

TECHNICAL SPECIFICATION FOR HARD LINED MSRL PIPES

MS Pipe	: Confirming to IS 1239 Part – I 1973, Medium duty
Pipe Make	: TATA, JINDAL, NEZONE, UTKARSH
Flange Thickness	: 16 mm drilled to ANSI B 16.5 Class 150 Tolerance in overall length including rubber lining +0.00 mm - 5.00 mm Flanges should be parallel and holes should be collinear
Rubber Lining	: Confirming to IS 4682, Vulcanization should be done in autoclave, joints should be overlapped with bevel joints and lining should be done with calendared sheet
Properties of Rubber	: HARD NATURAL RUBBER Rubber lining thickness – 4.5 mm Hardness : Shore D 60 \pm 5° Sp. Gr. : 1.0 to 1.2 Ash Content : 7 % Max Adhesion : 3.6 kg/cm as per IS : 3400 Part V
Test Report	: Test reports of above mentioned properties of rubber should be provided alongwith each supply. High frequency spark test should be carried out for checking continuity of lining.
Painting	: Pipes should be painted externally including flanges with one coat of Red Oxide Zinc Chromate Primer & two coats of synthetic enamel golden yellow paint of 1 st quality – “BERGER “ MAKE
Inspection	: 1) Final Inspection shall be done at our site 2) It include fabrication of pipes, Hydraulic Pressure testing, Properties of rubber, rubber lining quality by spark testing, visual
Guarantee	: The MSRL Pipes shall be guaranteed for a period of 12 months from the date of receipt against failure of Rubber lining / MS Pipes.

