

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 FITTING

Lot No / Batch No : 20230520 Date Of Manufacturing : 20 05 2023
Size : 110 mm Test Report No : -
Machine No. : C3 Date of Testing : 21 05 2023

Name of Fittings : Single BEND (87.5)

DIMENSION: (All dimensions are in mm)

Min. I.D. of socket at Midpoint (D1) 110.1 Min. Wall Thickness at plain end (e) : 2.0
Max. I.D. of socket at Midpoint (D1) 110.4 Max. Wall Thickness at plain end (e) : 2.5
Min. I.D. of Grooved socket at Midpoint (d1) - Min. Wall Thickness at Socket (e2) : 1.9
Max. I.D. of Grooved socket at Midpoint (d2) - Min. Wall Thickness Socket (e3) : -
Min. Socket Depth 48.0 A- Max. Length of beading & Neck : -
Min. O.D. of Spigot portion 110.0 B- Min. Neck of socket : -
Max. O.D. of Spigot portion 110.4 C- Max. Length of Beyond beading : -

No.	Min. e	Max. e	Min. e ₂	Min. e ₃	Min. OD	Max. OD	MOD	Socket Depth 'C'	Min. I.D.	Max. I.D.
1	2.05	2.12	2.19	-	110.20	110.30	110.25	51.08	110.10	110.15
2	2.21	2.33	2.14	-	110.10	110.20	110.15	51.26	110.12	110.21
3										
4										
5										
6										
7										
8										
9										
10										
Min	2.05	2.12	2.14	0.00	110.10	110.20	110.15	51.08	110.10	110.15
Max	2.21	2.33	2.19	0.00	110.20	110.30	110.25	51.26	110.12	110.21

VISUAL APPEARANCE :

- Colour-Dark Grey : Yes /No
- Reasonably Round : Yes /No
- Internal Surface : Smooth / Net-Smooth
- External Surface : Smooth / Net-Smooth
- Grooving : Present / Not present
- Other Defects : Present / Not present
- **Assessment** : **PASS/FAIL**

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STRESS RELIEF TEST : (specified value : not more than 20 %)

- No. of Test Samples : 3
- Length of Sample : Full Socket End portion
- Temperature : 150°C ± 2°C
- Wall Thickness : 2.15 mm
- Period of Condition of Sample : One hour
- After Test Blisters, excessive delamination
cracking or signs of weld line : 2.16mm, 2.12mm , 2.06mm
- Average : 2.11 mm
- | | |
|-------------------|--------------|
| 2.15 mm - 2.10 mm | X 100 |
| 2.15 mm | |
- Assessment : **PASS/FAIL**

SULPHATED ASH CONTENT (specified value : not more than 10%)

Temperature of muffle furnace : 850° ± 10°C

DESCRIPTION	NORMS	UNIT	OBSERVATIONS
Weight of the crucible	W ₁	gm	25.7056
Weight of the crucible with sample	W ₂	gm	29.2648
Weight of the sample (W ₂ -W ₁)	W _s	gm	3.5592
Weight of the crucible with ash	W ₃	gm	25.9456
Weight of ash (W ₃ -W ₁)	W _A	gm	0.2400
Sulphated Ash Content (W _A /W _s X100)		%	6.74

IMPACT STRENGTH TEST :

- Temperature of Specimen : 0°C ± 1°C
- Period of Conditioning : 30 min.
- Height of Fall : 2000mm
- Stroke No. 1 : Pass
- Stroke No. 2 : Pass
- Stroke No. 3 : Pass
- Assessment : **PASS/FAIL**

WATER TIGHTNESS OF JOINT TEST :

- No. of Test Samples : 03
- Req. Pressure : 0.5 kg/cm²
- Applied Pressure : 0.5 kg/cm²
- Duration of Test : 15 minutes
- Presence of Leakage : NIL
- Assessment : **PASS/FAIL**

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