

4 Product range

On the following pages you will find the complete Akatherm product range for specialist drainage systems. The product range is divided into a general section and a section tools.

4.1 Dimensions

The dimensions of the pipe and fittings in the product tables are all in mm unless stated differently. The standard wall thickness of the fittings is not included in the tables but can be found in the table below, any deviation is mentioned in the product table.

diameter d_1	wall thickness e
32	3,0
40	3,0
50	3,0
56	3,0
63	3,0
75	3,0
90	3,5
110	4,2
125	4,8
160	6,2
200	6,2
250	7,7
315	9,7

Table 4.1 Wall thickness pipe fittings

4.2 Pipe

Akatherm produces tempered pipe according to the standard EN 1519 which has undergone an extra heat treatment after extrusion. The result is less shrinkage when cooled down from high operational temperature. This gives less stress on joints resulting in a longer life of the pipe system.

The Akatherm tempered pipes are suited for applications where the temperature of the pipe can get relatively high or vary considerably. Both can be caused by ambient temperature or temperature of the medium.

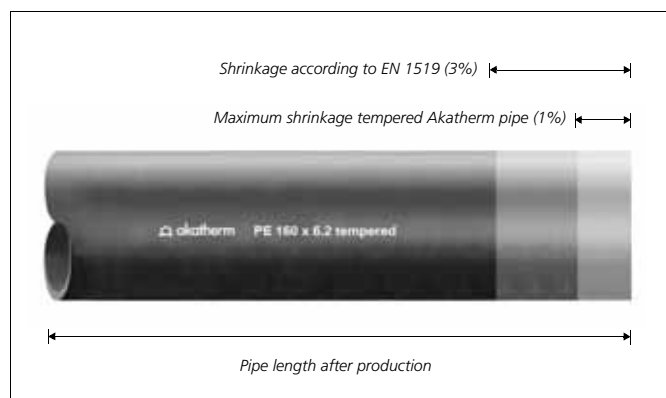


Illustration 4.1

4.3 Electrofusion

The Akatherm products can be welded by electrofusion unless stated differently in the product table. Electrofusion is the preferred method of on-site jointing.

4.4 Butt-welding and the k-dimension

All Akatherm products can be welded using this jointing method. Fittings can be shortened by up to the k-dimension (when indicated in the catalogue), still allowing butt-welding on a standard butt-welding machine.

4.5 Abbreviations

Abbreviation	
A	Cross section area flow
AG	Article group
Art. Nr.	Article number
D	External dimension fitting part
$d_1, d_2 \dots$	External dimension fitting/pipe
DN	Nominal size
e	Wall thickness
$k_1, k_2 \dots$	Maximum length for shortening fittings
L	Total length fitting
$l_1, l_2 \dots$	Partial length of fitting
q	Packing quantity
s	Pipe class according to ISO-S (SDR-1)/2
SDR	Ratio diameter/wall thickness d_1/e

Table 4.2

4.6 Handling and storage

Pipes

The high impact strength of Akatherm HDPE provides some protection against damage but care should be taken at all stages of handling, transportation and storage.

Pipe must be transported by a suitable vehicle and properly loaded and unloaded, e.g. wherever possible moved by hand or mechanical lifting equipment. Pipes must not be dragged across the ground. The storage should be flat, level and free from sharp objects.

Lengths

Pipe lengths stored individually should be stacked in a pyramid not more than one metre high, with the bottom layer fully restrained by wedges. Where possible, the bottom layer of pipes should be laid on timber battens at one-metre centres. On site, pipes may be laid out individually (where appropriate, protective barriers should be placed with adequate warning signs and lamps).

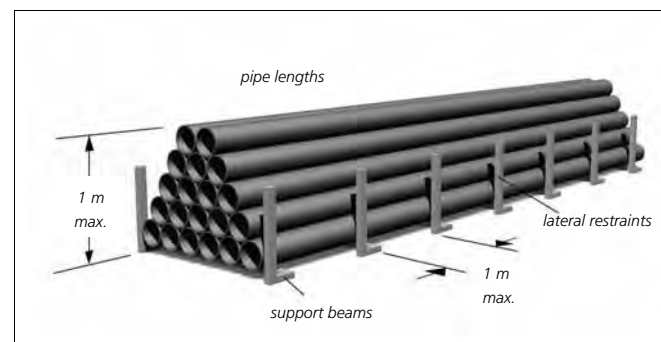


Illustration 4.2 Storage of loose pipes

Product range

Bundles

Bundled packs of pipe should be stored on clear, level ground with the battens supported from the outside by timber or concrete blocks. For safety, bundled packs should not be stacked more than 3 m high. Smaller pipes may be nested inside larger pipes. Side bracing should be provided to prevent stack collapse.

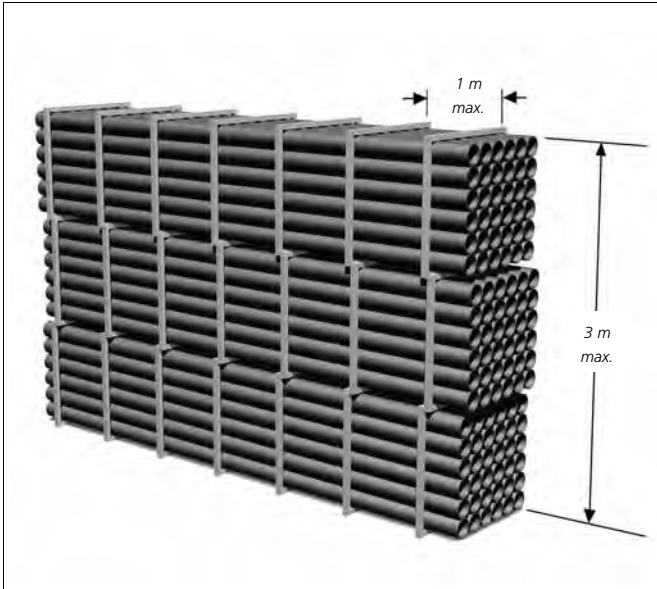


Illustration 4.3

Fittings

The fittings and electrofusion couplers need to be stored at a dry place. To prevent oxidation and contamination it is recommended to leave the fittings in their original packaging until required for use.

Tools

All tools, especially electrical, must be protected against moisture, dust and should not be dropped.

Recycling residual waste

According to regulations, residual waste materials should be recycled:

PE/electrofusion couplers	: recycle/residual waste
Carton boxes	: recycled paper
Plastic containers	: residual waste
Chips	: residual waste
Cleaning cloths	: residual waste