**Annexure – ‘B’**

**Technical Specification of** HDPE 160 mm dia Pipe of PE-80 PN-4 Class.

1. SCOPE –

Manufacturing Testing and Supply of HDPE 160 mm dia Pipe of PE-80 PN-4 Class as per IS:4984 1995 (latest amendment) for under-ground of 11 KV and 33KV Cable protection laying by HDD methodology. Color coding as per Electrical code for HT Cable.

1. Applicable Standards:

All manufacturing and testing of HDPE pipe shall be in accordance to IS4985/1995,

1. Dimension

Outside Diameter

The outside diameters of pipes, tolerance on the same and ovality of pipe shall confirms to Table 2 in IS4984/1995.

Wall Thickness

The minimum and maximum wall thickness of pipes for the PE-80 grade shall confirms to Table 4 in IS4984/1995.

1. Length of Straight Pipe

The length of straight pipe shall be 5 m to 20 m, as agreed between the manufacturer and the purchaser.Short lengths of 3 metre ( Min ) up to a maximum of10% of the total supply may be permitted.

1. Coiling

The pipes supplied k coils shall be coiled on drums of minimum diameter of 25 times the nominal diameter of the pipe ensuring that kinking of pipe is prevented.

1. VISUAL APPEARANCE

The internal and external surfaces of the pipes shall be smooth, clean and free from grooving and other defects. The cuds shall be cleanly cut and shall be square with axis of the pipes. Slight shallow longitudinal grooves or irregularities in the wall thickness shall be permissible,

provided that the wall thickness remains within the permissible limits.

1. MARKING

Each straight length of pipe shall be clearly marked in indelible ink/painted on either end and

for coil at both ends or hot embossed on white base every meter through out the length of pipe/coil with the following information

a) Manufacturer’s name/trade-mark,

b) Designation of pipe

c) Lot number/Batch number.

d) BIS Certification Marking/Standard Mark