

DIN 16961-2:2010-03 (E)

Thermoplastics pipes and fittings with profiled wall and smooth pipe inside - Part 2: Technical delivery specifications

Contents		Page
Foreword		4
1	Scope	5
2	Normative references	5
3	Material (moulding materials)	6
4	Requirements	6
4.1	General	6
4.2	Form supplied	6
4.3	Strength	6
4.3.1	Ring stiffness	6
4.3.2	Creep modulus (E_c modulus)	7
4.4	Strength of welded joints	8
4.5	Tightness of joints	8
4.6	Resistance to root penetration	8
4.7	Melt mass-flow rate (MFR) for PE 63, PE 80, PE 100, PE-HD and PP pipes and fittings	8
4.8	Surface finish	8
4.9	Colour	9
4.10	Dimensions	9
5	Testing	9
5.1	Form supplied	9
5.2	Strength	9
5.2.1	Ring stiffness	9
5.2.2	Creep modulus	12
5.3	Tightness of joints	12
5.4	Resistance to root penetration	12
5.5	Melt mass-flow rate (MFR) for PE and PP pipes and fittings	12
5.6	Surface finish	12
5.7	Colour	12
5.8	Dimensions	12
5.9	Weldability of PE and PP pipes and fittings	12
6	Inspection	12
6.1	General	12
6.2	Internal control	13
6.2.1	Type, scope and frequency	13
6.2.2	Defects	13
6.2.3	Documentation	13
6.3	Third party inspection	14
6.3.1	Type, scope and frequency	14
6.3.2	Sampling	14
6.3.3	Inspection report	15
7	Marking	15
Annex A (informative)	Calculating SR24 ring stiffness on a solid wall cross section (Example)	16
A.1	Schematic test set-up and measured values	16

A.2	Calculation steps	16
A.2.1	Step 1: Determination of the theoretical moment of inertia I	16
A.2.2	Step 2: Determination of the theoretical ring stiffness SR24(th)	17
A.2.3	Step 3: Determination of the test force F	17
A.2.4	Step 4: Test procedure	18
A.2.5	Step 5: Calculation of mean vertical deflection ivmd in %	18
A.2.6	Step 6: Calculation of coefficient of deflection for a deflection of 2,77 %	18
A.2.7	Step 7: Calculation of SR24 value	19
Annex B (informative) Methods of assessing the load capacity of pipes		20
B.1	General	20
B.2	Structural design based on practical experience	20
B.3	Structural design based on design calculations	23
B.4	Suitability of methods for large pipes	23
Annex C (normative) Durability of profiled pipes		24
C.1	General	24
C.2	Verification of durability	24
C.2.1	Use of materials meeting the requirements of the European Standards relating to waste water	24
C.2.2	Use of other materials and mixtures of materials	24
Annex D (normative) Specification of wall thicknesses for profiled pipes of nominal sizes greater than DN 1 200 for use as non-pressure underground sewage pipes		25
D.1	General	25
D.2	Minimum wall thickness for pipes > DN 1 200	25
Bibliography		27
Figures Figure 1 -- Ring stiffness test using bearing plates		10
Figure 2 -- Ring stiffness test using steel angles		11
Figure B.1 -- Long-term pipe deflection: maximum values		21
Figure B.2 -- Maximum permissible groundwater level above the invert (GW) as in ATV-DVWK-A 127 (DWA-A 127 Code of practice)		22
Figure D.1 -- Examples of profiles with wall thicknesses as in DIN EN 13476-2 and DIN EN 13476-3 .		26
Tables Table 1 -- Ring stiffness		7
Table 2 -- Ring stiffness classes SN		7
Table 3 -- Minimum creep modulus		8
Table 4 -- Coefficient of deflection		10
Table 5 -- Scope and frequency of internal control		13
Table 6 -- Scope and frequency of third party inspection		14
Table A.1 -- Result of deflection after subjecting the pipe to test force F		18
Table A.2 -- Coefficients of deflection		19
Table B.1 -- Conditions on which the graphs in Figure B.1 are based		23
Table D.1 -- Minimum wall thickness		25