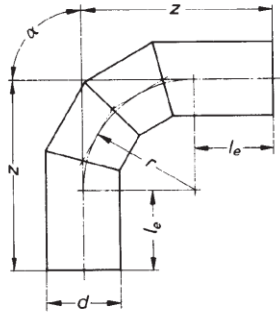


No guarantee can be given in respect of this translation. In all cases the user of this Standard shall be taken as authoritative.	Pipe Joints and Elements for High Density Polyethylene (HDPE) Pressure Pipelines Types 1 and 2 Pipe Bends of Segmental Construction for Butt-welding Dimensions	DIN 16 963 Part 1
	Rohrverbindungen und Rohrleitungsteile für Druckrohrleitungen aus Polyethylen hoher Dichte (HDPE), Typ 1 und 2; in Segmentbauweise hergestellte Rohrbogen für Stumpfschweißung, Masse Dimensions in mm	
Reproduction, even in parts, only with the explicit permission of the DIN Deutsches Institut für Normung e. V., Berlin.	<p>1 Scope</p> <p>This Standard applies to pipe bends of high density polyethylene (HDPE), type 1 and type 2 which are constructed of segments from pipes in accordance with DIN 8074 Part 1 or Part 2, which are butt-welded with a heating element in accordance with DIN 1910 Part 3 or DVS 2207 to pipes of HDPE, type 1 and type 2 in accordance with DIN 8074 Part 1 or Part 2.</p> <p>The pipe bends must conform to the requirements of DIN 16 963 Part 5 or Part 25 *).</p> <p>For technical reasons the pipe bends may only be welded to pipes of the same series in accordance with DIN 8074 Part 1 or Part 2. Deviation from this requirement is allowed if the wall thicknesses are equal in the welding zone.</p> <p><i>Note:</i> Instead of the designation "Hard Polyethylene (hard PE)", the designation "High density polyethylene (HDPE)" was adopted in accordance with DIN 7728 Part 1, April 1978 edition.</p> <p>The previously used short designation "Hard Polyethylene (hard PE)" may, however, continue to be used during the transitional period (e.g. the service life of the stamping tools for marking pipes and pipe elements).</p> <p>2 Other relevant Standards</p> <p>DIN 1910 Part 3 Welding; welding of plastics, methods</p> <p>DIN 8074 Part 1 Hard polyethylene (hard PE) pipes; type 1, dimensions</p> <p>DIN 8074 Part 2 High density polyethylene (HDPE) pipes; type 2, dimensions</p> <p>DIN 16963 Part 5 Pipe joints and elements of hard polyethylene (hard PE) for pressure pipelines; type 1, general quality requirements, testing</p> <p>DIN 16963 Part 25 (at present still in draft form) Pipe joints and elements of high density polyethylene (HDPE) for pressure pipelines; type 2, general quality requirements, testing</p> <p>*) At present still in draft form</p>	
Translation: Translation Help to Exporters Service of ISI	Continued on pages 2 and 3	

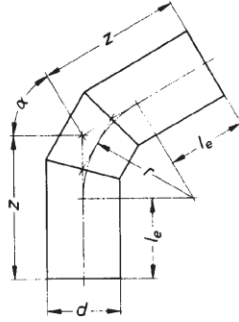
3 Dimensions, designation

The pipe bends do not have to conform to the illustrations; only the specified dimensions must be adhered to.

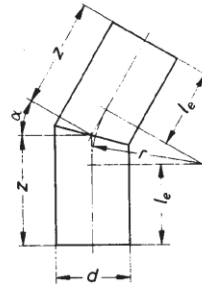
Pipe bend B1
90° bend



60° + 45° bend



20° bend



Designation of a segmentally welded pipe bend B1 having an angle of 45° and external pipe diameter $d = 140$ mm of pipes of series 3 and type 2:

Bend DIN 16 963 – B1 – 45 – 140 – 3 – 2

d	l _e min.	r ¹⁾	α ± 2°			
			90° z min.	60° z min.	45° z min.	30° z min.
110	150	165	315	245	218	194
125		188	338	258	228	200
140		210	360	271	237	206
160		240	390	288	249	214
180		270	420	305	262	222
200		300	450	323	274	230
225		338	488	345	290	241
250	250	375	625	466	412	350
280		420	670	492	424	362
315	300	473	773	576	498	428
355		533	833	608	520	443
400		600	900	646	548	461
450		675	975	689	580	481
500	350	750	1100	783	665	551
560		840	1190	835	698	575
630		945	1295	896	741	603
710		1065	1415	965	792	636
800		1200	1550	1043	847	672
900	400	1350	1750	1179	960	762
1000		1500	1900	1266	1022	802

1) $r = 1,5 d$

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