

**ACP**

AUSTRALIAN CUSTOM PIPES

PLASTIC PIPE • FABRICATION • MOULDING SPECIALIST

ACP PE COMMUNICATIONS CONDUIT**1. Scope**

This specification applies to the manufacture of PE communication conduits.

2. Marking

(M/MARK) ACP AUSTRALIAN CUSTOM PIPES (SIZE) (CLASS)(SDR) PE COMMUNICATION PIPE
(DATE OF MANUFACTURE) ACPF1

3. Material

Colour	Supplier	Virgin Grade	Reprocessed Material
Black or Black with white stripes or White	Various	PE	Up to 100% inhouse regrind

4. Packaging

Length to be crated in wooden frame

Pipes can be supplied on drum or free standing coils

Coil sizes:

Size (mm)	Coil Length (m)	Coil ID (mm)	Coil Width (mm)	Coil OD (mm)
25	600	1000	320	1700
32	600	1360	450	2000
32	250	800	320	1400
63	100	1260	350	1900
63	140	1575	350	2300
63	500	1600	600	2750
110	100	2000	450	3000
140	100	2200	540	3250

Note 1: 63mm x100m coils are made to nest inside 110mm coils for transport.

Note 2: 32mm x 600m coils are made to nest inside 110mm coils for transport.

5. Inspection and Test Requirements

Requirement	Test Method	Minimum Frequency
Dimensions	In line	Hourly
Hydrostatistic Pressure Test	800kPa, 60 minutes	Once per run



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6. Dimensional Requirements

Nom OD	Outside Diameter		Ovality 3%	Class 6			Class 9		
				Wall Thickness		W/F kg/100m	Wall Thickness		W/F kg/100m
	Min	Max		Min	Max		Min	Max	
32	32.0	32.3	0.96	1.9	2.2	18.6	2.7	3.1	25.6
40	40.0	40.4	1.20	2.3	2.7	28.5	3.4	3.9	40.3
50	50.0	50.4	1.50	2.9	3.3	44.1	4.2	4.8	62.1
63	63.0	63.5	1.89	3.6	4.1	69.0	5.3	6.0	98.2
75	75.0	75.6	2.25	4.3	4.9	98.1	6.3	7.1	138.7
90	90.0	90.8	2.70	5.2	5.9	142.1	7.5	8.4	197.8
110	110.0	110.9	3.30	6.3	7.1	209.8	9.2	10.3	296.3
125	125.0	126.0	3.75	7.2	8.1	272.0	10.4	11.6	380.1
140	140.0	141.2	4.20	8.0	8.9	336.9	11.7	13.0	477.9

*note ovality is measured prior to coiling

Dimensions in mm to old AS1159 Standard

OR

Nom. OD	Outside Diameter		Ovality	SDR13.6 PN10		
				Wall Thickness		W/F kg/100m
	Min	Max		Min	Max	
25	25.0	25.3	0.75	1.9	2.2	14.3
32	32.0	32.3	0.96	2.4	2.8	22.8
40	40.0	40.4	1.20	3.0	3.4	35.2
50	50.0	50.5	1.50	3.7	4.2	54.3
63	63.0	63.6	1.89	4.7	5.3	86.6
75	75.0	75.7	2.25	5.5	6.2	120.8
90	90.0	90.9	2.70	6.6	7.4	173.5
110	110.0	111.0	3.30	8.1	9.1	260.3
125	125.0	126.2	3.75	9.2	10.3	335.5
140	140.0	141.3	4.20	10.3	11.5	420.1
180	180.0	181.7	3.60	13.3	14.8	706.8

*note ovality is measured prior to coiling

Dimensions to AS4130

7. Special Instructions

Note:

32mm on drums approx length 2200-3000m depending on drum

One break per drum acceptable as long it is over 1000m and marked on side of drum