

Corrugated Duct

Technical Data Sheet

I. Manufacturer / Supplier

GM Plast A/S
Plutovej 7
DK-8722 Hedensted

Tel. +45 75 89 22 99 Fax +45 75 89 29 30

II. Definition

This technical specification is valid for PE twin-wall cable protection pipes according to EN 61386-24 (latest edition)

- bars dimension from DN 50 up to DN 200
- coils dimension from DN 40 up to DN 175

III. Technical Data

1. fulfillment of standard

The pipes meet all requirements of standard EN 61386-24.	
<hr style="width: 20px; margin-left: 0;"/>	
bars:	
ring stiffness:	requirements for at least „type 450“ are fulfilled
impact test:	requirements for „light version“ are fulfilled
<hr style="width: 20px; margin-left: 0;"/>	
coils:	
ring stiffness:	requirements for at least “type 450” are fulfilled
impact test:	requirements for „normal version“ are fulfilled.
2. material

Polyethylene according to EN 50086 is used exclusively.

The standard version of the pipes is made with an inside layer of PE-HD/bars resp. PE-LD/coils and an outside layer of PE-HD/both bars and coils.
3. colouring

inside layer:	black, approximately RAL9011
outside layer:	black, approximately RAL9011 red, approximately RAL3020 blue, approximately RAL 5015
4. UV-stability

twin-wall pipes meet the requirements of this technical specification as to stiffness and colouring also after outside storage with central european solar radiation as mentioned below

black pipes:	at least 2 years for stiffness and colour
coloured pipes:	at least 1 year for stiffness light bleaching of the colours possible
5. dimensions

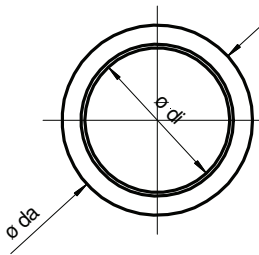
The values mentioned in the charts 1 and 2 are valid for the dimensions and tolerances of the items.

Corrugated Duct

Technical Data Sheet

chart 1: dimensions and bending radius / bars

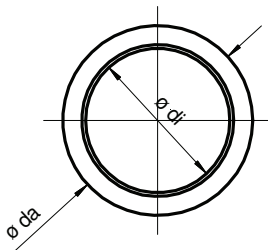
bars



DN	$\varnothing d_i$ [mm]	$\varnothing d_a$ [mm]	ovality [mm]	Bending radius at -5 °C [m]	Bending radius at 23 °C [m]
50	39 ^{+1,5}	50 ^{+1,0}	1)	2,5	2,5
63	50 ^{+1,2}	63 ^{+1,2}	1)	3,0	3,0
75	61 ^{+1,5}	75 ^{+1,4}	1)	3,0	3,0
90	74 ^{+2,0}	90 ^{+1,7}	1)	3,5	3,5
110	93 ^{+2,0}	110 ^{+2,0}	1)	4,0	4,0
120	100 ^{+2,0}	120 ^{+0,5/-0,5}	1)	4,0	4,0
125	107 ^{+2,0}	125 ^{+2,3}	1)	6,0	6,0
160	138 ^{+2,5}	160 ^{+2,3}	1)	8,0	8,0
175	150 ^{+2,5}	175 ^{+1,8/-1,0}	1)	8,0	8,0
200	173 ^{+2,5}	200 ^{+3,6}	1)	15,0	15,0

chart 2: dimensions and bending radius / coils

coils



DN	$\varnothing d_i$ [mm]	$\varnothing d_a$ [mm]	ovality [mm]	Bending radius at -5 °C	Bending radius at 23 °C [m]
40	30 ^{+2,0}	40 ^{+0,8}	1)	0,35	0,35
50	40 ^{+2,0}	50 ^{+1,0}	1)	0,35	0,35
63	50 ^{+2,0}	63 ^{+1,2}	1)	0,35	0,35
75	60 ^{+2,0}	75 ^{+1,4}	1)	0,35	0,35
90	74 ^{+2,0}	90 ^{+1,7}	1)	0,40	0,40
110	93 ^{+2,0}	110 ^{+2,0}	1)	0,40	0,40
120	102 ^{+2,0}	120 ^{+0,5/-0,5}	1)	0,50	0,50
125	105 ^{+2,5}	125 ^{+2,3}	1)	0,50	0,50
160	137 ^{+2,5}	160 ^{+2,3}	1)	0,65	0,65
175	150 ^{+2,5}	175 ^{+1,8/-1,0}	1)	0,70	0,70

1) ovality at least 95 % of the inside diameter stated of unrolled coils resp. after having taken it from the pallet (subject to correct storage)

bars



coils



Corrugated Duct

Technical Data Sheet

IV. Packaging / Marking / Storing

bars

Usually the bars are delivered on pallets (wooden crates) according to the following chart 3. The standard version – sand tight without profile seal – is supplied with a double connection sleeve mounted on.

If required the pipes can be delivered in water tight version. The water tightness of the connection up to 0,5 bar according to DIN EN 16961 is achieved by mounting one profile seal and afterwards the coupler on the bar.

chart 3: packaging bars

KSR twin wall pipe DN	50	63	75	90	110	120	125	160	175	200
Number of 6 m-bars per pallet	195	104	163	108	125	102	48	33	45	20
Dimension of pallet	B [mm]	6050	6060	6090	6100	6100	6100	6130	6150	6170
	H [mm]	630	670	900	780	1350	1330	720	780	1290
	T [mm]	920	820	1070	1220	1110	1190	1150	1220	1170

coils

Usually delivered in **50 m-coils** as per chart 4. Each coil is manufactured with a draw-in aid. During transportation the draw-in aid has to be protected.

A double connection sleeve is mounted on each 50m-coil, sand tight connection. If desired the pipes can be supplied with water tight connection. For this purpose a profile seal is mounted on both ends of the coils followed by the double connection sleeve. This leads to a tightness of the connection up to 0,5 bar according to standard DIN 16961.

chart 4: packaging coils

KSR twin-wall pipe DN	40	50	63	75	90	110	120	125	160	175
Inside diameter of coil	560	600	600	610	700	760	800	810	850	850
Outside diameter of coil	900	950	900	1100	1250	1550	1450	1600	1950	2000
Height of coil	300	370	500	450	650	500	650	700	750	800

Corrugated Duct

Technical Data Sheet

The pipes are marked as follows:

type of pipe
PE-HD resp. PE-HD/PE-LD
DN ...
EN 50086-2-4 *N 450
Quarter of production / year of production
+ (country-specific data)

Labels with the following text are necessarily to be fixed on each coil resp. pallet:

DN ...
content
item number
order number

V. Miscellaneous

1. **sampling / release**

Sampling only on explicit customer's request.

2. **test certificates**

Test certificates are only generated on request based on the required standard (EN 10204, ...). They are either attached directly to the delivery or sent to the delivery address (via mail or e-mail) in advance.