

KALSON PLAST PVT.LTD.

PLOT NO.G-1930, ROAD NO. 7E,BEHIND ALMIGHTY AGROTECH, ALMIGHTY GATE,
LODHKA G.I.D.C., METODA - 360021, RAJKOT(GUJ).INDIA

TESTING REPORT OF SWR PIPES

Lot No / Batch No : 202305150011 Date Of Manufacturing : 16-05-2023
Size : 110mm / TYPE A Date of Testing : 17-05-2023

(1) 7.1, 7.2, 7.3 DIMENSION: (All dimensions are in mm)

	Min	Max	A- Max. Length of Beading & Neck	26.0
Wall Thickness (S)	2.2	2.7	B- Min. Neck of Socket	6.0
O.D. at any point	108.6	111.4	C- Min. Length Beyond Beading	32.0
Mean Outside Diameter	110.0	110.4	Minimum Socket Wall Thickness (S ₂)	2.0
I.D. of Socket (d ₁)	110.4	111.6	Minimum Socket Wall Thickness (S ₃)	1.2
Minimum I.D. of Beading (d)	120.3	121.3	Length of Pipe	3000

Sr.	Thickness		S ₂ Min	S ₃ Min.	O.D. at any P.		Mean OD	A	B	C	Socket I.D. D1		Socket I.D. D2	
	Min.	Max			Min.	Max		Max	Min.	Min.	Min.	Max	Min.	Max
1	2.24	2.55	2.11	1.55	109.10	110.95	110.20	24.15	9.55	34.10	110.60	110.98	120.50	120.85
2	2.28	2.55	2.12	1.61	109.15	111.00	110.25	24.28	10.15	33.80	110.55	110.85	120.45	120.70
3														
4														
5														
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7														
8														
9														
10														
Min	2.24	2.55	2.11	1.55	109.10	110.95	110.20	24.15	9.55	33.80	110.55	110.85	120.45	120.70
Max	2.28	2.55	2.12	1.61	109.15	111.00	110.25	24.28	10.15	34.10	110.60	110.98	120.50	120.85

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.1 VISUAL APPEARANCE :

Colour-Dark Grey : Yes /~~No~~
Reasonably Round : Yes /~~No~~
Internal Surface : Smooth / ~~Not Smooth~~
External Surface : Smooth / ~~Not Smooth~~
Grooving : ~~Present~~ / Not present
Other Defects : ~~Present~~ / Not present
Pipe End : ~~4th Chamfer~~ / Without Chamf
Assessment : **PASS/FAIL**

(3) 8.2 REVERSION TEST : (Max. 5%)

Oil Bath Temperature : 150°C ± 2°C
Duration of Test : 15 Minutes

No. of test samples	:	1	2	3
Initial length before Heating	:	100	100	100
Length after Heating	:	96.63	97.03	96.69
Length Alteration %	:	3.37	2.97	3.31

Assessment : **PASS/FAIL**

(4) 10.1 IMPACT STRENGTH TEST :

Length of Specimen : 200 mm
Temperature of Specim : 0°C ± 1°C
Period of Conditioning : One hour
Weight of Striker : 500 gm
Height of Fall : 2000 mm ± 10 mm
Number of equidistant lines drawn : 6 Number
Observed Value : 25 strikes
Cracks/ Ruptures Observed : Nil
Assessment : **PASS/FAIL**

(5) 11 WATER TIGHTNESS OF JOINT TEST :

No. of Test Samples : 3
Req. Pressure : 0.5 kg/cm²
Applied Pressure : 0.5 kg/cm²
Duration of Test : 15 minutes
Presence of Leakage : NIL
Assessment : **PASS/FAIL**

5 STRESS RELIEF TEST (for Socket End pipe only) :

No. of Test Samples : 5
 Length of Sample : Full Socket End portion with 100 mm length of plain
 Temperature : 150°C ± 2°C
 Wall Thickness : 2.31
 Period of Condition of Sample : One hour
 Depth of Spider Line or Weld Line (after testing Not greater than 20% of wall thickness) : in range/out of range
 Blisters, excessive delamination or cracking or Assessment : NIL
Assessment : PASS/FAIL

(7) 12 RESISTANCE TO DICHLOROMETHANE AT SPECIFIED TEMPERATURES

→ No. of Test Samples : 3
 → Length of Sample : 160 mm
 → Temperature : 15°C ± 0.5°C
 → Wall Thickness : 2.31
 → Sample End Chamfer : 10°
 → Duration of Test : 30 minutes
 → After Test Sample End Chamfer : ATTACK / NO ATTACK
Assessment : PASS/FAIL

(8) 10.3 AXIAL SHRINKAGE TEST (for Type B Pipes only)

		1	2	3
No. of test samples	:			
Temp. during Conditioning	:			
Temp. of Water Bath	:			
Conditioning Period	:			
Duration of Test	:			
Mean Axial Shrinkage (MAX)	:			

Assessment : PASS/FAIL

(9) 10.2 TENSILE STRENGTH TEST NOT LESS THEN 45 Mpa

Conditioning : Temperature 27° ± 2°C
 Relative Humidity 65 ± 5%
 Number of Sample : ONE
 Sample dimension (1) Width : 0.995 Cm
 (2) Thick. : 0.232 Cm
 Maximum load (kgf) : 107.6 kgf
 Speed of separation : 50 ± 10 % mm/min.
 Result in MPA : 46.59

Calculation : $\frac{\text{Maximum load (kgf)}}{\text{width(mm)} \times \text{thickness(mm)}}$

Assessment

PASS/FAIL

Sign of Quality Controller