

RIGID PVC SOCKET
FITTINGS

KALSON PLAST PVT .LTD.
PLOT NO. 1930, ROAD No. 7E,B/H
ALMIGHTY AGRO TECH, LODHIKA
G.I.D.C, METODA, DIST-RAJKOT

INTERNAL TEST REPORT AS PER IS

Machine No. : D1
Date of Manufacturing & sampling : 12/04/2023
Date of Testing : 13/04/2023

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Name: 90° TEE, Size 75mm

(1) DIMENSION: (All dimensions are in mm) (Cl.3, 4, 5.1)


A. Socket Length : 33.90 (Req. :- 35.00 mm)
B. Diameter at mid-point : 20.15 Min. To 20.22 Max. (Req. :- Min.20.10 To Max.20.30)
C. Laying length Z : 10.50 (Req. :- 10.00 mm To 12.00mm)
D. Wall Thickness : 2.05 mm (Req.Min. :- 2.00 mm)

Sr. No.	WALL THICKNESS IN MM					
	1	2	3	4	5	6
1	2.10	2.03	2.05	2.10	2.04	2.05
2	2.05	2.05	2.11	2.10	2.05	2.10
3						
4						
5						

(2) VISUAL APPEARANCE:

➤ Colour- 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
➤ Assessment : **PASS/FAIL**

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O.C. /C.

(3) OPACITY TEST: (Cl.6.2)

➤ Thickness of spaceman :

1	2	3
2.05	2.10	2.10
0.00%	0.01%	0.01%

➤ Observed % of light transmitted :
(Maximum permissible value 0.2%)

➤ Assessment : **PASS / FAIL**

4 SHORT TERM HYDRALIC PRESSURE TEST: (Cl.6.4)

➤ No. of Samples required : -
 ➤ Conditioning period of joint : 24 Hours
 ➤ Applied pressure : 15.10 Kgf/cm²
 ➤ Water bath temperature : 27 ° c ± 2°c
 ➤ Duration of test : 1 Hour

➤ Assessment : **PASS/FAIL**

5 STRESS RELIEF TEST (Cl.6.1&6.1.1)

➤ No. of Test Samples : Three
 ➤ Wall Thickness of samples : 2.10mm
 ➤ Temperature : 150 ° c ± 4°c
 ➤ test periods : 1 Hour
 ➤ Blisters

➤ Excessive delamination or cracking :

1	2	3
OK	OK	OK

➤ Or signs of weld line splitting.
(Penetration not greater than 20%
of the wall thickness at that point.)

➤ Assessment : **PASS/FAIL**

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 PREPARED BY :- *[Signature]*
 Q.C. /C.

Signature of Q. C. I