a given  $\Delta L$  (mm) and the relevant pipe size:

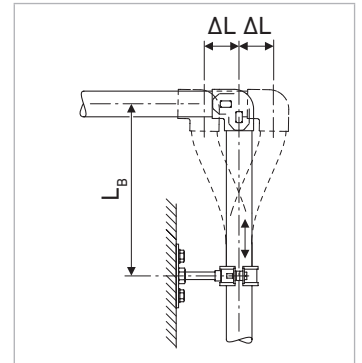
Flexible section $L_B$ (cm)													
$\Delta L$ (mm)	10	20	30	40	50	60	70	80	90	100	150	200	300
d32/75	71	101	123	142	159	174	188	201	214	225	276	318	390
d40/90	78	110	135	156	174	191	206	221	234	247	302	349	427
d50/90	78	110	135	156	174	191	206	221	234	247	302	349	427
d63/110	86	122	149	172	193	211	228	244	259	273	334	386	472
d75/125	92	130	159	184	206	225	243	260	276	291	356	411	503
d90/140	97	138	168	195	218	238	257	275	292	308	377	435	533
d110/160	104	147	180	208	233	255	275	294	312	329	403	465	570
d140/200	116	164	201	233	260	285	308	329	349	368	450	520	637



**Flexible section for COOL-FIT 2.0F**

The values for  $L_B$  (cm) from this table can be used for a given  $\Delta L$  (mm) and the relevant pipe size:

Flexible section $L_B$ (cm)													
$\Delta L$ (mm)	10	20	30	40	50	60	70	80	90	100	150	200	300
d32/75	92	130	159	183	205	225	243	259	275	290	355	410	503
d40/90	101	142	174	201	225	246	266	284	302	318	389	449	550
d50/90	101	142	174	201	225	246	266	284	302	318	389	449	550
d63/110	111	157	192	222	248	272	294	314	333	351	430	497	609
d75/125	118	168	205	237	265	290	313	335	355	375	459	530	649
d90/140	125	177	217	251	280	307	332	355	376	396	485	561	687
d110/160	134	190	232	268	300	328	355	379	402	424	519	599	734
d140/200	150	212	259	300	335	367	396	424	449	474	580	670	821



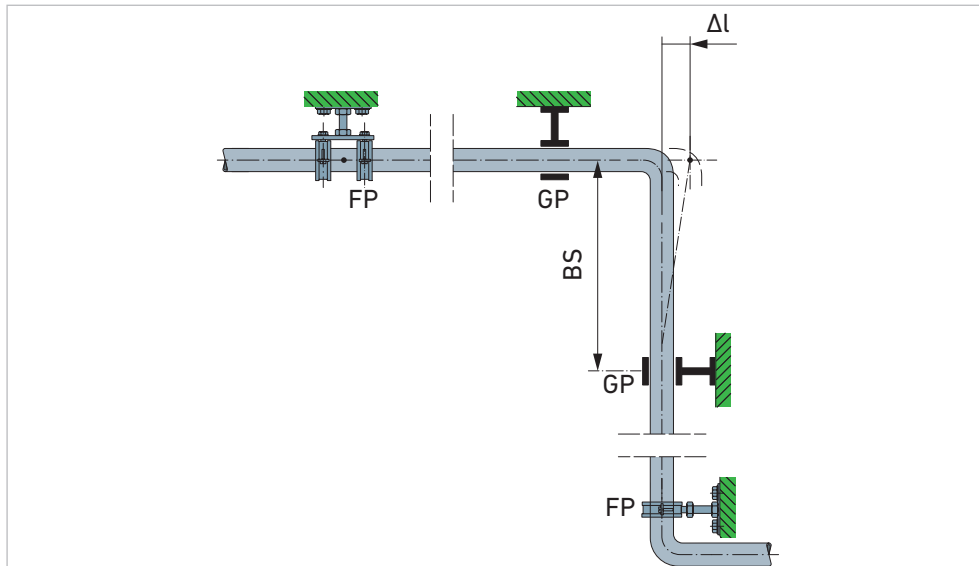
**Flexible section for COOL-FIT 2.0 Push System**

Medium	Cold water
Dimension	d16 – d32
Length of pipeline $L \leq 12$ m	If using insulated pipelines, compensation for the change in length does not require floating points and fixed points
Length of pipeline $L \geq 12$ m	If using insulated pipelines, compensation for the change in length does not require floating points and fixed points

**Calculation of the length of the flexible pipe leg**

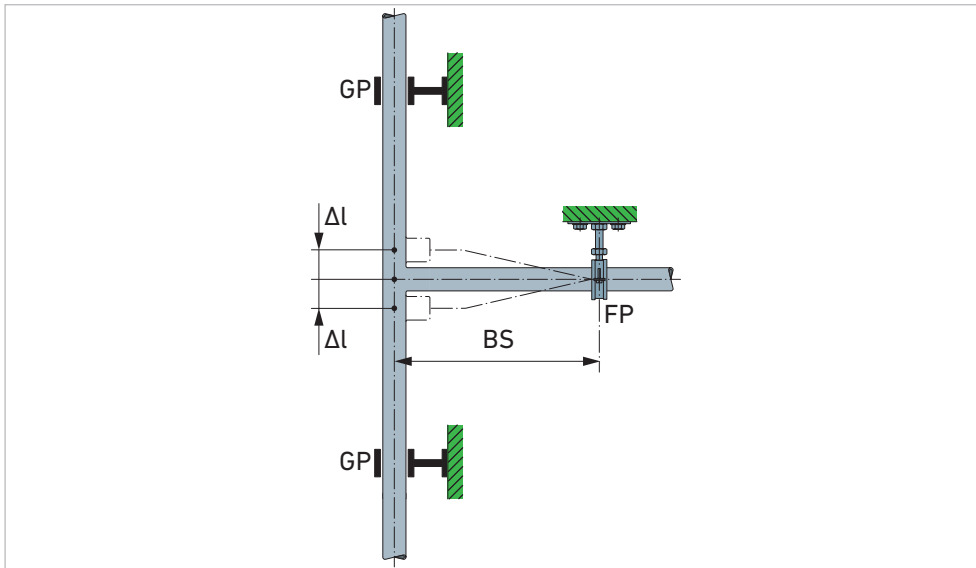
Due to the thermally induced change in length  $\Delta L$ , a pipeline shifts a pipe bend by a value  $\Delta L$ . This change must be absorbed by a flexible pipe leg with a length equal to  $L_{BS}$ .

**Length of flexible pipe leg**



- Length of flexible pipe leg**
- GP Floating point
- FP Fixed point
- BS Length of flexible pipe leg

Length of flexible pipe leg intended to use for the branch line



**Length of flexible pipe leg**  
 GP Floating point  
 FP Fixed point  
 BS Length of flexible pipe leg

The length of the flexible pipe leg BS is calculated from the change in length Δl and the outside diameter d of the pipe, using the following formula:

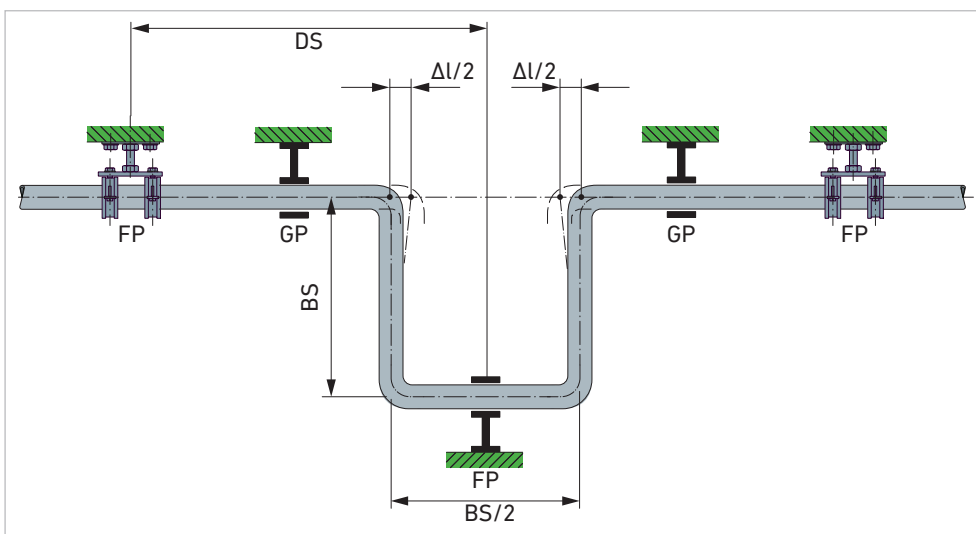
$$BS = C \cdot \sqrt{d \cdot \Delta l}$$

Symbol	Meaning	Unit	Remark
BS	Length of flexible pipe leg	[mm]	-
d	Pipe diameter	[mm]	-
Δl	Change in length	[mm]	-
C	Material constant	-	product/material-specific

Calculation of the length of the flexible pipe leg in a U-shaped expansion loop

Due to the thermally induced change in length Δl a pipe displaces a U-shaped loop at both bends by half the value Δl. This change must be absorbed by the two flexible pipe legs BS.

Length of the U-shaped expansion loop



**Length of the U-shaped expansion loop**  
 GP Floating point  
 FP Fixed point  
 BS Length of flexible pipe leg  
 DS Length of the 2D expansion loop

### √ Sample calculation using a multilayer composite pipe

The length of the pipeline is 7 m. The thermally induced change in length of this pipe section must be absorbed by a flexible pipe leg. The difference between the installation temperature and the maximum operating temperature is 60 K.

#### Example: Multilayer composite pipe, PE-RT

PE-RT pipe, dimension	d16
Material constant C	33
Change in length $\Delta l$	10.08 mm

#### Calculation of the length of the flexible pipe leg

$$BS = C \cdot \sqrt{d \cdot \Delta l}$$

$$BS = 33 \cdot \sqrt{(16 \text{ mm} \cdot 10.08 \text{ mm})}$$

$$BS = 419.1 \text{ mm}$$

In order to simplify the determination of the required length of the flexible pipe leg, a material-specific diagram can also be used to determine the length of the flexible pipe leg. When comparing this result with the result of a metal pipe—which has the same dimension—the size of a flexible pipe leg made of metal will be significantly larger. The explanation for this is the much higher material constant C for metal pipes than the material constant C for multilayer composite pipes.

- + Due to heat and depending on the material, pipelines expand to varying degrees. Even if the temperatures of the medium (e.g. drinking water) exceeds room temperature, this causes a thermal expansion and must be taken into account in the design of the installation.

### i How to calculate the change in length

In order to calculate the change in length, product and material-specific values are required:

- Technical data for system, Chapter [2.1]

This thermally induced change in length can be compensated during the installation and mounting of the pipe. Suitable measures are:

- Directional changes of the pipeline
- Providing expansion space
- Installation of expansion joints
- Setting the fixed points and floating points

The bending and torsional forces occurring during the operation of a pipeline are safely absorbed, taking into account the above-mentioned measures. The following parameters have a significant influence on the expansion compensation:

- Material
- Structural conditions
- Operating conditions

Minor changes in length of the pipelines, especially if using smaller dimensions, can be compensated for by the elasticity of the piping system or with a corresponding insulation.

For larger piping systems, the changes in length must be absorbed by the **expansion joints**: Insulations, flexible pipe legs and U-shaped expansion loops compensate for the thermally induced change in length. The required measures for GF's plastic piping systems are – depending on the type of installation:

Medium	Cold water	
Dimension	d16 – d32	
Length of pipeline $L \leq 12$ m	If using insulated pipelines, compensation for the change in length does <b>not</b> require floating points and fixed points	
Length of pipeline $L \geq 12$ m	If using insulated pipelines, compensation for the change in length does <b>not</b> require floating points and fixed points	Compensation for the change in length requires floating points and fixed points

Measures for the expansion compensation for plastic pipelines made by GF

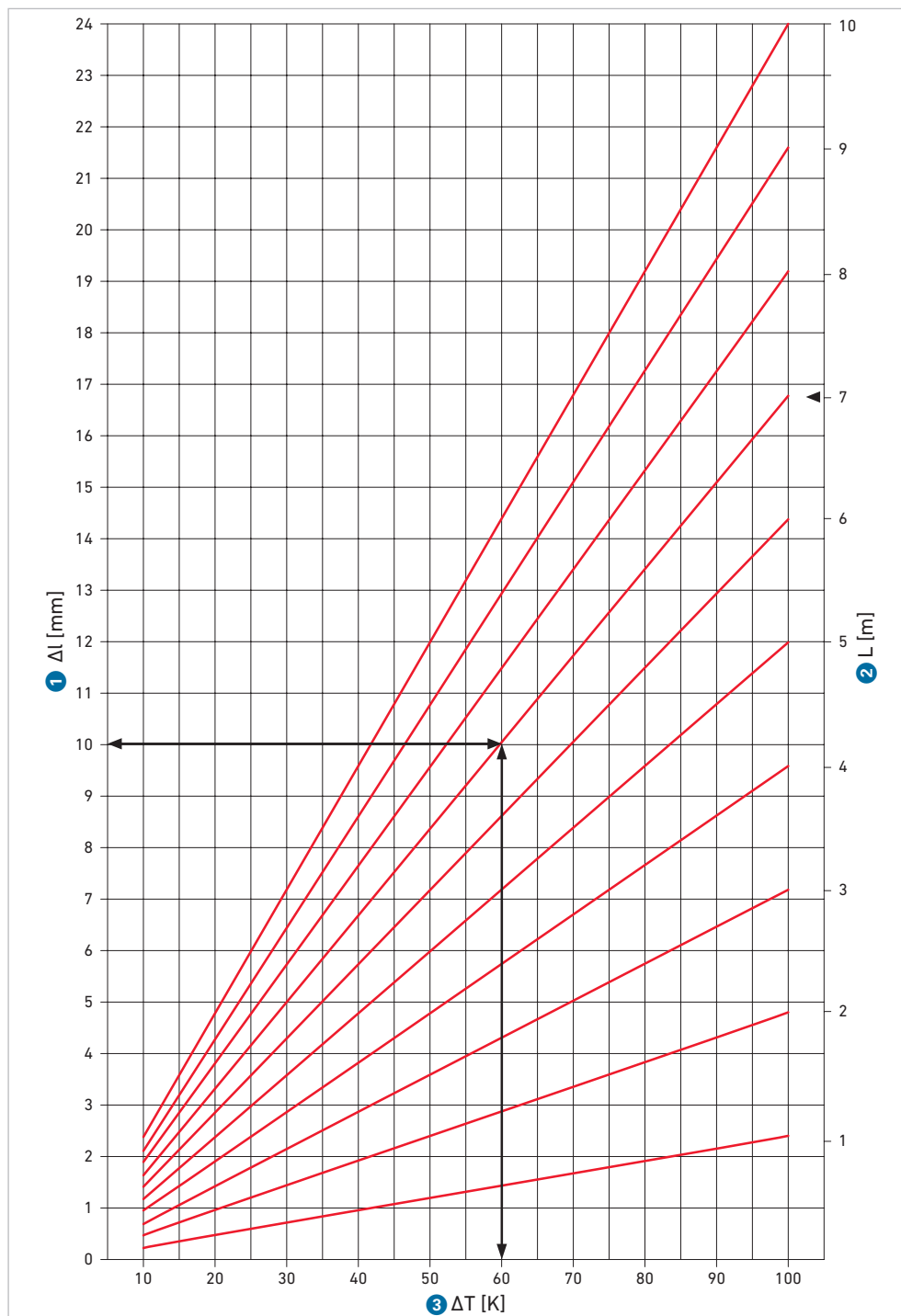
### Change in length COOL-FIT 2.0 Push System multilayer composite pipes (PE-RT)

The diagram shows the longitudinal expansion of COOL-FIT 2.0 Push System multi-layer composite pipes as a function of the temperature and length of the pipe when installed without resistance.



**How to read the table**

Multilayer composite pipe (PE-RT), Dimension	d16
Length of pipeline L	7.0 m
Linear coefficient of thermal expansion $\alpha$	0.024 mm/(m·K)
Temperature difference $\Delta T$	60 K
$\Delta l = 10.08 \text{ mm}$	



**Change in length - COOL-FIT 2.0 Push System pipes (PE-RT)**  
 1 Change in length  
 2 Length of pipeline  
 3 Temperature difference

## Change in length iFIT multilayer composite pipes (PE-RT)

## T5.4 Thermally induced change of length – COOL-FIT 2.0 Push System pipes (PE-RT)

Length of pipeline [m]	Temperature difference $\Delta T$ [K]					
	10	20	30	40	50	60 ▼
Change in length [mm]						
1	0.2	0.5	0.7	1.0	1.2	1.4
2	0.5	1.0	1.4	1.9	2.4	2.9
3	0.7	1.4	2.2	2.9	3.6	4.3
4	1.0	1.9	2.9	3.8	4.8	5.8
5	1.2	2.4	3.6	4.8	6.0	7.2
6	1.4	2.9	4.3	5.8	7.2	8.6
7 ▶	1.7	3.4	5.0	6.7	8.4	10.1
8	1.9	3.8	5.8	7.7	9.6	11.5
9	2.2	4.3	6.5	8.6	10.8	13.0
10	2.4	4.8	7.2	9.6	12.0	14.4
20	4.8	9.6	14.4	19.2	24.0	28.8
30	7.2	14.4	21.6	28.8	36.0	43.2
40	9.6	19.2	28.8	38.4	48.0	57.6
50	12.0	24.0	36.0	48.0	60.0	72.0

▶ Example for  $L = 7$  m:  $\Delta T = 60$  K

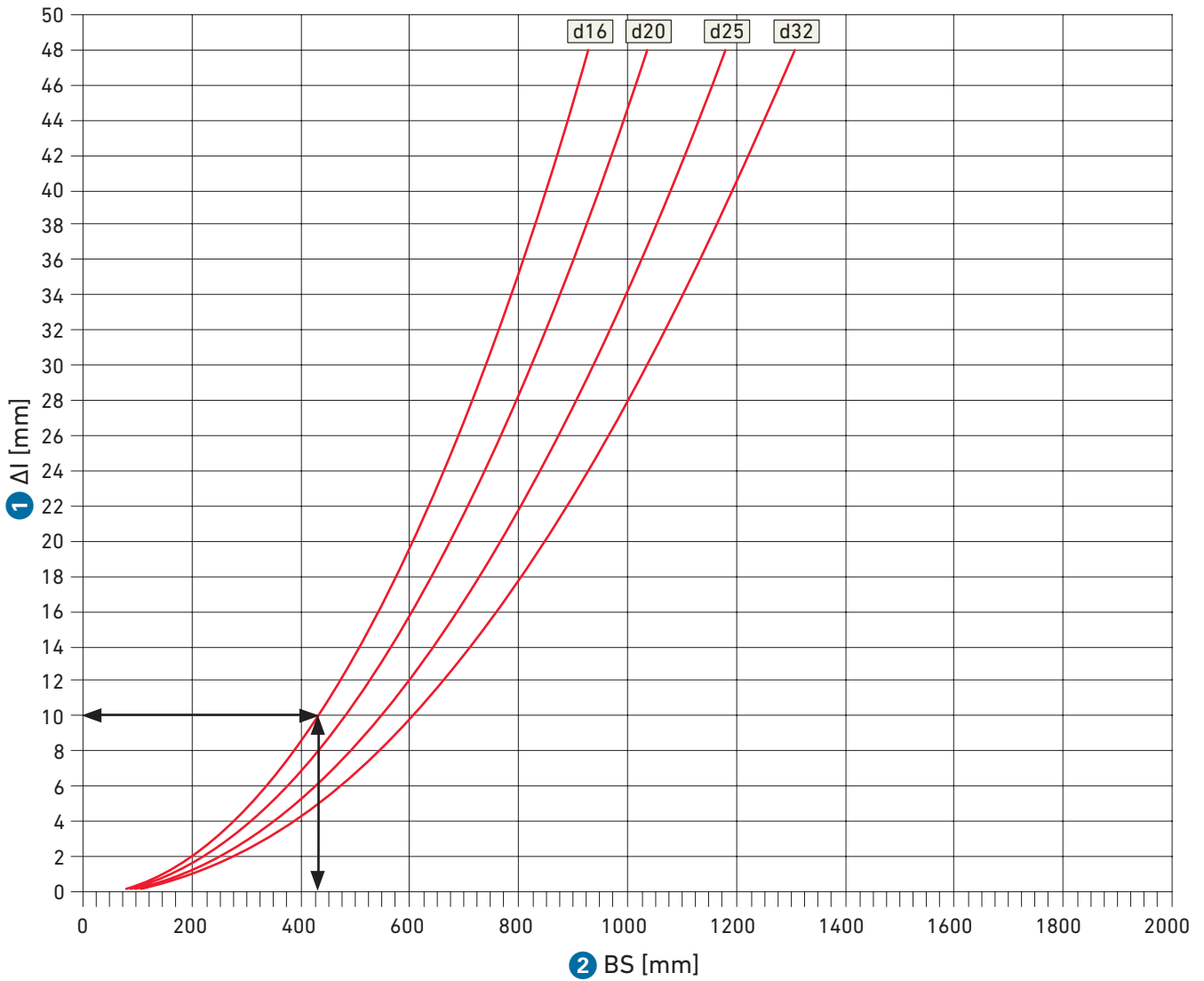
### Change of the flexible pipe leg iFIT multilayer composite pipes (PE-RT)

The length of the flexible pipe leg is derived from the pipe's change in length:

**How to read the table**

PE-RT pipe, dimension	d16
Material constant C	33
Change in length $\Delta l$	10.08 mm

**BS = 419.1 mm**



**Length of flexible pipe leg**  
 1 Change in length of the pipe  
 2 Length of flexible pipe leg



## Bending

Bending radius	Pipe	Polybutene pipe (PB)			Multilayer composite pipe (PE-RT / Al / PE)			
	Dimension	d16	d20	d25	d16	d20	d25	d32
Bending radius R, interchangeable: 8 · d [mm]		128	160	200	–	–	–	–
Bending radius R, manually: 5 · d [mm]		–	–	–	80	100	200	–
Bending radius R, with tool: 3.5 · d [mm]		–	–	–	56	70	98	112

Mounting distance	Pipe	Polybutene pipe (PB)			Multilayer composite pipe (PE-RT / Al / PE)			
	Dimension	d16	d20	d25	d16	d20	d25	d32
Mounting distances [mm]		1.0	1.0	1.0	1.0	1.0	1.5	2.0
Assembly with pipe saddles		1.5	1.5	2.5	1.5	1.5	2.0	2.5

## Bending methods

### Manual bending using a die

COOL-FIT 2.0 Push System pipes can be bent by hand without the use of bending tools.

### Hydraulic cylinders or bending springs

Commercially available hydraulic cylinders can be used, considering the following aspects:

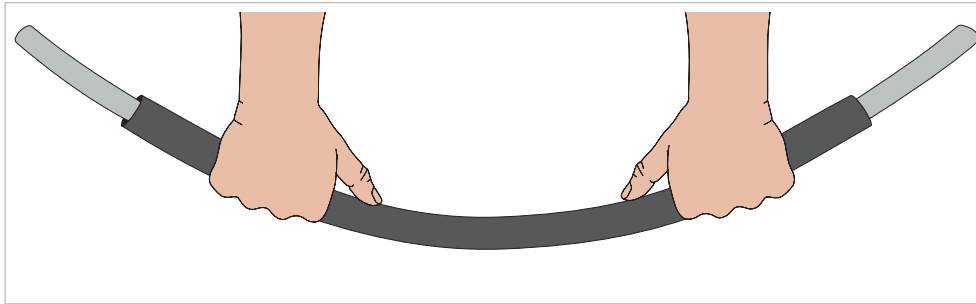
- The shape of the bending gauge must correspond with the outside diameter of the iFIT pipe.
- Do not use internal bending springs.
- Ensure the bending radius is not less than  $3.5 \cdot d$ .

### COOL-FIT 2.0 Push System multilayer composite pipe

COOL-FIT 2.0 Push System multilayer composite pipes can be bent by hand without the use of bending tools.

For each dimension, however, an **outside pipe bending tool** is also available as an aid.

COOL-FIT 2.0 Push System multi-layer composite pipes can be easily shaped into the desired angle with the outside pipe bending tool.



Bending the COOL-FIT 2.0 Push System multilayer composite pipe

Designation	Multilayer composite pipe (PE-RT / Al / PE)			
Nominal width DN	12	16	20	25
Outside diameter d [mm]	16	20	25	32
<b>Bending radius R</b>				
Bending radius R, with bending spring: $5 \cdot d$ [mm]	80	100	200	–
Bending radius R, with tool: $3.5 \cdot d$ [mm]	56	70	98	112

Minimum bending radii of the COOL-FIT 2.0 Push System multilayer composite pipe

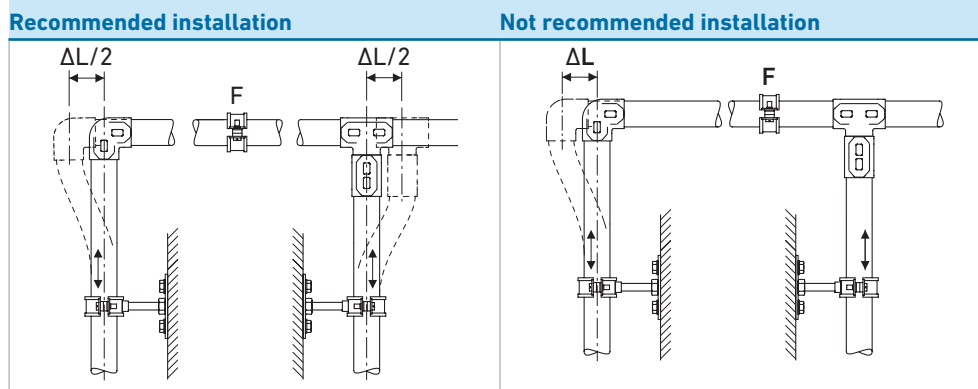
### ! NOTE! Risk of damaging the pipes due to improper bending!

- Ensure the pipes do not kink when bending them.
- Do not use internal bending springs.

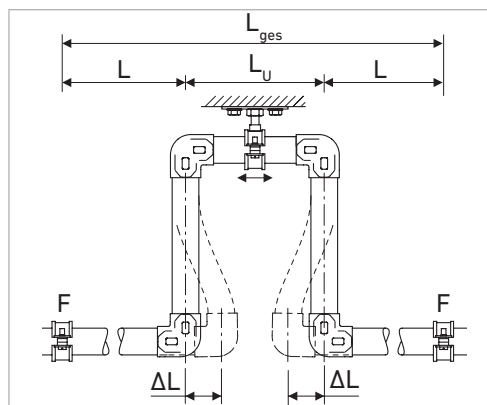
## 1.4.11 Installation

### Recommendations for installation

Length changes in pipe sections should always be accommodated through the arrangement of fixed brackets. The following examples show how the changes can be distributed in pipe sections by suitable positioning of fixed brackets:



Expansion loops can be installed to take up changes in length when flexible sections cannot be included at a change in direction or branch in the piping system or if substantial changes in the length of a straight section need to be taken up. In such a case the compensation for changes in length is distributed over two flexible sections.



Bending stress can lead to leaks in mechanical joints.

Do not use any unions or flanged connections close to expansion bends and loops.

### Pre-tensioning

In particularly difficult situations with large changes in one direction only, it is possible to pre-tensioning the flexible section during installation and thereby shorten its length  $L_B$ , as illustrated in the next example:



#### Example

Pipe length L	25 m
Diameter	d50/D90 mm
Installation temperature	25 °C
Min ambient temperature	25 °C konstant
Max ambient temperature	25 °C konstant
Min flow temperature	10 °C
Max flow temperature	25 °C

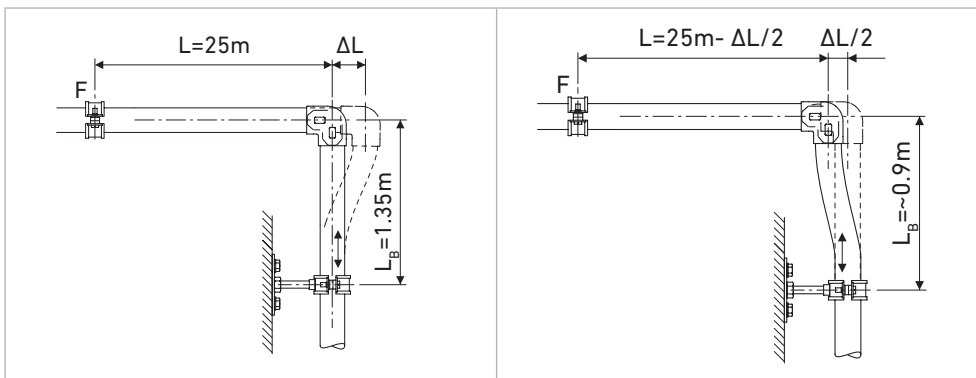
Change in length from the table or Cooling Calculation Tool:

$$-\Delta L = 29 \text{ mm}$$

A flexible section to take up a change in length of  $\pm \Delta L = 29 \text{ mm}$  needs to be  $L_B \text{ (mm)} = \sim 1350 \text{ mm}$  long according to the table.

If the flexible section is pre-tensioned to  $\Delta L/2$ , the flexible section required is reduced to  $\sim 94 \text{ cm}$ . The change in length starting from the 0 position is then  $\pm \Delta L/2 = 29/2 = 14.5 \text{ mm}$ .

By pre-tensioning the flexible section makes it possible to reduce its required length in installations where space is restricted. Pre-stressing also reduces the bending of the flexible section in service, improving the appearance of the piping system.



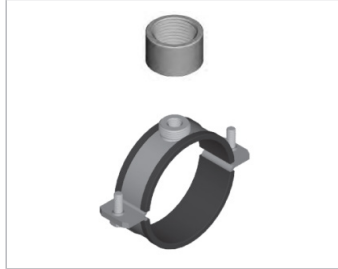
## 1.4.12 Pipe bracket spacing and support of piping systems

### Overview

#### Installation of plastic pipe

COOL-FIT 2.0 pipe should be installed using supports designed for use with plastics and should then be installed taking care not to damage or overstress the pipe.

Thanks to the excellent insulating properties of the COOL-FIT 2.0 pipe and its hard, impact resistant outer jacket, standard pipe clamps may be used. Special insulation pipe clamps or cold clamps are not necessary.



#### Installation of COOL-FIT Push System

COOL-FIT 2.0 Push System tubes must be installed using suitable tube supports. In doing so, the pipes must not be under too much tension.

The COOL-FIT 2.0 Push System, pipes can be inserted into standard sliding pipe clamps with the COOL-FIT 2.0 Push System, holding shell. Special insulation pipe clamps or cold clamps are not necessary.



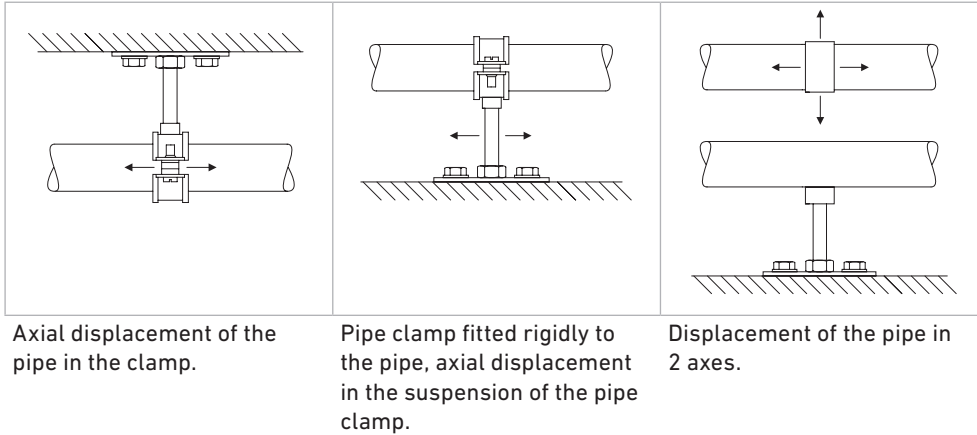
A retaining clamp must be placed next to each fitting.



## Arranging loose brackets

### What is a loose bracket?

A loose bracket is a pipe bracket which allows axial movement of the pipe. This allows stress-free compensation of temperature changes and compensation of any other operating condition changes.

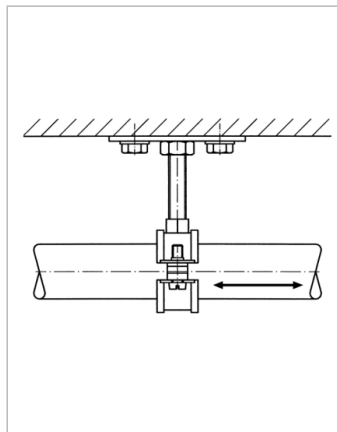


The inner diameter of the bracket must be larger than the outer diameter of the pipe to allow free movement of the pipe. The inner edges of the brackets should be free from any sharp contours to avoid damaging the pipe surface.

Another method is to use brackets with spacers in the bolts which also avoids clamping the bracket on the pipe

The axial movement of the piping may not be hindered by fittings arranged next to the pipe bracket or other diameter changes.

Sliding brackets and hanging brackets permit the pipe to move in different directions. Attaching a sliding block to the base of the pipe bracket permits free movement of the pipe along a flat supporting surface. Sliding and hanging brackets are needed in situations where the piping system changes direction and free movement of the pipe must be allowed.

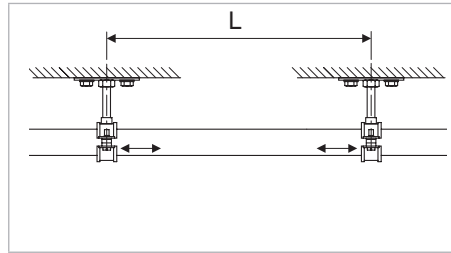


Spacers prevent pinching the pipe

### Pipe bracket spacing

The pipe bracket spacing have been determined for conveying water on the basis of a specific deflection of the pipe between two clamps considered acceptable.

The pipe bracket spacing for COOL-FIT 2.0 pipe is always consistent independent of pressure and temperature.



L Pipe clamp spacing

#### Pipe clamp intervals L for COOL-FIT 2.0

d/D (mm)	32/75	40/90	50/90	63/110	75/125	90/140	110/160	140/200
L (mm)	1'600	1'700	1'700	1'850	1'950	2'000	2'100	2'350

#### Pipe clamp intervals L for COOL-FIT 2.0F

d/D (mm)	32/75	40/90	50/90	63/110	75/125	90/140	110/160	140/200
L (mm)	2'200	2'300	2'300	2'400	2'500	2'600	2'700	2'900

#### Pipe clamp intervals L for COOL-FIT 2.0 Push System

d/D (mm)	16/44	20/48	25/54	32/61
L (mm)	1'200	1'200	1'700	2'200

The pipe clamp intervals from the table can be increased by 30% for vertical pipe. Multiply the values given by 1.3 in this case.

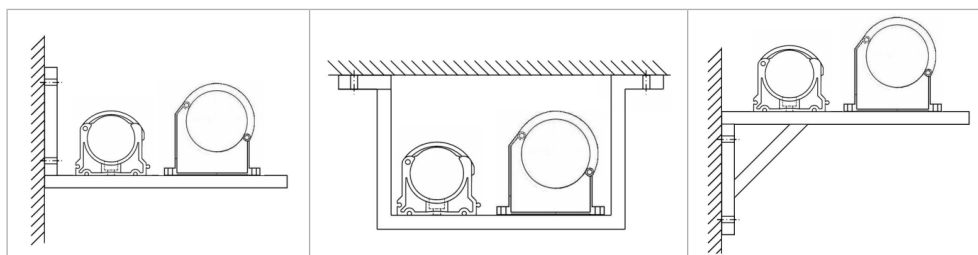
**⚠** Pipe which are axially clamped and rigidly fixed must be tested for their resistance to kinking. In most cases, this test results in a reduction of the maximum internal pressure and more tightly spaced supports. The forces acting on the fixed points should be considered.

### KLIP-IT pipe brackets

These robust plastic pipe brackets can be used not only under rigorous operating conditions, but also where the pipework is subject to aggressive media or atmospheric conditions. Pipe brackets and pipe clamps from GF Piping Systems are suitable for all pipe materials used.

Do not use KLIP-IT pipe brackets as fixed points!

**⚠** From d90 upwards KLIP-IT pipe clamps must be mounted upright, as in the installation examples below.



### Arranging fixed points

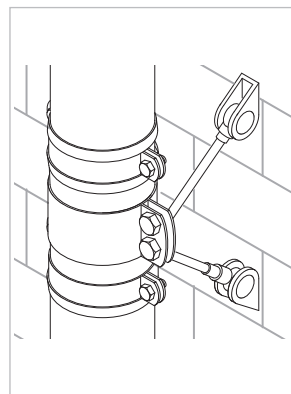
A fixed point is a bracket which prevents the pipe from moving in any direction. The purpose of a fixed point is to control tension caused by temperature changes and guide elongation in a certain direction.

**⚠ Fixed point design**  
 The pipe must not be fixed by clamping it in the pipe bracket. This can cause deformation and physical damage to the pipe, damage that sometimes does not appear until very much later.

**⚠ Pipe brackets must be robust and mounted firmly to be able to take up the forces arising from changes in length in the piping system. Hanging brackets or KLIP-IT pipe brackets are unsuitable for use as fixed points.**

#### COOL-FIT 2.0 fixed point

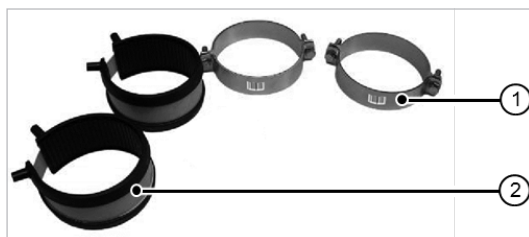
Fixed points for COOL-FIT 2.0 are established with the special COOL-FIT 2.0 fixed points. The product consists of fusion bands and pipe brackets. Electrofusion bands as permanent joints transmit the forces that occur in the pipe to the fixed point. The supplied pipe brackets serve to build up the fusion pressure during installation of the fusion bands and provide stability during operation. For fusion, use an MSA 2.x, MSA 4.x, MSA 250, 300, 350, 400 or commercially available 220-V electrofusion unit. If you use an MSA electrofusion unit by GF Piping Systems, use the y-cable kit with code No. 790 156 032. Please take note of the maximum allowed forces in the table below.



Diameter (mm)	d32/ D75	d40/ D90	d50/ D90	d63/ D110	d75/ D125	d90/ D140	d110 / D160	d140 / D200
Maximum force F (kN)	2.0	3.0	5.0	8.0	10.0	10.0	10.0	10.0

**⚠ COOL-FIT 2.0 fixed points must be calculated on the basis of the application. Fixed point brackets and cross braces are not included.**

#### Scope of delivery



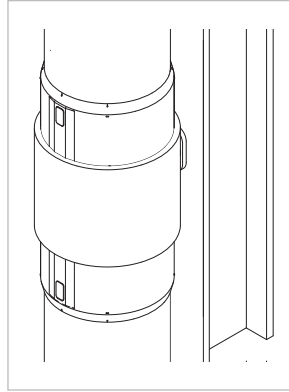
- 1 Clamps to maintain fusion pressure
- 2 Electrofusion band

#### Y-cable kit for COOL-FIT fixed points

The COOL-FIT Y-cables can be used for a faster installation of COOL-FIT 2.0 fix points. Since electrofusion bands always come in pairs, Y-cables allow for a simultaneous fusion process, cutting fusion time in half.

**COOL-FIT 2.0 fixed point for higher forces**

For applications with higher forces, such as long risers, fixed points must be planned specifically for the application. Attachment to the beam is via a weld-on plate on the metal pipe clamp. The clamp is positioned between two COOL-FIT electrofusion fittings and is subsequently insulated. The insulation is designed for indoor applications, for outdoor applications further precautions are required to protect the insulation.



<b>Diameter (mm)</b>	<b>d140 / D200</b>
<b>Maximum force F (kN)</b>	<b>35.0</b>

**⚠** COOL-FIT fixed points for higher forces must be calculated according to the application. The pipeline, support, weld seam type and other influencing factors must be taken into account in the force analysis. Please contact GF Advanced Engineering.

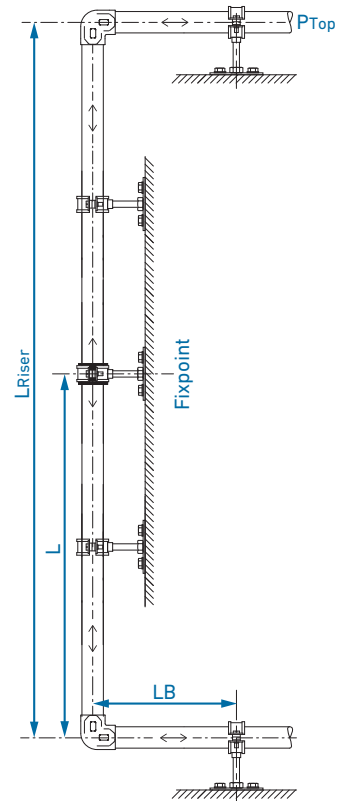
**Example of maximal achievable riser length:**

- Installation temperature -5 to +40°C
- Ambient temperature -5 to +45°C
- Flow temperature +6 to +47°C
- Fixpoint position Middle of the riser pipe
- Pressure on top level 3 bar (P<sub>Top</sub>)
- Support distance vertical Equal to horizontal
- Pipe class d32 - d140 SDR11

	Pipe support distance reduced for long riser		Fixpoint		Fixpoint for increased forces	
	Horizontal [m]	Vertical [m]	Max. riser length (L <sub>Riser</sub> ) [m]	Fixpoint force [kN]	Max. riser length (L <sub>Riser</sub> ) [m]	Fixpoint force [kN]
d32/75	1.6	1.6	32.5	0.6		
d40/90	1.7	1.7	40.5	1.0		
d50/90	1.7	1.7	32.5	1.0		
d63/110	1.9	1.9	39.5	1.9		
d75/125	2.0	2.0	43.5	2.9		
d90/140	2.0	2.0	48.0	4.4		
d110/160	2.1	2.1	52.0	6.6		
d140/200	2.4	2.4	48.5	10.0	54.5	11.2

**⚠** Following sections are recommended to be proofed by GF Advanced Engineering before installation:

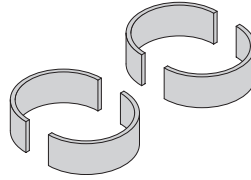
- Riser pipe with multiple dimensions
- Installation differ from normal installation with fixpoint in the middle





**COOL-FIT 2.0F fixed points**

Four half shells which are cemented on both sides to the fixed point pipe clamp.



Diameter (mm)	d32/ D75	d40/ D90	d50/ D90	d63/ D110	d75/ D125	d90/ D140	d110 / D160	d140 / D200
Maximum force F (kN)	2.0	3.0	5.0	8.0	10.0	10.0	10.0	10.0

**⚠** COOL-FIT 2.0F fixed points must be calculated on the basis of the application. Fixed point brackets and cross braces are not included.

**Rigidly fixed installations**

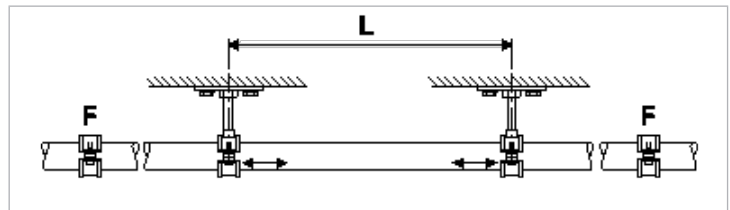
**⚠** Pipe which are axially clamped and rigidly fixed must be tested for their resistance to kinking. In most cases, this test results in a reduction of the maximum internal pressure and more tightly spaced supports. The forces acting on the fixed points should be considered.

COOL-FIT 2.0 / 2.0F pipes and fittings are suitable for a rigidly fixed installation

Values for forces acting on fixed points as well as the resulting pipe bracket spacing are listed in following tables.

**Example of use:**

Installation temperature	25 °C
Min. ambient temperature	25 °C constant
Max. ambient temperature	25 °C constant
Min. flow temperature	See table
Max. flow temperature	25 °C



**Fixed installation, maximum axial forces (kN) at 15°C fluid temperature**

d/D (mm)	d32/75	d40/90	d50/90	d63/110	d75/125	d90/140	d110/160	d140/200
F (kN)	0.38	0.59	0.87	1.38	1.92	2.74	4.06	6.54
L (mm)	1'600	1'700	1'700	1'850	1'950	2'000	2'100	2'350

\* max allowed force for COOL-FIT fixed point exceeded

**Fixed installation, maximum axial forces (kN) at 10°C fluid temperature**

d/D (mm)	d32/75	d40/90	d50/90	d63/110	d75/125	d90/140	d110/160	d140/200
F (kN)	0.58	0.92	1.36	2.15	2.99	4.28	6.33	10.21*
L (mm)	1'600	1'700	1'700	1'850	1'950	2'000	2'100	2'350

**Fixed installation, maximum axial forces (kN) at 5°C fluid temperature**

d/D (mm)	d32/75	d40/90	d50/90	d63/110	d75/125	d90/140	d110/160	d140/200
F (kN)	0.81	1.27	1.88	2.98	4.13	5.92	8.76	14.13*
L (mm)	1'600	1'700	1'700	1'850	1'950	2'000	2'100	2'350

**COOL-FIT 2.0F**

**Fixed installation, maximum axial forces (kN) at 15°C fluid temperature**

d/D (mm)	d32/75	d40/90	d50/90	d63/110	d75/125	d90/140	d110/160	d140/200
F (kN)	0.38	0.60	0.88	1.39	1.93	2.75	4.07	6.56
L (mm)	2'200	2'300	2'300	2'400	2'500	2'600	2'700	2'900


**Fixed installation, maximum axial forces (kN) at 10°C fluid temperature**

d/D (mm)	d32/75	d40/90	d50/90	d63/110	d75/125	d90/140	d110/160	d140/200
F (kN)	0.59	0.93	1.37	2.17	3.01	4.29	6.35	10.25*
L (mm)	2'200	2'300	2'300	2'400	2'500	2'600	2'700	2'900

**Fixed installation, maximum axial forces (kN) at 5°C fluid temperature**

d/D (mm)	d32/75	d40/90	d50/90	d63/110	d75/125	d90/140	d110/160	d140/200
F (kN)	0.81	1.28	1.89	2.99	4.16	5.94	8.78	14.18*
L (mm)	2'200	2'300	2'300	2'400	2'500	2'600	2'700	2'900

\* max allowed force for COOL-FIT fixed point exceeded

 Please contact GF Piping Systems for rigidly fixed installations that contain ball valves and mechanical joints as well as if the max. allowed force on the fixed points are exceeded

**1.4.13 Hoses**

**Installation of elastomer hoses**

To ensure the usability of hose lines and to avoid shortening their service life through additional stresses, please note the following:

- Hose lines must be installed so that their natural position and movement is not hindered.
- During operation, hose lines must in principle not be subjected to external forces such as tension, torsion and compression, unless they have been specially made for the purpose.
- The minimum radius of curvature specified by the manufacturer must be observed.
- Buckling is to be avoided, particularly by the joint.
- Before putting the system into operation, check that the mechanical connections are properly tightened.
- If there is visible external damage, the hose line must not be put into operation.
- The connection fittings should be firmly screwed together.

**Proper use of the hose line**

- Pressure: do not exceed maximum permitted working pressure and operating vacuum
- Temperature: do not exceed maximum permitted temperature for the medium

**Storage**

- Store in a cool, dry and dust-free area; avoid direct sunlight or ultraviolet irradiation; protect from nearby heat sources. Piping must not come into contact with substances that can cause damage.
- Hoses and hose assemblies must be stored horizontally, free of tension or bending forces.

### 1.4.14 COOLING Tool-Box

The GF Piping Systems Cooling Calculation Tool is used to help in the dimensioning and design of cooling systems.

The Cooling Calculation Tool handles:

- Expansion, contraction
- Flexible section design
- Energy savings
- Pipe exterior temperature
- Pipe dimensioning
- Pressure loss
- Dew point/ insulation thickness
- Pipe bracket spacing
- Freezing time
- Weight comparison
- CO<sub>2</sub> footprint

The most common coolants are already stored in the calculation tool. It calculates all system components, such as pipe, fittings and valves. Its menu-based navigation is available in nine languages and allows for efficient and optimized dimensioning of a system. Data for the most commonly used coolants are already stored in the calculation tool. It calculates all system components such as pipe, fittings and valves. The menu is available in nine different languages. It allows system design to be efficient and optimized.

The "comparison" function compares a COOL-FIT system to a steel, stainless steel or copper system.



■ Cooling Calculations Tool: Get it contact to your GF Piping Systems representative or visit [www.gfps.com](http://www.gfps.com)



## 1.5 Jointing and Installation

### 1.5.1 Jointing of COOL-FIT 2.0/2.0F

**i** For general notes and information on electrofusion, see Planning Fundamentals Chapter "Jointing technology", section "Electrofusion joints".

#### General advice

The quality of a weld is largely determined by careful preparation. The welding surface must be protected from adverse weather conditions such as rain, snow or wind. The permissible temperature range for fusion is -10 °C to 45 °C. National regulations must be observed. In direct sunlight, shielding of the welding area can help to create an even temperature profile around the whole circumference of the pipe. It is particularly important to ensure that the climate conditions are the same for both the electrofusion machine and the welding area.

#### Executing electrofusion

##### Protect the welding area

The surfaces to be welded on the pipe and the fitting must be carefully protected from dirt, grease, oils and lubricants. Only cleaning agents suitable for PE must be used.

**⚠** No fats (i.e. hand cream, oily rags, silicone, etc.) must be introduced into the fusion zone!

- 1 Without touching the surface, remove product immediately before the installation from packaging

Prepare pipe with stripping and peeling tool for electrofusion welding connection (stripping, peeling and sheath cutting) and check pipe spigot with circumferential measuring tape for compliance with minimum permissible pipe outer diameter.

#### Minimum permitted pipe external diameter after peeling for COOL-FIT 2.0/2.0F

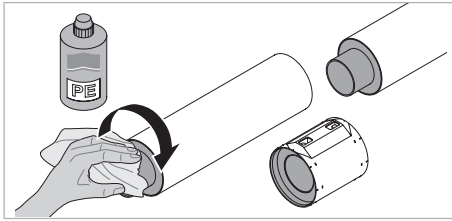
Temperature (°C)	d nominal diameter (mm)							
	32	40	50	63	75	90	110	140
	<b>dmin after peeling (mm)*</b>							
40	31.4	39.4	49.4	62.5	74.5	89.6	109.6	139.7
30	31.3	39.4	49.4	62.4	74.4	89.4	109.5	139.5
20	31.3	39.3	49.3	62.3	74.3	89.3	109.3	139.3
10	31.3	39.2	49.2	62.2	74.2	89.2	109.1	139.1
0	31.2	39.2	49.2	62.1	74.1	89.0	109.0	138.9

\* Minimum diameter do not comply with the pipe tolerance specifications for GF electrofusion fittings. COOL-FIT minimum diameter are verified by release tests.

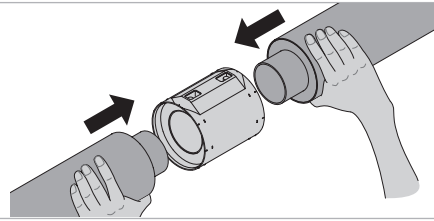
**⚠** If the pipe outside diameter falls below the min. permissible value, cut off the spigot and check the blade quality by measuring the chip thickness with a caliper gauge: the reference dimension over the entire length is between 0.2 - 0.4 mm. Replace blade in case of deviation.

**⚠** COOL-FIT 2.0 valves and COOL-FIT 2.0 fittings (type B and barrel nipple) need not to be peeled.

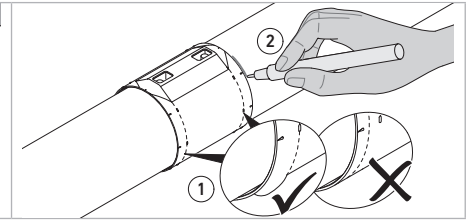
**2 Cleaning and installation**



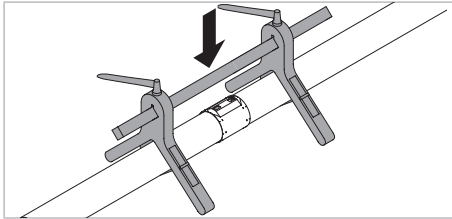
**Step 1**  
Clean the fusion area of the components with PE cleaner and lintfree colourless and clean cloth in circumferential direction.



**Step 2**  
Insert pipe in clamping tool and align free of stress. Push fitting up to the limit stop on the pipe.

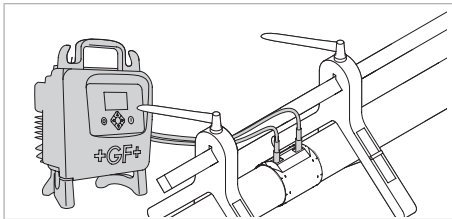


**Step 3**  
Pay attention that the sealing lip arches upwards. Mark end of lip on pipe (to check the change in position during welding).

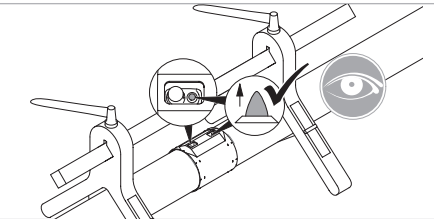


**Step 4**  
Take care for low stress installation and secure the pipe and fitting against dislocation. Tight clamps of clamping tool.

**3 Fusion process**

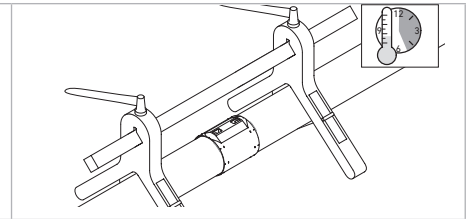


**Step 5**  
Fuse in accordance to the operating instructions of the fusion unit.

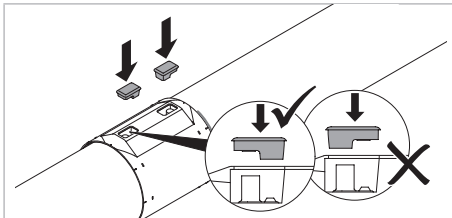


**Step 6**  
During and after fusion, check fusion indicators on the electrofusion fitting and note the messages on the display of the electrofusion machine. Afterwards mark the fitting with following information

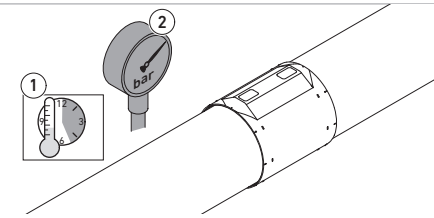
- Date
- Welder/ Weld number
- Time at the end of cooling time



**Step 7**  
Ensure fusion area remains stress free and avoid dislocation until cooling time has elapsed.



**Step 8**  
After fusion process, fit the insulation of the weld pins onto the fusion contacts and remove retaining device



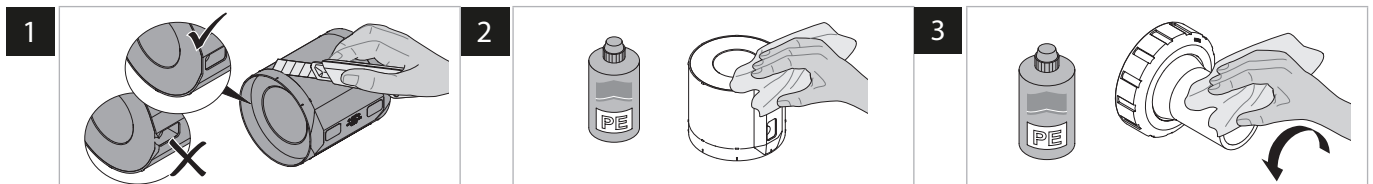
**Step 9**  
After cooling perform pressure tests as per table.

Cooling times before removing retention device and pressure/leak testing

d (mm)	Cooling time before Remove retention device (min.)	Cooling time before internal pressure test at ≤ 6 bar (min.)	Cooling time before internal pressure test at ≤ 18 bar (h)
32	10	15	3
40	10	15	5
50	10	15	4
63	10	20	5
75	15	25	6
90	20	35	8
110	30	35	8
140	45	60	8

The values are valid for pressure tests using a liquid at ≤ 20 ° C. For testing with gas a cooling time of 12 hours is recommended.

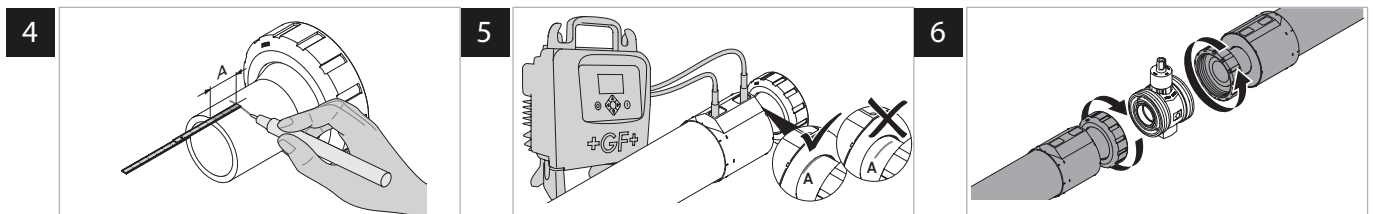
Preparation of fitting – remove sealing lip on one side, clean the sealing surfaces



For the jointing to a valve or flange adaptor, the sealing lip of the fitting has to be removed at the valve or flange adaptor side and sealing and fusion surfaces have to be cleaned.

Standard fusion

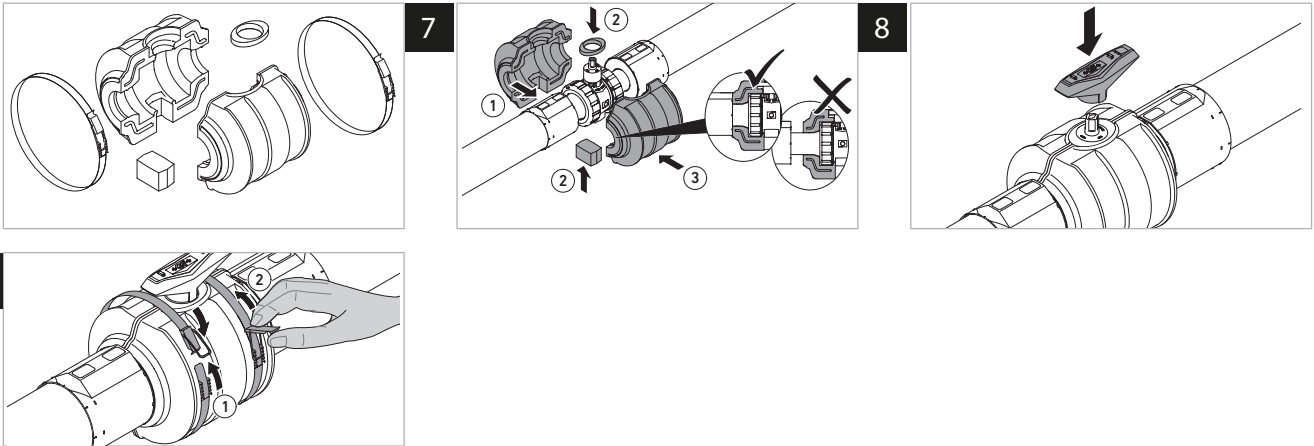
Fuse both valve ends without valve mounted



Following insertion depths are valid for COOL-FIT 2.0 components:

d/D (mm)	32/75	40/90	50/90	63/110	75/125	90/140	110/160	140/200
A (mm)	36	40	44	48	55	62	72	84

Mounting the valve insulation



**i** Further information can be found in the assembly instructions. "Insulation for Ball Valve" and "Insulation for Butterfly Valve and Flange Adapter".

Compact connection fitting-to-fitting

When there is enough space, Fitting-to-Pipe-to-Fitting connections can be realized using a short COOL-FIT 2.0 pipe. The foam removal tool enables the foam removal of pipe lengths of ~110mm for the dimensions d32-d90, or respectively ~170mm for the dimensions d110-d140.

■ Shorter connections Fitting-to-Pipe-to-Fitting can be realized using an un-insulated PE100 SDR11 pipe in combination with a piece of insulation that results of a foam removal process of the foam removal tool.

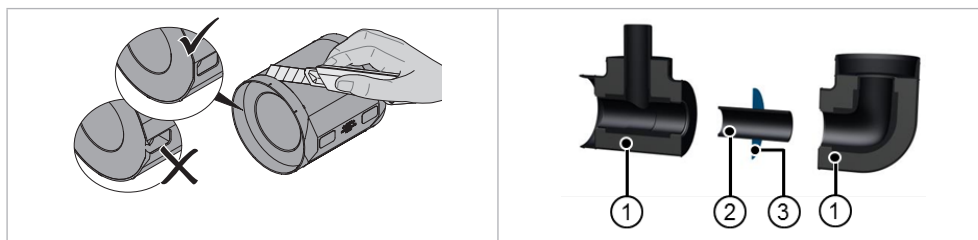
After the peeling of the oxid layer of the un-insulated PE pipe, the insulation ring is pulled over the pipe and the pipe is welded with the fitting.



d	d32	d40	d50	d63	d75	d90	d110	d140
L (mm)	108	120	132	144	165	186	216	252

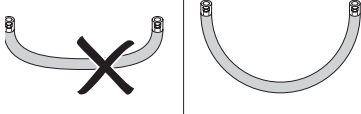
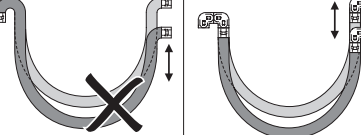
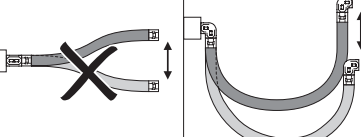
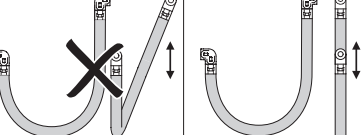
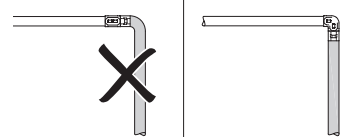
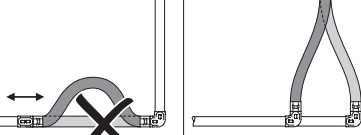
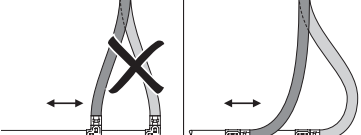
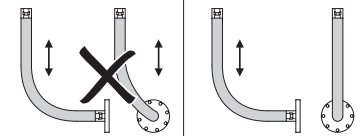
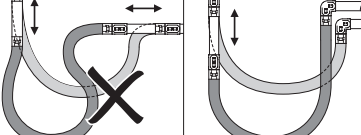
L : Length of un-insulated PE100 SDR11 pipe needed

For situations with very limited space the sealing lip at the fittings can be removed at the respective side. The jointing of the Fitting-to-Fitting is performed using a barrel nipple, the sealing of the insulation is being done with an adhesive ring which is to be adhered to the cleaned surface of the fittings.



- 1 Fittings
- 2 Barrel nipple
- 3 Adhesive ring

Hoses

Installation and handling instructions (false/correct)	Description
	<p>Ensure hose is long enough to observe the minimum radius of curvature.</p>
	<p>Avoid excessive bending of hoses, use elbows.</p>
	<p>Avoid fluctuating bending stress and excessive curvature behind the fitting, use elbows.</p>
	<p>Where there is significant axial expansion, the direction of movement and hose axis must lie in the same plane in order to avoid torsion.</p>
	<p>Avoid excessive bending stress by using elbows.</p>
	<p>If the hose absorbs expansion, it must be installed transversally to the direction of expansion.</p>
	<p>For large lateral movements, a 90° angle should be allowed.</p>
	<p>Expansion take-up must be in the plane of the pipe; torsion should be avoided.</p>
	<p>For major axial expansion, the pipe must be installed in a U-shape to avoid kinking.</p>



## Transition Fittings

The GF Piping Systems range of fittings provides a variety of transitions and threaded fittings to connect plastic piping components to pipe, fittings or valves in metal (or vice versa). The metal threads Rp and R can be sealed with hemp or PTFE tape as long as the counterpart is not made of plastic. Male and female G threads must be sealed with flat gaskets. The advantage of a threaded G connection is radial and torsion-free possibility for installing and uninstalling.

Next to the traditional transition to metal piping, these fittings can also be used to connect a manometers.



To prevent electrochemical corrosion, stainless steel connecting elements should preferably be used for steel transitions and brass connecting elements for transitions to non-ferrous metals.

### Combining G and R threads

The connection of a male parallel pipe thread G in accordance with EN ISO 228-1, with a female parallel pipe thread Rp in accordance with ISO 7-1 is not intended according to standards. A tight connection is possible under favorable conditions, but cannot be established reliably.

## Connecting the insulations of Transition Fittings and jointing elements of Flexible Hoses

The NBR insulation of the COOL-FIT 2.0 Transition Fittings is applied following the jointing of the COOL-FIT 2.0 Transition Fittings with the COOL-FIT 2.0 Fitting Type A, and the mechanical jointing of the threaded components of Hose and Transition Fitting. The NBR insulation of Transition Fittings is supplied with axial adhesive tapes. The adhesive tapes are used for a condensation proof axial sealing of the NBR insulation. The radial jointing of the jointing face of the NBR insulation can be applied either by adhesive cement or by adhesive tape.

On joining transition fittings to flexible hoses, the insulation of the flexible hoses can be jointed directly at the COOL-FIT electrofusion fitting using adhesive cement or adhesive tape.

### Jointing Instructions for the adhesive cement

The adhesive should be thoroughly stirred before use. A thin film is applied by means of the brush to both surfaces to be bonded. Doing this, the consumption is ~0.2 – 0.25kg/m<sup>2</sup>.

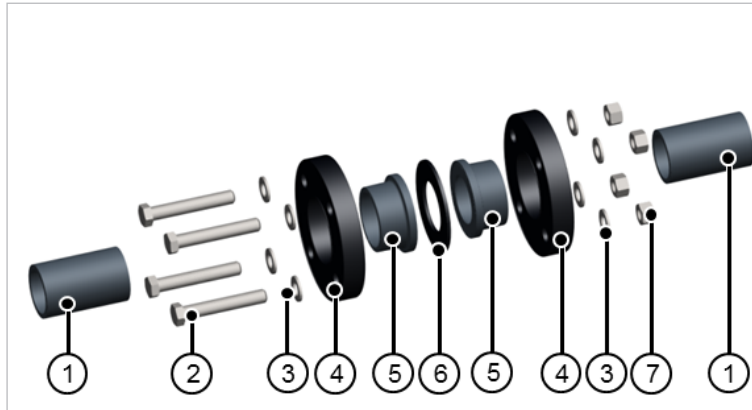
The open joint time is about 3:15 minutes depending on temperature and humidity of air.

Before the coated surfaces are brought together the, the adhesive must still be tacky but should not transfer to the skin when finger-tested. The surfaces should be brought together quickly and firmly and should be held together for a few seconds.

The recommended temperature and for storage and processing is in the range between +15°C and 25°C. The adhesive should not be used below +10°C.

## Flange connections

Flanges with sufficient thermal and mechanical stability must be used. The different flange types by GF Piping Systems fulfill these requirements. The gasket dimensions must match the outer and inner diameter of the flange adaptor or valve end. Differences between the inner diameters of gasket and flange that are higher than 10 mm may result in malfunctioning flange connections.



- 1 Pipe
- 2 Bolt
- 3 Washer
- 4 Backing Flange
- 5 Flange Adaptor/ Valve end
- 6 Flange gasket
- 7 Nut

## Comparison of flange connections

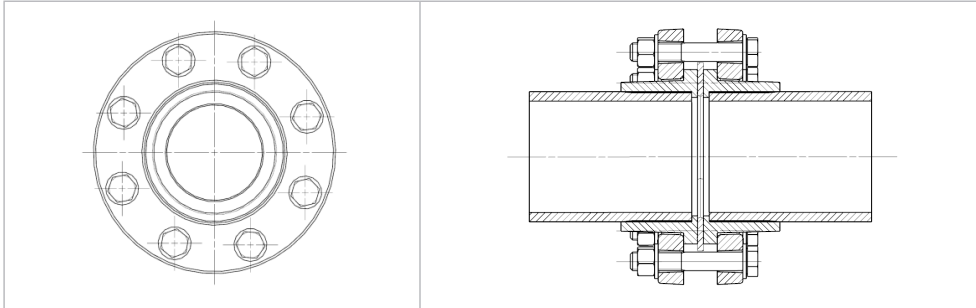
Flange connection	Properties
PP-V flange	<ul style="list-style-type: none"> <li>• Corrosion-free all-plastic flange made of polypropylene PP-GF30 (fiber-glass reinforced)</li> <li>• High chemical resistance (hydrolysis-resistant)</li> <li>• Maximum possible break resistance due to elasticity (deforms if it is tightened too much)</li> <li>• Use for ambient temperatures up to 80 °C</li> <li>• UV-stabilized</li> <li>• With integrated bolt-fixing</li> <li>• Self-centering aid of the backing flange on the flange adaptor</li> <li>• Symmetric design allows assembly on either side: A "reverse" installation is never possible. All important information is readable</li> <li>• V-groove (patented)</li> <li>• Even distribution of forces across the backing flange (conserves components)</li> <li>• Supports a longer-lasting torque for a safe joint</li> </ul>
PP-steel flange	<ul style="list-style-type: none"> <li>• Very robust and stiff due to the steel inlay</li> <li>• Corrosion-free plastic flange made of polypropylene PP-GF30 (fiber-glass reinforced) with steel inlay</li> <li>• High chemical resistance (hydrolysis-resistant)</li> <li>• Maximum ambient temperature 80 °C</li> <li>• UV-stabilized</li> </ul>

## Creating flange joints

When executing flange joints, the following points should be noted:

### Orientation of bolts beyond the two main axes

- For horizontal pipings systems, the orientation shown of the bolts beyond the main axes (see the following figure) is preferred since possible leaks at the flange connection do not cause the medium to run directly onto the bolts.



Flange with main axes (centered crosswise)

- Flange adaptor, valve end or fixed flange, seal and loose flange must be aligned centrally on the pipe axis.
- Before tightening the screws, the sealing surfaces must be aligned parallel and snug against the seal. Tightening misaligned flanges with the resulting tensile stress is to be avoided at all costs.

### Selecting and handling bolts

- The length of the bolts should be in such a way that the bolt thread does not protrude more than 2-3 turns of the thread at the nut. Washers must be used at the bolts as well as the nut. If too long bolts are used it's not possible to mount the insulation half shells afterwards.
- To ensure that the connecting bolts can be easily tightened and removed after a lengthy period of use, the thread should be lubricated, e.g. with molybdenum sulphide.
- Tightening the bolts by using a torque wrench.
- The bolts must be tightened diagonally and evenly: First, tighten the bolts by hand so that the gasket is evenly contacting the jointing faces. Then tighten all bolts diagonally to 50 % of the required torque, followed by 100 % of the required torque. The recommended bolt tightening torques are listed in the following table. However, deviations may occur in practice, e.g. through the use of stiff bolts or pipe axes that are not aligned. The Shore hardness of the gasket can also influence the necessary tightening torque.
- In practice, deviations from this may occur, e.g. due to the use of difficult screws that are difficult to turn or due to non-aligned pipe axes. The Shore hardness of the seal also influences the necessary tightening force.
- We recommend checking the tightening torques 24 hours after assembly according to the specified values and, if necessary, retighten them. Always tighten diagonally here, as well.
- After the pressure test, the tightening torques must be checked in any case and, if necessary, retightened.

**i** For more information on flanges, see DVS 2210-1 supplement 3.

**i** In the area of flexible sections and expansion loops, no bolt connections or flange connections should be used since the bending stress may cause leaks.

### Bolt tightening torque guidelines for metric (ISO) flange connections with PP-V and PP- steel flanges

The indicated torques are recommended by GF Piping systems. These torques already ensure a sufficient tightness of the flange connection. They deviate from the data in the DVS 2210-1 Supplement 3, which are to be understood as upper limits. The individual components of the flange connection (valve ends, flange adapters, flanges) by GF Piping systems are dimensioned for these upper limits.

Pipe outside diameter d (mm)	Nominal Diameter DN (mm)	Tightening torque		
		MD (Nm)	Flat ring maximum pressure 10 bar / 40 ° C	Profile seal maximum pressure 16 bar
d32	DN25	15	10	10
d40	DN32	20	15	15
d50	DN40	25	15	15
d63	DN50	35	20	20
d75	DN65	50	25	25
d90	DN80	30	15	15
d110, 125	DN100	35	20	20
d140	DN125	45	25	25

### Length of bolts

In practice, it is often difficult to determine the correct bolt length for flange joints. It can be derived from the following parameters:

- Thickness of the washer (2x)
- Thickness of the nut (1x)
- Thickness of the gasket (1x)
- Flange thickness (2x)
- Thickness of flange collar (valve end or flange adaptor) (2x)
- Valve installation length, if applicable (1x)

In order to ensure the fitting of the insulation half shells of the COOL-FIT 2.0 flange adaptors the used bolts must not be too long.

The following table is useful in determining the necessary bolt length.

**i** Under DVS 2210-1, the screw length should be such that it extends 2 to 3 threads beyond the nut.

■ Online "screw lengths and tightening torques" tool on [www.gfps.com/tools](http://www.gfps.com/tools)



For a COOL-FIT 2.0 Flange adaptors used together with PP-Steel backing flanges, the following bolt lengths can be used.

Dimension	d32	d40	d50	d63	d75	d90	d110	d140
Screws	M12x80	M16x80	M16x90	M16x90 or M16x100	M16x100	M16x100	M16x100	M16x130

### Installation fittings (for sensors)

Transitions and threaded plastic fittings should first be screwed finger tight. The fittings are then screwed in using an appropriate tool until 1 or 2 threads remain visible.

GF Piping Systems recommends using PTFE tape to seal transitions and threaded plastic fittings. Alternatively, Henkel Tangit Uni-Lock or Loctite 55 thread seal or Loctite 5331 thread sealant gel can be used. Follow the manufacturer's instructions. When using other sealants, you must check compatibility with the plastic used.

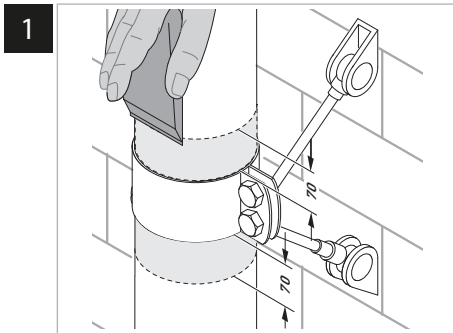
On installing Installation fittings in horizontal piping systems, the sensors should be in 1 – 5 or 7 – 11 clock position.



**Do not use hemp! It may swell up, putting force on the plastic fittings and damaging plastic threads. Hemp is also not resistant to chemicals used in some media.**

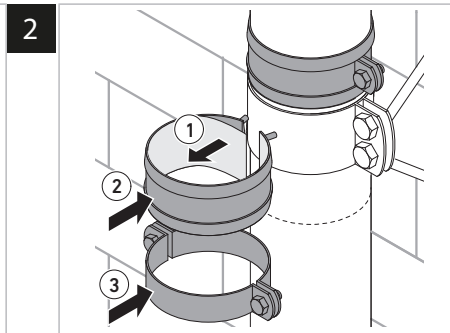
### Installation of COOL-FIT 2.0 fixed points

The COOL-FIT pipe shall be installed with a standard fix point as shown below.



#### Step 1

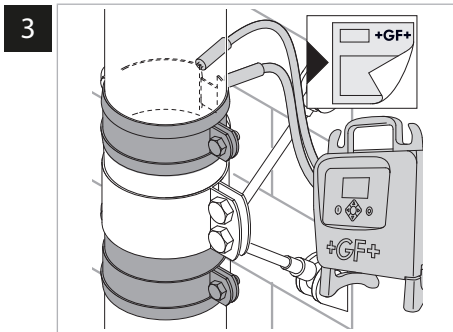
Remove the outer layer of the PE jacket with a pipe scraper



#### Step 2

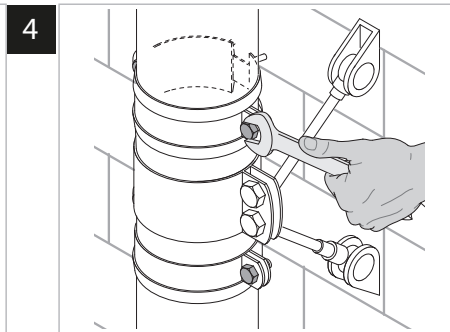
Remove the yellow protection band from the welding bands and place them on the COOL-FIT pipe. Fix the welding bands with the pipe clips provided.

**Note:** The necessary welding pressure on the clean and dry COOL-FIT pipe is achieved by tightening the pipe clips. Take care that between fixed point clip and weld band there are no visible holes.



#### Step 3

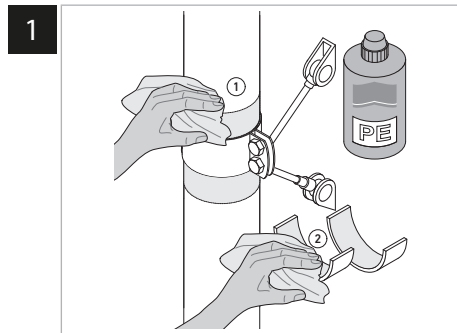
Bond the welding band with the COOL-FIT pipe in accordance with the operating instructions of the electrofusion machine. Use welding adaptors of the y-cable with integrated welding adaptors for the bonding.



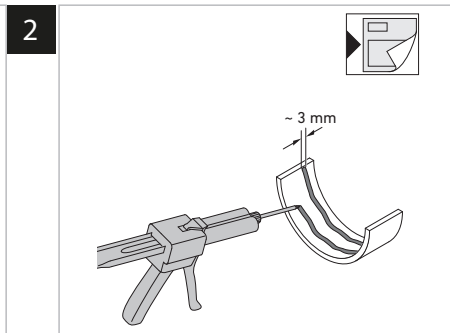
#### Step 4

Retighten the pipe clips after 10 minutes.

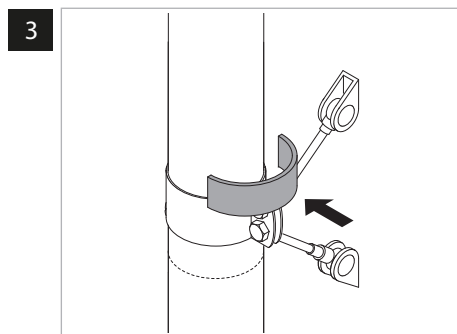
**Installation of COOL-FIT 2.0F fixed points**



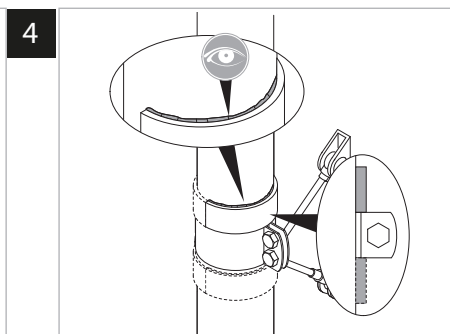
**Step 1**  
Clean the cementing area on the pipe and the components with Tangit PE cleaner and lintfree colourless and clean cloth in circumferential direction.



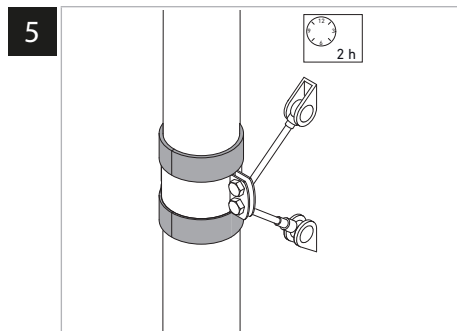
**Step 2**  
Place the Tagit RAPID in about 3mm stripes on the inner side of the fixed point set half shells.



**Step 3**  
Cement the half shells on the pipe next to the pipe clamp.



**Step 4**  
Check the cementing and ensure the fixed point half shells are next to the pipe clamp.



**Step 5**  
Let the fixed point dry for minimum 2hours.

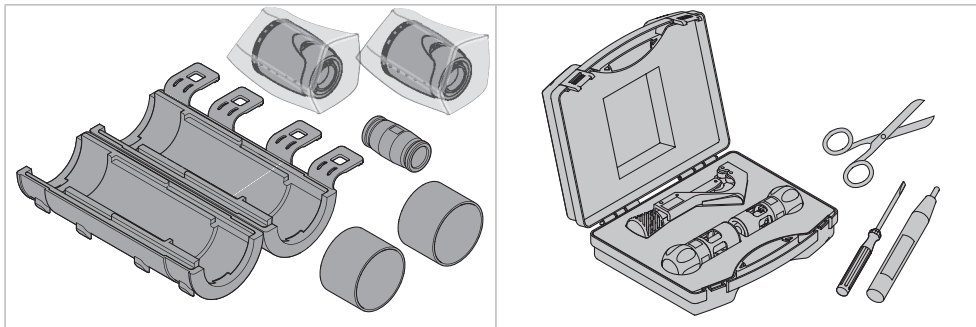
## 1.5.2 Jointing of COOL-FIT 2.0 Push System

### General advice

The push-in fittings may only be installed by skilled personnel who have been regularly instructed in work safety and environmental protection on pressurized pipes. The quality of the mechanical connection is largely determined by the careful execution of the preparatory work. The mating area must be protected from adverse weather conditions such as rain, snow or wind. Permissible temperature range for processing is  $-10\text{ }^{\circ}\text{C}$  to  $+45\text{ }^{\circ}\text{C}$ . The national guidelines must be observed.

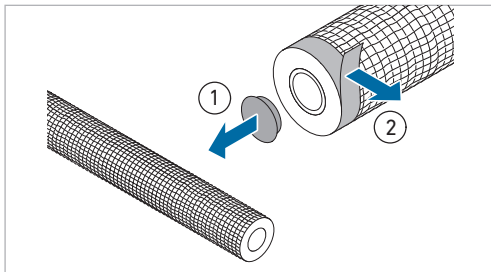
The surfaces to be welded on the pipe and fitting must be carefully protected from dirt, any grease, oil and lubricants. Only cleaning agents suitable for PE may be used.

### Work preparation



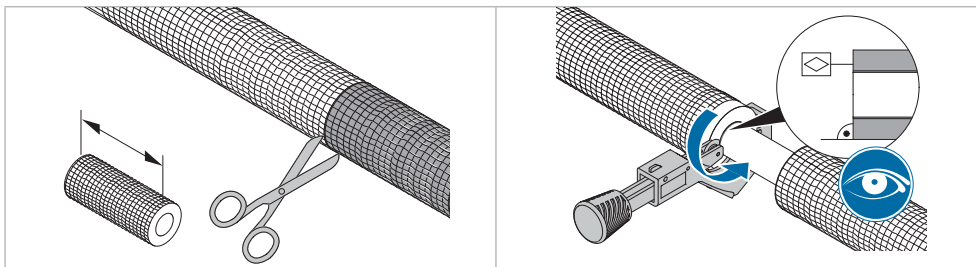
Remove products from packaging immediately before assembly and have necessary tools ready.

### Prepare pipe



#### Step A

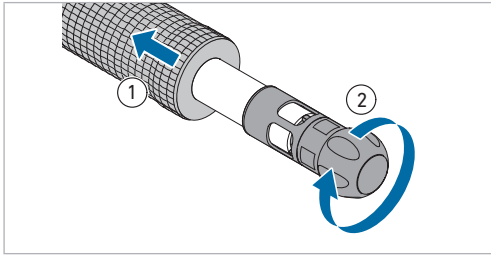
For new pipe start: Remove cap from pipe end and remove tape from insulation.



#### Step B

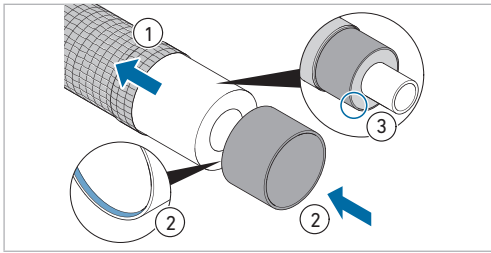
Pipe lengths: Cut the insulation at right angles at the interface using scissors. Push the insulation aside and cut the pipe flush with the insulation using a pipe cutter.

## Joint



### Step 1

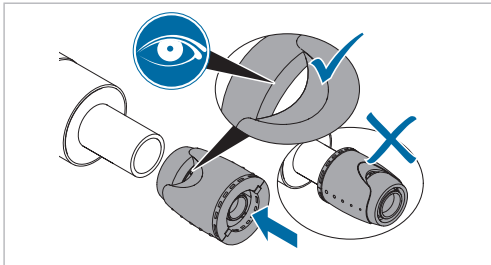
Push back the insulation and chamfer and calibrate the tube end with the chamfering tool. Visually check the chamfering. Remove any chips that may be adhering, also inside the tube.



### Step 2

Pull the net of the insulation to the rear. Push the ring over the insulation with the chamfered side first. The surface of the insulation must lie flush in the ring.

**i** It is easier to attach the ring if the insulation is first pulled off the pipe, then the ring is slid over the insulation. Then both are pushed back over the pipe.

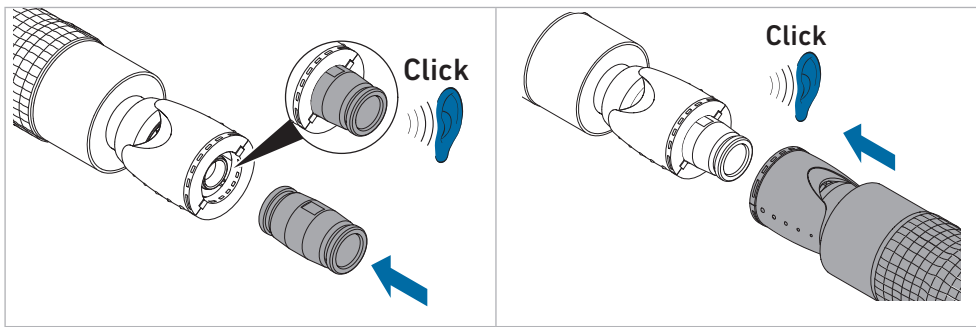


### Step 3

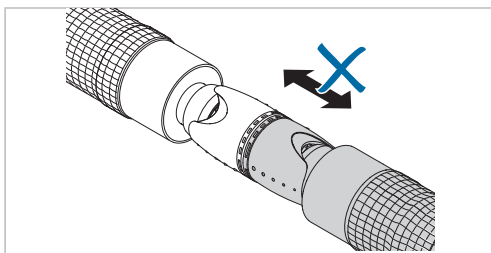
The adapters are packaged individually. The packaging is only opened immediately before use.

Push the adapter onto the tube end as far as it will go. Visually check that the viewing window of the adapter is completely filled by the tube.



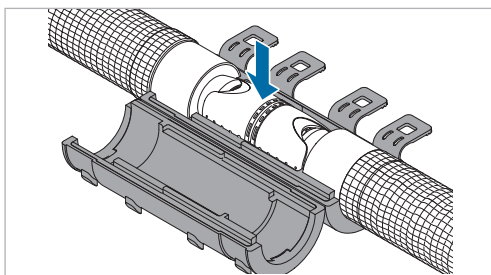
**Step 4- 5**

Insert the module into the adapter and push it in until an audible click is heard (acoustic check). Prepare the second tube end and also push it onto the module until an audible click is heard.

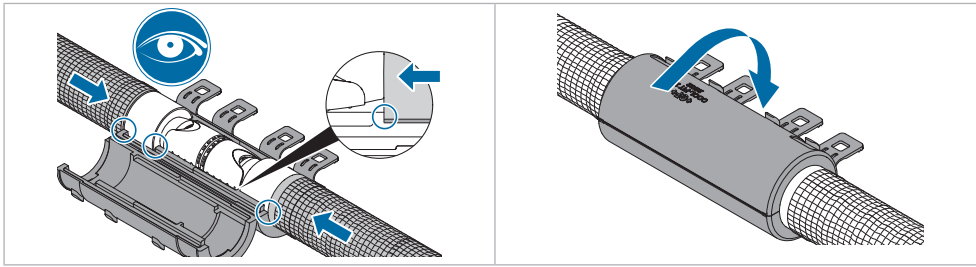
**Step 6**

Check by counter-tensioning whether the tube adapter and module are firmly connected to each other.

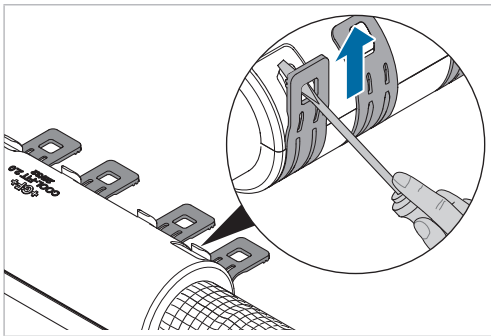
During the counter-tension test, the adapter and module may slide apart by up to 5 mm. Due to the dynamic holding mechanism, the pipe moves back slightly during operation or during the pressure test. This is not a defect of the assembly from a technical point of view.

**Insert joint into shell****Step 7**

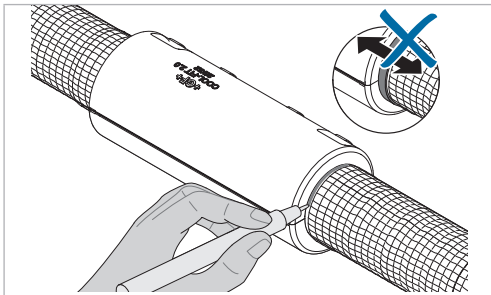
Insulation with ring is pushed to butt against the adapter. The net must be outside the shell.

**Step 8 - 9**

Visually check that the insulation is butted in the shell and, if necessary, push the adapter into place. The ring must be completely in the shell. Then close the shell.

**Step 10**

Close the tabs with a screwdriver.

**Step 11**

After closing the shell, a mark is placed along the edge of the shell. The mark indicates whether the insulation has shifted during the further installation process. If the mark is no longer visible along the shell, the shell must be reopened and checked.

## Disassembly

### Fitting

The fitting can be opened and released again.



**NOTE! Loss of warranty if adapters are opened!**

If adapters have been opened, e.g. during disassembly, the warranty is no longer valid.

→ Do not reuse opened adapters.

### Shell

The shell can be opened at the tabs and reused.

### Plug connection

It is possible to loosen the connection, but the adapter will be destroyed in the process.



**NOTE! Destruction of the adapter by loosening the connection.**

Loosening the connection is possible, but the adapter will be destroyed in the process.

→ For the next assembly: Use a new adapter.

1. Use water pump pliers to fix the collar of the half shells. Use a second pair of water pump pliers to loosen the adapter housing in an anticlockwise direction.
2. This destroys the housing and it must not be used again.
3. Unscrew the adapter housing completely.
4. Pull the tube off the support nipple.
5. Remove the adapter housing, support ring and toothed ring from the tube.
6. Remove the half shells of the adapter from the support nipple of the module.
7. Pull the support nipple of the adapter out of the module.
8. Loosen the clamping ring by squeezing it lightly with pliers and remove it from the tube.
9. Dispose of all parts of the dismantled adapter properly.

### Module

The module can be reused.

The tube end must be shortened by 6 mm (this complies with the insertion depth of the toothed ring) and recalibrated.

### 1.5.3 Pressure test

#### Internal pressure test

For internal pressure testing and commissioning, the same conditions apply for COOL-FIT 2.0 / 2.0F as for the non-insulated ecoFIT system (PE).

### 1.5.4 Internal pressure and leak testing

#### Introduction to the pressure test

#### Overview of the various test methods

Leakage test	Inner Pressure test		Leakage test	
Medium	Water	Gas <sup>1</sup>	Compressed air <sup>1</sup>	Gas/air (oil-free)
Type	Incompressible	Compressible	Compressible	Compressible
Test pressure (overpressure)	$P_{p(perm)}$ or $0.85 \cdot P_{p(perm)}$	Operating pressure 2 bar	Operating pressure 2 bar	0.5 bar
Potential risk during the pressure test	Low	High	High	Low
Significance	High: Proof of pressure resistance incl. impermeability to test medium	High: Proof of pressure resistance incl. impermeability to test medium	High: Proof of pressure resistance incl. impermeability to test medium	Gering

<sup>1</sup> Observe the applicable safety precautions. More information is available in DVS 2210-1 addendum 2.

A number of international and national standards and guidelines are available for leak and pressure tests. Therefore, it is often not easy to find the applicable test procedure and for example the test pressure.

The purpose of a pressure test is:

- Ensure the resistance to pressure of the piping system, and
- Show the leak-tightness against the test medium

Usually, the internal pressure test is done as a water pressure test and only in exceptional cases (under consideration of special safety precautions) as a gas pressure test with air or nitrogen.

Water is an incompressible medium. In case of a leakage during the pressure test relative low energy is set free. Therefore the hazard potential is significantly lower compared to testing with a compressible medium like e.g. compressed air.

#### Internal pressure test with water or similar incompressible test medium

The internal pressure test is done when installation work has been completed and presupposes an operational piping system or operational test sections. The test pressure load is intended to furnish experimental proof of operational safety. The test pressure is not based on the operating pressure, but rather on the internal pressure load capacity, based on the pipe wall thickness.

Addendum 2 of DVS 2210-1 forms the basis for the following information. This replaces the data in DVS 2210-1 entirely. The modifications became necessary because the reference value "nominal pressure (PN)" is being used less and less to determine the test pressure (1.5 x PN, or 1.3 x PN) and is being replaced by SDR. In addition, a short-term overload or even a reduction in the service life can occur if the pipe wall temperature  $TR = 20\text{ °C}$  is exceeded by more than 5 °C in the course of the internal pressure test based on the nominal pressure.

Test pressures are, therefore, determined in relation to SDR and the pipe wall temperature. The 100-h value from the long-term behavior diagram is used for the test pressure.

### Test parameters

The following table provides recommendations on the performance of the internal pressure test

Purpose	Preliminary Review	Main examination
Test pressure $p_p$ (depends on the pipe wall temperature and the permitted test pressure of the installed components, see "determination of the test pressure")	$\leq P_{p(zul)}$	$\leq 0.85 P_{p(zul)}$
Test duration (depends on the length of the pipe sections)	L ≤ 100 m: 3 hrs 100 m < L ≤ 500 m: 6 hrs	L ≤ 100 m: 3 hrs 100 m < L ≤ 500 m: 6 hrs
Checks during the test (test pressure and temperature curves must be recorded)	At least 3 checks distributed across the test period with test pressure restored	At least 3 checks distributed across the test period without restoring the test pressure

### Pre-test

The pre-test serves to prepare the piping system for the actual test (main test). In the course of pre-testing, a tension-expansion equilibrium in relation to an increase in volume will develop in the piping system. A material related drop in pressure will occur which will require repeated pumping to restore the test pressure and also frequently a re-tightening of the flange connection bolts.

The guidelines for an expansion-related pressure decrease in pipe are:

Material	Pressure drop (bar/h)
COOL-FIT 2.0 / 2.0F	1.2

### Main test

In the context of the main test, a much smaller drop in pressure can be expected at constant pipe wall temperatures so that it is not necessary to pump again. The checks can focus primarily on leak detection at the flange joints and any position changes of the pipe.

#### Observe if using compensators

If the piping system to be tested contains compensators, it has an influence on the expected axial forces on the fixed points of the piping system. Because the test pressure is higher than the operating pressure, the axial forces on the fixed points increase proportionately. This has to be taken into account when designing the fixed points.

#### Observe if using valves

When using a valve at the end of a piping system (end or final valve), the valve and the pipe end should be closed by a dummy flange or cap. This prevents an inadvertent opening of the valve and release of the medium.

### Filling the pipe

Before starting the pressure test, the following points should be checked:

1. The installation has been carried out in accordance with its plans.
2. All pressure relief and check valves are fitted in the direction of flow.
3. All end valves have been closed.
4. All valves for devices have been closed to secure against pressure.
5. A visual inspection has been made of all connections, pumps, measurement devices and tanks.
6. The waiting time after the last weld or bond has been observed

Now the piping system can be filled from the geodetic lowest point. Special attention should be given to the air vent. If possible, vents should be provided at all the high points of the piping system and these should be open when filling the system. Flushing velocity should be at least 1 m/s.

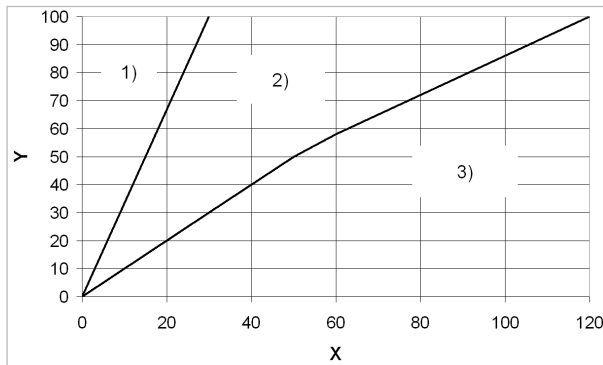
Reference values for the filling volume are given in the table below.

d (mm)	v (l/s)
≤ 90	0.15
110	0.3
140	0.7

Allow sufficient time to pass between filling and testing the pipe for the air in the piping system to escape through the vents: about 6 to 12 hours, depending on nominal diameter.

### Applying the test pressure

The test pressure is applied in accordance with this diagram. It is important to ensure that the rate of pressure increase does not cause any water hammers.



- Y Test pressure (%)
- X Time of test pressure increase (min)
- 1) Rate of pressure increase up to DN100 mm
- 2) Range of pressure increase rates between DN100 and DN400 mm
- 3) Guideline rate of pressure increase for DN500 and higher: 500/DN (bar/10 min)

### Determination of the test pressure

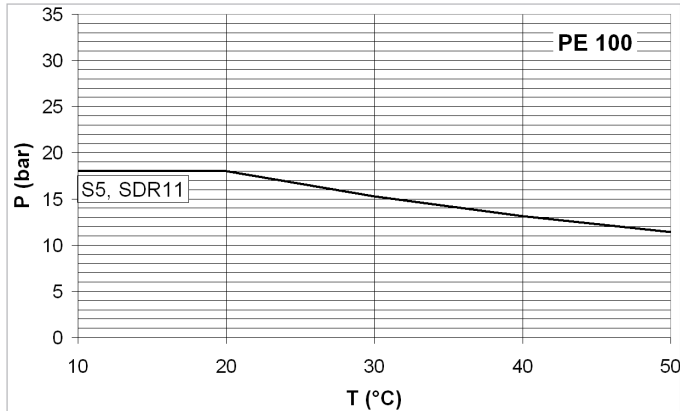
The permissible test pressure is calculated using the following formula:

$$P_{p(zul)} = \frac{1}{SDR} \cdot \frac{20 \cdot \sigma_{v(T, 100 h)}}{S_p \cdot A_G}$$

- $\sigma_{v(T, 100 h)}$  Creep strength for the pipe wall temperature
- $S_p$  Minimum safety factor for creep strength
- $A_G$  Processing method or geometry specific factor which reduces the permissible test pressure
- $T_R$  Pipe metal temperature: mean temperature of test medium and pipe surface

Material	Sp minimum safety factor
PE100	1.25
PVC-U	2.5

To make things easier, the permissible test pressures can be taken directly from the following diagrams.



P permitted test pressure (bar)  
T pipe wall temperature (°C)

#### Checks during testing

The following measurement values must be recorded consistently during testing:

8. Internal pressure at the absolute lowest point of the piping system
9. Medium and ambient temperature
10. Water volume input
11. Water volume output
12. Pressure drop rates

### 1.5.5 Start-up with secondary coolants

Secondary coolants such as glycol solutions must only be introduced in liquid, pre-mixed form into COOL-FIT 2.0 piping systems. Filling should be performed slowly from the lowest point of the system to allow the piping system to vent at its highest point.

#### Filling and Venting

It is important to vent air from all piping systems. This is particularly important with saline solutions, because of their corrosive properties. Venting process:

- The system must be filled slowly.
- Manual or automatic venting devices must be fitted at the highest point of the system.
- Long horizontal lines should be installed at a slight gradient.
- The piping layout should be chosen in such a way as to prevent the formation of air pockets.
- Installation of an air vent with a medium column as a reserve.
- Follow the specific manufacturer instructions for the liquids as regards filling.

## 1.6 Transport, Handling and Storage

### 1.6.1 Transport

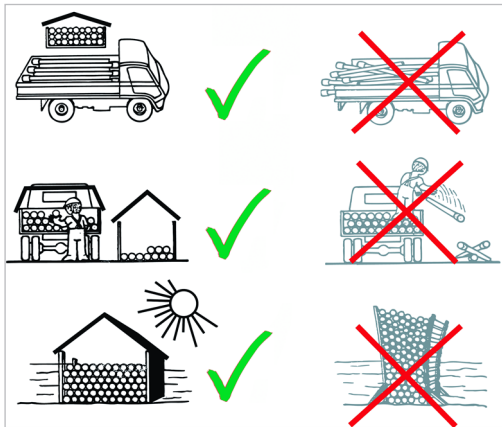
On trucks/in crates, manual transport.

For hygienic reasons, all openings on pipes, fittings and valves must be closed until final assembly.

- Protect the product against external force (impact, shock, vibration, etc.) during transport.
- Transport and/or store product in unopened original packaging.
- Protect the product from dust, dirt, moisture, heat and UV radiation.
- Make sure that the product is not damaged by mechanical or thermal influences.
- Check the product for transport damage before assembly.

### 1.6.2 Storage

All plastic pipe including pre-insulated plastic pipe such as COOL-FIT 2.0 must be stacked on a flat surface with no sharp edges. During handling, care must be taken to avoid damage to the external surface of the pipe, i.e. by dragging along the ground). Pipe should not cross over each other in storage as this is likely to cause bending.



## 1.7 Environment

The materials used for COOL-FIT 2.0 are suitable for recycling. GF Piping Systems aims to satisfy its customer's wishes concerning environmental aspects.

**i** For more information at [www.coolfit.georgfischer.com](http://www.coolfit.georgfischer.com)

### 1.7.1 Disposal

#### **i** Country-specific regulations

Disposal and recycling may be regulated differently in different countries by laws, directives, ordinances, standards, regulations and instruction leaflets.

When disposing of or recycling the product, the single components and the packaging, the locally applicable regulations must be observed.



## 2 COOL-FIT 4.0

### 2.1 General Information

COOL-FIT 4.0 is a pre-insulated piping system for the delivery of secondary refrigerants. The COOL-FIT 4.0 system is a completely pre-insulated plastic piping system for secondary refrigerant circuits that run with water, brine, or Glycol based solutions. Thanks to its insulation thickness of 40 mm, typical areas of application are industrial refrigeration systems with medium temperatures up to -50 °C and chilled water systems for media above 0 °C.

COOL-FIT 4.0 is based on established, impact resistant and corrosion free PE pipe and fittings. The smooth inner surface of the fluid pipe provides minimal losses of pressure. The low thermal conductivity and high quality insulation guarantee low operating cost over the entire lifespan of the system. Thanks to the 3 in 1 design – Fluid pipe / Insulation / Robust jacket – installation time is kept very short.



All components are pre-insulated or supplied with mountable insulation shells. The COOL-FIT 4.0 tools allow for fast and safe installation of the system.



#### The COOL-FIT 4.0 system is suitable for use in applications like:

- Fruit and vegetable processing
- Bakeries
- Fish and meat processing
- Cold stores
- Breweries and wineries
- Air conditioning
- Airports
- Apartments
- Hospitals
- Industrial buildings
- Data centers
- Hotels
- Shopping centers
- Sports centre / leisure centre
- Universities
- Bank / public institutions

## 2.2 System Specification

Specification		COOL-FIT 4.0	COOL-FIT 4.0F
			
Materials <sup>1)</sup>	Pipe	PE100	PE100
	Insulation	GF-HE foam, halogen free, closed-cell	GF-HE foam, halogen free, closed-cell
	Outer jacket	Pipe HDPE Fitting GF-HE	Flame retardant - GF-FR
Size		d32DN25 – d450DN450	d160DN150 + d225DN200
Connection technology		Electrofusion	Electrofusion
Nominal pressure <sup>2)</sup>	16 bar, SDR 11	d32DN25-d450DN450	-
	10 bar, SDR17	d160DN150-d450DN450	d160DN150 + d225DN200
Temperature	Medium	-50 °C bis +60 °C	0 °C bis +60 °C
	Environment	-30 °C bis +60 °C	0 °C bis +55 °C
Insulation	Thermal conductivity $\lambda_{20^\circ\text{C}}$		
	PE Inner pipe	0.38 W/mK	0.38 W/mK
	HE Foam	0.022 W/mK (d32-d110); 0.026 W/mK (d140-d450)	0.026 W/mK
	PE jacket	0.38 W/mK	
	GF-FR jacket		0.15 W/mK
	Density	$\geq 70 \text{ kg/m}^3$	$\geq 70 \text{ kg/m}^3$
	Foam cell size	max. $\varnothing 0.5 \text{ mm}$	max. $\varnothing 0.5 \text{ mm}$
Nominal thickness	40 mm	40 mm	
Mechanical strength (from insulation)	Axial shear strength	$\geq 0.12 \text{ N/mm}^2$	$\geq 0.12 \text{ N/mm}^2$
	Compressive strength	$\geq 0.3 \text{ N/mm}^2$	$\geq 0.3 \text{ N/mm}^2$
Colour	Outer jacket	Black	Black
Weight (without medium)	Pipe d32	1.39 kg/m	
	Pipe d110	6.12 kg/m	
	Pipe d225	16.42 kg/m	19.84 kg/m
Oxygen diffusion at $\leq 14.5^\circ\text{C}$	ISO 17455	$\leq 0.32 \text{ mg}/(\text{m}^2 \text{ d})$	$\leq 0.32 \text{ mg}/(\text{m}^2 \text{ d})$
Fire classification <sup>3)</sup>	EN 13501-1	E	B-s2, d0
Environment	Stability	Moisture and vapor-tight	Moisture and vapor-tight
	Resistance	Weather resistant UV resistant	
	Ozone Depletion Potential	Zero	Zero
Standards and Guidelines	DIN EN 12201-2	Plastics piping systems for water supply, and for drainage and sewerage under pressure - Polyethylene (PE)	
	ISO 7	Threaded Joints	
	EN ISO 16135	Industrial valves ...	
	EN ISO 16136	– Ball valves made of thermoplastics	
	EN ISO 16137	– Butterfly valves made of thermoplastics	
	EN ISO 16138	– Backflow protection made of thermoplastics	
	EN ISO 16871	– Diaphragm valve made of thermoplastics	
EN ISO 16871	Plastic piping and ducting systems – Plastic pipe and fittings – Method for exposure to direct (natural) weathering		
EN ISO 13501-1	Fire classification of construction products and building elements		

- <sup>1)</sup> All three materials are firmly bonded together.
- <sup>2)</sup> At 20 °C, medium water, the specified value is valid for all system components, with the exception of the butterfly valves, PN10 applies to the nominal pressure and for flexible hoses with maximum pressure according product datasheet.
- <sup>3)</sup> Additional information in chapter "Fire behavior and fire prevention measures".

Specification	COOL-FIT 4.0	COOL-FIT 4.0F
Product	BNB BN 2015	
declarations Green	BREEAM Int 2016	
buildings	DGNB 2015	
	DGNB 2018	
	LEED V3	
	LEED V4	
	WELL V1 2019	
eco-bau	(BKP 240, 244, 250)	
	201710.1518	201908.5716

## 2.3 Technical Details

### 2.3.1 COOL-FIT 4.0 Pipe and Fittings

#### COOL-FIT 4.0 Pipe

COOL-FIT 4.0 pipe are made from PE 100. The high efficiency GF-HE hard foam insulation exhibits a thermal conductivity  $\lambda$  of 0.022 W/mK (d32-d110) respectively 0.026 W/mK (d140-d450). The pipe are protected by an impact- and weather resistant PE jacket.

All three materials are firmly bonded in order to ensure good insulation properties and low thermal expansion or contraction for the system.

The pipes are available in 5m lengths for dimensions d32 to d225, and in 5.9m for dimensions d250 to d450. The pipe have free, uninsulated ends, prepared already for the jointing with the COOL-FIT 4.0 fittings.




Standard range (inner pipe SDR17 for d160- d450mm)	Inner pipe d x e (mm)	Inner pipe d <sub>i</sub> (mm)	Pipe class SDR	Outer jacket D x e <sub>1</sub> (mm)	Weight		Volume (l/m)	Insulati- on thick- ness (mm)	Heat trans- fer coeffi- cient (U) (W/m K)	Fire load (kWh/m)
					empty (kg/m)	with water (kg/m)				
d32/90	32 x 2.9	26.2	11	90 x 3	1.39	1.93	0.54	26.0	0.13	14.96
d40/110	40 x 3.7	32.6	11	110 x 3.4	2.02	2.85	0.83	31.6	0.14	21.66
d50/110	50 x 4.6	40.8	11	110 x 3.4	2.19	3.49	1.31	26.6	0.18	24.02
d63/125	63 x 5.8	51.4	11	125 x 3.8	2.94	5.02	2.07	27.2	0.21	32.72
d75/140	75 x 6.8	61.4	11	140 x 4	3.70	6.66	2.96	28.5	0.23	41.35
d90/160	90 x 8.2	73.6	11	160 x 4	4.75	9.00	4.25	31.0	0.24	53.07
d110/180	110 x 10	90.0	11	180 x 4	6.12	12.48	6.36	31.0	0.28	68.94
d140/225	140 x 12.7	114.6	11	225 x 5	9.68	19.99	10.31	37.5	0.35	109.43
d160/250	160 x 9.5	141.0	17	250 x 5	9.81	25.42	15.61	40.0	0.37	109.29
d225/315	225 x 13.4	198.2	17	315 x 6	16.42	47.27	30.85	39.0	0.50	187.00
d250/355	250 x 14.8	220.4	17	355 x 5.1	19.04	57.19	38.15	47.4	0.47	213.97
d280/400	280 x 16.6	246.8	17	400 x 6.3	24.67	72.51	47.84	53.7	0.47	277.80
d315/450	315 x 18.7	277.6	17	450 x 6.4	30.42	90.95	60.52	61.1	0.47	341.40
d355/500	355 x 21.1	312.8	17	500 x 7.4	38.35	115.20	76.85	65.1	0.49	432.43
d400/560	400 x 23.7	352.6	17	560 x 8.4	48.40	146.05	97.65	71.6	0.50	546.74
d450/630	450 x 26.7	396.6	17	630 x 7.6	58.19	181.72	123.54	82.4	0.49	653.01

- d Nominal outer diameter of the PE pipe
- d<sub>i</sub> Nominal inside diameter of the pipe
- D Nominal outside diameter of the outer PE jacket
- e, e<sub>1</sub> Nominal wall thickness

Extended range (inner pipe SDR11 for d160- d450mm)	Inner pipe d x e (mm)	Inner pipe d <sub>i</sub> (mm)	Pipe class SDR	Outer jacket D x e <sub>1</sub> (mm)	Weight		Volume (l/m)	Insulati- on thick- ness (mm)	Heat trans- fer coeffi- cient (U) (W/m K)	Fire load (kWh/m)
					empty (kg/m)	with water (kg/m)				
d160/250	160 x 14.6	130.8	11	250 x 5	11.88	25.31	13.44	40	0.37	134.53
d225/315	225 x 20.5	184	11	315 x 6	20.47	47.06	26.59	39	0.49	236.4
d250/355	250 x 22.7	204.6	11	355 x 5.1	24.05	56.92	32.88	47.4	0.46	275.1
d280/400	280 x 25.4	229.2	11	400 x 6.3	30.93	72.18	41.26	53.7	0.46	354.06
d315/450	315 x 28.6	257.8	11	450 x 6.4	38.33	90.53	52.2	61.1	0.46	437.89
d355/500	355 x 32.2	290.6	11	500 x 7.4	48.34	114.67	66.33	65.1	0.48	554.36
d400/560	400 x 36.3	327.4	11	560 x 8.4	61.19	145.37	84.19	71.6	0.49	702.72
d450/630	450 x 40.9	368.2	11	630 x 7.6	74.39	180.87	106.48	82.4	0.49	850.72

**Energy Act for Buildings GEG**

COOL-FIT 4.0 meets the specifications of the Energy Act for Buildings GEG for cold distribution and cold water pipes.

 Please contact Georg Fischer Piping Systems when using COOL-FIT 4.0 according to the GEG specification for heating cables.

**COOL-FIT 4.0F pipe**

COOL-FIT 4.0F inner pipe is made from PE100. The GF-HE foam insulation has a thermal conductivity  $\lambda$  of 0.026 W/mK. The pipe is protected by the GF fire retardant GF-FR jacket.



All three materials are firmly bonded in order to ensure good insulation properties and low thermal expansion or contraction for the system.

The pipes are available in 5m bars and are already prepared for jointing. They can be connected with all fittings from COOL-FIT 4.0.

Pipe size (mm)	Inner Pipe d x e (mm)	Inner Pipe d <sub>i</sub> (mm)	Outer jacket D x e1 (mm)	Weight empty (kg/m)	Weight with Water (kg/m)	Volume (l/m)	Insulation thickness (mm)	Heat transfer coefficient (U) (W/m K)	Fire load (kWh/m)
d160/250	160 x 9.5	141.0	250 x 3	9.48	25.09	15.61	42.0	0.36	81.51
d225/315	225 x 13.4	198.2	315 x 3.5	15.79	46.65	30.85	41.5	0.48	144.33

d Nominal outer diameter of the PE pipe  
 d<sub>i</sub> Nominal inside diameter of the pipe  
 D Nominal outside diameter of the outer PE jacket  
 e, e1 Nominal wall thickness

**COOL-FIT 4.0 Fittings**

**General**

The media fitting and insulation used for COOL-FIT 4.0 fittings fulfill the same specifications as the COOL-FIT 4.0 pipe. The COOL-FIT 4.0 fittings are based on ELGEF electrofusion fittings, which have been in use successfully for years. They provide an easy and safe connection.

The pre-insulated COOL-FIT 4.0 fittings are available in two types:

**Type A**

Electrofusion fitting with integrated heat coils for direct electrofusion pipe-to-fitting connections.



90° elbow and reducer as an example

**Type B**

Spigot fitting with free ends for electrofusion with COOL-FIT 4.0 electrofusion fittings.



Reduction as an example

**Usefull functions**  
**Fusion indicators**

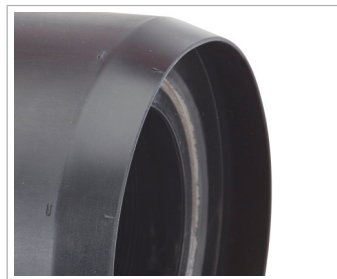
After the welding process, the indicator pin shows that energy has been applied to the welding zone.



**Sealing lip at fittings Type A d32-d225**

The sealing lip ensures a moisture-proof and vapour tight sealing of the insulation towards the outside.

On joining the fittings to the pipe, it's sealing mechanically. Due to this an additional sealing of the joints is not necessary.



**Label**

The fittings have abrasion-resistant marking.



**Trace code**

Relevant product data can be traced back to production via traceability codes.



**Angle marking**

By marking the ends of the fittings, connections between pipe and fittings can be optimally aligned.



**Jointing**

**Pipe and Fitting**

Type A fittings have integrated resistance wires, which are put under electric current during the welding operation through welding contacts on the fittings. This heats up the inside of the fitting and bonds the melting zone with the pipe.

Type B fittings feature non-insulated spigot ends. They are connected with electrofusion fittings type A to a pipe.

**Fitting-to-fitting**

Two COOL-FIT 4.0 fittings are usually connected by using a piece of COOL-FIT 4.0 pipe with free ends. For compact joints, the special COOL-FIT 4.0 barrel nipple with insulation can be used.

Two COOL-FIT 4.0 Type B fittings can be joined using an electrofusion fittings type A.

The direct connection of a COOL-FIT 4.0 fitting Type A and Type B is also possible.

**Components****COOL-FIT 4.0 Electrofusion coupler**

COOL-FIT 4.0 electrofusion couplers are used to connect pipe and components with free ends like type B fittings, valves and transition fittings.

**COOL-FIT 4.0 Elbows 45° and 90°**

(Refer to „General Information“ chapter above)

**COOL-FIT 4.0 T90° equal and COOL-FIT T90° reduced**

The equal and reduced type A 90° tees have, like the coupler, resistance wires for electrofusion. The central branches can be connected to the type A fitting, so all combinations are possible.

**COOL-FIT 4.0 Reducer**

The COOL-FIT 4.0 reducer can be used to reduce the flow of the starting size by up to 3 to 5 sizes (e.g. from d225 up to d63).



**Combination of T90° and Reducer**

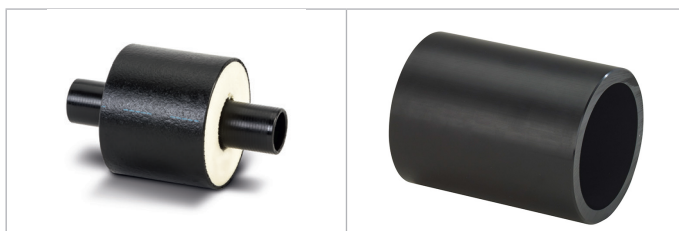
If a reducer in a system is fitted behind a tee, either a COOL-FIT 4.0 T90° reduced or a COOL-FIT 4.0 T90° reduced/equal connected to a reducer should be used.

Run Branch	40	50	63	75	90	110	140	160	225
32	X	X	X	0	0	0	0	0	0
40		X	X	0	0	0	0	0	0
50			X	0	0	0	0	0	0
63				Δ	Δ	Δ	Δ	Δ	Δ
75					Δ	Δ	Δ	[ ]	[ ]
90						Δ	Δ	Δ	Δ
110							Δ	Δ	Δ
140								Δ	Δ

- Δ T90° reduced
- X T90° equal + reducer type A
- 0 T90° reduced to d63 + reducer type A
- T90° reduced to d90 + coupler d90 + reducer type B

**COOL-FIT 4.0 Barrel nipple**

COOL-FIT 4.0 Barrel nipple serves as a compact direct connector for type A fittings.



**COOL-FIT 4.0 Sliding coupler kit**

The sliding coupler kit is a radially insertable element for connecting two fixed pipe spigots.



**COOL-FIT 4.0 Fixed point for high forces**

The fixpoint placed on the media pipe allows the transmission of higher forces. The fixed point is placed between two electrofusion fittings.





### 2.3.2 Accessories for dimensions d32 - d225

#### Insulation for fusion contacts

Supplied with each fitting. Prevent formation of a cold bridge at the fusion contacts. Insulation parts can also serve as an indicator that a connection has been welded. Install insulation after welding to show that the welding has been completed.



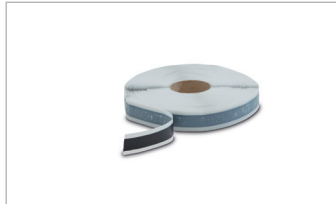
#### Sealing clamps

For vertical installations outdoors, sealing clamps mounted at the top lip of the fitting are recommended.



#### Sealing tape

As an alternative to the sealing clamps, the sealing tape with width 25mm is intended to be used for vertical installations outdoors, to seal the top lip of the fitting.



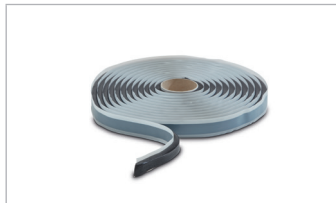
#### Sealant

The silicone-free sealant is used to join the EPDM insulation of Weld-in ports to the COOL-FIT pipes, as well as to cement the end caps d250-d450.



#### Transition of insulation

The Transition of insulation is used for a moisture-proof and vapour tight sealing of the interface of COOL-FIT 4.0 Fitting to COOL-FIT 2.0 pipe.



#### Cement

For frontal bonding of the insulations of transition fittings and flexible hoses.



#### Adhesive tape

Optional for covering hand-cut faces as well as for bonding of the insulations of transition fittings to the insulation of flexible hoses.



## COOL-FIT 4.0 Weld-In Port

The COOL-FIT Weld-in port significantly increases the flexibility by enabling the branching-off on already laid, unfilled and dry COOL-FIT pipes in dimensions d63-d225.

The product range of fittings includes Weld-in ports with transitions to female threads, as well as Weld-in ports that allow transitions within the GF piping portfolio.

The EPDM soft foam insulation supplied with the Weld-in ports is designed to ensure a condensation-free connection to the COOL-FIT pipe, and to insulate the nipples up to the corresponding interface.



Connection type, material	Size	Purpose
Female threads RP + NPT, PE/Stainless steel	½", ¾", 1"	Installation of instruments, probes, sensors as well as transition to other piping systems
iFIT, PE/Brass	25/32	Transition from COOL-FIT 2.0 and COOL-FIT 4.0 to COOL-FIT 2.0 Push System
Sanipex MT, PE/Brass	32	Transition from COOL-FIT 2.0 and COOL-FIT 4.0 to GF Sanipex MT
PE spigot SDR11	32, 40, 50	Connection within COOL-FIT 2.0 and COOL-FIT 4.0

The Weld-in ports can be used with COOL-FIT 4.0 and COOL-FIT 4.0F pipes.

### Jointing

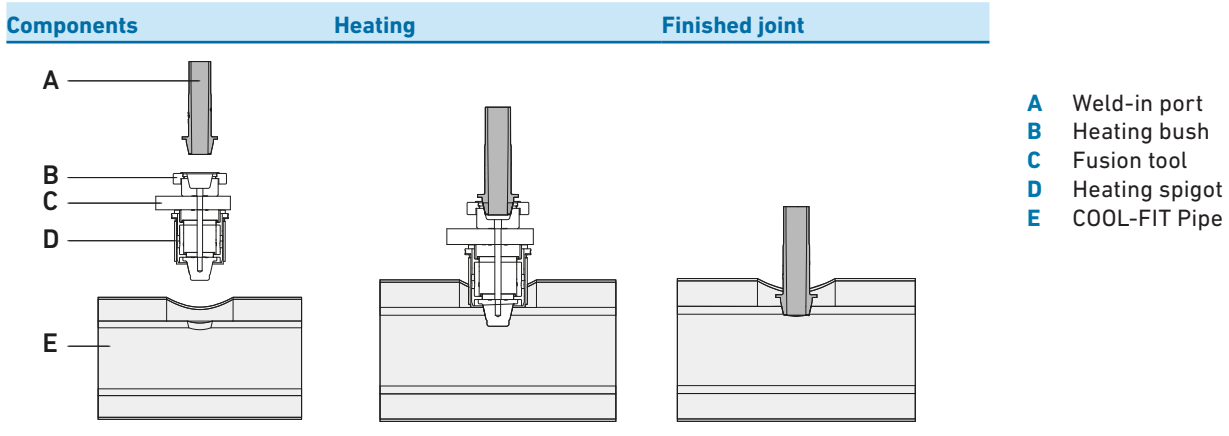
After the controlled local tapping of jacket and inner pipe of the respective COOL-FIT pipe, the welded joint is made.

In the cone welding process used here, a modified version of heating element socket welding, the inner pipe of the COOL-FIT pipe and the Weld-in port are welded in an overlapping material-to-material bond without the use of additional filler materials.

The welding surfaces of the pipe and the fitting are heated to welding temperature on a conical socket- or spigot-shaped heating element and then joined together.

The dimensionally matched geometry of the components ensures the welding pressure during joining and a homogeneous joint.

Jointing principle



After the fusion process, the EPDM insulation is mounted to the Weld-in port. Bonding of insulation the COOL-FIT pipe is done using the COOL-FIT sealant.

Distance of COOL-FIT Weld-in ports and pressure de-rating of main pipes

On positioning the Weld-in ports on the COOL-FIT pipe, the following distances must be taken into account:

- Distances between Weld-in ports along the pipe axis.
- Arrangement around the circumference of the pipe.

	Ports with metal insert	Ports with PE spigot
<b>Distances along pipe axis*</b>	$x \geq 120\text{mm}$ ▶ no pressure de-rating of main pipe	$x \geq 2 \cdot d$ main pipe ▶ no pressure de-rating of main pipe  or  $x < 2 \cdot d$ main pipe ▶ pressure de-rating factor of main pipe of 0.8
<b>Arrangement around circumference</b>	$\alpha \geq 60^\circ$ ▶ no pressure de-rating of main pipe	$x \geq 0$ mm (along pipe axis), $\alpha \geq 60^\circ$ ▶ no pressure de-rating of main pipe

\* The minimum distance due to the tool dimensions is 120 mm.

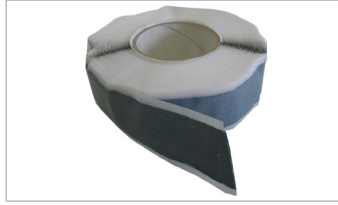
Height of Weld-in ports 1/2"-1" towards the middle of the pipe axis

Height h1 [mm]/d [mm]	d63	d75	d90	d110	d140	d160	d225
1/2" Rp	117	123	130	140	155	165	198
1/2" NPT	120	126	134	144	159	169	201
3/4" RP + NPT	117	123	130	140	155	165	198
1" Rp + NPT	118	124	131	141	156	166	199

### 2.3.3 Accessories for dimensions d250 - d450

#### Sealing tape

A roll of 40 mm wide butylene rubber-based sealing tape. For a water- and vapor-tight connection of inspection gaps with shrink sockets. The sealing tape is affixed to the circumference of the pipe or fitting.



#### Shrink socket

The shrink socket is used to water and vapor seal the respective welded joints on the outer jacket and can seal only components with the same outside diameter. Functionality is ensured only in combination with the butylene-rubber sealing tape. This version provides additional mechanical strength with regard to bending forces. The socket shrinks uniformly, resulting in a good visual appearance. It can be shrunk with an open, soft flame.



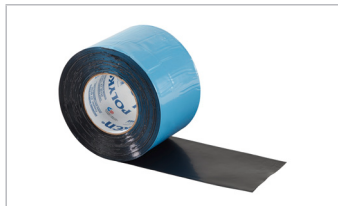
#### End cap

End caps are used to cap the pre-insulated system. They seal the PUR insulation and prevent moisture from entering. Sealing PUR is achieved by using a suitable sealant.



#### Cold shrink tape

The cold shrink tape is used on the respective welded joints for the water- and vapor-tight sealing of the outer jacket. It is only suitable for indoor applications and can be applied by hand without heat.



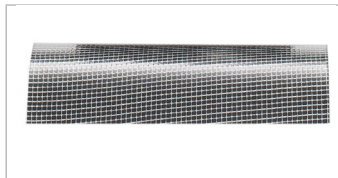
#### Hot shrink tape

The heat shrink tape is used on the respective welded joints for the water and vapor tight sealing of the outer jacket. The adhesive-coated tape must be glued with a sealing patch and shrunk under the influence of heat.



#### Sealing patch

The sealing patch is used to close the heat-shrink tape. One patch must be used per sealing.



### COOL-FIT 4.0 Heat tracing

Frozen pipes can cause high costs. When water-filled COOL-FIT pipes are exposed to temperatures below zero °C without circulation and for extended periods of time, the water freezes and proper operation of the cooling system can no longer be maintained.

The heat-tracing system for COOL-FIT 4.0 offers an effective solution for the freeze protection of COOL-FIT lines. The self-regulating heating tape in combination with the insulation of the COOL-FIT 4.0 pipe system prevents the cooling pipe from freezing.

With the COOL-FIT 4.0 heat tracing, reliable frost protection down to  $-30^{\circ}\text{C}$  ambient temperature is provided across all COOL-FIT 4.0 dimensions from d32 - d450.

Please contact GF if you need antifreeze protection at ambient temperatures below  $-30^{\circ}\text{C}$ .

### Tracing cable

The COOL-FIT heat-tracing system uses a self-regulating heat-tracing cable installed inside the pipe. This efficiently protects the medium from freezing directly and without heat loss through the pipe wall insulation.



### Cable glands

The entry and exit of the cable into the COOL-FIT system is performed via cable glands, which are connected to the COOL-FIT system via metallic thread transitions.



### Thermostat

The thermostat is designed to provide userfriendly measurement and control for the self regulating heating cable for COOL-FIT. It can be chosen between efficient temperature control via the media temperature or proportional ambient sensing control (PASC) algorithm for enhanced energy savings in ambient sensing mode.



### Cold lead connection and end seal kit

The kit contains all necessary components like crimps and shrink sleeves for the joining of the heating cable to power cable as well as for the end seal of the heating cable.



### COOL-FIT 4.0 Valves

The plastic valves designed for COOL-FIT 4.0 valves are based on Georg Fischer Piping Systems standard plastic valves. The valves are supplied including PE-/GF-HE insulation shells with a protective PE jacket. The sealing faces between the shells are vapor tight by their design. No additional tape or sealant is required.



Releasable plastic bands for sizes d32DN25 – d63DN50 and metal straps with tension locks for sizes d75DN65 – d225DN200 permit the pre-insulated shells to be fitted to and removed from the valves easily, allowing easy maintenance.

The insulated ball valve in ABS is available in sizes d32DN25 – d90DN80. For the sizes d110DN100 – d225DN125, butterfly valves kits are available that consist of butterfly valve, flange adaptor, backing flange PP-St, screw-kits and insulation half shells.

Both valve types are available either as manually operated or electric actuated version.



The electric actuators used feature following benefits:

- Position feedback via relais (open/close/middle)
- Heating element to prevent condensation
- Optical position indicator with LED status monitoring
- Third position between “open” and “closed” optional
- Relay output for “ready to operate” and 7-segment error display
- Integrated manual override with magnetic lock
- Long service life due to robust design and superior electronics
- Flexible configuration thanks to modular concept
- Numerous monitoring and control options
- Simple handling

### COOL-FIT 4.0 Transition fittings, flange joints

Transition fittings and flange connectors enable connections to different systems in either metal or plastic, such as the Georg Fischer systems iFIT or Sanipex MT. The components are supplied including PE- insulation half shells with a protective PE jacket. The sealing faces between the shells are vapor tight by their design. No additional tape or sealant is required.



	Size	Material	Thread type/connector/ bolt circle
Adaptor fitting to metal	d32 – d63 1/2" – 2"	PE – stainless steel	male thread (R, NPT), female thread (Rp, NPT), loose nut (G)
Adaptor Fitting to iFIT or Sanipex MT	d32	Stainless steel / Brass	iFIT, Sanipex MT
Unions	d32 – d63 d32 – d110	PE – PE, PE – ABS	Welding spigots cementing sockets
Flange Adaptor (flange joints)	d32 – d225	PE	Suitable for Bolt circle PN 16/10

### COOL-FIT 4.0 flex hoses

The flexible hoses in EPDM permit mobile access to devices such as chillers and fan coils. In addition to this the flex hose are compensating expansion or contraction within the system. The tear-resistant protective jacket and EPDM insulation ( $\lambda_{0^\circ\text{C}} \leq 0.036 \text{ W/mK}$ ) ensure the temperature of the cooling medium remains unchanged. Versatile connectivity options mean that system connection is ensured: G thread (male thread + loose nut including gasket)



d (mm)	DN (mm)	Thread	Length (mm)	Max. compen- sation $\Delta L$ (mm)	Rmin (min. bending radi- us) (mm)
d20	DN15	1/2"	1'000	276	119
d25	DN20	3/4"	1'000	161	156
d32	DN25	1"	1'000	68	192
d40	DN32	1 1/4"	1'500	233	252
d50	DN40	1 1/2"	2'000	396	312
d63	DN50	2"	2'000	233	372

### COOL-FIT 4.0 Installation fittings type 313

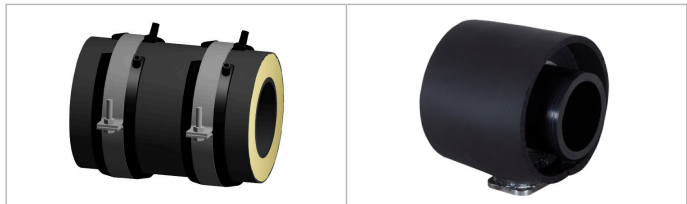
Installation fittings are used to install various types of sensors to the system. Pressure or temperature sensors can be connected using the 1/2" or 3/4" Rp or NPT female thread.

The insulation is comprised of highly efficient GF-HE foam with excellent insulating capabilities.



### COOL-FIT 4.0 Fixed point

The fixed point is used to direct pipe movement or retain forces from pipe weight at risers. The electrofusion welding tapes allow a permanent connection and transmit occurring forces between pipe and clamp.



## 2.3.4 COOL-FIT Tools

### Electrofusion machines

Electrofusion machines are required to join COOL-FIT 4.0 components. The range includes dedicated and multipurpose electrofusion machines which are reliable and easy to use.

Georg Fischer Piping Systems recommends: MSA-Series electrofusion machines.



### Long fusion adaptors

Long Fusion adaptors serve as an extension of the fusion plugs of electrofusion machines. Compared to standard adaptors, the longer adaptor length matches the insulation of the COOL-FIT 4.0 electrofusion Fittings. The long fusion adaptors are needed for electrofusion of fittings  $d \geq d160/D250$



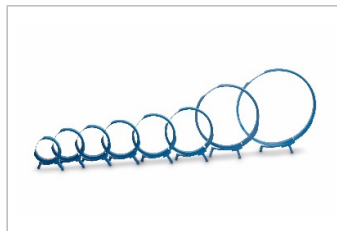
### Y-cable kit for COOL-FIT fixed point

Saves half of the normal welding time of the COOL-FIT fixed points.



### Assembly aids

The COOL-FIT 4.0 assembly aids are used for an easy mounting of COOL-FIT 4.0 Fitting on COOL-FIT 4.0 pipe. The assembly aid splays the pre-stressed sealing lips of the fittings enabling the easy insertion of the COOL-FIT 4.0 pipe.



### Foam removal tool and peeling tool – manually operated

The foam removal tool is used to prepare shortened COOL-FIT 4.0 pipe for electrofusion. The tool removes the foam and cuts outer jacket, and also peels the surface of the inner pipe. Any oxide layer present is removed when the welding zone is treated. The tool is available in three dimension range versions:

1. for sizes  $d32 - d90$ ,
2. for sizes  $d110 - d225$ .
3. for sizes  $d250 - d450$ .

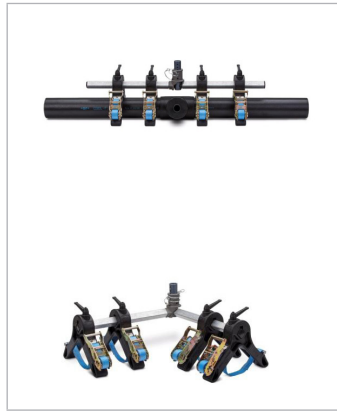




### Clamping tool

The fusion process gives rise to forces that can pull the pipe out of the coupler. Therefore it is recommended that the assembly should be fitted with COOL-FIT installation clamps. This prevents movement during the welding and cool-down process.

The central hinge allows the use of the clamps on elbows and reducers. Depending on the length of the pipe, 2 or 4 of the glass-reinforced plastic holders can be used. The linkage is made of galvanized steel. Tension bands are included and a T-adaptor is optional available.



### Weld-In Port installation tool

Using the installation tool, the different COOL-FIT Weld-in ports can be installed safe, reliable, reproducible and quick.

Drilling of jacket, drilling of inner pipe as well as the subsequent welding joint is supported in a clever way.

Depending on the need in Weld-in ports to be installed, the tool is available in 230V as well as in 110V in different equipment variants.



### Plastic pipe cutter PEcut 1200

Plastic pipe cutter for precise and safe cutting of COOL-FIT pipes in dimension from d160.



## 2.4 Dimensioning and Design

### 2.4.1 General information about the dimensioning and installation of plastic piping

Plastics have different physical characteristics to metals. When designing and installing thermoplastic piping systems, this needs to be taken into account. Although PE and COOL-FIT 4.0 are very robust systems, care should be taken to avoid damage during handling and transportation.

For over 50 years, GF Systems has developed and sold a variety of plastic piping systems which are subjected to very rigorous demands, such as optimized insulation properties in cooling applications. Experience has shown that plastic provides an economical and reliable alternative to metal when designers and installers take account of the recommendations in the technical documentation. In the professional production of plastic piping systems, for example, piping systems must be able to move to accommodate changes in length caused by temperature and pressure changes. To allow for these changes in length, the use of pipe holders that permit this movement is vital.

The following technical information contains the basic information needed to ensure an economical and trouble-free installation. However, this chapter does not contain all of the details. For more information, or if you have specific questions, please call your local GF Piping Systems representative. Additional information is available on the official GF Piping Systems website.

### 2.4.2 COOL-FIT 4.0 pressure-temperature diagram

The pressure resistance for thermoplastic pipe for water is always specified at +20 °C. At higher temperatures allowance must be made for a lower maximum operating pressure.

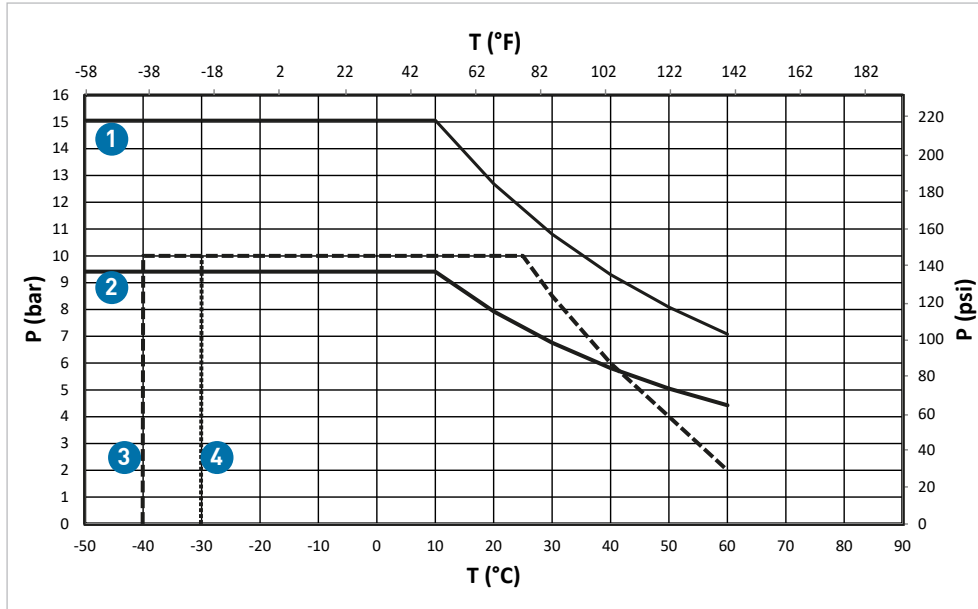
The graph shows the maximum permissible pressure for COOL-FIT 4.0 pipe and fittings at various temperatures, up to the maximum permissible media temperature of +60 °C. The graph is based on an ambient temperature of +20 °C. A safety factor of 1.6 and a minimum lifespan of 25 years have been allowed for in all calculations.

The values given in this chapter apply to both COOL-FIT 4.0 and COOL-FIT 4.0F.

**Pressure/temperature limits for COOL-FIT 4.0 pipe, fittings, valves – water as secondary refrigerant**

Limits for COOL-FIT 4.0: 25-year values allowing for the safety factor 1.6 (with water as the secondary refrigerant).

**i** In case of long-term operating pressure at temperatures above 47 °C, please contact your authorized GF Piping Systems representative.



- P Allowable pressure (bar, psi)
- T Temperature (°C, °F)
- C Safety factor
  
- 1** COOL-FIT 4.0 Pipe and fitting d32 – d450, C1.6, SDR11
- 2** COOL-FIT 4.0 Pipe and fitting d160 – d450, C1.6, SDR17
- 3** COOL-FIT 4.0 Ball valve PN10
- 4** COOL-FIT 4.0 Butterfly valve PN10

**Influence of secondary refrigerants with antifreeze additives**

At media temperatures below 0 °C, antifreeze must be used in the water to prevent it from freezing during a plant shut-down.

COOL-FIT 4.0 is generally resistant to secondary refrigerants such as glycol and salt solutions. For some refrigerants a reduction factor is necessary depending on the type and mixing ratio. The permissible operating pressure is corrected downwards from the pressure-temperature curve for water.

Reduction factors	COOL-FIT 4.0 Pipe and Fitting	COOL-FIT 4.0 Valves
Inorganic brine solutions	F = 1	F = 1
Organic salt solutions	F = 1	F = 1.25
Glycol solutions (max. 50 %)	F = 1.1	F = 1.7

For the calculation, the following formula is used:

$$P_{AF} = \frac{P_w}{AF}$$

$P_{AF}$  Permissible pressure with reduction factor

$P_w$  Permissible pressure for water

AF Reduction factor

## Glycol solutions

COOL-FIT 4.0 can be used with glycol solutions with concentrations up to 50%. The chemical resistance of COOL-FIT 4.0 systems is suitable for the following antifreeze types:

Brand name	Manufacturer	Type
Antifrogen N	Clariant	Ethylene glycol
Antifrogen L	Clariant	Propylene glycol
Showbrine Blue Showa standard EC brine	Showa Brine	Ethylene glycol
Tyfocor L	Tyfo	Propylene glycol
Tyfocor	Tyfo	Ethylene glycol
DOWFROST	DOW	Propylene glycol
Zytrec FC	Frigol	Propylene glycol
Zytrec LC	Frigol	Propylene glycol
Zytrec MC	Frigol	Ethylene glycol
Neutroge Neo	Climalife Dehon	Ethylene glycol
Friogel Neo	Climalife Dehon	Propylene glycol
DOWTHERM SR-1	DOW	Ethylene glycol

When using other secondary refrigerants, compatibility with COOL-FIT 4.0 should be clarified with Georg Fischer Piping Systems.

### √ Example – glycol dissolved in water

For water-glycol mixture  $\leq 50\%$ , the reduction factor for the pressure-temperature diagram is 1.7 (for COOL-FIT 4.0 valves). Thus, at  $+10\text{ °C}$ , with a minimum life of 25 years, the maximum allowable working pressure is reduced as follows:

$$P_{AF} = \frac{10 \text{ bar}}{1.7} = 5.88 \text{ bar}$$

## Organic salt solutions

These media are usually potassium formates or potassium acetates: aqueous solutions with low viscosity at low temperatures. COOL-FIT 4.0 can be used with the media below. The manufacturer's instructions must be followed.

Brand name	Manufacturer	Type
Antifrogen KF	Clariant	Brine
Zytrec S-55	Frigol	Brine
Temper	Temper	Brine
Hycool	Addcon	Brine

**i** For detailed information on resistance and reduction factors, see Planning Fundamentals "Material selection – Chemical resistance".

### 2.4.3 Polyethylene (PE)

The dominant material for the COOL-FIT 4.0 system is polyethylene (PE). As the inner pipe which comes into contact with the media is made of PE-100, its properties are of particularly high relevance.

#### Properties of PE (approximate)

Property	PE 100-value <sup>1</sup>	Unit	Testing standard
Density	0.95	g/cm <sup>3</sup>	EN ISO 1183-1
Yield stress at 23 ° C	25	N/mm <sup>2</sup>	EN ISO 527-1
Tensile modulus at 23 ° C	900	N/mm <sup>2</sup>	EN ISO 527-1
Charpy notched impact strength at 23 ° C	83	kJ/m <sup>2</sup>	EN ISO 179-1/1 eA
Charpy notched impact strength at -40 ° C	13	kJ/m <sup>2</sup>	EN ISO 179-1/1 eA
Crystallite melting point	130	°C	DIN 51007
Thermal conductivity at 23 ° C	0.38	W/m K	EN 12664
Water absorption at 23 ° C	0.01 to 0.04	%	EN ISO 62
Color	9,005		RAL
Oxygen Index (LOI)	17.4	%	4589-1

<sup>1</sup> Typical, measured on material characteristics, should not be used for calculations.

#### General information

All polymers made from hydrocarbons of the formula C<sub>n</sub>H<sub>2n</sub> are constructed with a double bond (ethylene, propylene, butene-1, isobutene) are referred to collectively as polyolefins. Among them is polyethylene (PE). It is a semi-crystalline thermoplastic. Polyethylene is probably the best known plastic. The chemical formula is: -(CH<sub>2</sub>-CH<sub>2</sub>)<sub>n</sub>. Polyethylene is an environmentally friendly hydrocarbon product. PE, like PP, is a non-polar material. Therefore, it is insoluble and scarcely swellable in conventional solvents. PE pipe cannot therefore be adhesively bonded to fittings. Welding is the appropriate connection method for the material.

The most widespread in piping system construction is PE for use in underground gas and water pipe. In this area polyethylene has become the dominant material in many countries. However, the advantages of this material mean that it is also used in domestic installations and industrial piping.

#### Advantages of PE

- Light weight
- Excellent flexibility
- Good wear resistance (abrasion resistance)
- Corrosion resistance
- Ductile fracture properties
- High impact strength even at very low temperatures
- Very good chemical resistance
- Weldable

## Mechanical properties, chemicals, weathering and abrasion resistance

### UV and weather resistance

Because of the black pigments used, polyethylene is very weather resistant. Even at long exposure to direct sunlight, wind and rain the material can be used without restrictions.



### Chemical resistance

Polyethylene exhibits good resistance to a wide range of media. For detailed information, please see the detailed chemical resistance list from Georg Fischer Piping Systems, or contact the person responsible at Georg Fischer Piping Systems directly.



### Abrasion resistance

PE has excellent resistance to abrasive wear. You can therefore find PE piping systems in use in numerous applications for transporting solids and media containing solids. For many applications, PE has proven especially advantageous with metals.



## Thermal and electrical properties

### Operating limits

The application limits of the material depend on both embrittlement and softening temperatures and on the manner and method of application. Details are provided in the relevant pressure-temperature charts.



### Electrical properties

Polyethylene, like most thermoplastics, is non-conductive. This means that systems in PE do not suffer from electrolytic corrosion. However, the non-conductive properties must be taken into consideration, as electrostatic charges can build up in the pipe. Polyethylene has good electrical insulation properties. The volume resistance is  $3.5 \times 10^{16} \Omega\text{cm}$ , the surface resistance  $10^{13} \Omega$ . This must be taken into account in applications where there is danger of fire or explosion.



## 2.4.4 Fire behavior and fire prevention measures

### Firestop classes

#### Classification of fire behavior

Construction materials are classified into different firestop classes depending on their fire behavior. The classification is decisive for whether specific materials may be legally used for construction in certain areas of construction projects.

#### European classification according to EN 13501-1

In the year 2001, the EN 13501-1 was introduced, a European classification system for construction materials. EN 13501-1 defines 6 construction material classes from A to F:

A	No contribution to the development of a fire (A1, A2)
B	Very little contribution to the development of a fire
C	Limited contribution to the development of a fire
D	Acceptable contribution to the development of a fire
E	Acceptable fire behavior
F	No performance criteria detected

In addition to the fire behavior, the European standard also rates fire side effects: smoke release (s1, s2, s3) and burning droplets (d0, d1, d2).

Smoke release:

s1	Limited smoke release
s2	Average smoke release
s3	High smoke release, or smoke release not tested

Burning droplets:

d0	No burning droplets/fall off within 600 seconds
d1	No burning droplets/fall off with an afterglow time of more than 10 seconds within 600 seconds
d2	No performance criteria detected

### Fire prevention classes COOL-FIT 4.0 EN13501-1, VKF and British building codes

	COOL-FIT 4.0	COOL-FIT 4.0F	COOL-FIT 4.0/ mineral wool <sup>2</sup>
			
EN 13501-1	E	B – s2, d0	A2 <sub>L</sub>
BS 5422:2009 <sup>1</sup>	National Class 3		National Class 0

<sup>1</sup> Test method according to BS 476-6 and BS 476-7

<sup>2</sup> Type: Rockwool 800

## Thermal load

The thermal load corresponds to a thermal potential (energy release) related to a specific base area, fire section area in m<sup>2</sup>, for example an escape route. The physical unit for the thermal load is energy per surface area kWh/m<sup>2</sup>. The calculative thermal load is equivalent to the sum of the different thermal potentials of all used combustible used elements, such as pipelines. When the energy released per running meter of the pipe (kWh/m) is known, the thermal load of the pipe is calculated from the used pipe length.

d/D (mm)	32/90	40/110	50/110	63/125	75/140	90/160	110/180	140/225
Thermal load COOL-FIT 4.0 SDR11 pipes (kWh/m)	15.0	21.7	24.0	32.7	41.4	53.1	68.9	109.43

d/D (mm)	160/250	225/315	250/355	280/400	315/450	355/500	400/560	450/630
Thermal load COOL-FIT 4.0 SDR17 pipes (kWh/m)	109.3	187.0	214.0	277.8	341.4	432.4	546.7	653.0

d/D (mm)	160/250	225/315	250/355	280/400	315/450	355/500	400/560	450/630
Thermal load COOL-FIT 4.0 SDR11 pipes (kWh/m)	134.5	236.4	275.1	354.1	437.9	554.4	702.7	850.7

d/D (mm)	160/250	225/315
Thermal load COOL-FIT 4.0F pipes (kWh/m)	106.75	193.73

## Fire resistance of components

While the fire behavior characterizes individual materials, the fire resistance must be considered for complete components, for example a solid wall with pipe perforations. The fire resistance is equivalent to the amount of time in which a component maintains its function during a standard fire.

The European system allows classification according to different criteria, stating the respective fire resistance duration in minutes.

## Fire resistance and classification according to the European standards

Pipe insulation systems are exposed to a standard fire according to EN 1363-3. Classification is according to EN 13501-2 and generally includes the criteria integrity (E, Étanchéité) and thermal insulation (I, Insulation).

Abbreviation	Criterion	Rating
E – Étanchéité	Flame protection or integrity	Measurement of an element's capacity of preventing the passage of gases and flames in case of fire.
I – Insulation	Insulation or thermal insulation	Measurement of the insulation capacity of an element, i.e. the duration in which the side of the element facing away from the fire does not exceed 180° C + the ambient temperature.



## Firestop collars/Fire sealing

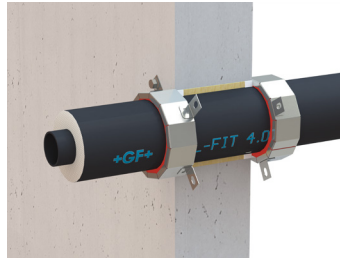
When pipes are installed through fire-rated assemblies, whose reliable functioning must not be affected, firestop collars that comply with local requirements and legislation must be used.

### Hilti firestop

#### System description

The firestop collar (incl. fastening hook) is made of galvanized steel sheet into which strips of intumescent material (i.e. that swells in case of fire) are inserted.

The fire retardation sealing with straight pipes is regulated in conjunction with the following products in the individual countries:



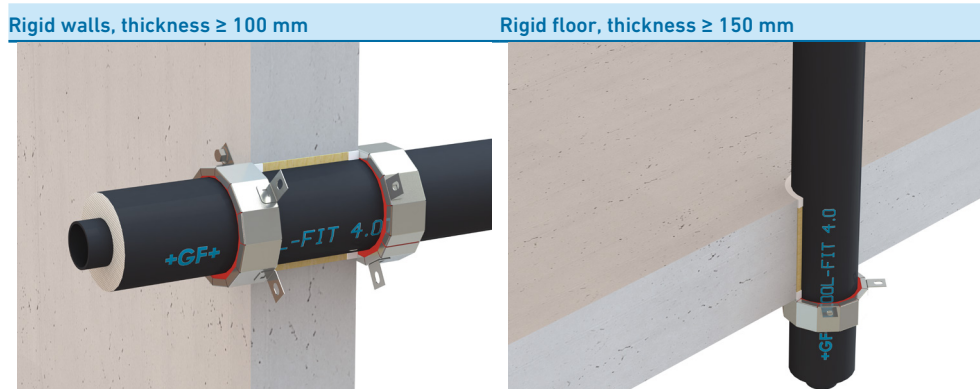
Product	Proof of applicability	Countries
Hilti firestop collar CP 644	Allgemeine Bauartgenehmigung (aBg) Z-19.53-2330	DE
Hilti firestop collar CP 644	VKF Technische Auskunft 14108	CH
Hilti firestop collar CFS-C P	ETA-10/0404	EU

The respective details of the proofs of application must be taken into account.

Additional information is available at Hilti online or from your Hilti contact person.

Hilti CP 644	Hilti CFS-C P
Info   Shop	Info   Shop
	
<a href="https://qr.hilti.com/r3069">qr.hilti.com/r3069</a>	<a href="https://qr.hilti.com/r4831">qr.hilti.com/r4831</a>

The following applications are regulated via the above proofs of application:



## Fire-retarding sealing

COOL-FIT 4.0 pipes up to and including an outside diameter D of 250mm\*, can be sealed in rigid walls and D of 140mm in rigid floors by a Hilti fire protection collar.

Wall ≥ 100mm solid		Product DE, CH	Product EU	Fire resistance	Mounting
d (mm)	D (mm)	CP 644	CFS-C P		Number of hooks
32	90	CP 644-90/3"	CFS-C P 90/3"	EI 120-U/C	3
40	110	CP 644-110/4"	CFS-C P 110/4"	EI 120-U/C	4
50	110	CP 644-110/4"	CFS-C P 110/4"	EI 120-U/C	4
63	125	CP 644-125/5"	CFS-C P 125/5"	EI 120-U/C	4
75	140	CP 644-160/6"	CFS-C P 160/6"	EI 120-U/C	6
90	160	CP 644-160/6"	CFS-C P 160/6"	EI 120-U/C	6
110	180	CP 644-180/7"	CFS-C P 180/7"	EI 120-U/C	8
160	250	CP 644-250/10"	CFS-C P 250/10"	EI 120-U/C	12

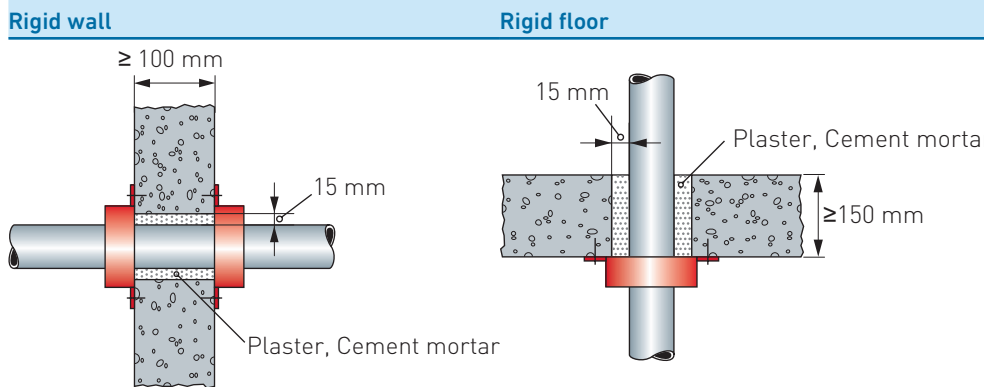
Ceiling ≥ 150mm solid		Product DE, CH	Product EU	Fire resistance	Mounting
d (mm)	D (mm)	CP 644	CFS-C P		Number of hooks
32	90	CP 644-90/3"	CFS-C P 90/3"	EI 120-U/C	3
40	110	CP 644-110/4"	CFS-C P 110/4"	EI 120-U/C	4
50	110	CP 644-110/4"	CFS-C P 110/4"	EI 120-U/C	4
63	125	CP 644-125/5"	CFS-C P 125/5"	EI 120-U/C	4
75	140	CP 644-160/6"	CFS-C P 160/6"	EI 120-U/C	6

\* For bigger dimensions see chapter "Additional approved fire retarding sealing".

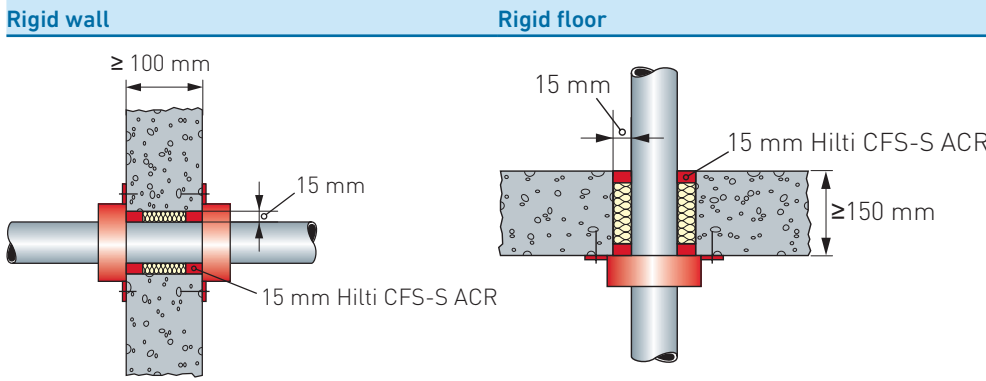
## Gap sealing

For the installation situations there are several options for sealing gaps against smoke gas.

Gap sealing with non-combustible construction materials:



Joint closure with Hilti firestop sealant CFS-S ACR and mineral wool backfill up to 15mm annular gap width for Hilti firestop collar CP 644 and CFS-C P.

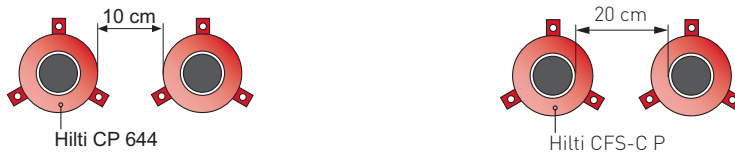


**Distance regulations**

The distance of the component openings to be closed to other openings or installed elements must comply with the data provided in the following table.

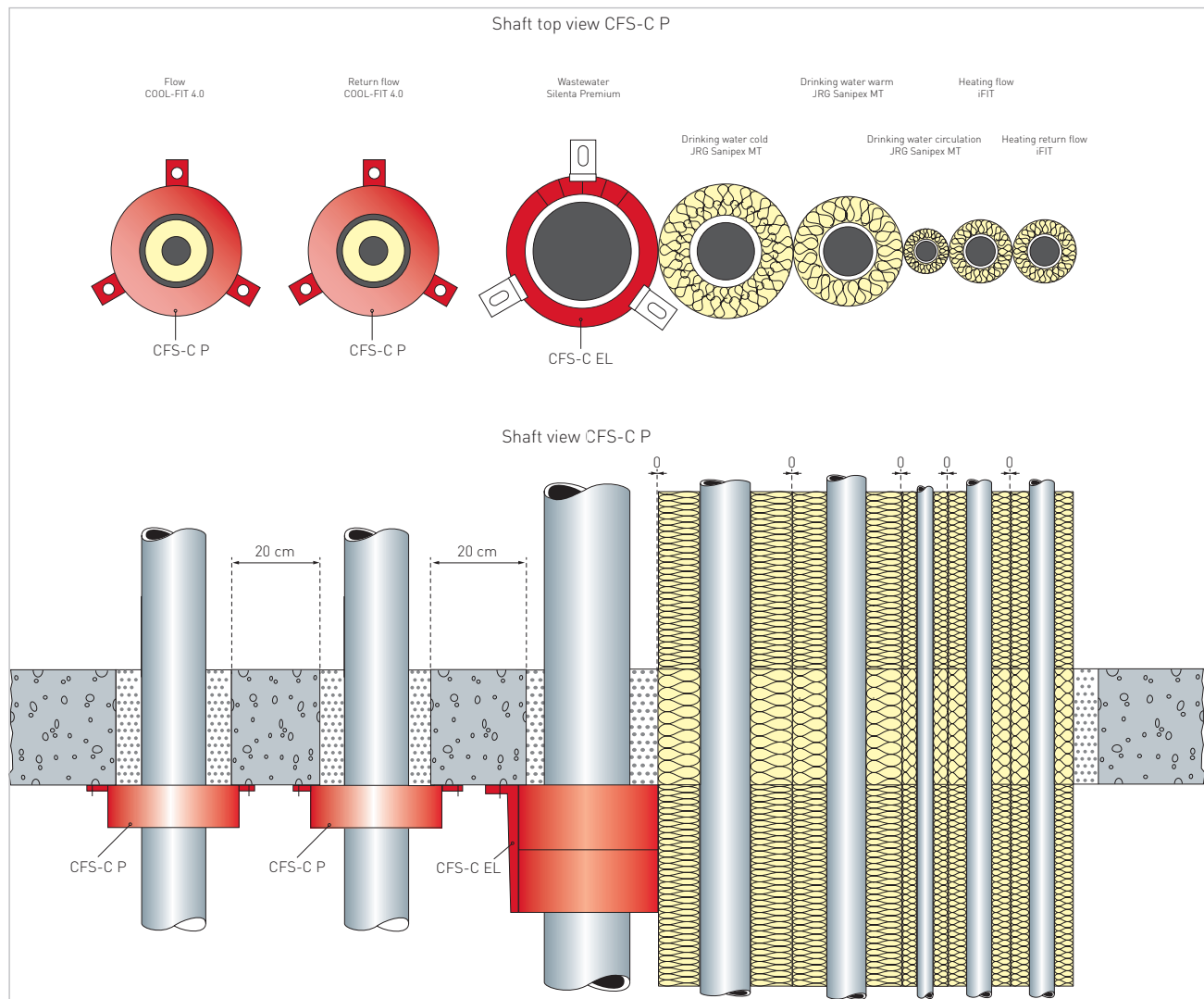
Distance of the pipe sealing to	Size of the adjacent openings	Distance between the openings DE, CH	Distance between the openings EU
Other cable or pipe sealing	one/both openings > 40cm x 40cm	≥ 20cm	≥ 20cm
	Both openings ≤ 40cm	≥ 10cm	
Other openings or installed elements	one/both openings > 20cm x 20cm	≥ 20cm	≥ 20cm
	Both openings ≤ 20cm	≥ 10cm	

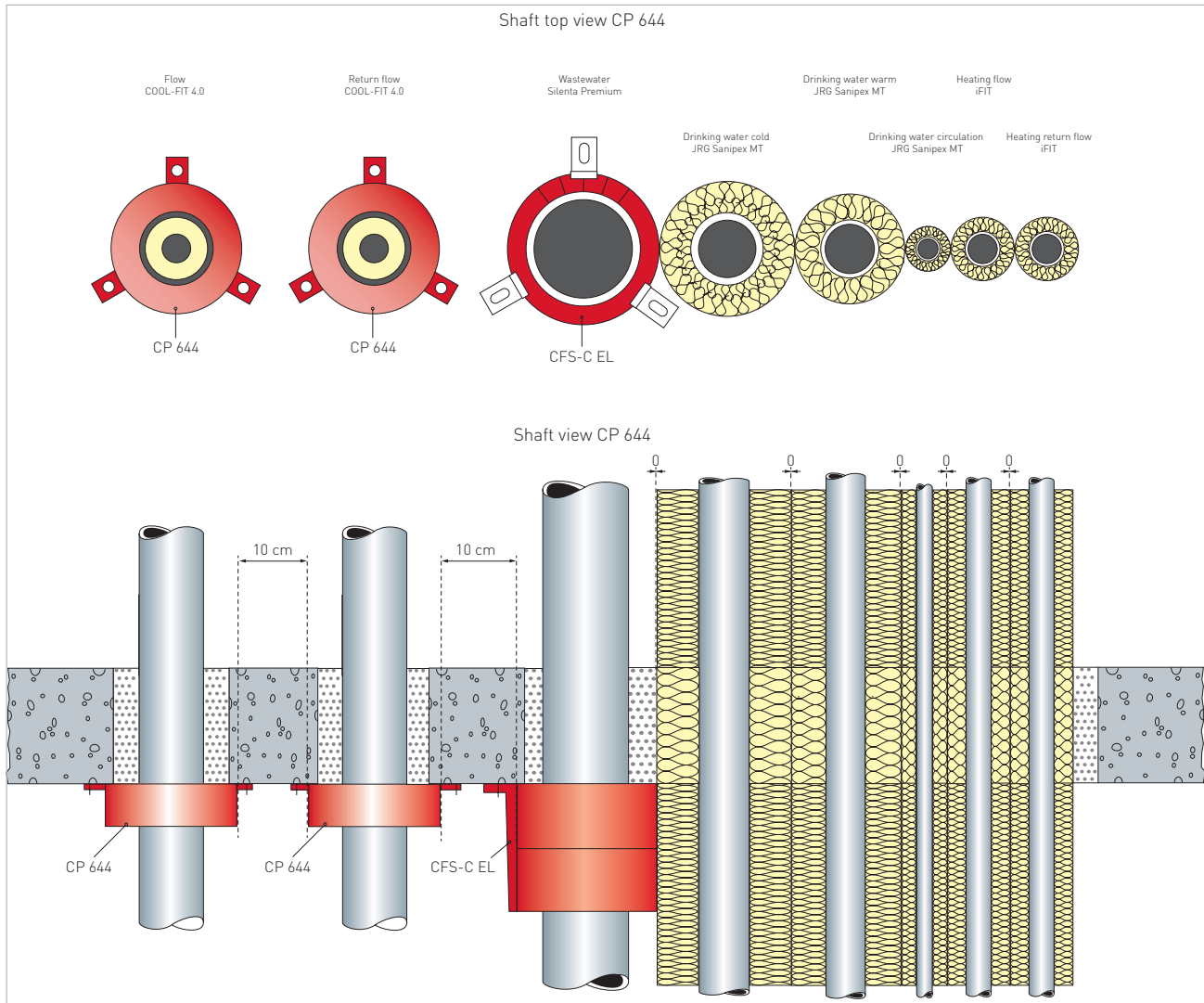
The following pipe distances between the openings of the pipe lead through are derived from this for pipe sealing with the Hilti firestop collar for COOL-FIT 4.0:



## Shaft installation

A shaft installation with additional pipelines, for example for heating and drinking water, may look as follows:





**Additional approved fire retarding sealing**

The following firestop collars were tested with COOL-FIT 4.0 / 4.0F pipes.

Fire-retarding sealing	Manufacturer	Approval
ROKU® AWM II	Rolf Kuhn GmbH	ETA 17/0753
BIS Pacifyre® AWM II	Walraven	ETA 17/0753

The firestop system ROKU® R – type AWM II carries the European technical approval ETA 17/0753. COOL-FIT 4.0 (up to dimensions d355/D500) and 4.0F was tested with AWM II firestop collars.

For detailed product information on AWM II see [www.svt-global.com](http://www.svt-global.com)

## ROKU® System AWM II

### System description

The ROKU® system AWM II consists of a firestop collar housing, which is equipped on the inside with several layers of the highly effective intumescent material "ROKU® Strip." In case of fire, the foaming material reacts with a strong foaming pressure and permanently seals the construction component opening against fire and smoke. On walls, one collar should be fitted on each side, and on ceilings only one collar underneath the ceiling.

### Application areas

- Sealing of plastic pipes up to Ø 400 mm in solid walls, light partition walls, and solid ceilings
- For plastic pipes, mineral fiber-reinforced plastics, plastic composite pipes
- Suitable for insulated and non-insulated plastic pipes and acoustically insulating sewage pipes

## Solutions for emergency corridors

Within emergency corridors the use of only non-combustible materials is allowed. The supplier Rockwool offers with Rockwool 800 a protection sleeve, made of mineral wool, which allows the use of normal combustible pipe within emergency areas. This solution is approved on pipe outer diameters of up to 160 mm.

For detailed information about Rockwool 800 see:

[www.rockwool.de](http://www.rockwool.de).



## Roxtec RS PPS seal

### System description

The Roxtec RS PPS is a sealing for pipes through steel decks and bulkheads in vessels. The intumescent-based sealing strips that wrap around the plastic pipe ensure blocking of smoke, flames and water in case of fire.

Fire-retarding sealing	Manufacturer	Approval
Roxtec RS PPS und RS PPS/S	Roxtec International AB	MEDB000036A LR2090258SF

For detailed information about Roxtec see [www.roxtec.com](http://www.roxtec.com)

## 2.4.5 Hydraulic design

### Determination of pipe diameter based on flow rate

As a first approximation, the required pipe cross-section for a certain flow rate can be calculated using the following formula:

$$d_i = 18.8 \cdot \sqrt{\frac{Q_1}{v}} \quad \text{oder} \quad d_i = 35.7 \cdot \sqrt{\frac{Q_2}{v}}$$

v	flow velocity (m/s)
d <sub>i</sub>	Pipe internal diameter (mm)
Q <sub>1</sub>	Flow rate (m <sup>3</sup> /h)
Q <sub>2</sub>	Flow rate (l/s)
18.8	Conversion factor for units Q <sub>1</sub> (m <sup>3</sup> /h)
35.7	Conversion factor for units Q <sub>2</sub> (l/s)

#### √ Example calculation of an internal diameter d<sub>i</sub>

COOL-FIT 4.0 pipe	SDR17
Flow rate Q <sub>2</sub>	55 l/s
Usual flow velocity v	1.5 m/s

$$d_i = 35.7 \cdot \sqrt{\frac{55}{1.5}} = 216.2 \text{ mm}$$

A pipe with d225/D315 is used. After the internal diameter has been determined that way, the actual flow rate is determined with the following formula:

$$v = 354 \cdot \frac{Q_1}{d_i^2} = 1.8 \frac{\text{m}}{\text{s}} \quad \text{oder} \quad v = 1275 \cdot \frac{Q_2}{d_i^2} = 1.8 \frac{\text{m}}{\text{s}}$$

v	Flow velocity v (m/s)
d <sub>i</sub>	Pipe internal diameter (mm)
Q <sub>1</sub>	Flow rate (m <sup>3</sup> /h)
Q <sub>2</sub>	Flow rate (l/s)
354	Conversion factor for units Q <sub>1</sub> (m <sup>3</sup> /h)
1275	Conversion factor for units Q <sub>2</sub> (l/s)

### Determination of pipe diameter based on cooling capacity

As a first approximation, the required pipe cross section for a certain cooling power can be calculated using the following formula.

$$d_i = 18.8 \cdot \sqrt{\frac{Q_L \cdot 3600}{\Delta T \cdot c \cdot \rho \cdot v}}$$

d <sub>i</sub>	Pipe inner diameter (mm)
Q <sub>L</sub>	Cooling capacity in kW
ΔT	Temperature difference supply - return (K)
c	Specific heat capacity (kW*s/(kg*K))
ρ	Density of the medium (kg/m <sup>3</sup> )
v	Flow velocity (m/s)

#### √ Example for calculating the inner diameter d<sub>i</sub> based on cooling capacity with water medium water

Cooling capacity $Q_L$	2'000 kW
Specific heat capacity (20 °C) $c$	4.187 kJ/(kg*K)
Water density (20 °C) $\rho$	998.2 kg/m <sup>3</sup>
Temperature difference $\Delta T$	10 K
Flow velocity $v$	1.5 m/s

$$d_i = 18.8 \cdot \sqrt{\frac{\left(\frac{2000 \cdot 3600}{10 \cdot 4.187 \cdot 998.2}\right)}{1.5}} = 18.8 \cdot \sqrt{\frac{172.3}{1.5}} = 201.5 \text{ mm}$$

The flow rate should be estimated on the basis of the intended purpose of the pipe. As a guide for the flow rate, the following specifications apply.

**Liquids**

$v = 0.5 - 1.0$  m/s for the suction side

$v = 1.0 - 3.0$  m/s for the pressure side

This method of calculation of pipe diameter does not allow for hydraulic losses. They must be calculated separately. The following sections serve that purpose.

(m <sup>3</sup> /h)	(l/min)	(l/s)	(m <sup>3</sup> /s)
1.0	16.67	0.278	$2.78 \times 10^{-4}$
0.06	1.0	0.017	$1.67 \times 10^{-5}$
3.6	60	1.0	$1.00 \times 10^{-3}$
3'600	60'000	1'000	1.0

Conversion table with units of flow rate.

**Correlation of outer diameter - inner diameter**

To determine the outer diameter based on the internal diameter and SDR, the following formula can be used:

$$d = d_i \cdot \frac{SDR}{SDR - 2}$$

**Correlation between pipe external and internal diameter**

<b>d (mm)</b>	32	40	50	63	75	90	110	140
<b>d<sub>i</sub> SDR11 (mm)</b>	26.2	32.6	40.8	51.4	61.4	73.6	90	114.6
<b>d<sub>i</sub> SDR17 (mm)</b>								
<b>d (mm)</b>	160	225	250	280	315	355	400	450
<b>d<sub>i</sub> SDR11 (mm)</b>	130.8	184	204.6	229.2	257.8	290.6	327.4	368.2
<b>d<sub>i</sub> SDR17 (mm)</b>	141	198.2	220.4	246.8	277.6	312.8	352.6	396.6



### 2.4.6 Nomogram for easy calculation of diameter and pressure loss

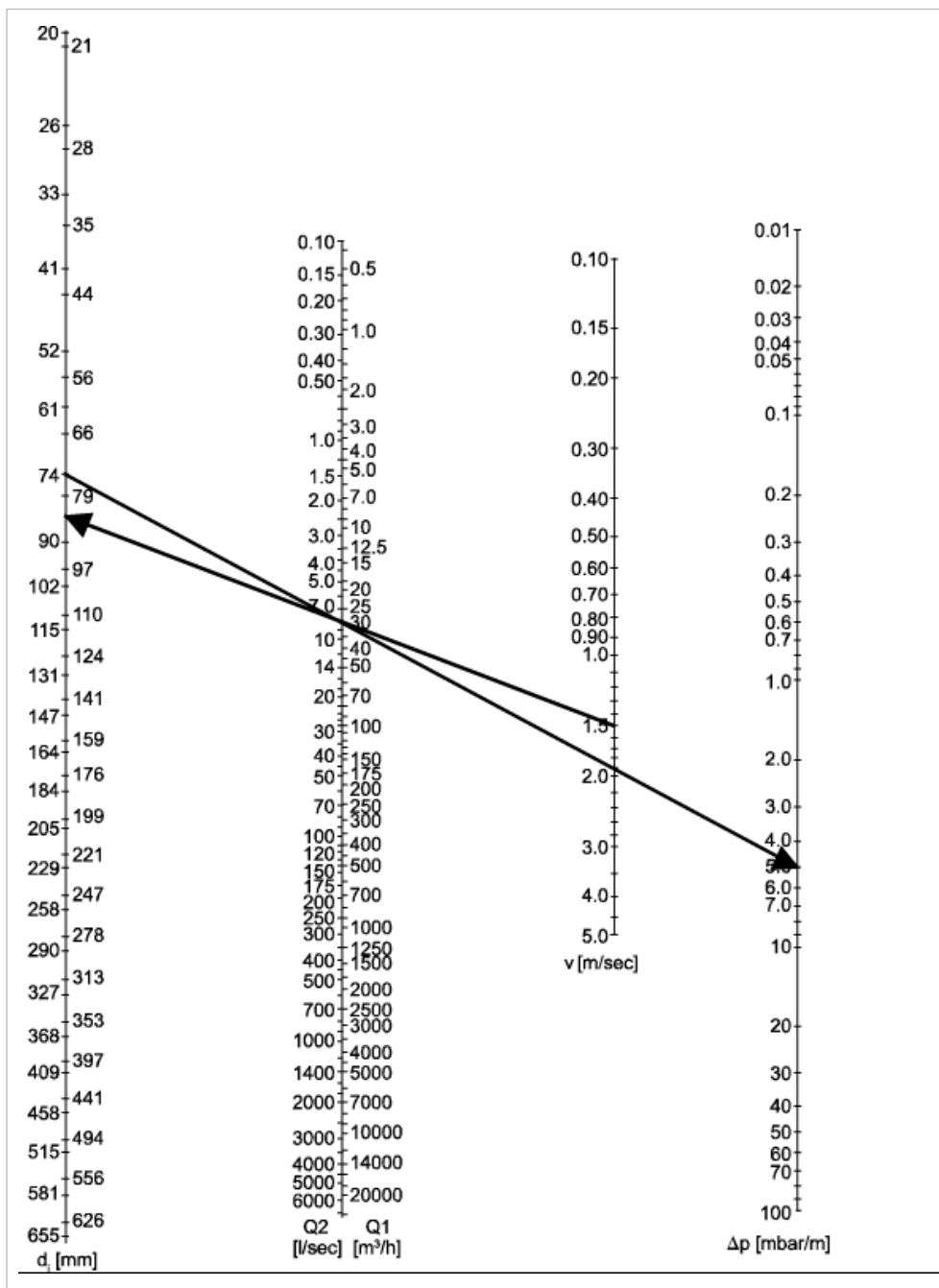
The nomogram below can be used to simplify the determination of the diameter required. The pressure loss in the pipe can be read off per meter of the pipe length.

**⚠** The pressure loss calculated using the nomogram only applies to flows of substances with density 1000 kg/m<sup>3</sup>, i.e. water. Further pressure losses from fittings, valves, etc. also need to be considered using the instructions that follow.

#### Using the nomogram

Based on a flow velocity of 1.5 m/s, a line is drawn through the desired flow rate (i.e. 30 m<sup>3</sup>/h) to the axis which shows an internal diameter  $d_i$  ( $\approx$  84 mm). Here, a closely matching diameter (74 mm for SDR11) and a second line is drawn back through the desired flow rate to the pressure drop axis  $\Delta p$  (5 mbar per meter of pipe).

#### Nomogram for COOL-FIT 4.0 pipe (PE, SDR11) using the metric system



**i** For detailed information on the determination of diameter and pressure loss, see Planning Fundamentals "Hydraulic calculation and pressure losses of metric industrial piping systems".

## 2.4.7 Pressure loss

### Pressure loss in straight pipe

In determining pressure losses in straight pipe sections, a distinction is made between laminar and turbulent flows. The Reynolds number (Re) determines this. The change from laminar to turbulent occurs at the critical Reynolds number  $Re_{crit} = 2320$ .

In practice laminar flows occur particularly for the movement of viscous liquids such as lubricating oils. In most applications, thus including flows of aqueous materials, there is turbulent flow with a substantially more uniform velocity distribution over the pipe cross-section than in laminar flow.

The pressure loss in a straight pipe section is inversely proportional to the pipe diameter and is calculated as follows:

$$\Delta p_R = \lambda \cdot \frac{L}{d_i} \cdot \frac{\rho}{2 \cdot 10^2} \cdot v^2$$

- $\Delta p_R$  Pressure loss in the straight pipe run (bar)
- $\lambda$  Pipe friction factor
- L Length of the straight pipe section (m)
- $d_i$  Inner diameter of the pipe (mm)
- $\rho$  Density of the flow material ( $kg/m^3$ ) ( $1\text{ g/cm}^3 = 1000\text{ kg/m}^3$ )  
for water  $20\text{ }^\circ\text{C} = 998.2\text{ kg/m}^3$
- v Flow velocity v (m/s)

**⚠** In practice, when making a rough calculation (i. e. smooth plastic pipe and turbulent flow) it is enough to use the value  $\lambda = 0.02$  to represent the hydraulic pressure loss.

### Pressure losses in fittings

#### Coefficient of resistance

The pressure losses depend upon the type of fitting as well as on the flow in the fitting. The so-called coefficient of resistance ( $\zeta$  value) is used for calculations.

Fitting type	Coefficient of resistance $\zeta$	
Elbow 90°	1.2	
Elbow 45°	0.3	
T-90 <sup>1)</sup>	1.3	
Reducer (contraction)	0.5	
Reducer (extension)	1.0	
Coupler, Flange joints, Transition Fittings	d32: 0.8 d40: 0.7 d50: 0.6	d63: 0.4 d75: 0.3 d90-d225: 0.1
Flexible hoses	½": 2.0 ¾": 1.8 1": 1.4	1 ¼": 1.1 1 ½": 1.0 2": 0.8

<sup>1)</sup> For a more detailed view differentiate between coalescence and separation values for  $\zeta$  up to a maximum of 1.3 can be found in the respective literature. Usually the part of a T in the overall pressure loss is very small, therefore in most cases  $\zeta = 1.3$  can be used.

#### Calculation of the pressure loss

To calculate the total pressure loss in all fittings in a piping system, take the sum of the individual losses, i. e. the sum of all the  $\zeta$ -values. The pressure loss can then be calculated according to the following formula:

$$\Delta p_{Fi} = \Sigma \zeta \cdot \frac{v^2}{2 \cdot 10^5} \cdot \rho$$

- $\Delta p_{Fi}$  Pressure loss of all fittings (bar)
- $\Sigma \zeta$  Sum of all individual losses
- $v$  Flow velocity  $v$  (m/s)
- $\rho$  Density of the medium in  $\text{kg/m}^3$  ( $1 \text{ g/cm}^3 = 1000 \text{ kg/m}^3$ )

### Pressure losses in valves

The  $k_v$  factor is a convenient means of calculating the hydraulic flow rates for valves. It allows for all internal resistances and for practical purposes is regarded as reliable. It is defined as the flow rate of water in liters per minute with a pressure drop of 1 bar across the valve. The technical data of the Georg Fischer Piping Systems valves contains the  $k_v$  values as well as pressure loss charts. The latter make it possible to read off the pressure loss directly. But the pressure loss can also be calculated from the  $k_v$  value according to the following formula:

$$\Delta p_{Ar} = \left( \frac{Q}{k_v} \right)^2 \cdot \frac{\rho}{1000}$$

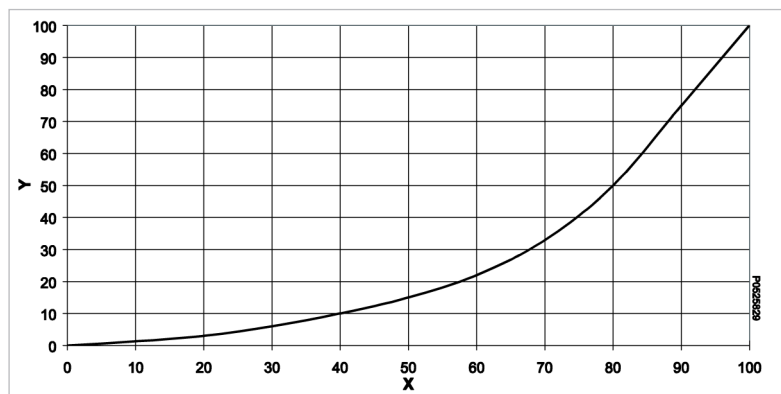
- $\Delta p_{Ar}$  Pressure loss for the valve (bar)
- $Q$  Flow rate ( $\text{m}^3/\text{h}$ )
- $\rho$  Density of the conveyed medium ( $\text{kg/m}^3$ ) ( $1 \text{ g/cc} = 1000 \text{ kg/m}^3$ )
- $k_v$  Valve characteristic value ( $\text{m}^3/\text{h}$ )

### $k_v$ 100-Werte

DN (mm)	Zoll (inch)	d (mm)	$k_v$ 100 (l/min)	$C_v$ 100 (gal/min)	$k_v$ 100 ( $\text{m}^3/\text{h}$ )
25 <sup>1</sup>	1	32	700	49.0	42
32 <sup>1</sup>	1 ¼	40	1'000	70.0	60
40 <sup>1</sup>	1 ½	50	1'600	112.0	96
50 <sup>1</sup>	2	63	3'100	217.1	186
65 <sup>1</sup>	2 ½	75	5'000	350.0	300
80 <sup>1</sup>	3	90	7'000	490.0	420
100 <sup>2</sup>	4	110	3'800	455	390
125 <sup>2</sup>	5	140	8'600	602	516
150 <sup>2</sup>	6	160	16'600	1'162	1'000
200 <sup>2</sup>	8	225	39'600	2'772	2'380

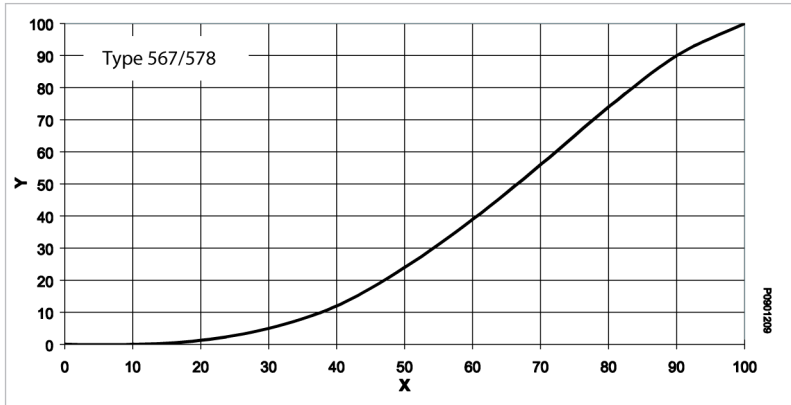
- <sup>1</sup> COOL-FIT 4.0 Ball valve
- <sup>2</sup> COOL-FIT 4.0 Butterfly valve

### Flow characteristic Ball valve



- X Opening angle (%)
- Y  $k_v$ ,  $C_v$  value (%)

Flow characteristic butterfly valve




X Opening angle (%)  
 Y  $k_v, C_v$  value (%)

Pressure difference between the static pressure

If the piping system is installed vertically, then a geodetic pressure difference must be calculated for it. This pressure difference is calculated as follows:

$$\Delta p_{geod} = \Delta H_{geod} \cdot \rho \cdot 10^{-4}$$


$\Delta p_{geod}$  Geodetic pressure difference (bar)  
 $\Delta H_{geod}$  Difference in elevation of the piping system (m)  
 $\rho$  Density of the medium (kg/m<sup>3</sup>) (1 g/cm<sup>3</sup> = 1000 kg/m<sup>3</sup>)

 At closed systems, the geodetic pressure difference does not need to be considered

Sum of pressure losses

The sum of all pressure drops for a piping system is calculated as follows:

$$\Sigma \Delta p = \Delta p_R + \Delta p_{Fi} + \Delta p_{Ar} + \Delta p_{geo}$$

 Example for pressure drop calculations

The following example illustrates the calculation process for determining the pressure loss of a piping system.

COOL-FIT 4.0 pipe	d40 mm	<b>Number of Fittings</b>
SDR11 - flow rate	1.5 l/s	12 x 90° angle
Medium	Water	4 x 45° angle
Density of the medium	1.0 g/cm <sup>3</sup>	3 x T-piece
Length straight pipe	15 m	3 x screws
Height difference	2.0 m	2 x flange connections
		1 x ball valve, 80 % opened

The wall thickness of the piping system can be calculated as follows with the SDR:

$$e = \frac{d}{SDR} = \frac{40 \text{ mm}}{11} = 3.6 \text{ mm}$$

The inner diameter of the piping system is as follows:

$$d_i = d - 2 \cdot e = d - \frac{2 \cdot d}{SDR} = 32.8 \text{ mm}$$

With the desired flow rate of 1.5 l/s, the flow velocity is as follows:

$$v = 1275 \cdot \frac{Q_2}{d_i^2} = 1275 \cdot \frac{1.5 \text{ m}}{32.8^2 \text{ sec}} = 1.78 \frac{\text{m}}{\text{sec}}$$

Pressure loss	Formula
Pressure loss for straight pipe sections	$\Delta p_R = 0.02 \cdot \frac{15}{32.8} \cdot \frac{1000}{2 \cdot 10^2} 1.78^2 = 0.14 \text{ bar}$
Pressure loss for fittings incl. connections	$\Sigma \zeta = (12 \cdot 1.2) + (4 \cdot 0.3) + (3 \cdot 1.3) + (5 \cdot 0.7) = 23$ $\Delta p_{Fi} = 23 \cdot \frac{1.78^2}{2 \cdot 10^5} \cdot 1000 = 0.36 \text{ bar}$
Pressure loss for the valve 80 % opened. With the flow characteristics diagram for ball valves type 546, from an 80 % opening angle a percentile $k_v$ value of 50 % can be read out, that means 50 % of the $k_v$ value 100: $0.5 \cdot 60 \text{ m}^3/\text{H}$ (flow rate $1.5 \text{ l/s} = 5.4 \text{ m}^3/\text{h}$ )	$\Delta p_{Ar} = \left( \frac{5.4}{0.5 \cdot 60} \right)^2 \cdot \frac{1000}{1000} = 0.03 \text{ bar}$
Pressure loss of height difference	$\Delta p_{geod} = 2.0 \cdot 1000 \cdot 10^{-4} = 0.2 \text{ bar}$
Whole pressure loss of the piping	$\Sigma \Delta p = 0.14 \text{ bar} + 0.36 \text{ bar} + 0.03 \text{ bar} + 0.2 \text{ bar} = 0.73 \text{ bar}$

### 2.4.8 Dimension comparison COOL-FIT 4.0 metal

COOL-FIT 4.0		Stainless steel	
d (mm)	DN	inches	da (mm)
32	25	1	33.4
40	32	1 ¼	42.2
50	40	1 ½	48.3
63	50	2	60.3
75	65	2 ½	73.0
90	80	3	88.9
110	90	4	114.3
140	125	5	141.3
160	150	6	168.3
225	200	8	219.1
250	250	10	244.5
280	250	10	273.1
315	300	12	323.9
355	350	14	355.6
400	400	16	406.4
450	450	18	457.2

d Nominal external diameter of PE pipe

## 2.4.9 Z-dimension method

### Overview

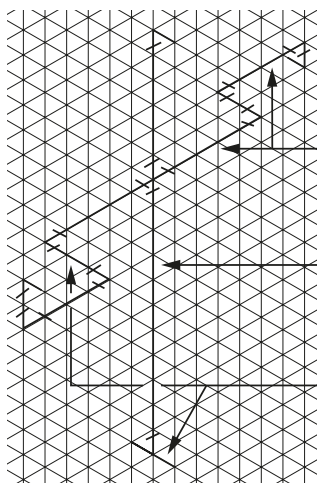
The pressure of competition and high wages makes it essential to install piping systems efficiently. The Georg Fischer Piping Systems method of assembly is highly suited to this task. It replaces the tedious and time-consuming cutting to size of one pipe at a time by a fast and precise way of preparing whole groups of pipe according to plans or jigs.

The respective pipe group with the corresponding design dimensions and cut lengths can be entered in the isometric paper of Georg Fischer Piping Systems, see Measuring Sheet Seite 491.

Please adhere to the following guidelines for drawing:

#### Pipe running perpendicular to one another

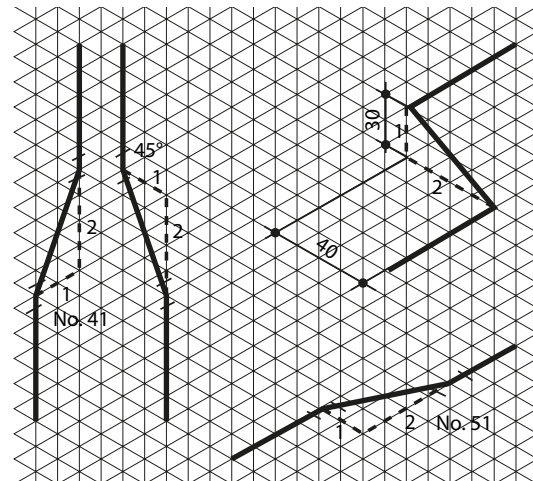
#### Pipe running diagonally



Horizontally:  
left and right

Vertical

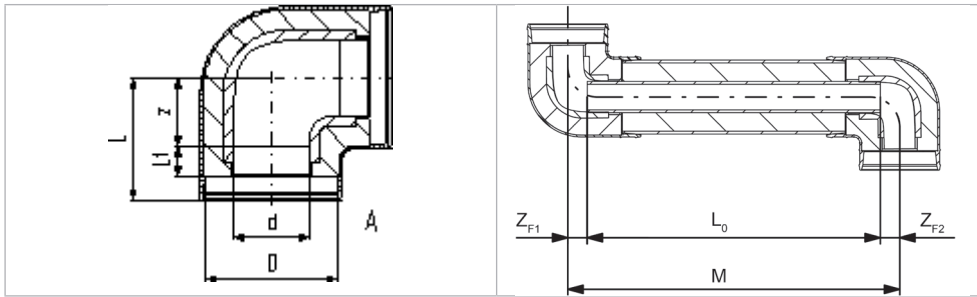
Horizontally:  
front and rear



The z-dimensions of the fittings are needed for determining the actual cutting lengths of the pipe. The tables in our product ranges and in the online catalogues contain all the relevant data for the fittings. The length of pipe to be cut is given as in the following diagram by the distance between the center of adjoining fittings less the sum of the z-dimension of the fittings.

## Procedure

### Electrofusion



### Formula for determining the required pipe length

$$L_0 = M - Z_{F1} - Z_{F2}$$

$L_0$  Pipe length to be cut

$M$  Center to center distance between fittings

$Z_{F1}$  z measurement for fitting 1

$Z_{F2}$  z measurement for fitting 2



### Example

Dimension	d32/D90
Center to center distance $M$	1'000 mm
z measurement for 90° elbow $Z_{F1}$	20 mm
z measurement for 90° elbow $Z_{F2}$	20 mm
$M = 1000 \text{ mm}; L_0 = ?$	

$$L_0 = 1000 \text{ mm} - 20 \text{ mm} - 20 \text{ mm} = 960 \text{ mm}$$





### 2.4.10 Length changes and flexible sections

#### Overview

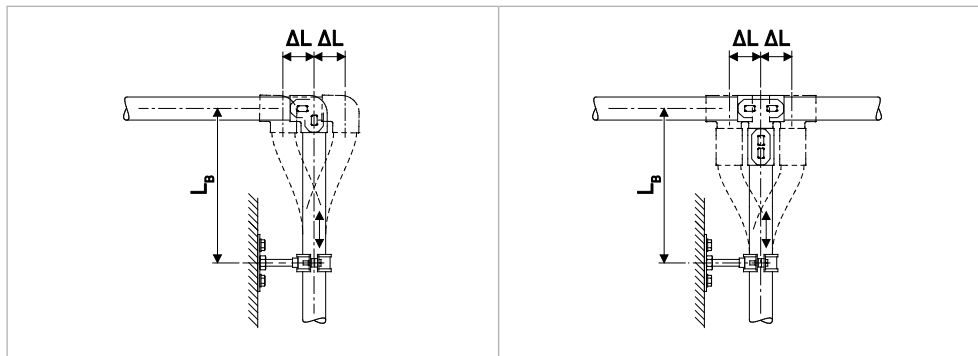
##### Length changes $\Delta L$ and expansion bend $L_B$ – General

Thermoplastics are subject to higher thermal expansion and contraction than metallic materials. Pipe installed above ground, against walls or in ducts, require changes in length to be taken up in order to prevent any superimposed extra strain on the pipe. This applies especially to pipe exposed to operating temperature variations.

To accommodate a change in length, the following options can be considered:

- A Flexible sections
- B Flexible hoses
- C Compensators

Flexible sections are the most common, the simplest and the most economical solution. The calculations for and the positioning of flexible sections are therefore described in detail.



$\Delta L$  Change in length  
 $L_B$  Flexible section

#### Fundamentals

The low elasticity of thermoplastics allows changes in length to be taken up by special pipe sections, where pipe supports are positioned so that they can take advantage of the natural flexibility of the material. The length of such sections is determined by the diameter of the piping system and the extent of the thermal expansion to be compensated.



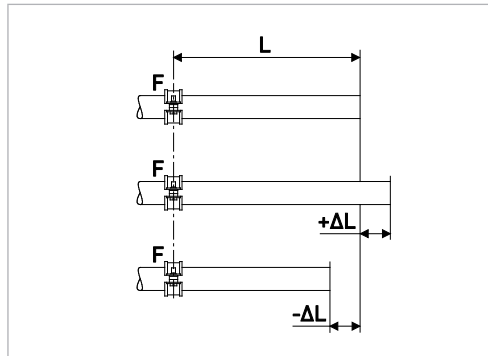
Flexible sections arise naturally at any branching or change in direction of the piping system. The movement  $L_B$  of the flexible section as a result of a change  $\Delta L$  in the length must not be restrained by fixed pipe brackets, wall protrusions, girders or the like.

### Calculation of length changes

To determine the change in length due to temperature  $\Delta L$  (mm) of COOL-FIT 4.0 pipe, the following temperatures must be known:

**Installation temperature**

- Minimum flow temperature
- Maximum flow temperature
- Minimum ambient temperature
- Maximum ambient temperature



F Fixpoint  
L Length of pipe section

■ The following tables show changes in length at different media temperatures for certain conditions. To determine the change in length for other conditions, the COOLING Tool-Box can be used. Contact your local GF Piping Systems representative or visit [www.gfps.com](http://www.gfps.com)



**Example of use:**

Installation temperature                    25 °C  
 Min. ambient temperature                25 °C constant  
 Max. ambient temperature                25 °C constant  
 Min. flow temperature                    See table  
 Max. flow temperature                    25 °C  
 Pipe class                                      d32 - d140 SDR11 and d160 - d450 SDR17

Length change $\Delta L$ (mm) at 20° C flow temperature					Length change $\Delta L$ (mm) at 15° C flow temperature				
L (m)	25	50	100	150	L (m)	25	50	100	150
d32	-4	-9	-18	-27	d32	-9	-18	-37	-55
d40	-5	-10	-19	-29	d40	-10	-20	-40	-59
d50	-6	-13	-26	-38	d50	-13	-26	-52	-78
d63	-7	-15	-29	-44	d63	-15	-30	-60	-90
d75	-8	-16	-32	-48	d75	-16	-33	-65	-98
d90	-9	-18	-36	-54	d90	-18	-36	-73	-109
d110	-10	-20	-41	-61	d110	-21	-41	-82	-124
d140	-10	-21	-41	-62	d140	-21	-42	-84	-126
d160	-9	-18	-37	-55	d160	-19	-37	-75	-112
d225	-11	-21	-43	-64	d225	-22	-43	-86	-129
d250	-11	-23	-45	-68	d250	-23	-46	-91	-137
d280	-11	-22	-44	-66	d280	-22	-44	-89	-133
d315	-11	-22	-45	-67	d315	-23	-45	-91	-136
d355	-11	-23	-45	-68	d355	-23	-46	-91	-137
d400	-11	-23	-45	-68	d400	-23	-46	-92	-137
d450	-12	-24	-48	-72	d450	-24	-48	-96	-144

L Laid pipe length

Length change $\Delta L$ (mm) at 10° C flow temperature					Length change $\Delta L$ (mm) at 5° C flow temperature				
L (m)	25	50	100	150	L (m)	25	50	100	150
d32	-14	-28	-56	-84	d32	-19	-38	-76	-115
d40	-15	-30	-61	-91	d40	-21	-41	-83	-124
d50	-20	-40	-80	-120	d50	-27	-54	-109	-163
d63	-23	-46	-91	-137	d63	-31	-62	-124	-185
d75	-25	-50	-100	-150	d75	-34	-67	-135	-202
d90	-28	-55	-111	-166	d90	-37	-75	-149	-224
d110	-31	-62	-125	-187	d110	-42	-84	-168	-252
d140	-32	-64	-127	-191	d140	-43	-86	-171	-257

L Laid pipe length

Length change $\Delta L$ (mm) at 10° C flow temperature					Length change $\Delta L$ (mm) at 5° C flow temperature				
L (m)	25	50	100	150	L (m)	25	50	100	150
d160	-28	-57	-114	-171	d160	-38	-77	-154	-230
d225	-33	-65	-130	-196	d225	-44	-88	-175	-263
d250	-34	-69	-138	-207	d250	-46	-93	-185	-278
d280	-34	-67	-134	-201	d280	-45	-90	-180	-270
d315	-34	-69	-138	-206	d315	-46	-92	-185	-277
d355	-35	-69	-138	-207	d355	-46	-93	-186	-278
d400	-35	-69	-139	-208	d400	-46	-93	-186	-279
d450	-36	-73	-145	-218	d450	-49	-97	-195	-292

Length change $\Delta L$ (mm) at 0° C flow temperature					Length change $\Delta L$ (mm) at -5° C flow temperature				
L (m)	25	50	100	150	L (m)	25	50	100	150
d32	-24	-49	-97	-146	d32	-30	-59	-119	-178
d40	-26	-53	-105	-158	d40	-32	-64	-128	-192
d50	-34	-69	-138	-207	d50	-42	-84	-168	-252
d63	-39	-78	-157	-235	d63	-48	-95	-190	-286
d75	-43	-85	-171	-256	d75	-52	-104	-207	-311
d90	-47	-94	-189	-283	d90	-57	-114	-228	-342
d110	-53	-106	-212	-318	d110	-64	-128	-256	-384
d140	-54	-108	-215	-323	d140	-65	-130	-260	-390
d160	-48	-97	-194	-291	d160	-59	-117	-234	-352
d225	-55	-110	-221	-331	d225	-67	-133	-266	-399
d250	-58	-116	-233	-349	d250	-70	-140	-280	-420
d280	-57	-113	-226	-340	d280	-68	-136	-273	-409
d315	-58	-116	-232	-348	d315	-70	-140	-279	-419
d355	-58	-117	-233	-350	d355	-70	-140	-281	-421
d400	-58	-117	-234	-350	d400	-70	-141	-281	-422
d450	-61	-122	-244	-367	d450	-73	-147	-294	-441

L Laid pipe length

Length change $\Delta L$ (mm) at -10° C flow temperature					Length change $\Delta L$ (mm) at -15° C flow temperature				
L (m)	25	50	100	150	L (m)	25	50	100	150
d32	-35	-71	-141	-212	d32	-41	-82	-163	-245
d40	-38	-76	-152	-228	d40	-44	-88	-176	-264
d50	-50	-99	-198	-297	d50	-57	-115	-229	-344
d63	-56	-112	-225	-337	d63	-65	-130	-259	-389
d75	-61	-122	-244	-366	d75	-70	-140	-281	-421
d90	-67	-134	-268	-402	d90	-77	-154	-308	-463
d110	-75	-150	-300	-450	d110	-86	-172	-344	-516
d140	-76	-152	-305	-457	d140	-87	-175	-349	-524
d160	-69	-138	-275	-413	d160	-79	-158	-316	-475
d225	-78	-156	-312	-467	d225	-89	-178	-357	-535
d250	-82	-164	-328	-491	d250	-94	-187	-375	-562
d280	-80	-160	-319	-479	d280	-91	-183	-366	-549
d315	-82	-163	-327	-490	d315	-93	-187	-374	-561
d355	-82	-164	-328	-492	d355	-94	-188	-376	-563
d400	-82	-164	-329	-493	d400	-94	-188	-376	-564
d450	-86	-172	-343	-515	d450	-98	-196	-392	-588

L Laid pipe length

COOL-FIT 4.0F

Length change $\Delta L$ (mm) at 20° C flow temperature					Length change $\Delta L$ (mm) at 15° C flow temperature				
L (m)	25	50	100	150	L (m)	25	50	100	150
d160	-6	-12	-25	-37	d160	-13	-25	-51	-76
d225	-7	-15	-30	-45	d225	-15	-30	-61	-91

Length change $\Delta L$ (mm) at 10° C flow temperature					Length change $\Delta L$ (mm) at 5° C flow temperature				
L (m)	25	50	100	150	L (m)	25	50	100	150
d160	-19	-39	-77	-116	d160	-26	-53	-105	-158
d225	-23	-47	-93	-140	d225	-32	-63	-126	-189

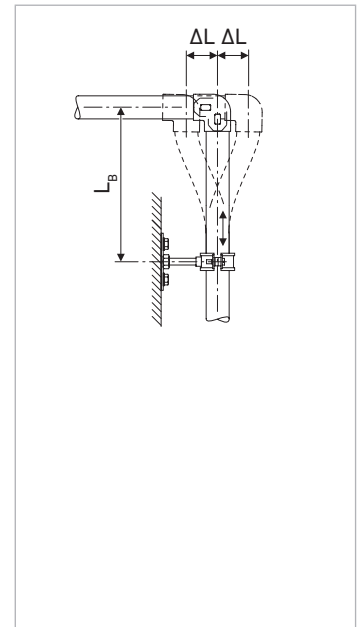
L Laid pipe length

Flexible sections for COOL-FIT 4.0

Flexible Section  $L_B$

Valid for SDR11 and SDR17. The values for  $L_B$  (cm) from this table can be used for a given  $\Delta L$  (mm) and the relevant pipe size:

Flexible section $L_B$ (cm)													
$\Delta L$ (mm)	10	20	30	40	50	60	70	80	90	100	150	200	300
d32	78	110	135	156	174	191	206	221	234	247	302	349	427
d40	86	122	149	172	193	211	228	244	259	273	334	386	472
d50	86	122	149	172	193	211	228	244	259	273	334	386	472
d63	92	130	159	184	206	225	243	260	276	291	356	411	503
d75	97	138	168	195	218	238	257	275	292	308	377	435	533
d90	104	147	180	208	233	255	275	294	312	329	403	465	570
d110	110	156	191	221	247	270	292	312	331	349	427	493	604
d140	123	174	214	247	276	302	326	349	370	390	478	552	675
d160	130	184	225	260	291	318	344	368	390	411	503	581	712
d225	146	206	253	292	326	357	386	413	438	461	565	653	799
d250	155	219	268	310	346	379	410	438	465	490	600	693	848
d280	164	233	285	329	368	403	435	465	493	520	637	735	901
d315	174	247	302	349	390	427	461	493	523	552	675	780	955
d355	184	260	318	368	411	450	486	520	552	581	712	822	1'007
d400	195	275	337	389	435	477	515	550	584	615	754	870	1'066
d450	206	292	357	413	461	505	546	584	619	653	799	923	1'130

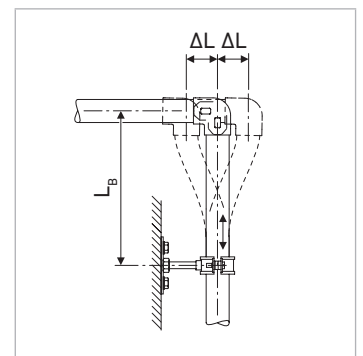


Flexible sections for COOL-FIT 4.0F

Flexible Section  $L_B$

The values for  $L_B$  (cm) from this table can be used for a given  $\Delta L$  (mm) and the relevant pipe size:

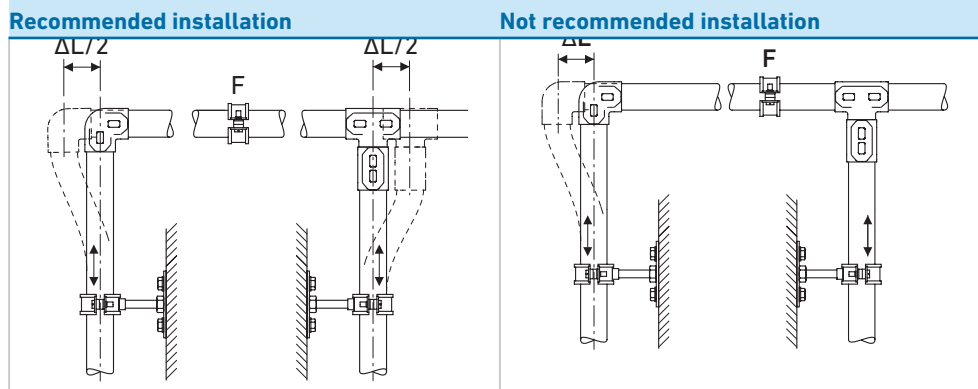
Flexible section $L_B$ (cm)													
$\Delta L$ (mm)	10	20	30	40	50	60	70	80	90	100	150	200	300
d160	168	237	290	335	375	410	443	474	503	530	649	749	917
d225	188	266	326	376	420	461	497	532	564	595	728	841	1'030



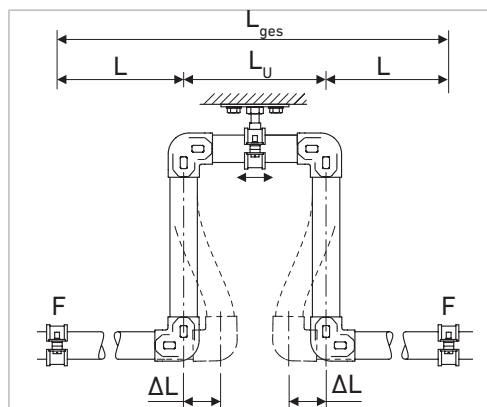
## 2.4.11 Installation

### Recommendations for installation

Length changes in pipe sections should always be accommodated through the arrangement of fixed brackets. The following examples show how the changes can be distributed in pipe sections by suitable positioning of fixed brackets:



Expansion loops can be installed to take up changes in length when flexible sections cannot be included at a change in direction or branch in the piping system or if substantial changes in the length of a straight section need to be taken up. In such a case the compensation for changes in length is distributed over two flexible sections.



Bending stress can lead to leaks in mechanical joints.

Do not use any unions or flanged connections close to expansion bends and loops.

## Pre-tensioning

In particularly difficult situations with large changes in one direction only, it is possible to pre-tensioning the flexible section during installation and thereby shorten its length  $L_B$ , as illustrated in the next example:



### Example

Pipe length L	25 m
Diameter	d225/D315 mm
Installation temperature	25 °C
Min ambient temperature	25 °C constant
Max ambient temperature	25 °C constant
Min flow temperature	10 °C
Max flow temperature	25 °C

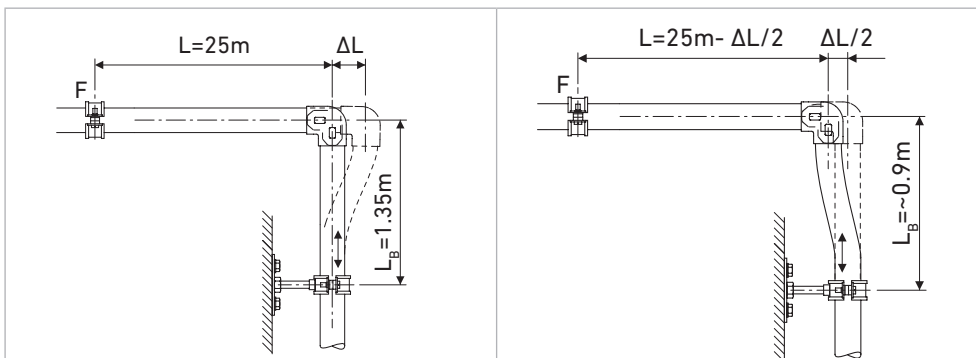
Change in length from the table or COOLING Tool-Box:

$$-\Delta L = 39 \text{ mm}$$

A flexible section to take up a change in length of  $\pm \Delta L = 40 \text{ mm}$  needs to be  $L_B (\text{mm}) = 2920 \text{ mm}$  long according to the table.

If the flexible section is pre-tensioned to  $\Delta L/2$ , the flexible section required is reduced to  $\sim 2060 \text{ mm}$ . The change in length starting from the 0 position is then  $\pm \Delta L/2 = 39/2 = 19.5 \text{ mm}$ .

By pre-tensioning the flexible section makes it possible to reduce its required length in installations where space is restricted. Pre-stressing also reduces the bending of the flexible section in service, improving the appearance of the piping system.



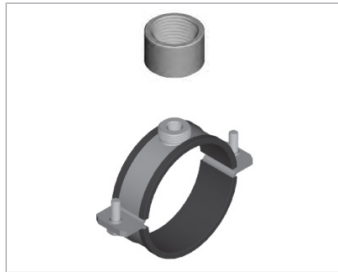
## 2.4.12 Pipe bracket spacing and support of piping systems

### Overview

#### Installation of plastic pipe

COOL-FIT 4.0 pipe should be installed using supports designed for use with plastics and should then be installed taking care not to damage or overstress the pipe. Specifically COOL-FIT 4.0 must be installed in order to allow stress-free operation.

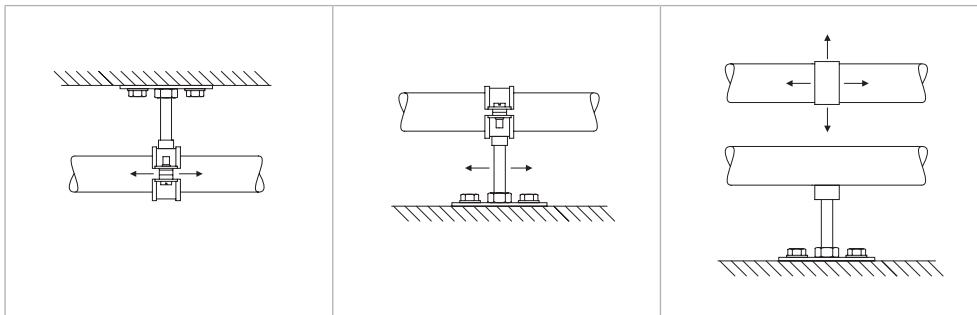
Thanks to the excellent insulating properties of the COOL-FIT 4.0 pipe and its hard, impact resistant outer jacket, standard pipe clamps with hard plastic inlay may be used. Special insulation pipe clamps or cold clamps are not necessary.



### Arranging loose brackets

#### What is a loose bracket?

A loose bracket is a pipe bracket which allows axial movement of the pipe. This allows stress-free compensation of temperature changes and compensation of any other operating condition changes.



Axial displacement of the pipe in the clamp.

Pipe clamp fitted rigidly to the pipe, axial displacement in the suspension of the pipe clamp.

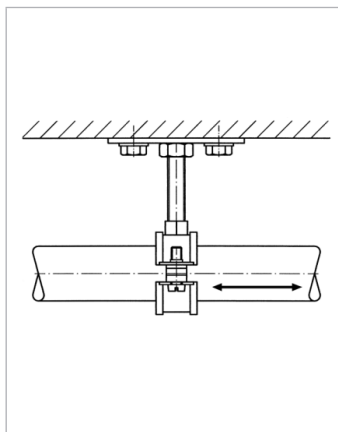
Displacement of the pipe in 2 axes.

The inner diameter of the bracket must be larger than the outer diameter of the pipe to allow free movement of the pipe. The inner edges of the brackets should be free from any sharp contours to avoid damaging the pipe surface.

Another method is to use brackets with spacers in the bolts which also avoids clamping the bracket on the pipe

The axial movement of the piping may not be hindered by fittings arranged next to the pipe bracket or other diameter changes.

Sliding brackets and hanging brackets permit the pipe to move in different directions. Attaching a sliding block to the base of the pipe bracket permits free movement of the pipe along a flat supporting surface. Sliding and hanging brackets are needed in situations where the piping system changes direction and free movement of the pipe must be allowed.

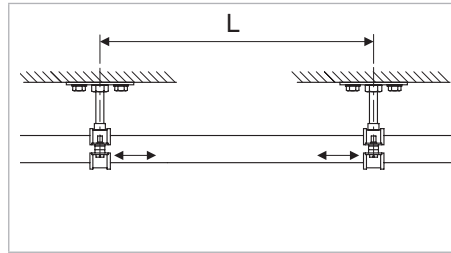


Spacers prevent pinching the pipe

### Pipe bracket spacing

The pipe bracket spacing have been determined for conveying water on the basis of a specific deflection of the pipe between two clamps considered acceptable.

The pipe bracket spacing for COOL-FIT 4.0 pipe is always consistent independent of pressure and temperature.



L Pipe bracket spacing

#### Pipe bracket intervals L for COOL-FIT 4.0

d/D (mm)	d32/ D90	d40/ D110	d50/ D110	d63/ D125	d75/ D140	d90/ D160	d110/ D180	d140/ D225	d160/ D250
L (mm)	1'800	1'950	1'950	2'000	2'100	2'150	2'300	2'450	2'600

d/D (mm)	d225/ D315	d250/ D355	d280/ D400	d315/ D450	d355/ D500	d400/ D560	d450/ D630
L (mm)	2'850	3'300	3'500	3'700	3'900	4'100	4'300

#### Pipe bracket intervals L for COOL-FIT 4.0F

d/D (mm)	d160/ D250	d225/ D315
L (mm)	3'400	3'700

The pipe clamp intervals from the table can be increased by 30% for vertical pipe. Multiply the values given by 1.3 in this case.

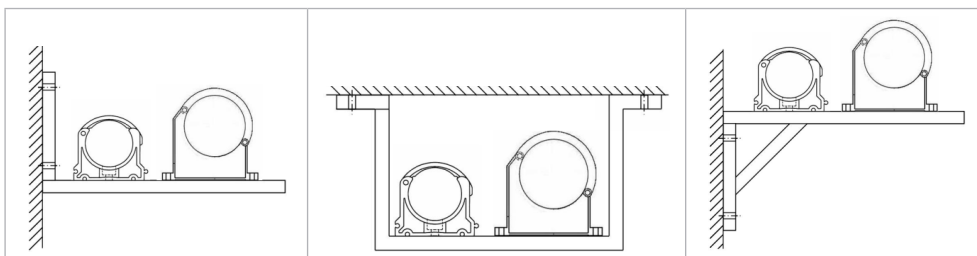
Valid for SDR11 and SDR17.

### KLIP-IT pipe brackets

These robust plastic pipe brackets can be used not only under rigorous operating conditions, but also where the pipework is subject to aggressive media or atmospheric conditions. Pipe brackets and pipe clamps from Georg Fischer Piping Systems are suitable for all pipe materials used.

Do not use KLIP-IT pipe brackets as fixed points!

**⚠** From d90 upwards KLIP-IT pipe clamps must be mounted upright, as in the installation examples below.



### Arranging fixed points

A fixed point is a bracket which prevents the pipe from moving in any direction. The purpose of a fixed point is to control tension caused by temperature changes and guide elongation in a certain direction.

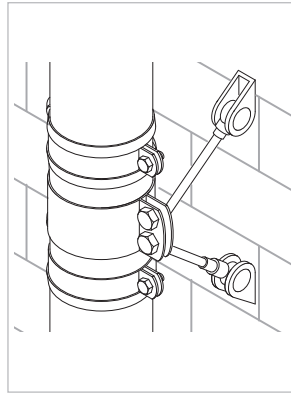
**⚠** **Fixpoint design**  
The pipe must not be fixed by clamping it in the pipe bracket. This can cause deformation and physical damage to the pipe, damage that sometimes does not appear until very much later.



**⚠** Pipe brackets must be robust and mounted firmly to be able to take up the forces arising from changes in length in the piping system. Hanging brackets or KLIP-IT pipe brackets are unsuitable for use as fixed points.

**COOL-FIT 4.0 Fixed points**

Fixed points for COOL-FIT are established with the special COOL-FIT fixed points. The product consists of fusion tapes and pipe brackets. Electrofusion bands as permanent joints transmit the forces that occur in the pipe to the fixed point. The supplied pipe brackets serve to build up the fusion pressure during installation of the fusion bands and provide stability during operation. For fusion, use an MSA 2.x, MSA 4.x, MSA 250, 300, 350, 400 or commercially available 220-V electrofusion unit. If you use an MSA electrofusion unit by Georg Fischer Piping Systems, use the y-cable kit with code 790.156.032.



Please take note of the maximum allowed forces in the table below.

Diameter (mm)	d32/ D90	d40/ D110	d50/ D110	d63/ D125	d75/ D140	d90/ D160	d110/ D180	d140/ D225	d160/ D250	d225/ D315	d250/ D355
Maximum force F (kN)	2.0	3.0	5.0	8.0	10.0	10.0	10.0	10.0	10.0	10.0	10.0

**⚠** COOL-FIT 4.0 / 4.0F fixed points must be calculated on the basis of the application. Fixed point brackets and cross braces are not included.

**Maximum force F (kN)**

**Scope of delivery**



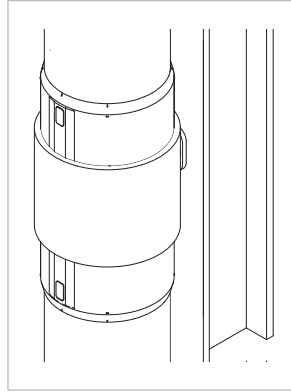
- 1 Clamps to maintain fusion pressure
- 2 Electrofusion band

**Y-cable kit for COOL-FIT fixed points**

The COOL-FIT Y-cables can be used for a faster installation of COOL-FIT fix points. Since electrofusion tapes always come in pairs, Y-cables allow for a simultaneous fusion process, cutting fusion time in half.

**COOL-FIT 4.0 fixed point for higher forces**

For applications with higher forces, such as long risers, fixed points must be planned specifically for the application. Attachment to the beam is via a weld-on plate on the metal pipe clamp. The clamp is positioned between two COOL-FIT electrofusion fittings and is subsequently insulated. Please take note of the maximum allowed forces in the table below.



Diameter (mm)	d140/ D225	d160/ D250	d225/ D315	d250/ D355	d280/ D400	d315/ D450	d355/ D500	d400/ D560	d450/ D630
Maximum force F (kN)	35.0	35.0	35.0	35.0	35.0	35.0	35.0	35.0	35.0

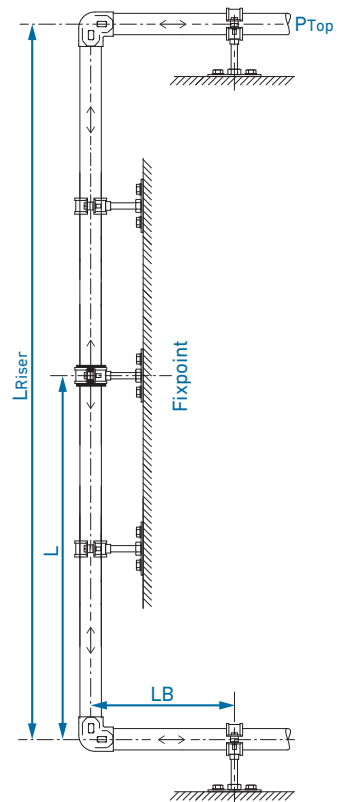
**⚠** COOL-FIT fixed points for higher forces must be calculated according to the application. The pipeline, support, weld seam type and other influencing factors must be taken into account in the force analysis. Please contact GF Advanced Engineering.

**Example of maximal achievable riser length:**

- Installation temperature -5 to +40°C
- Ambient temperature -5 to +45°C
- Flow temperature -33 to +47°C
- Fixpoint position Middle of the riser pipe
- Pressure on top level 3 bar (P<sub>Top</sub>)
- Support distance vertical Equal to horizontal
- Pipe class d32 - d450 SDR11

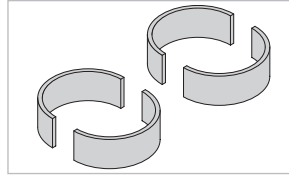
	Pipe support distance reduced for long riser		Fixpoint at jacket pipe		Fixpoint at media pipe	
	Horizontal [m]	Vertical [m]	Max. riser length (LRiser) [m]	Fixpoint force [kN]	Max. riser length (LRiser) [m]	Fixpoint force [kN]
d32/90	1.8	1.8	43	0.9		
d40/110	2.0	2.0	54	1.7		
d50/110	2.0	2.0	44	1.7		
d63/125	2.0	2.0	49	2.7		
d75/140	2.1	2.1	52	3.8		
d90/160	2.2	2.2	54	5.4		
d110/180	2.3	2.3	54	7.5		
d140/225	2.5	2.5	45	10	55	12
d160/250	2.6	2.6	35	10	55	16
d225/315	2.9	2.9	17	10	54	29
d250/355	3.3	3.3	14	10	54	35
d280/400	3.5	3.5			41	35
d315/450	3.7	3.7			32	35
d355/500	3.9	3.9			24	35
d400/560	4.1	4.1			18	35
d450/630	4.3	4.3			14	35

**⚠** Following sections are recommended to be proofed by GF Advanced Engineering before installation: Riser pipe dimension >d160; Riser pipe with multiple dimensions; Installation differ from normal installation with fixpoint in the middle



**COOL-FIT 4.0F Fixed points**

Four half shells which are cemented on both sides to the fixed point pipe clamp.



Diameter (mm)	d160/ D250	d225/ D315
Maximum force F (kN)	10.0	10.0

**⚠** COOL-FIT 4.0 fixed points must be calculated on the basis of the application. Fixed point brackets and cross braces are not included.

**Rigidly fixed installations**

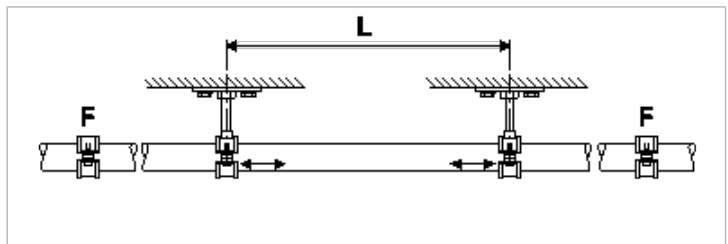
**⚠** Pipe which are axially clamped and rigidly fixed must be tested for their resistance to kinking. In most cases, this test results in a reduction of the maximum internal pressure and more tightly spaced supports. The forces acting on the fixed points should be considered.

COOL-FIT 4.0 pipe and fittings are suitable for a rigidly fixed installation

Values for forces acting on fixed points as well as the resulting pipe bracket spacing are listed in following tables.

**Example of use:**

Installation temperature	25 °C
Min. ambient temperature	25 °C constant
Max. ambient temperature	25 °C constant
Min. flow temperature	See table
Max. flow temperature	25 °C
Pipe class	d32 - d140 SDR11 and d160 - d450 SDR17



**Fixpoint forces F and maximal pipe bracket spacing L at 15 °C flow temperature**

d/D (mm)	32/90	40/110	50/110	63/125	75/140	90/160	110/180	140/225	160/250	225/315	250/355	280/400	315/450	355/500	400/560	450/630
F (kN)	0.4	0.6	0.9	1.4	2.0	2.8	4.1	6.7	6.0	11.6*	14.3*	18.0*	22.8*	29.0*	36.6*	46.4*
L (mm)	1'800	1'950	1'900	2'000	2'100	2'150	2'200	2'450	2'600	2'850	3'300	3'500	3'700	3'900	4'100	4'300

**Fixpoint forces F and maximal pipe bracket spacing L at 10 °C flow temperature**

d/D (mm)	32/90	40/110	50/110	63/125	75/140	90/160	110/180	140/225	160/250	225/315	250/355	280/400	315/450	355/500	400/560	450/630
F (kN)	0.6	1.0	1.4	2.2	3.0	4.4	6.4*	10.4	9.3*	18.1*	22.3*	28.1*	36.6*	45.1*	57.1*	72.5*
L (mm)	1'800	1'950	1'900	2'000	2'100	2'150	2'200	2'450	2'600	2'850	3'300	3'500	3'700	3'900	4'100	4'300

**Fixpoint forces F and maximal pipe bracket spacing L at 5 °C flow temperature**

d/D (mm)	32/90	40/110	50/110	63/125	75/140	90/160	110/180	140/225	160/250	225/315	250/355	280/400	315/450	355/500	400/560	450/630
F (kN)	0.9	1.4	2.0	3.1	4.2	6.1	8.9*	14.4	12.9*	25.1*	30.9*	38.9*	49.3*	62.5*	79.0*	100.2*
L (mm)	1'800	1'950	1'900	2'000	2'100	2'150	2'200	2'450	2'600	2'850	3'300	3'500	3'700	3'900	4'100	4'300

**Fixpoint forces F and maximal pipe bracket spacing L at 0 °C flow temperature**

d/D (mm)	32/90	40/110	50/110	63/125	75/140	90/160	110/180	140/225	160/250	225/315	250/355	280/400	315/450	355/500	400/560	450/630
F (kN)	1.1	1.8	2.5	3.9	5.5	7.8	11.5*	18.6	16.7*	32.4*	40.0*	50.3*	63.7*	80.8*	102.2*	130.0*
L (mm)	1'800	1'950	1'900	2'000	2'100	2'150	2'200	2'450	2'600	2'850	3'300	3'500	3'700	3'900	4'100	4'300

**Fixpoint forces F and maximal pipe bracket spacing L at -5 °C flow temperature**

d/D (mm)	32/90	40/110	50/110	63/125	75/140	90/160	110/180	140/225	160/250	225/315	250/355	280/400	315/450	355/500	400/560	450/630
F (kN)	1.4	2.2	3.1	4.9	6.8	9.7*	14.3*	23.0	20.7*	40.2*	49.5*	62.2*	79.0*	100.0*	126.6*	160.6*
L (mm)	1'800	1'950	1'900	2'000	2'100	2'150	2'200	2'450	2'600	2'850	3'300	3'500	3'700	3'900	4'100	4'300

**Fixpoint forces F and maximal pipe bracket spacing L at -10 °C flow temperature**

d/D (mm)	32/90	40/110	50/110	63/125	75/140	90/160	110/180	140/225	160/250	225/315	250/355	280/400	315/450	355/500	400/560	450/630
F (kN)	1.6	2.6	3.8	5.9	8.1	11.6*	17.2*	27.7	24.8*	48.3*	59.3*	74.8*	94.9*	120.3*	152.1*	193.0*

**Fixpoint forces F and maximal pipe bracket spacing L at -10 °C flow temperature**

d/D (mm)	32/90	40/110	50/110	63/125	75/140	90/160	110/180	140/225	160/250	225/315	250/355	280/400	315/450	355/500	400/560	450/630
L (mm)	1'800	1'950	1'900	2'000	2'100	2'150	2'200	2'450	2'600	2'850	3'300	3'500	3'700	3'900	4'100	4'300

**Fixpoint forces F and maximal pipe bracket spacing L at -15 °C flow temperature**

d/D (mm)	32/90	40/110	50/110	63/125	75/140	90/160	110/180	140/225	160/250	225/315	250/355	280/400	315/450	355/500	400/560	450/630
F (kN)	1.9	3.0	4.4	6.9	9.5	13.7*	20.2*	32.5	29.2*	56.8*	70.0*	87.9	111.5*	141.4*	178.8*	226.8*
L (mm)	1'800	1'950	1'900	2'000	2'100	2'150	2'200	2'450	2'600	2'850	3'300	3'500	3'700	3'900	4'100	4'300

\* max allowed force for COOL-FIT fixed point exceeded

**COOL-FIT 4.0F**

**Fixpoint forces F and maximal pipe bracket spacing L at 15 °C flow temperature**

d/D (mm)	d160/250	d225/315
F (kN)	6.01	11.65*
L (mm)	3'400	3'700


**Fixpoint forces F and maximal pipe bracket spacing L at 10 °C flow temperature**

d/D (mm)	d160/250	d225/315
F (kN)	9.37	18.18*
L (mm)	3'400	3'700

**Fixpoint forces F and maximal pipe bracket spacing L at 5°C flow temperature**

d/D (mm)	d160/250	d225/315
F (kN)	12.95*	25.14*
L (mm)	3'400	3'700

\* max allowed force for COOL-FIT fixed point exceeded

 Please contact GF Piping Systems for rigidly fixed installations that contain ball valves and mechanical joints as well as if the max. allowed force on the fixed points are exceeded

### 2.4.13 Hoses

#### Installation of elastomer hoses

To ensure the usability of hose lines and to avoid shortening their service life through additional stresses, please note the following:

- Hose lines must be installed so that their natural position and movement is not hindered.
- During operation, hose loines must in principle not be subjected to external forces such as tension, torsion and compression, unless they have been specially made for the purpose.
- The minimum radius of curvature specified by the manufacturer must be observed.
- Buckling is to be avoided, particularly by the joint.
- Before putting the system into operation, check that the mechanical connections are properly tightened.
- If there is visible external damage, the hose line must not be put into operation.
- The connection fittings should be firmly screwed together.

#### Proper use of the hose line

- Pressure: do not exceed maximum permitted working pressure and operating vacuum
- Temperature: do not exceed maximum permitted temperature for the medium

#### Storage

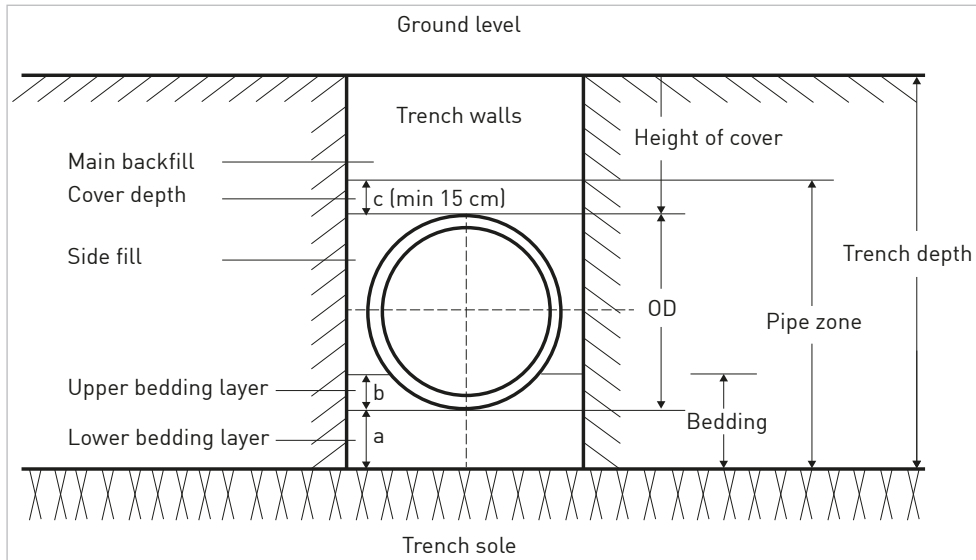
- Store in a cool, dry and dust-free area; avoid direct sunlight or ultraviolet irradiation; protect from nearby heat sources. Piping must not come into contact with substances that can cause damage.
- Hoses and hose assemblies must be stored horizontally, free of tension or bending forces.

#### Maintenance

We recommend a regular visual inspection of the hose line in case of high temperature fluctuations.

### 2.4.14 Underground installation

COOL-FIT 4.0 can be used underground. The corresponding national installation guidelines apply to building the pipe trenches and installing the pipe. In general, trenches should not be less than 1 meter deep, deeper if there is a risk of frost. The sand bed must be built in such a way that the pipe is evenly supported. The pipe must be laid in a sand bed and protected against sharp stones and debris. The sand must be well compacted.



The pipe zone has to be designed according to planning requirements and static calculations. The area between trench sole and side fill is referred to as bedding. A load-carrying bedding must be created by using soil replacement. For regular soil conditions, EN 1610 specifies a minimum thickness of  $a = 150$  mm for the lower bedding. In addition to the minimum thickness, corresponding requirements are also imposed on the building materials that must be used for the bedding.

No building materials with components exceeding the following OD ranges may be used:

- 22 mm for  $DN \leq 200$

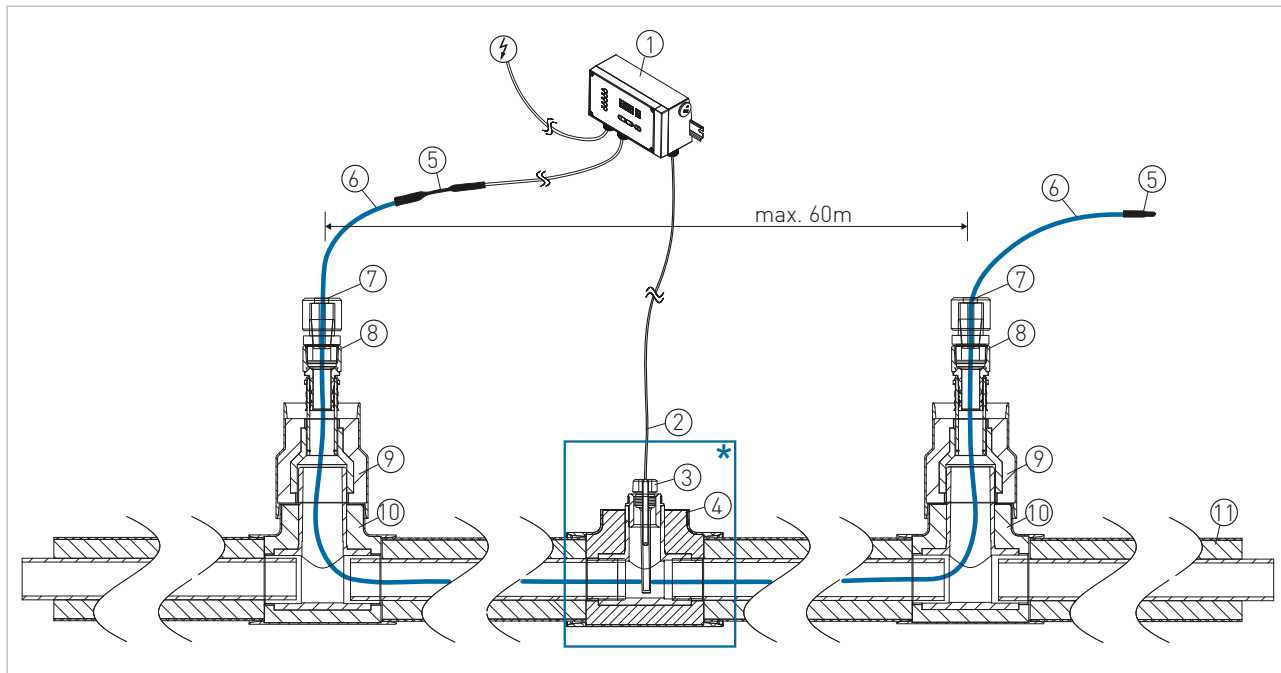
The upper bedding layer  $b$  is derived from static calculations. It is also important to ensure that no cavities are created below the pipe. The bedding dissipates all loads from the pipe securely and evenly into the ground. For this reason, the COOL-FIT 4.0 pipe has to rest solidly on the bedding across its entire length. The upper end of the pipe zone is defined according to EN 1610 as 150 mm above the pipe apex or 100 mm above the pipe connection. Ensure that the pipe is not damaged when the cover and main backfill are filled and compacted.

COOL-FIT 4.0 pipe have a higher degree of stiffness and a higher weight than non-insulated pipe. For this reason, the pipe should always be connected in the trench. Unnecessary stress on the COOL-FIT 4.0 jointing elements is thus avoided. Under normal circumstances, it is not necessary to install expansion loops in the system.

**⚠ A movement of the pipe before filling the pipe trench should be avoided. Please contact Georg Fischer Piping Systems concerning recommendations for underground installations.**

**⚠ Installation in water is not permitted; any water that occurs must be able to drain off.**

## 2.4.15 COOL-FIT 4.0 Heat Tracing Installation



No.	Designation	No.	Designation
1	Thermostat	7	Cable glands ¾" male thread R
2	Temperature sensor	8	Adaptor fitting d32-¾" female thread Rp
3	Immersion sleeve for sensor*	9	COOL-FIT 4.0 Reducer to d32
4	COOL-FIT 4.0 Installation fitting ½" Rp*	10	COOL-FIT 4.0 T90°
5	Cold lead connection and end seal kit	11	COOL-FIT 4.0 pipe
6	Heating cable		

### Components installation

#### General notes:

Installation instructions included in the kit must be followed, including those for preparation of the heating cable conductors for connections. Before assembly, use the guide given in the instructions to ensure that the kit is correct for the heating cable and environment.

- Self-regulating and power-limiting heating cables are parallel circuit design. Do not twist the conductors together as this will result in a short circuit.

#### Components required

For the installation of all components refer to the relevant component installation instructions.

Required for each heating cable run:

- Cold lead connection and end seal kit
- Cable entry and exit
- Fittings for inlet and outlet

Required for the installation of the temperature sensor of each thermostat (for control via the media temperature):

- COOL-FIT 4.0 Installation fitting ½" Rp
- Immersion sleeve for PT sensor

## Procedure

- ▶ Insert the heat tracing cable into the inner pipe during installation of the piping components and out again at the end of the heating circuit. If there are more than 2 changes in the direction of the pipe equipped with the heating tape, the use of a suitable lubricant is recommended for simpler installation.
- ▶ Note that the heating cable must not be routed through the inside of valves. If using COOL-FIT valves, the cable must be routed outwards on both sides of the valve end.

## Thermostats and control systems

- ▶ Follow the installation instructions supplied with the thermostat or control. Use the proper wiring diagram for the heating cable layout and control method desired.
- ▶ After switching on the heating cable, the cable ends must be warm after 5 to 10 minutes.

\* For the freezer protection on pipe sections, for each pipe dimension a separate heating circle with temperature sensor is recommended.

## 2.4.16 COOLING Tool-Box

The Georg Fischer Piping Systems COOLING Tool-Box is used to help in the dimensioning and design of cooling systems.

The COOLING Tool-Box handles:

- Expansion, contraction
- Flexible section design
- Energy savings
- Pipe exterior temperature
- Pipe dimensioning
- Pressure loss
- Dew point/ insulation thickness
- Pipe bracket spacing
- Freezing time
- Weight comparison
- CO<sub>2</sub> footprint



Data for the most commonly used secondary refrigerants are already stored in the calculation tool. It calculates all system components such as pipe, fittings and valves. The menu is available in several different languages. It allows system design to be efficient and optimized. With the function "comparison" a COOL-FIT system can be compared to a black steel, stainless steel or copper system.

■ **COOLING Tool-Box:** Get in contact with your GF Piping Systems representative or visit [www.gfps.com](http://www.gfps.com)





## 2.5 Jointing and Installation

### 2.5.1 Jointing of COOL-FIT 4.0

**i** For general information on electrofusion, see Planning Fundamentals chapter "Jointing technology", section "Electrofusion joints".

#### General advice

The quality of a weld is largely determined by careful preparation. The welding surface must be protected from adverse weather conditions such as rain, snow or wind. The permissible temperature range for fusion is -10 °C to 45 °C. National regulations must be observed. In direct sunlight, shielding of the welding area can help to create an even temperature profile around the whole circumference of the pipe. It is particularly important to ensure that the climate conditions are the same for both the electrofusion machine and the welding area.

#### Executing electrofusion

##### Protect the welding area

The surfaces to be welded on the pipe and the fitting must be carefully protected from dirt, grease, oils and lubricants. Only Tangit PE cleaner must be used for cleaning.

**⚠** No fats (i.e. hand cream, oily rags, silicone, etc.) must be introduced into the fusion zone!

#### Jointing d32 – d225

**1** Without touching the surface, remove product immediately before the installation from packaging

Prepare pipe with stripping and peeling tool for electrofusion welding connection (stripping, peeling and sheath cutting) and check pipe spigot with circumferential measuring tape for compliance with minimum permissible pipe outer diameter.

##### Minimum permitted pipe external diameter after peeling for COOL-FIT 4.0

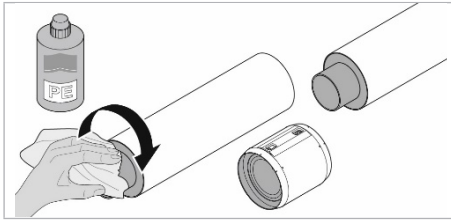
Temperature (°C)	d nominal diameter (mm)									
	32	40	50	63	75	90	110	140	160	225
	dmin after peeling (mm)*									
40	31.4	39.4	49.4	62.5	74.5	89.6	109.6	139.7	159.8	225.0
30	31.3	39.4	49.4	62.4	74.4	89.4	109.5	139.5	159.5	224.6
20	31.3	39.3	49.3	62.3	74.3	89.3	109.3	139.3	159.3	224.3
10	31.3	39.2	49.2	62.2	74.2	89.2	109.1	139.1	159.1	224.0
0	31.2	39.2	49.2	62.1	74.1	89.0	109.0	138.9	158.8	223.6
-10	31.2	39.1	49.1	62.0	74.0	88.9	108.8	138.7	158.6	223.3

\* Minimum diameters do not comply with the pipe tolerance specifications for GF electrofusion fittings. COOL-FIT minimum diameters are verified by release tests.

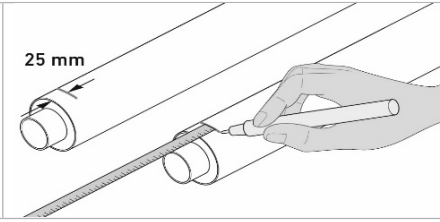
**⚠** If the pipe outside diameter falls below the min. permissible value, cut off the spigot and check the blade quality by measuring the chip thickness with a caliper gauge: the reference dimension over the entire length is between 0.2 - 0.4 mm. Replace blade in case of deviation.

**⚠** COOL-FIT 4.0 already factory-set free pipe ends, COOL-FIT 4.0 Valves and COOL-FIT 4.0 Fittings d32 – d225 (Type B, barrel nipple and transition fittings) need not to be peeled.

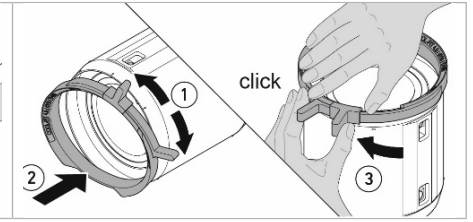
**2** Cleaning and installation for welding preparation



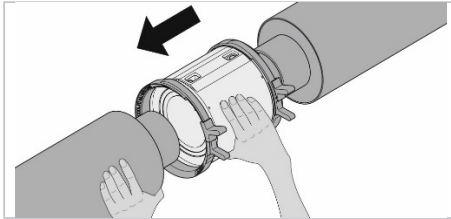
**Step 1**  
Clean the fusion area of the components with Henkel Tangit PE cleaner and lintfree colourless and clean cloth in circumferential direction.



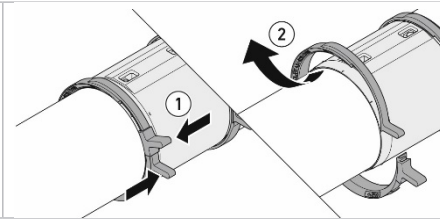
**Step 2**  
Mark the jacket pipe at a distance of 25 mm



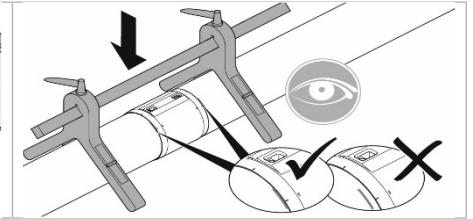
**Step 3**  
Mount the assembly aids on the sealing lips of the COOL-FIT 4.0 fitting



**Step 4**  
Insert pipe in pipe brackets and align free of stress. Push fitting up to the limit stop on the pipe.

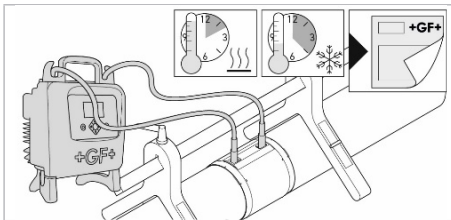


**Step 5**  
Remove the assembly aids

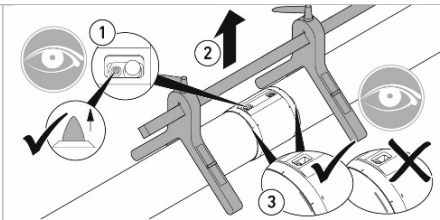


**Step 6**  
Take care for low stress installation and secure the pipe and fitting against dislocation. Check insertions depths of both pipe into the fitting

**3** Fusion process



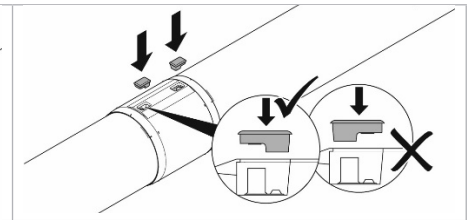
**Step 1**  
Fuse in accordance to the operating instructions of the fusion unit. Use long fusion adaptors (790128035). Pay attention to fusion and cooling time.



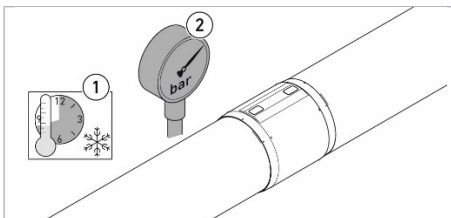
**Step 2**  
After fusion, check fusion indicators on the electrofusion fitting and note the messages on the display of the electrofusion machine.  
Mark the fitting with following information

- Date
- Welder/ Weld number
- Time at the end of cooling time

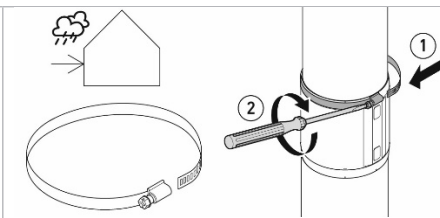
Remove the clamping tool after cooling time



**Step 3**  
Fit the insulation of the weld pins onto the fusion contacts



**Step 4**  
After cooling perform pressure tests as per table.



**Step 5 (optional)**  
For vertical installations outside, mount sealing clamps tightly at the top lip of the fitting.  
Alternatively to sealing clamps, sealing tapes, 25 mm width can be mounted underneath the top lip of the fittings.

## Joining d250 – d450

■ **Hint:** Factory-set free pipe ends at pipe and fittings type B have to be peeled for joining before.

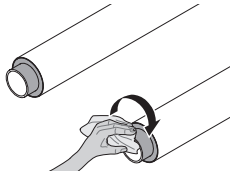
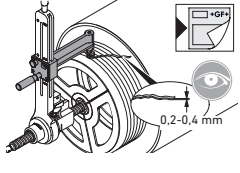
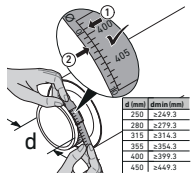
### 1 Preparation

Prepare pipe with stripping and peeling tool for electrofusion welding connection (stripping, peeling and sheath cutting) and check pipe spigot with circumferential measuring tape for compliance with minimum permissible pipe outer diameter.

Minimum permitted pipe external diameter after peeling for COOL-FIT 4.0

Temperature (°C)	d nominal diameter (mm)					
	250	280	315	355	400	450
	d <sub>min</sub> after peeling (mm)*					
40	250.0	280.1	315.2	355.4	400.5	450.6
30	249.7	279.7	314.8	354.8	399.9	450.0
20	249.3	279.3	314.3	354.3	399.3	449.3
10	248.9	278.9	313.8	353.8	398.7	448.6
0	248.6	278.5	313.4	353.2	398.1	448.0
-10	248.2	278.0	312.9	352.7	397.5	447.3

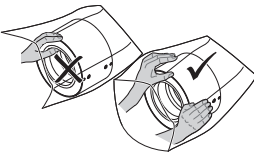
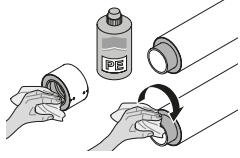
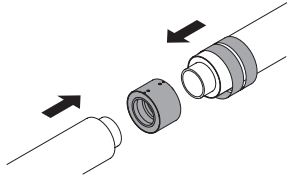
\* Minimum diameters do not comply with the pipe tolerance specifications for GF electrofusion fittings. COOL-FIT minimum diameters are verified by release tests.

Step 1	Step 2	Step 3
		
<p>Perform a preliminary cleaning of the media pipe, deburr at a right angle using the pipe cutter, if necessary.</p>	<p>Peel the media pipe as well as the fittings type B with the peeler, if not already done with foam removal. Observe min. peel removal of 0.2 to 0.4mm.</p>	<p>Check minimum permissible pipe outside diameter after peeling with a circumferential measuring tape.</p>

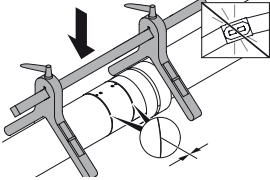
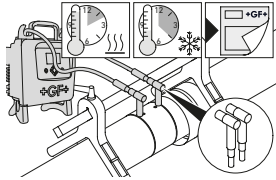
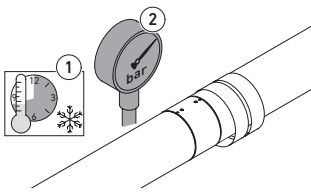
## Overview of pipe outer diameter and open spigot length

Dimension (mm)	Factory-set spigot length (mm)
d250	120-126
d280	123-129
d315	129-137
d355	144-152
d400	145-155
d450	160-170

**2 Cleaning and installation**

Step 1	Step 2	Step 3
		
<p>Unpack the coupler. Pay attention that you don't touch the inner surface of the coupler.</p>	<p>Clean fusion area of the electrofusion coupler, the pipe and as well of the fittings type B with Tangit PE cleaner and lint-free cloth and allow to air out.</p>	<p>Slide on the shrink sockets and afterwards the electrofusion coupler up to the insulation without touching the fusion area.</p>

**3 Fusion process**

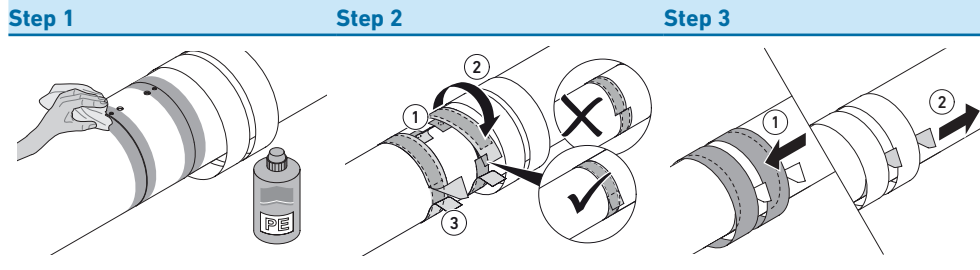
Step 1	Step 2	Step 3
		
<p>Take care for low stress installation and secure the pipe and fitting against dislocation. There must be no gap between coupler and pipes.</p>	<p>Fuse in accordance to the operating instructions of the fusion unit. Use long fusion adaptors (790128035). Pay attention to fusion and cooling time.</p>	<p>After cooling perform pressure tests as per table.</p>

**Cooling times before removing clamping tool and pressure/leak testing**

d (mm)	Cooling time before Remove clamping tool (min.)	Cooling time before internal pressure test at ≤ 6 bar (min.)	Cooling time before internal pressure test at ≤ 18 bar (hours)	Cooling time before internal pressure test at ≤ 11 bar (hours)
32	10	15	3	
40	10	20	5	
50	10	20	5	
63	10	20	5	
75	15	25	6	
90	20	35	8	
110	30	50	8	
140	45	90	12	
160	45	90	12	8
225	45	90	12	9.5
250	30	90	12	9.5
280	30	90	12	9.5
315	30	90	12	9.5
355	60	100	12	9.5
400	75	110	12	9.5
450	75	125	12	9.5

The values are valid for pressure tests using a liquid at ≤ 20 ° C. For testing with gas a cooling time of 12 hours is recommended.

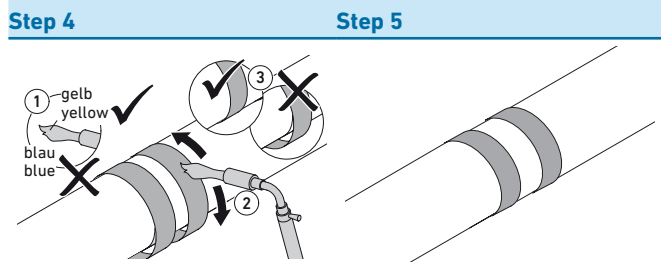
4 Sealing



Step 1  
Clean the pipe/fitting type B and partially the coupler over the gap with Tangit PE cleaner.

Step 2  
Affix the sealing tape centered over the gap and overlap it at the end. Press it on well and smooth out folds.

Step 3  
Position the shrink socket centered over the sealing tape, then remove the white separating tape.

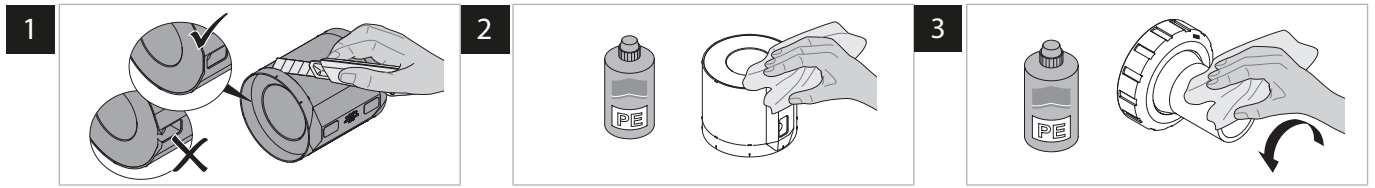


Step 4  
The yellow flame of the gas burner or hot-air stream must strike the shrink socket as vertically as possible. Avoid applying unnecessary heat to the fitting.

Step 5  
The jointing is now finished.

### Valves and flange joints

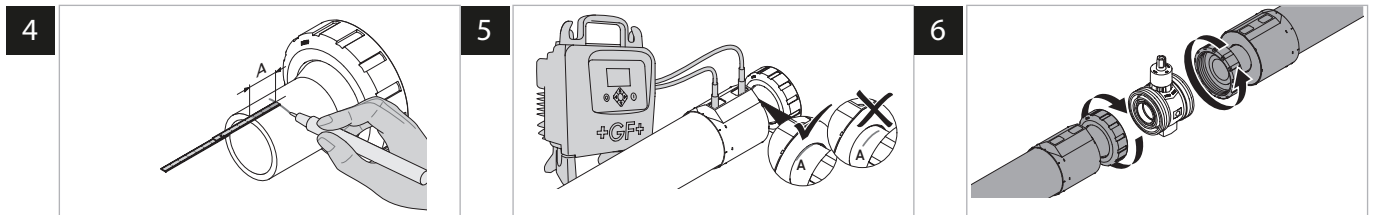
**1** Preparation of fitting – remove sealing lip on one side, clean the sealing surfaces



For the jointing to a valve or flange adaptor, the sealing lip of the fitting has to be removed at the valve or flange adaptor side and sealing and fusion surfaces have to be cleaned.

**2** Standard fusion

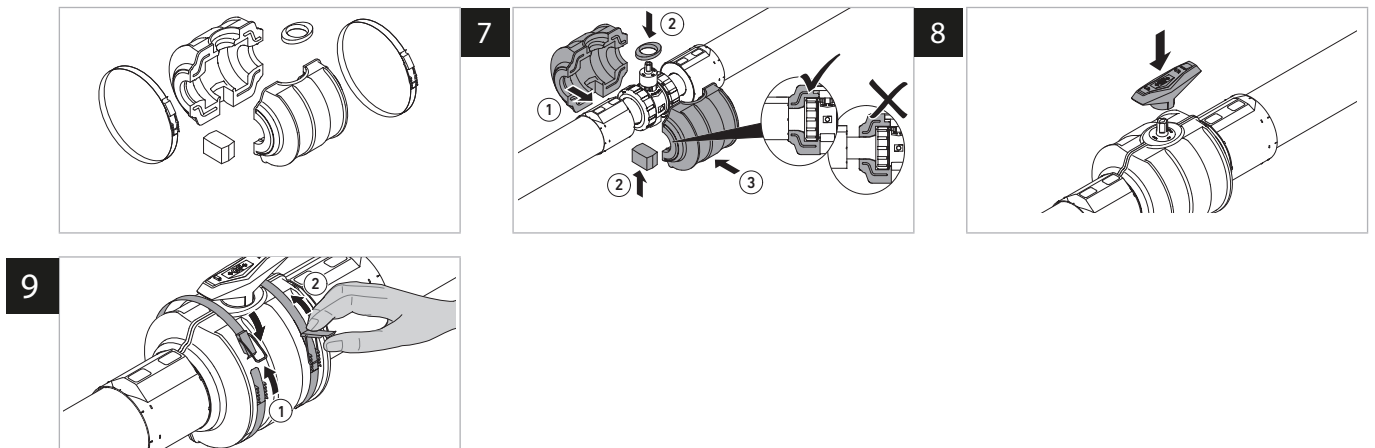
Fuse both valve ends without valve mounted.



Following insertion depths A are valid for COOL-FIT 4.0 components:

d/D (mm)	32/90	40/110	50/110	63/125	75/140	90/160	110/180	140/225	160/250	225/315
L1 (mm)	36	40	44	48	55	62	72	84	90	110

**3** Mounting the valve/flange insulation



**i** Further information can be found in the assembly instructions "COOL-FIT 2.0 / COOL-FIT 4.0 insulation for Ball Valve and Butterfly Valve".

**i** It's recommended to re-tighten the bolts of COOL-FIT 4.0 butterfly valves and flange joints at operating temperature.

### Compact connection fitting-to-fitting

When there is enough space, Fitting-to-Pipe-to-Fitting connections can be realized using a short COOL-FIT 4.0 pipe. The foam removal tool enables the foam removal of pipe lengths of ~110 mm for the dimensions d32-d90, or respectively ~170 mm for the dimensions d110-d225.

For compact fitting-to-fitting joints, COOL-FIT 4.0 barrel nipple can be used.

■ Shorter connections Fitting-to-Pipe-to-Fitting as of sizes d75mm can be realized using an un-insulated PE100 SDR11 pipe in combination with a piece of insulation that results of an foam removal process of the foam removal tool.

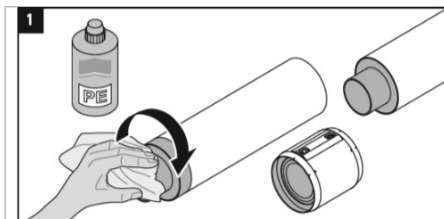
After the peeling of the oxid layer of the un-insulated PE pipe, the insulation ring is pulled over the pipe and the pipe is welded with the fitting.



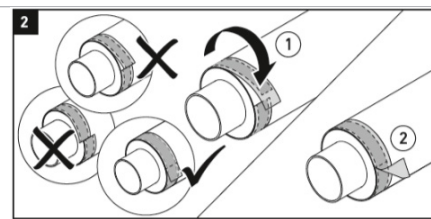
d	d75	d90	d110	d140	d160	d225
L (mm)	165	186	216	252	270	330

L: Length of un-insulated PE100 SDR11 pipe needed

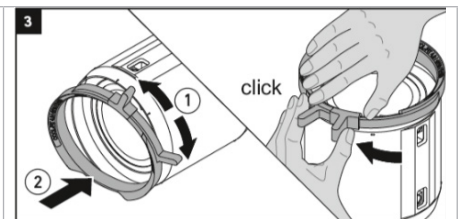
### Mounting of sealing tape and transition of insulation



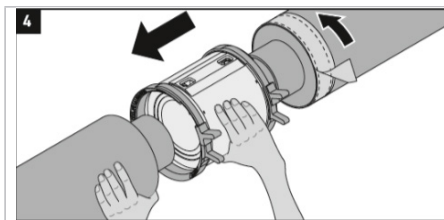
**Step 1**  
In addition to the fusion zone, also clean the jacket of the pipe



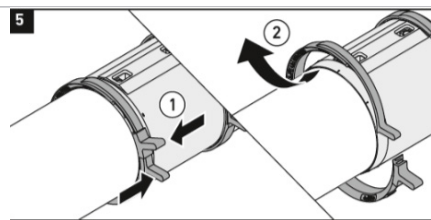
**Step 2**  
Mount sealing tape/ transition of insulation, end to end without offset and fold down liner



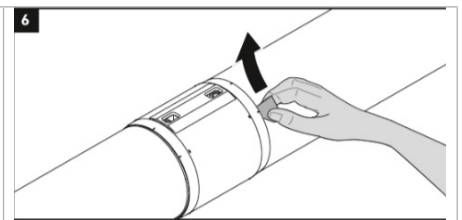
**Step 3**  
Mount the assembly aids on the sealing lips of the COOL-FIT 4.0 fitting



**Step 4**  
On pushing together, slightly turn either fitting or pipe assembled with sealing tape/ transition of insulation



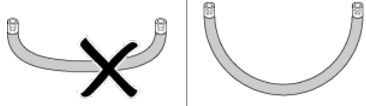
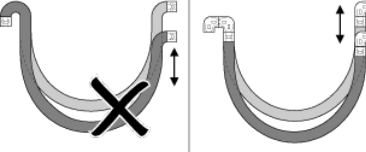
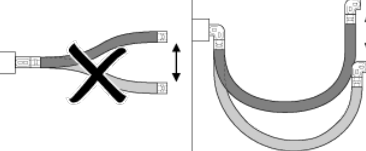
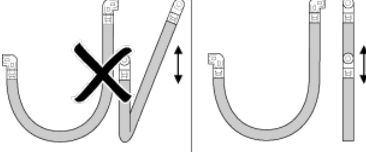
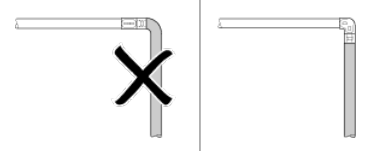
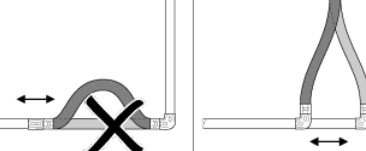
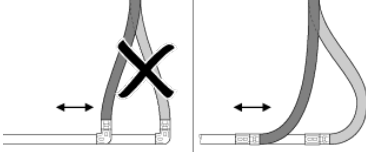
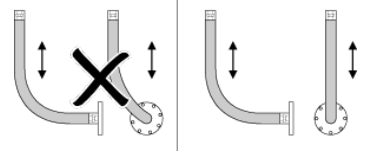
**Step 5**  
Remove the assembly aids



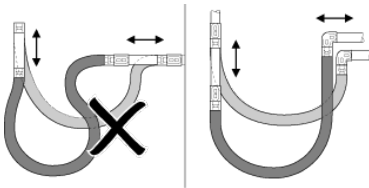
**Step 6**  
Pull off the liner after removal of assembly aids

**COOL-FIT Hoses**

In order to ensure the functionality of flexible hose joints following installation and handling instructions have to be considered.

Installation and handling instructions (false/correct)	Description
	<p>Ensure hose is long enough to observe the minimum radius of curvature.</p>
	<p>Avoid excessive bending of hoses, use elbows.</p>
	<p>Avoid fluctuating bending stress and excessive curvature behind the fitting, use elbows.</p>
	<p>Where there is significant axial expansion, the direction of movement and hose axis must lie in the same plane in order to avoid torsion.</p>
	<p>Avoid excessive bending stress by using elbows.</p>
	<p>If the hose absorbs expansion, it must be installed transversally to the direction of expansion.</p>
	<p>For large lateral movements, a 90° angle should be allowed.</p>
	<p>Expansion take-up must be in the plane of the pipe; torsion should be avoided.</p>



Installation and handling instructions (false/correct)	Description
	For major axial expansion, the pipe must be installed in a U-shape to avoid kinking.

## Transition Fittings

The Georg Fischer Piping Systems range of fittings provides a variety of transitions and threaded fittings to connect plastic piping components to pipe, fittings or valves in metal (or vice versa). The metal threads Rp, R or NPT can be sealed with hemp or PTFE tape as long as the counterpart is not made of plastic. Male and female G threads must be sealed with flat gaskets. The advantage of a threaded G connection is radial and torsion-free possibility for installing and uninstalling.

Next to the traditional transition to metal piping, these fittings can also be used to connect a manometers.

**⚠** To prevent electrochemical corrosion, stainless steel connecting elements should preferably be used for steel transitions.

### Combining G and R threads

The connection of an external parallel pipe thread G in accordance with EN ISO 228-1, with an internal parallel pipe thread Rp in accordance with ISO 7-1 is not intended according to standards. A tight connection is possible under favorable conditions, but cannot be established reliably.

### Mounting the insulation half shells of Transition Fittings

Following the jointing of the COOL-FIT 4.0 Transition Fittings with the COOL-FIT 4.0 Fitting Typ A, and the mechanical jointing of the threaded components, the insulation half shells can be mounted. Assembling of the shells can be done in the same way like for the COOL-FIT 4.0 valves. With the exception of COOL-FIT unions, the sealing lip of the type A fitting must not be cut off on mounting the insulation half shells of transition fittings.

**i** Further information can be found in the assembly instructions "COOL-FIT 4.0 insulation for transition fittings".

## Connecting the insulations of flexible hoses

The length of the insulation of flexible hoses enables a direct jointing at the face of the electrofusion fitting.

The radial jointing of the jointing face of the EPDM insulation of flexible hoses to the insulation of transition fittings can be applied either by adhesive cement or by adhesive tape.

### Jointing Instructions for the adhesive cement

The adhesive should be thoroughly stirred before use. A thin film is applied by means of the brush to both surfaces to be bonded. Doing this, the consumption is ~0.2 – 0.25 kg/m<sup>2</sup>.

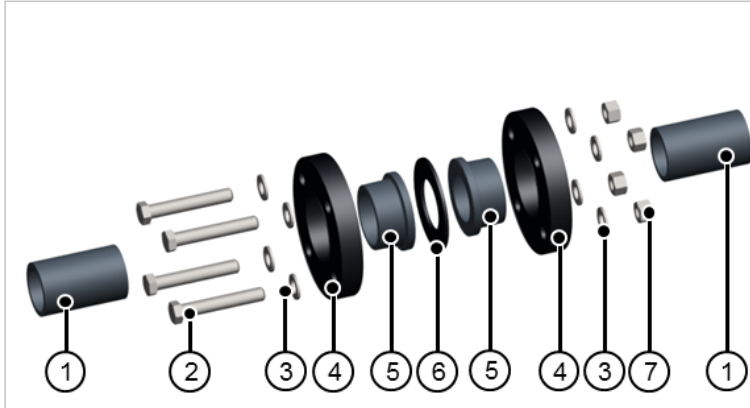
The open joint time is about 3 to 15 minutes depending on temperature and humidity of air.

Before the coated surfaces are brought together, the adhesive must still be tacky but should not transfer to the skin when finger-tested. The surfaces should be brought together quickly and firmly and should be held together for a few seconds.

The recommended temperature and for storage and processing is in the range between +15 °C and 25 °C. The adhesive should not be used below +10 °C.

## Flange joints

Flanges with sufficient thermal and mechanical stability must be used. The different flange types by Georg Fischer Piping Systems fulfill these requirements. The gasket dimensions must match the outer and inner diameter of the flange adapter or valve end. Differences between the inner diameters of gasket and flange that are higher than 10 mm may result in malfunctioning flange connections.



- 1 Pipe
- 2 Bolt
- 3 Washer
- 4 Backing Flange
- 5 Flange Adapter/Valve end
- 6 Flange gasket
- 7 Nut

### Recommended backing flange of COOL-FIT 4.0 flange joints

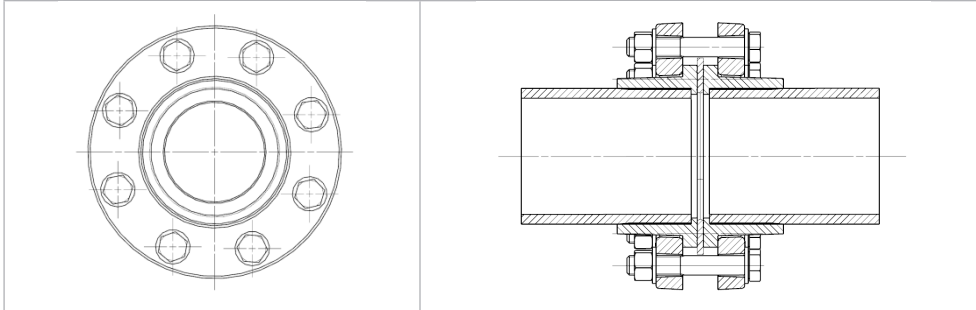
Flange	Properties
PP-steel flange	<ul style="list-style-type: none"> <li>• Very robust and stiff due to the steel inlay</li> <li>• Corrosion-free plastic flange made of polypropylene PP-GF30 (fiber-glass reinforced) with steel inlay</li> <li>• High chemical resistance (hydrolysis-resistant)</li> <li>• UV-stabilized</li> </ul>

### Creating flange joints

When executing flange joints, the following points should be noted:

#### Orientation of bolts beyond the two main axes

- For horizontal piping systems, the orientation shown of the bolts beyond the main axes (see the following figure) is preferred since possible leaks at the flange connection do not cause the medium to run directly onto the bolts.



Flange with main axes (centered crosswise)

- Flange adaptor, valve end or fixed flange, seal and loose flange must be aligned centrally on the pipe axis.
- Before tightening the screws, the sealing surfaces must be aligned parallel and snug against the seal. Tightening misaligned flanges with the resulting tensile stress is to be avoided at all costs.

#### Selecting and handling bolts

- The length of the bolts should be in such a way that the bolt thread does not protrude more than 2-3 turns of the thread at the nut. Washers must be used at the bolts as well as the nut. If too long bolts are used it's not possible to mount the insulation half shells afterwards.
- To ensure that the connecting bolts can be easily tightened and removed after a lengthy period of use, the thread should be lubricated, e.g. with molybdenum sulphide.
- Tightening the bolts by using a torque wrench.
- The bolts must be tightened diagonally and evenly: First, tighten the bolts by hand so that the gasket is evenly contacting the jointing faces. Then tighten all bolts diagonally to 50 % of the required torque, followed by 100 % of the required torque. The recommended bolt tightening torques are listed in the table.
- However, deviations may occur in practice, e. g. through the use of stiff bolts or pipe axes that are not aligned. The Shore hardness of the gasket can also influence the necessary tightening torque.
- We recommend checking the tightening torques 24 hours after assembly according to the specified values and, if necessary, retighten them. Always tighten diagonally here, as well.
- After the pressure test, the tightening torques must be checked in any case and, if necessary, retightened.

**i** For more information on flanges, see DVS 2210-1 supplement 3.

**i** In the area of flexible sections and expansion loops, no mechanical joints should be used since the bending stress may cause leaks.

### Bolt tightening torque guidelines for metric (ISO) flange connections with PP- steel flanges

The indicated torques are recommended by Georg Fischer Piping systems. These torques already ensure a sufficient tightness of the flange connection. They deviate from the data in the DVS 2210-1 Supplement 3, which are to be understood as upper limits. The individual components of the flange connection (valve ends, flange adapters, flanges) by Georg Fischer Piping systems are dimensioned for these upper limits.

Pipe outside diameter d (mm)	Nominal Diameter DN (mm)	Tightening torque MD (Nm)		
		Flat ring maximum pressure 10 bar / 40 °C	Profile seal maximum pressure 16 bar	O-ring maximum pressure 16 bar
d32	DN25	15	10	10
d40	DN32	20	15	15
d50	DN40	25	15	15
d63	DN50	35	20	20
d75	DN65	50	25	25
d90	DN80	30	15	15
d110	DN100	35	20	20
d140	DN125	45	25	25
d160	DN150	45	25	25
d225	DN200	70 <sup>1)</sup>	45	35
d250	DN250	65	35	
d280	DN250	65	35	
d315	DN300	90	50	
d355	DN350	90	50	
d400	DN400	100	60	
d450	DN450	190	70	

<sup>1)</sup> Maximum operating pressure 6 bar  
Bolt tightening torque guidelines for ISO flange connections

### Length of bolts

In practice, it is often difficult to determine the correct bolt length for flange joints. It can be derived from the following parameters:

- Thickness of the washer (2x)
- Thickness of the nut (1x)
- Thickness of the gasket (1x)
- Flange thickness (2x)
- Thickness of flange collar (valve end or flange adaptor) (2x)
- Valve installation length, if applicable (1x)

In order to ensure the fitting of the insulation half shells of the COOL-FIT 4.0 flange adaptors the used bolts must not be too long.

The following table is useful in determining the necessary bolt length.

**i** Under DVS 2210-1, the screw length should be such that it extends 2 to 3 threads beyond the nut.

■ Online "screw lengths and tightening torques" tool on [www.gfps.com/tools](http://www.gfps.com/tools)



For COOL-FIT 4.0 Flange adaptors used together with PP-Steel backing flanges, the following bolt lengths can be used:

Dimension	d32	d40	d50	d63	d75	d90	d110	d140	d160	d225
Screws	M12x80	M16x80	M16x90	M16x90 or M16x100	M16x100	M16x100	M16x100	M16x130	M16x200	M20x220

### Installation fittings (for sensors)

Transitions and threaded plastic fittings should first be screwed finger tight. The fittings are then screwed in using an appropriate tool until 1 or 2 threads remain visible.

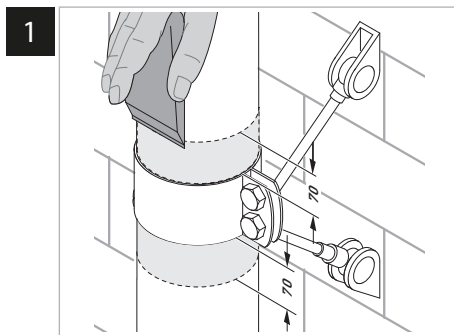
Georg Fischer Piping Systems recommends using PTFE tape to seal transitions and threaded plastic fittings. Alternatively, Henkel Tangit Uni-Lock or Loctite 55 thread seal or Loctite 5331 thread sealant gel can be used. Follow the manufacturer's instructions. When using other sealants, you must check compatibility with the plastic used.

On installing Installation fittings in horizontal piping systems, the sensors should be in 1 – 5 or 7 – 11 clock position.

**⚠ Do not use hemp! It may swell up, putting force on the plastic fittings and damaging plastic threads. Hemp is also not resistant to chemicals used in some media.**

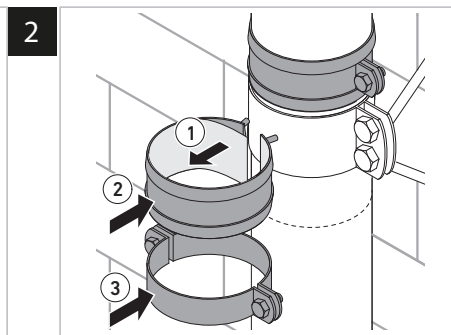
### COOL-FIT 4.0 Installation of fixed points

The COOL-FIT pipe shall be installed with a standard fix point as shown below.



#### Step 1

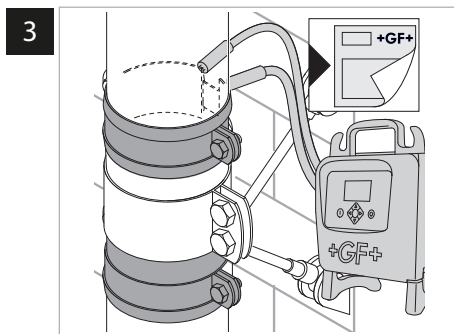
Remove the outer layer of the PE jacket with a pipe scraper



#### Step 2

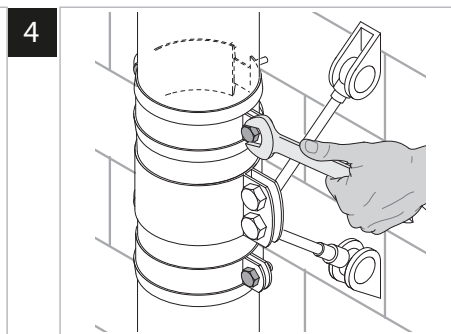
Remove the yellow protection band from the welding bands and place them on the COOL-FIT pipe. Fix the welding bands with the pipe clips provided.

**Note:** The necessary welding pressure on the clean and dry COOL-FIT pipe is achieved by tightening the pipe clips. Take care that between fixed point clip and weld band there are no visible holes.



#### Step 3

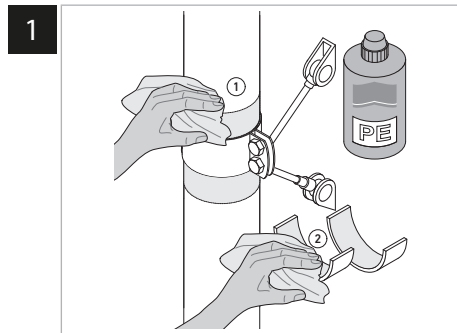
Bond the welding band with the COOL-FIT pipe in accordance with the operating instructions of the electrofusion machine. Use welding adaptors of the y-cable with integrated welding adaptors for the bonding.



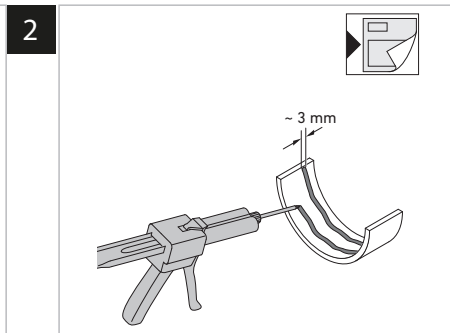
#### Step 4

Retighten the pipe clips after 10 minutes.

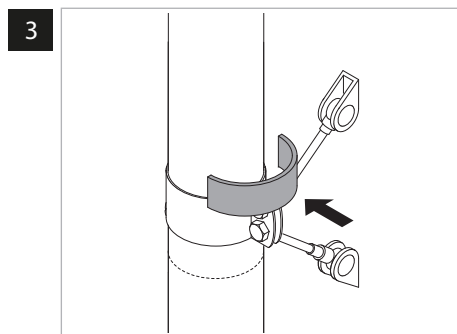
### Installation of COOL-FIT 4.0F fixed points



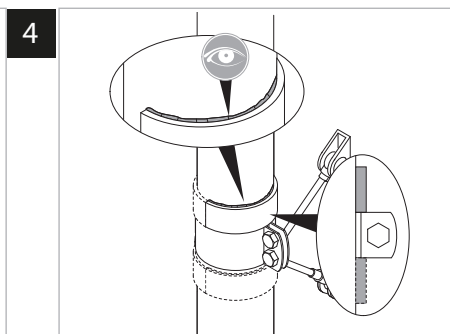
**Step 1**  
Clean the cementing area on the pipe and the components with Tangit PE cleaner and lintfree colourless and clean cloth in circumferential direction.



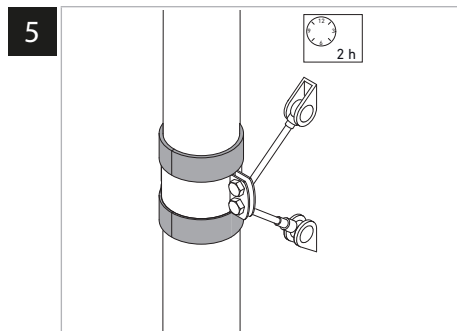
**Step 2**  
Place the Tagit RAPID in about 3mm stripes on the inner side of the fixed point set half shells.



**Step 3**  
Cement the half shells on the pipe next to the pipe clamp.



**Step 4**  
Check the cementing and ensure the fixed point half shells are next to the pipe clamp.



**Step 5**  
Let the fixed point dry for minimum 2hours.

## 2.5.2 Pressure test

### Internal pressure test

For internal pressure testing and commissioning, the same conditions apply for COOL-FIT 4.0 as for the non-insulated ecoFIT system (PE).

## 2.5.3 Internal pressure and leak testing

### Introduction to the pressure test

#### Overview of the various test methods

Test methods	Inner Pressure test		Leakage test	
Medium	Water	Gas <sup>1</sup>	Compressed air <sup>1</sup>	Gas/air (oil-free)
Type	Incompressible	Compressible	Compressible	Compressible
Test pressure (overpressure)	$P_{p(perm)}$ or $0.85 \cdot P_{p(perm)}$	Operating pressure + 2 bar	Operating pressure + 2 bar	0.5 bar
Potential risk during the pressure test	Low	Hoch	High	Low
Significance	High: Proof of pressure resistance incl. impermeability to test medium	High: Proof of pressure resistance incl. impermeability to test medium	High: Proof of pressure resistance incl. impermeability to test medium	Low

<sup>1</sup> Observe the applicable safety precautions. More information is available in DVS 2210-1 addendum 2.

A number of international and national standards and guidelines are available for leak and pressure tests. Therefore, it is often not easy to find the applicable test procedure and for example the test pressure.

The purpose of a pressure test is:

- Ensure the resistance to pressure of the piping system, and
- Show the leak-tightness against the test medium

Usually, the internal pressure test is done as a water pressure test and only in exceptional cases (under consideration of special safety precautions) as a gas pressure test with air or nitrogen.

Water is an incompressible medium. In case of a leakage during the pressure test relative low energy is set free. Therefore the hazard potential is significantly lower compared to testing with a compressible medium like e.g. compressed air.

### Internal pressure test with water or similar incompressible test medium

The internal pressure test is done when installation work has been completed and presupposes an operational piping system or operational test sections. The test pressure load is intended to furnish experimental proof of operational safety. The test pressure is not based on the operating pressure, but rather on the internal pressure load capacity, based on the pipe wall thickness.

Addendum 2 of DVS 2210-1 forms the basis for the following information. This replaces the data in DVS 2210-1 entirely. The modifications became necessary because the reference value "nominal pressure (PN)" is being used less and less to determine the test pressure ( $1.5 \times$  PN, or  $1.3 \times$  PN) and is being replaced by SDR. In addition, a short-term overload or even a reduction in the service life can occur if the pipe wall temperature  $TR = 20 \text{ °C}$  is exceeded by more than  $5 \text{ °C}$  in the course of the internal pressure test based on the nominal pressure.

Test pressures are, therefore, determined in relation to SDR and the pipe wall temperature. The 100-h value from the long-term behavior diagram is used for the test pressure.

### Test parameters

The following table provides recommendations on the performance of the internal pressure test

Purpose	Preliminary Review	Main examination
Test pressure $p_p$ (depends on the pipe wall temperature and the permitted test pressure of the installed components, see "determination of the test pressure")	$\leq P_{p(\text{perm})}$	$\leq 0.85 P_{p(\text{perm})}$
Test duration (depends on the length of the pipe sections)	L $\leq$ 100 m: 3 h 100 m < L $\leq$ 500 m: 6 h	L $\leq$ 100 m: 3 h 100 m < L $\leq$ 500 m: 6 h
Checks during the test (test pressure and temperature curves must be recorded)	At least 3 checks distributed across the test period with test pressure restored	At least 3 checks distributed across the test period without restoring the test pressure

### Pre-test

The pre-test serves to prepare the piping system for the actual test (main test). In the course of pre-testing, a tension-expansion equilibrium in relation to an increase in volume will develop in the piping system. A material related drop in pressure will occur which will require repeated pumping to restore the test pressure and also frequently a re-tightening of the flange connection bolts.

The guidelines for an expansion-related pressure decrease in pipe are:

Material	Pressure drop (bar/h)
COOL-FIT 4.0	1.2

### Main test

In the context of the main test, a much smaller drop in pressure can be expected at constant pipe wall temperatures so that it is not necessary to pump again. The checks can focus primarily on leak detection at the flange joints and any position changes of the pipe.

#### Observe if using compensators

If the piping system to be tested contains compensators, it has an influence on the expected axial forces on the fixed points of the piping system. Because the test pressure is higher than the operating pressure, the axial forces on the fixed points increase proportionately. This has to be taken into account when designing the fixed points.

#### Observe if using valves

When using a valve at the end of a piping system (end or final valve), the valve and the pipe end should be closed by a dummy flange or cap. This prevents an inadvertent opening of the valve and release of the medium.

#### Filling the pipe

Before starting the pressure test, the following points should be checked:

1. The installation has been carried out in accordance with its plans.
2. All pressure relief and check valves are fitted in the direction of flow.
3. All end valves have been closed.
4. All valves for devices have been closed to secure against pressure.
5. A visual inspection has been made of all connections, pumps, measurement devices and tanks.
6. The waiting time after the last weld or bond has been observed



Now the piping system can be filled from the geodetic lowest point. Special attention should be given to the air vent. If possible, vents should be provided at all the high points of the piping system and these should be open when filling the system. Flushing velocity should be at least 1 m/s.

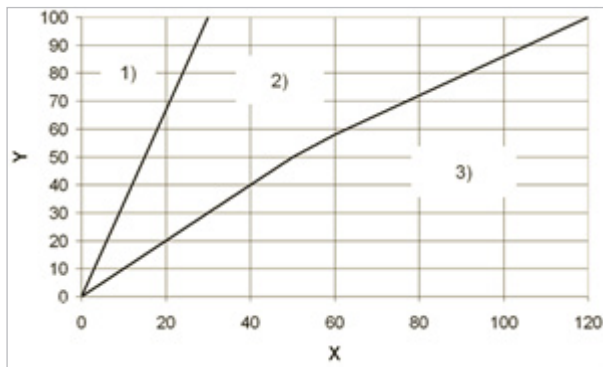
Reference values for the filling volume are given in the table below:

d (mm)	V (l/s)
≤ 90	0.15
110	0.3
160	0.7
225	1.5
250	2.0
315	3.0
400	6.0

Allow sufficient time to pass between filling and testing the pipe for the air in the piping system to escape through the vents: about 6 to 12 hours, depending on nominal diameter.

### Applying the test pressure

The test pressure is applied in accordance with this diagram. It is important to ensure that the rate of pressure increase does not cause any water hammers.



- Y Test pressure (%)  
X Time of test pressure increase (min)
- 1) Rate of pressure increase up to DN100 mm
  - 2) Range of pressure increase rates between DN100 and DN400 mm
  - 3) Guideline rate of pressure increase for DN500 and higher: 500/DN (bar/10 min)

### Determination of the test pressure

The permissible test pressure is calculated using the following formula:

$$P_{p(zul)} = \frac{1}{SDR} \cdot \frac{20 \cdot \sigma_{v(T, 100h)}}{S_p \cdot A_G}$$

$\sigma_{v(T, 100h)}$  Creep strength for the pipe wall temperature (at  $t = 100h$ )

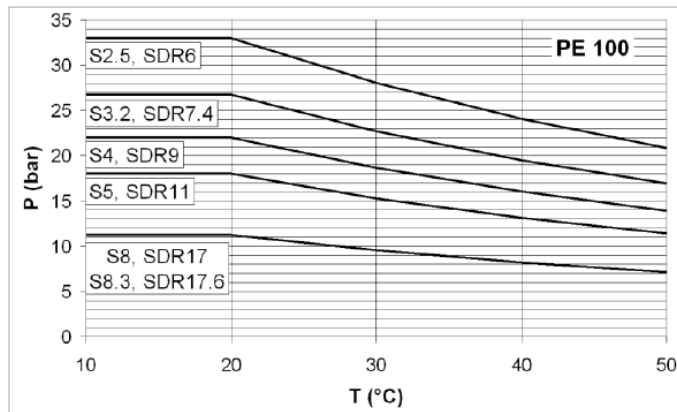
$S_p$  Minimum safety factor for creep strength

$A_G$  Processing method or geometry specific factor which reduces the permissible test pressure

$T_R$  Pipe metal temperature: mean temperature of test medium and pipe surface

Material	$S_p$ minimum safety factor
COOL-FIT 4.0 Pipe and Fittings (PE100)	1.25
COOL-FIT 4.0 Valves (ABS)	1.6

To make things easier, the permissible test pressures can be taken directly from the following diagrams.



P permitted test pressure (bar)  
T pipe wall temperature (°C)

#### Checks during testing

The following measurement values must be recorded consistently during testing:

1. Internal pressure at the absolute lowest point of the piping system
2. Medium and ambient temperature
3. Water volume input
4. Water volume output
5. Pressure drop rates

#### 2.5.4 Start-up with secondary refrigerants

Secondary refrigerants such as glycol solutions must only be introduced in liquid, pre-mixed form into COOL-FIT 4.0 piping systems. Filling should be performed slowly from the lowest point of the system to allow the piping system to vent at its highest point.

##### Filling and de-aeration

It is important to vent air from all piping systems. This is particularly important with saline solutions, because of their corrosive properties. Venting process:

- The system must be filled slowly.
- Manual or automatic venting devices must be fitted at the highest point of the system.
- Long horizontal lines should be installed at a slight gradient.
- The piping layout should be chosen in such a way as to prevent the formation of air pockets.
- Installation of an air vent with a medium column as a reserve.
- Follow the specific manufacturer instructions for the liquids as regards filling

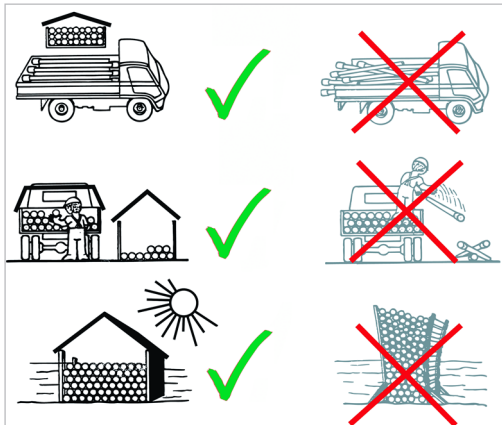
## 2.6 Transport, Handling and Storage

### 2.6.1 Transport

On trucks/in crates, manual transport

### 2.6.2 Storage

All plastic pipe including pre-insulated plastic pipe such as COOL-FIT 4.0 must be stacked on a flat surface with no sharp edges. During handling, care must be taken to avoid damage to the external surface of the pipe, i.e. by dragging along the ground). Pipe should not cross over each other in storage as this is likely to cause bending.



## 2.7 Environment

The materials used for COOL-FIT 4.0 are suitable for recycling. Georg Fischer Piping Systems aims to satisfy its customer's wishes concerning environmental aspects.



For more information at [www.coolfit.georgfischer.com](http://www.coolfit.georgfischer.com)





# Worldwide at home

Our sales companies and representatives ensure local customer support in more than 100 countries.

[www.gfps.com](http://www.gfps.com)

## Argentina / Southern South America

Georg Fischer Central Plastics Sudamérica S.R.L.  
Buenos Aires, Argentina  
Phone +54 11 4512 02 90  
[gfcentral.ps.ar@georgfischer.com](mailto:gfcentral.ps.ar@georgfischer.com)  
[www.gfps.com/ar](http://www.gfps.com/ar)

## Australia

George Fischer Pty Ltd  
Riverwood NSW 2210 Australia  
Phone +61 (0) 2 9502 8000  
[australia.ps@georgfischer.com](mailto:australia.ps@georgfischer.com)  
[www.gfps.com/au](http://www.gfps.com/au)

## Austria

Georg Fischer Rohrleitungssysteme GmbH  
3130 Herzogenburg  
Phone +43 (0) 2782 856 43-0  
[austria.ps@georgfischer.com](mailto:austria.ps@georgfischer.com)  
[www.gfps.com/at](http://www.gfps.com/at)

## Belgium / Luxembourg

Georg Fischer NV/SA  
1600 Sint-Pieters-Leeuw / Belgium  
Phone +32 (0) 2 556 40 20  
Fax +32 (0) 2 524 34 26  
[be.ps@georgfischer.com](mailto:be.ps@georgfischer.com)  
[www.gfps.com/be](http://www.gfps.com/be)

## Brazil

Georg Fischer Sist. de Tub. Ltda.  
04571-020 São Paulo/SP  
Phone +55 (0) 11 5525 1311  
[br.ps@georgfischer.com](mailto:br.ps@georgfischer.com)  
[www.gfps.com/br](http://www.gfps.com/br)

## Canada

Georg Fischer Piping Systems Ltd  
Mississauga, ON L5T 2B2  
Phone +1 (905) 670 8005  
Fax +1 (905) 670 8513  
[ca.ps@georgfischer.com](mailto:ca.ps@georgfischer.com)  
[www.gfps.com/ca](http://www.gfps.com/ca)

## China

Georg Fischer Piping Systems Ltd  
Shanghai 201319  
Phone +86 21 3899 3899  
[china.ps@georgfischer.com](mailto:china.ps@georgfischer.com)  
[www.gfps.com/cn](http://www.gfps.com/cn)

## Denmark / Iceland

Georg Fischer A/S  
2630 Taastrup  
Phone +45 (0) 70 22 19 75  
[info.dk.ps@georgfischer.com](mailto:info.dk.ps@georgfischer.com)  
[www.gfps.com/dk](http://www.gfps.com/dk)

## Finland

Georg Fischer AB  
01510 VANTAA  
Phone +358 (0) 9 586 58 25  
Fax +358 (0) 9 586 58 29  
[info.fi.ps@georgfischer.com](mailto:info.fi.ps@georgfischer.com)  
[www.gfps.com/fi](http://www.gfps.com/fi)

## France

Georg Fischer SAS  
95932 Roissy Charles de Gaulle Cedex  
Phone +33 (0) 1 41 84 68 84  
[fr.ps@georgfischer.com](mailto:fr.ps@georgfischer.com)  
[www.gfps.com/fr](http://www.gfps.com/fr)

## Germany

Georg Fischer GmbH  
73095 Albershausen  
Phone +49 (0) 7161 302 0  
[info.de.ps@georgfischer.com](mailto:info.de.ps@georgfischer.com)  
[www.gfps.com/de](http://www.gfps.com/de)

## India

Georg Fischer Piping Systems Pvt. Ltd  
400 083 Mumbai  
Phone +91 22 4007 2000  
Fax +91 22 4007 2020  
[branchoffice@georgfischer.com](mailto:branchoffice@georgfischer.com)  
[www.gfps.com/in](http://www.gfps.com/in)

## Indonesia

PT Georg Fischer Indonesia  
Karawang 41371, Jawa Barat  
Phone +62 267 432 044  
Fax +62 267 431 857  
[indonesia.ps@georgfischer.com](mailto:indonesia.ps@georgfischer.com)  
[www.gfps.com/id](http://www.gfps.com/id)

## Italy

Georg Fischer S.p.A.  
20063 Cernusco S/N (MI)  
Phone +39 02 921 861  
[it.ps@georgfischer.com](mailto:it.ps@georgfischer.com)  
[www.gfps.com/it](http://www.gfps.com/it)

## Japan

Georg Fischer Ltd  
530-0003 Osaka  
Phone +81 (0) 6 6341 2451  
[jp.ps@georgfischer.com](mailto:jp.ps@georgfischer.com)  
[www.gfps.com/jp](http://www.gfps.com/jp)

## Korea

Georg Fischer Korea Co. Ltd  
Unit 2501, U-Tower  
120 Heungdeok Jungang-ro  
(Yeongdeok-dong)  
Giheung-gu, Yongin-si, Gyeonggi-do  
Phone +82 31 8017 1450  
Fax +82 31 217 1454  
[kor.ps@georgfischer.com](mailto:kor.ps@georgfischer.com)  
[www.gfps.com/kr](http://www.gfps.com/kr)

## Malaysia

George Fischer (M) Sdn. Bhd.  
40460 Shah Alam, Selangor Darul Ehsan  
Phone +60 (0) 3 5122 5585  
Fax +60 (0) 3 5122 5575  
[my.ps@georgfischer.com](mailto:my.ps@georgfischer.com)  
[www.gfps.com/my](http://www.gfps.com/my)

## Mexico / Northern Latin America

Georg Fischer S.A. de C.V.  
Apodaca, Nuevo Leon  
CP66636 Mexico  
Phone +52 (81) 1340 8586  
Fax +52 (81) 1522 8906  
[mx.ps@georgfischer.com](mailto:mx.ps@georgfischer.com)  
[www.gfps.com/mx](http://www.gfps.com/mx)

## Middle East

Georg Fischer Piping Systems (Switzerland) Ltd  
Dubai, United Arab Emirates  
Phone +971 4 289 49 60  
[gcc.ps@georgfischer.com](mailto:gcc.ps@georgfischer.com)  
[www.gfps.com/int](http://www.gfps.com/int)

## Netherlands

Georg Fischer N.V.  
8161 PA Epe  
Phone +31 (0) 578 678 222  
[nl.ps@georgfischer.com](mailto:nl.ps@georgfischer.com)  
[www.gfps.com/nl](http://www.gfps.com/nl)

## Norway

Georg Fischer AS  
1351 Rud  
Phone +47 67 18 29 00  
[no.ps@georgfischer.com](mailto:no.ps@georgfischer.com)  
[www.gfps.com/no](http://www.gfps.com/no)

## Philippines

Georg Fischer Pte Ltd  
Representative Office  
Phone +632 571 2365  
Fax +632 571 2368  
[sgp.ps@georgfischer.com](mailto:sgp.ps@georgfischer.com)  
[www.gfps.com/sg](http://www.gfps.com/sg)

## Poland

Georg Fischer Sp. z o.o.  
05-090 Sekocin Nowy  
Phone +48 (0) 22 31 31 0 50  
[poland.ps@georgfischer.com](mailto:poland.ps@georgfischer.com)  
[www.gfps.com/pl](http://www.gfps.com/pl)

## Romania

Georg Fischer Piping Systems (Switzerland) Ltd  
020257 Bucharest - Sector 2  
Phone +40 (0) 21 230 53 80  
[ro.ps@georgfischer.com](mailto:ro.ps@georgfischer.com)  
[www.gfps.com/int](http://www.gfps.com/int)

## Russia

Georg Fischer Piping Systems (Switzerland) Ltd  
Moscow 125040  
Phone +7 495 748 11 44  
[ru.ps@georgfischer.com](mailto:ru.ps@georgfischer.com)  
[www.gfps.com/ru](http://www.gfps.com/ru)

## Singapore

Georg Fischer Pte Ltd  
11 Tampines Street 92, #04-01/07  
528 872 Singapore  
Phone +65 6747 0611  
Fax +65 6747 0577  
[sgp.ps@georgfischer.com](mailto:sgp.ps@georgfischer.com)  
[www.gfps.com/sg](http://www.gfps.com/sg)

## Spain / Portugal

Georg Fischer S.A.  
28046 Madrid  
Phone +34 (0) 91 781 98 90  
[es.ps@georgfischer.com](mailto:es.ps@georgfischer.com)  
[www.gfps.com/es](http://www.gfps.com/es)

## Sweden

Georg Fischer AB  
117 43 Stockholm  
Phone +46 (0) 8 506 775 00  
[info.se.ps@georgfischer.com](mailto:info.se.ps@georgfischer.com)  
[www.gfps.com/se](http://www.gfps.com/se)

## Switzerland

Georg Fischer Rohrleitungssysteme (Schweiz) AG  
8201 Schaffhausen  
Phone +41 (0) 52 631 3026  
[ch.ps@georgfischer.com](mailto:ch.ps@georgfischer.com)  
[www.gfps.com/ch](http://www.gfps.com/ch)

## Taiwan

Georg Fischer Co. Ltd  
San Chung Dist., New Taipei City  
Phone +886 2 8512 2822  
Fax +886 2 8512 2823  
[www.gfps.com/tw](http://www.gfps.com/tw)

## United Kingdom / Ireland

Georg Fischer Sales Limited  
Coventry, CV2 2ST  
Phone +44 (0) 2476 535 535  
[uk.ps@georgfischer.com](mailto:uk.ps@georgfischer.com)  
[www.gfps.com/uk](http://www.gfps.com/uk)

## USA / Caribbean

Georg Fischer LLC  
9271 Jeronimo Road  
92618 Irvine, CA  
Phone +1 714 731 8800  
Fax +1 714 731 6201  
[us.ps@georgfischer.com](mailto:us.ps@georgfischer.com)  
[www.gfps.com/us](http://www.gfps.com/us)

## International

Georg Fischer Piping Systems (Switzerland) Ltd  
8201 Schaffhausen/Switzerland  
Phone +41 (0) 52 631 3003  
Fax +41 (0) 52 631 2893  
[info.export@georgfischer.com](mailto:info.export@georgfischer.com)  
[www.gfps.com/int](http://www.gfps.com/int)

## Industry



Building Technology



Utility

Price 45 CHF