

Pipe Joints and Pipe Fittings
for Pipes under Pressure made of Unplasticized
Polyvinyl Chloride (Rigid PVC)
Bends Made by Injection Moulding for Bonding
Dimensions

DIN
8063
Part 2

Rohrverbindungen und Rohrleitungsteile für Druckrohrleitungen aus weichmacherfreiem Polyvinylchlorid (PVC hart);
Bogen aus Spritzguss für Klebung; Masse

Dimensions in mm

1 Scope

This Standard applies to bends made of unplasticized polyvinyl chloride (rigid PVC) which, in the form of injection moulded 1) bonding fittings, are bonded by means of a suitable adhesive 2) to pipes of unplasticized PVC of pipe series 4 of DIN 8062 and which meet the requirements of DIN 8063 Part 5.

2 Other relevant Standards

DIN 8062 Pipes of unplasticized PVC (rigid polyvinyl chloride); dimensions

DIN 8063 Part 5 Pipe joints and pipe fittings for pipes under pressure of unplasticized polyvinyl chloride (rigid PVC); general quality requirements, testing

3 Dimensions, designation

It is not essential that the fittings conform to the pictorial representation, only the dimensions specified are to be adhered to.

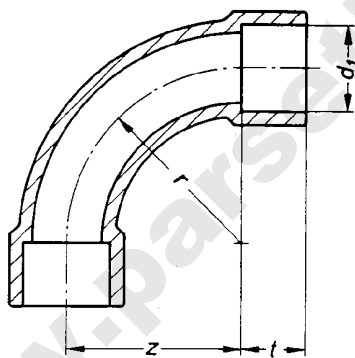
Permissible angular deviation: $\pm 2^\circ$.

Bend 90°

For bonding with a highly solvent adhesive

Type B Bend of $r = 2 d_1$

Type BK Short bend of $r = 0.75 d_1$



Designation of a bend of Type B for a pipe of external diameter $d = 25$ mm:

Bend DIN 8063 – B 25

External pipe diameter d according to DIN 8062	Mean socket diameter d_1		Socket length t	z		
		Allowances ⁴⁾		Type B	Type BK	Perm. dev.
6	6		12	12	—	± 1
8	8		12	16	—	± 1
10	10		12	20	—	± 1
12	12		12	24	—	± 1
16	16		14	32	—	± 1
20	20		16	40	—	± 1
25	25	+0.3 +0.1	19	50	—	+1.2 -1
32	32		22	64	—	+1.6 -1
40	40		26	80	—	+2 -1
50	50		31	100	—	+2.5 -1
63	63		38	126	—	+3.2 -1
75	75		44	150	—	+4 -1
90	90		51	180	—	+5 -1
110	110	+0.4 +0.1	61	220	—	+6 -1
140	140	+0.5 +0.2	76	280	—	+7 -1
160	160	+0.5 +0.2	86	320	—	+8 -1
225	225	+0.6 +0.3	119	—	168	+9 -1

³⁾ The mean socket diameter is determined as the arithmetical mean of two socket diameters perpendicular to each other at the midpoint of the socket depth.

⁴⁾ The allowances quoted are valid for bonding with a highly solvent adhesive; for external pipe diameters of 12 to 160 mm, they correspond to those of Type B of ISO 727 – 1979.

⁵⁾ Socket length $t = 0.5 d_1 + 6$ mm, but with a minimum of 12 mm, in conformity with ISO 727 – 1979.

1) For definition of injection moulding, see DIN 16 700

2) For definition of adhesive, see DIN 16 921

Continued on page 2
Explanations on page 2

Further Standards

- DIN 8061 Part 1 Pipes of unplasticized polyvinyl chloride (rigid PVC); general quality requirements, test
- DIN 8061 Part 2 Pipes of unplasticized polyvinyl chloride, especially impact-proof (HIPVC); general quality requirements, testing
- DIN 8063 Part 1 Pipe joints and pipe fittings for pipes under pressure of unplasticized polyvinyl chloride (rigid PVC); socket and double socket bends of unplasticized PVC pipe, dimensions
- DIN 8063 Part 3 Pipe joints and pipe fittings for pipes under pressure of unplasticized polyvinyl chloride (rigid PVC); screwed pipe joints, dimensions
- DIN 8063 Part 4 Pipe joints and pipe fittings for pipes under pressure of unplasticized polyvinyl chloride (rigid PVC); bushings, flanges, seals, dimensions
- DIN 8063 Part 6 Pipe joints and pipe fittings for pipes under pressure of unplasticized polyvinyl chloride (rigid PVC); injection moulded elbows for bonding, dimensions
- DIN 8063 Part 7 Pipe joints and pipe fittings for pipes under pressure of unplasticized polyvinyl chloride (rigid PVC); injection moulded tees and branches for bonding, dimensions
- DIN 8063 Part 8 Pipe joints and pipe fittings for pipes under pressure of unplasticized polyvinyl chloride (rigid PVC); injection moulded sockets, caps and nipples for bonding, dimensions
- DIN 8063 Part 9 Pipe joints and pipe fittings for pipes under pressure of unplasticized polyvinyl chloride (rigid PVC); injection moulded reducers for bonding, dimensions
- DIN 8063 Part 10 Pipe joints and pipe fittings for pipes under pressure of unplasticized polyvinyl chloride (rigid PVC); wall discs, dimensions
- DIN 8063 Part 11 Pipe joints and pipe fittings for pipes under pressure of unplasticized polyvinyl chloride (rigid PVC); sockets with primary element of copper-zinc alloy (brass) for bonding, dimensions

Explanations

This Standard has been prepared by Sub-Committee 504.4 „Plastic Fittings for Pipes of Thermoplastics“ of the Normenausschuss Kunststoffe (Standards Committee Plastics) (FNK). Revision was necessary in order to give effect to a number of roundings of the dimensions of socket lengths to whole mm and to meet the wishes of the market for an extension of the Standard to include the external pipe diameter $d = 225$ mm.

Because of the limitations of injection moulding techniques in regard to piece weight and machine size, dimensioning with $r = 2 d_1$ could not be extended to this size. For this reason, what is known as a short bend of $r = 0.75 d_1$ has been introduced into the Standard.

As this Standard is a Basic Standard, no further steps have been taken to allot nominal widths to the external diameters of pipes.