

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ADDENDUM 1 TO ISO RECOMMENDATION R 531-1966

CAST IRON SANITARY PIPE FITTINGS
FOR WASTE WATER AND VENTILATION

PART IV
FITTINGS

1st EDITION

June 1970

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BRIEF HISTORY

The ISO Recommendation R 531-1966, *Cast iron sanitary pipes and fittings for waste water and ventilation*, was drawn up by Technical Committee ISO/TC 5, *Pipes and fittings*, the Secretariat of which is held by the Association Suisse de Normalisation (SNV).

Work on this question led to the adoption of Draft ISO Recommendation No. 743, which was circulated to all the ISO Member Bodies for enquiry in November 1964. It was approved by 22 Member Bodies; five Member Bodies opposed the approval of the Draft (Germany, Netherlands, Norway, Switzerland and the U.S.A.).

This Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in December 1966, to accept it as an ISO RECOMMENDATION.

BRIEF HISTORY RELATING TO ADDENDUM 1

The work which led to the publication of ISO Recommendation R 531-1966 was continued and an addendum to that ISO Recommendation was drawn up in the form of a Draft ISO Recommendation. This Draft (No. 1670), after having been adopted by the Technical Committee, was circulated to all the ISO Member Bodies for enquiry in September 1968. It was approved, subject to a few modifications of an editorial nature, by the following Member Bodies :

Australia	Greece	Poland
Austria	Hungary	Spain
Belgium	India	Thailand
Canada	Israel	Turkey
Denmark	Italy	U.A.R.
France	Korea, Rep. of	

The following Member Bodies opposed the approval of the Draft :

Czechoslovakia	Sweden
Netherlands	Switzerland
Norway	United Kingdom

This Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided to accept it as Addendum 1 to ISO Recommendation R 531-1966.

FOREWORD

ISO Recommendation R 531, *Cast iron sanitary pipes and fittings for waste water and ventilation*, consists of three parts as follows :

- I Technical specification
- II Spigot and socket dimensions for pipes and fittings
- III Pipes and short connecting pipes

This Addendum forms Part IV of ISO Recommendation R 531-1966, namely :

- IV Fittings.

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CAST IRON SANITARY PIPE FITTINGS FOR WASTE WATER AND VENTILATION

PART IV FITTINGS

1. SCOPE

This addendum to ISO Recommendation R 531-1966, *Cast iron sanitary pipes and fittings for waste water and ventilation*, applies to cast iron fittings used in the building industry for the laying of waste water and ventilation pipes, and has the object of

- reducing the dimensions of the castings (lengths b and L) and thus facilitating casting;
- limiting the number of types in order to simplify the manufacture, supply and storage in factories, stores, and on site.

2. GENERAL CHARACTERISTICS OF FITTINGS

The considerations explained in section 1, together with the study of the provisions adopted by the various countries, have led to the adoption of the following rules which rationally connect the various fitting types.

2.1 Bends and single branches

The slope of oblique pipeline portions has been fixed at 45° , $67^\circ 30'$ and $87^\circ 30'$. The same values have been ascribed to the angle of the bends and to the inclination of the branch pipes.

2.2 Double branches

Double branches, which are used far less than single branches, are provided for exclusively with the most common branch inclination : $67^\circ 30'$.

2.3 S fitting

The spacing between the S branches has been fixed at 75 or 150 mm, the larger spacing being obtained through the combination of two bend pipes connected, if necessary, by a short pipe.

2.4 Thickness of fittings

The wall thicknesses provided for fittings are equal to those provided for pipes of the same nominal diameters. As an exception to the above, fittings with orifices of different diameters have a uniform thickness, equal to the thickness corresponding to the nominal diameter of the largest orifice.

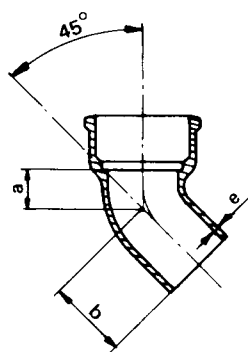
2.5 Change of diameters

A series of branch pipe fittings has been provided for in order to ensure the junction of the main and branch pipes.

3. DIMENSIONS, MASSES AND SYMBOLS

3.1 45° bends

Symbol :



Dimensions in millimetres

Nominal diameter <i>DN</i>	<i>e</i>	<i>a</i>	<i>b</i>	Mass (approx.) kg
50	3.5	41	94	1.4
75	3.5	47	104	2.1
100	4	53	114	3.3
150	5	65	129	6.5

NOTE. — For spigot and socket dimensions, see Table J 1 of ISO Recommendation R 531, *Cast iron sanitary pipes and fittings for waste water and ventilation*.