

Pipe joint assemblies and fittings for high-density polyethylene (PE-HD) pressure pipes
Fittings for resistance welding
Dimensions

DIN
16963
Part 7

Rohrverbindungen und Rohrleitungsteile für Druckrohrleitungen aus Polyethylen hoher Dichte (PE-HD); Helzwendel-Schweiß fittings, Maße

Supersedes August 1980 edition, withdrawn in January 1986.

In keeping with current practice in standards published by the International Organization for Standardization (ISO), a comma has been used throughout as the decimal marker.

Dimensions in mm

1 Field of application

This standard specifies requirements for high-density polyethylene (PE-HD) fittings to be joined with PE-HD pipes as specified in DIN 8074 of MFI groups 005 and 010*).

Where fittings are to be welded to pipes of other MFI groups, verification of weldability shall be provided.

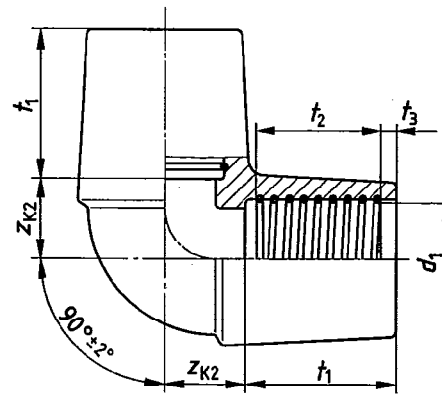
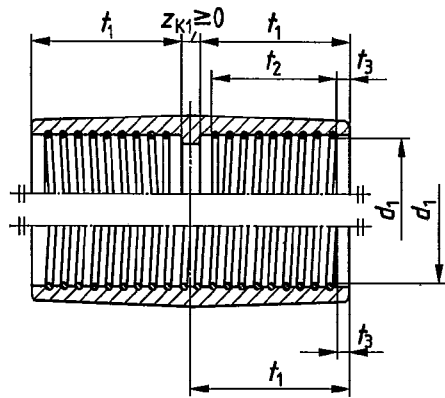
These fittings shall also comply with the requirements specified in DIN 16963 Part 5.

2 Dimensions and designation

Fittings are not expected to conform to the designs illustrated here; compliance is only required in the case of the dimensions specified.

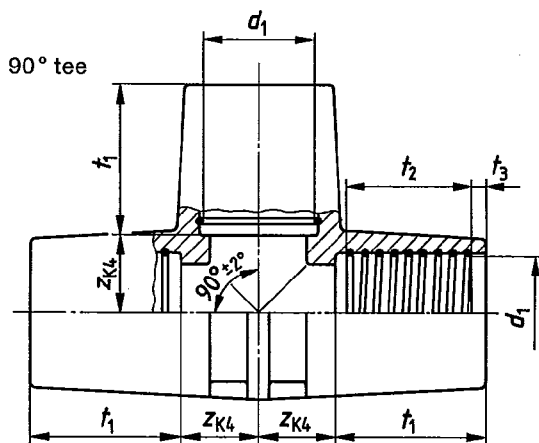
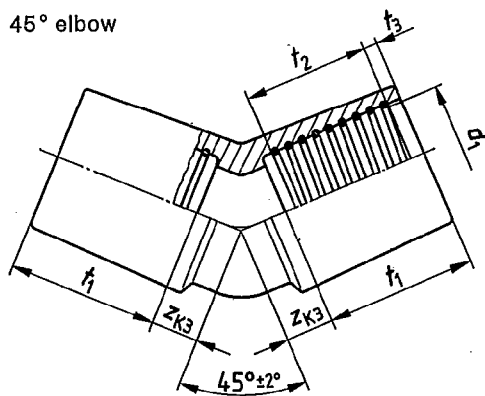
Socket
(with or without stop, subject to agreement)

90° elbow



45° elbow

90° tee



*) See also Explanatory notes to the October 1989 edition of DIN 16963 Part 5.

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Designation of a 45° elbow for resistance welding as specified in this standard (7), with $d_1 = 63$ mm, to be joined with PE-HD pipes of pipe series 5:

Elbow DIN 16963 – 7 – 45 – 63 – 5 PE-HD

Pipe outside diameter, d	Mean internal socket diameter		Socket depth, t_1		Minimum welding length, t_2	t_3 min.	Elbows		Tees Z_{K4} min.
	d_1 min.	Maximum out-of-roundness	min.	max.			90° elbows Z_{K2} min.	45° elbows Z_{K3} min.	
20	20,1	0,3	15	37	10	5	10	3	10
25	25,1	0,4	15	40	10	5	13	3	13
32	32,1	0,5	16	44	10	5	16	4	16
40	40,1	0,6	18	49	10	5	20	5	20
50	50,1	0,8	20	55	10	5	25	6	25
63	63,2	1,0	23	63	11	5	32	7	32
75	75,2	1,2	25	70	12	5	38	9	38
90	90,2	1,4	28	79	13	5	45	10	45
110	110,3	1,5	32	85	15	5	55	13	55
125	125,3	1,5	35	90	16	5	63	14	63
140	140,3	1,5	38	95	18	5	70	16	70
160	160,4	1,5	42	101	20	5	80	18	80
180	180,4	1,5	46	108	21	5	—	—	—
200	200,4	1,5	50	115	23	5	—	—	—
225	225,5	1,5	55	123	26	5	—	—	—

Standards referred to

- DIN 8074 High-density polyethylene (PE-HD) pipes; dimensions
 DIN 16963 Part 5 Pipe joint assemblies and fittings for high-density polyethylene (PE-HD) pressure pipes; general quality requirements and testing

Previous edition

DIN 16963 Part 7: 08.80.

Amendments

The following amendments have been made to the August 1980 edition, withdrawn in January 1986.

- The status of the standard is no longer that of a preliminary standard.
- PE-HD is no longer classified into type 1 and type 2.
- The specification for 45° branches (type A 45) has been deleted.
- The dimensions have been amended.
- The standard designation has been changed.

Explanatory notes

This standard has been prepared by Subcommittee 504.4 *Kunststoff-Fittings für Rohre aus Thermoplasten* of the *Normenausschuß Kunststoffe* and, in contrast to the previous edition, takes into account the work of ISO/TC138/WG 9. Instead of specifying different dimensional systems, this standard establishes a basic system based on minimum dimensions, which leaves room for future developments.

International Patent Classification

F 16 L 47/00
E 03 B 7/00