

GENERAL SPECIFICATIONS

ITEM	STANDARDS
Lined Pipes and Fittings	ASTM F-1545
PTFE Liners	ASTM D1457, D4894, D4895
PFA Lining	ASTM D3307
PVDF Liners	ASTM D3222
PP Liners	D4101
Pipe ½" - 8": Carbon Steel, Sch 40	ASTM A106 Gr B
Pipe 10" - 12": Carbon Steel, Sch 30	ASTM A106 Gr B
Flanges ½" - 12": Carbon Steel	ANSI 150, ASTM A105, B16.5
Elbows ½" - 3": Carbon Steel	A234 Gr WPB, B16.9 (Long Radius)
Elbows 4" - 12": Carbon Steel	A234 Gr WPB, B16.9 (Short Radius)
Tees ½" - 8": Carbon Steel, Sch 40	ASTM A106 Gr B
Tees 10" - 12": Carbon Steel, Sch 30	ASTM A106 Gr B
Instr Tees ½" - 8": Carbon Steel, Sch 40	ASTM A106 Gr B
Instr Tees 10" - 12": Carbon Steel, Sch 30	ASTM A106 Gr B
Reducers ½" - 8": Carbon Steel	ASTM A106 Gr B
Red Flanges 1" - 12": Carbon Steel	AB-EH36 /ST52-3 ASTM A106 Gr B

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Paint Finish	Sand blast to SA 2.5 and one coat Zinc Silicate Primer 40 micron DFT
Hydro Test	Double pressure tested to 29 BarG
Holiday Test	15,000 VDC.
Packing	Wooden end covers fitted to protect the ends

ITEM	LINEAR TOLERANCE	ANGULAR TOLERANCE
Pipes < 300 mm	+1 / -3 mm	+ / - 0.5°
Pipes 300 – 1,000 mm	+2 / -4 mm	+ / - 0.5°
Pipes 1,000 – 6,000 mm	+3 / -5 mm	+ / - 0.5°
Fittings 1"-4"	+1 / -3 mm	+ / - 0.5°
Fittings 6"-8"	+2 / -4 mm	+ / - 0.5°
Fittings 10"-12"	+3 / -5 mm	+ / - 0.5°

TEMPERATURE	PRESSURE (#150)	PRESSURE (#300)
40 °C	17.0 BarG	30.0 BarG
70 °C	16.5 BarG	28.0 BarG
90 °C	16.0 BarG	26.0 BarG
150 °C	14.0 BarG	23.0 BarG
200°C	13.0 BarG	20.0 BarG
260°C	11.5 BarG	16.0 BarG

ITEM	LINER THICKNESS	150°C	200°C
Pipe ¾"	3.1 mm	Full Vacuum	Full Vacuum
Pipe 1"	3.1 mm	Full Vacuum	Full Vacuum
Pipe 1½" - 2"	3.3 mm	Full Vacuum	Full Vacuum
Pipe 3"	3.2 mm	Partial Vacuum	
Pipe 4"	4.0 mm	Partial Vacuum	Partial Vacuum
Pipe 6"	7.2 mm	Full Vacuum	
Pipe 8"	8.2 mm	Full Vacuum	Full Vacuum
Pipe 10"	7.0 mm	Partial Vacuum	Partial Vacuum
Pipe 12"	10.0 mm	Partial Vacuum	Partial Vacuum