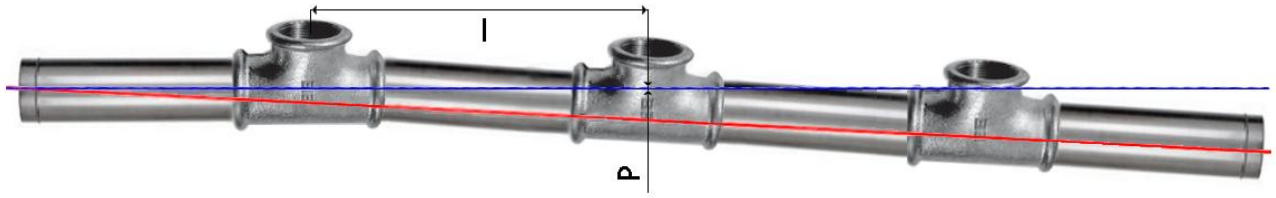
ODLEWNIA ŻELIWA ZAWIERCIE

Instruction concerning assembling of the pipelines made from fittings EE brand and threaded pipes.

According to PN-EN 10242 "Threaded pipe fittings made from malleable cast iron" the angle between axis of the threads is contained in the accuracy +/- ½° (+/- 0°30').
For straight fittings it is 180° +/- 0°30'; for bends and elbows it is 90°+/- 0°30'; for tees it is 180° +/- 0°30' and 90° +/- 0°30'.

During assembling of fittings the deviations +/- 0°30' cause the deviations of the pipelines from the axis (both in the horizontal plane as well as vertical plane). In case of long, multisegment pipelines, the deviations may be summed.



The deviation from the precised axis of the "P" pipeline are calculated like below :
P_{max} = 0,0087 x l – where l = length of the connecting segment

	Length of the pipe (connecting interval) - /meters/									
	1	2	3	4	5	6	7	8	9	10
P /mm/	8,7	17,4	26,1	34,8	43,5	52,2	60,9	69,6	78,3	87

The deviations coming from the chart may increase because of misalignment of the pipes and because of misalignment of the threads at their ends. Pipes have to fulfill the requirements of the special standards. Deviations from precised axis of the pipelines may be corrected by using of the controllable tensions, supports, hangers, etc.

It shall be paid attention on the fact that pipelines and supports had not any influence on the quality of the threaded connections. Other informations are included in the catalogues of Odlewnia Żeliwa S.A. Zawiercie.