



Especially in underground networks, a waterproofing test between the mantle and the PVC shell is required, following the requirements of EN 13941 regarding EN 489. Leakage control can be carried out with air pressure or other suitable gases.

The test requires a pressure of 0.2bar for 2min duration at a maximum outer temperature of 40°C.

We also test the hydraulic system for its strength and permeability, according to Interplast's pressure test protocol.

SOCKET			
DIMENSION	POLYOL (mL)	ISOCYANATE (mL)	TOTAL (mL)
20/63	28	28	56
25/63	26	26	52
32/63	23	23	46
40/75	31	31	62
50/90	44	44	88
63/100	45	45	90
75/125	117	117	234
90/140	134	134	268
110/160	159	159	318
125/200	300	300	600
160/225	302	302	604
200/250	377	377	754
250/315	471	471	942
315/400	589	589	1178

ELBOW 90°			
DIMENSION	POLYOL (mL)	ISOCYANATE (mL)	TOTAL (mL)
20/63	34	34	68
25/63	32	32	64
32/63	28	28	56
40/75	38	38	76
50/90	54	54	108
63/100	55	55	110
75/125	143	143	286
90/140	163	163	326
110/160	194	194	388
125/200	366	366	732
160/225	368	368	736
200/250	420	420	840
250/315	622	622	1244
315/400	808	808	1616

ELBOW 45°			
DIMENSION	POLYOL (mL)	ISOCYANATE (mL)	TOTAL (mL)
20/63	31	31	62
25/63	29	29	58
32/63	26	26	52
40/75	35	35	70
50/90	49	49	98
63/100	50	50	100
75/125	131	131	262
90/140	150	150	300
110/160	178	178	356
125/200	336	336	672
160/225	338	338	676
200/250	439	439	878
250/315	571	571	1142
315/400	742	742	1484

TEE			
DIMENSION	POLYOL (mL)	ISOCYANATE (mL)	TOTAL (mL)
20/63	51	51	102
25/63	48	48	96
32/63	42	42	84
40/75	57	57	114
50/90	81	81	162
63/100	82	82	164
75/125	214	214	428
90/140	245	245	490
110/160	291	291	582
125/200	549	549	1098
160/225	553	553	1106
200/250	791	791	1582
250/315	949	949	1898
315/400	1139	1139	2278