



Appendices
Appendix H - Special Information on Fabricated Fittings

Except for fittings produced to ASTM F1866, Spears® Fabricated Fittings conform to Spears® Manufacturing Company Special Engineering Specifications.

Not all of the Fabricated Fittings listed in this price schedule are carried in Spears® Distribution Center inventories. When ordering Fabricated Fittings, please check your servicing Distribution Center for availability. ALL ORDERS FOR NON-STOCKED Fabricated Fittings are NON-CANCELABLE and NON-RETURNABLE.

18" and larger Fabricated Fittings are available upon request. Please contact your servicing Spears® Regional Distribution Center for pricing and availability.

All 15" Fabricated Fittings shown as Class 63 are PIP O.D. Reducing fittings are 15" PIP O.D. x specified IPS size. Plastic Irrigation Pipe (PIP) and Iron Pipe Size (IPS) are not the same.

Pipe Dimension Reference Chart

Pipe Type O.D. Size SDR	LH PIP 91	80 PIP 51	100 PIP 41	125 PIP 32.5	CL 63 IPS 64	CL 100 IPS 41	SEWER PSM 35	CL 125 IPS 32.5	CL 160 IPS 26	CL 200 IPS 21	40 DWV IPS —	80 DWV IPS —	SCH 40 IPS —	SCH 80 IPS —	C-900 CI DR 18	
4"	O.D.	4.130	4.130	4.130	4.130	4.500	4.500	4.215	4.500	4.500	4.500	4.500	4.500	4.500	4.500	4.800
	I.D.	4.000	3.968	3.928	3.876	4.360	4.280	3.89	4.224	4.154	4.072	3.998	3.786	3.998	3.786	4.22
	Wall PSI	.065 43	.081 80	.101 100	.127 125	.070 63	.110 100	0.125 117.5	.138 125	.173 160	.214 200	.237 100	.337 100	.237 220	.337 320	.267 150
6"	O.D.	6.140	6.140	6.140	6.140	6.625	6.625	6.275	6.625	6.625	6.625	6.625	6.625	6.625	6.625	6.900
	I.D.	6.000	5.898	5.840	5.762	6.417	6.301	5.742	6.217	6.115	5.993	6.031	5.709	6.031	5.709	6.08
	Wall PSI	.070 43	.121 80	.150 100	.189 125	.104 63	.162 100	0.18 117.5	.204 125	.255 160	.316 200	.280 100	.432 100	.280 180	.432 280	.383 150
8"	O.D.	8.160	8.160	8.160	8.160	8.625	8.625	8.4	8.625	8.625	8.625	8.625	8.625	8.625	8.625	9.050
	I.D.	7.984	7.840	7.762	7.658	8.355	8.205	7.665	8.095	7.961	7.805	7.943	7.565	7.943	7.565	7.97
	Wall PSI	.088 43	.160 80	.199 100	.251 125	.135 63	.210 100	0.24 117.5	.265 125	.332 160	.410 200	.322 100	.500 100	.322 160	.500 250	.503 150
10"	O.D.	10.200	10.200	10.200	10.200	10.750	10.750	10.5	10.750	10.750	10.750	10.750	10.750	10.750	10.750	11.100
	I.D.	9.980	9.800	9.702	9.572	10.414	10.226	9.563	10.088	9.924	9.748	9.976	9.492	9.976	9.492	9.78
	Wall PSI	.110 43	.200 80	.249 100	.314 125	.168 63	.262 100	0.3 117.5	.331 125	.413 160	.511 200	.365 100	.593 100	.365 140	.593 230	.617 150
12"	O.D.	12.240	12.240	12.240	12.240	12.750	12.750	12.5	12.750	12.750	12.750	12.750	12.750	12.750	12.750	13.200
	I.D.	11.975	11.760	11.642	11.486	12.352	12.128	11.361	11.966	11.770	11.538	11.890	11.294	11.890	11.294	11.63
	Wall PSI	.132 43	.240 80	.299 100	.377 125	.199 63	.311 100	0.36 117.5	.392 125	.490 160	.606 200	.406 100	.687 100	.406 130	.687 230	.733 150
14"	O.D.	14.280	14.280	14.280	14.280	*	*	*	*	14	14.000	14.000	14.000	14.000	15.3	
	I.D.	14.000	13.720	13.584	13.402	*	*	*	*	12.86	13.072	12.410	13.072	12.410	13.48	
	Wall PSI	.140 43	.280 80	.348 100	.439 125	*	*	*	*	0.538 160	.438 100	.750 100	.438 130	.750 220	0.85 235	
15"	O.D.	15.300	15.300	15.300	15.300	*	*	15.3	*	*	*	*	*	*	*	
	I.D.	14.970	14.700	14.550	14.358	*	*	13.898	*	*	*	*	*	*	*	
	Wall PSI	.165 43	.300 80	.375 100	.471 125	*	*	0.44 117.5	*	*	*	*	*	*	*	
16"	O.D.	*	*	*	*	*	*	*	16	16.000	16.000	16.000	16.000	16.000	17.4	
	I.D.	*	*	*	*	*	*	*	14.696	14.940	14.214	14.940	14.214	15.33		
	Wall PSI	*	*	*	*	*	*	*	0.615 160	.500 100	.843 100	.500 130	.843 220	0.967 235		
18"	O.D.	18.360	18.701	18.701	18.701	*	18.000	18.701	18.000	18.000	18	18.000	18	18.000	19.5	
	I.D.	17.964	17.967	17.789	17.551	*	17.122	17.629	16.616	16.616	16.808	16.014	16.808	16.014	17.83	
	Wall PSI	.198 43	.367 80	.456 100	.575 125	*	.439 100	0.536 117.5	.692 160	.562 100	.937 100	.582 120	.937 220	1.083 235		
20"	O.D.	20.400	*	*	*	*	20.000	*	20.000	20.000	20	20	20	20	21.6	
	I.D.	19.962	*	*	*	*	19.026	*	18.462	18.863	17.814	18.863	17.614	18.863	19.03	
	Wall PSI	.219 43	*	*	*	*	.487 100	*	.769 160	.533 100	1.031 100	.533 120	1.031 220	1.2 235		
21"	O.D.	*	22.047	22.047	22.047	*	*	22.047	*	*	*	*	*	*	*	
	I.D.	*	21.183	20.971	20.691	*	*	20.783	*	*	*	*	*	*	*	
	Wall PSI	*	.432 80	.538 100	.678 125	*	*	0.632 117.5	*	*	*	*	*	*	*	
24"	O.D.	*	24.803	24.803	24.803	*	24.000	24.8	24	24	24	24	24	24	25.800	
	I.D.	*	23.831	23.593	23.277	*	22.748	23.381	22.043	22.043	22.54	21.418	22.54	21.418	23.73	
	Wall PSI	*	.486 80	.605 100	.763 125	*	.585 100	0.711 117.5	.923 160	.687 100	1.218 100	0.687 120	1.218 210	1.200 235		

* Information Not Available

Suitable for Oil-Free air handling to 25 psi, not for distribution of compressed air or gas

JJ DOWNS INDUSTRIAL PLASTICS INC.

416.236.1884 Toronto, ON JJDOWNNS.COM

GASKET INSTALLATION PROCEDURES

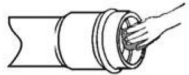


Figure 1



Figure 2



Figure 3

1. Gasket area and pipe or spigot end should be clean and free of dirt and debris. **DO NOT** attempt to remove the formed-in gasket — **Figure 1**.
2. Lubricate the entire sealing surface of the gasket and the pipe or spigot end with a light coating of a suitable lubricant. Make sure the pipe or spigot end has a proper bevel to insure ease of installation — **Figure 2**.
3. Push the pipe or spigot end into the gasket bell while maintaining a straight alignment. The proper insertion depth is equal to the total gasket bell length minus one-half inch (1/2") — **Figure 3**.

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