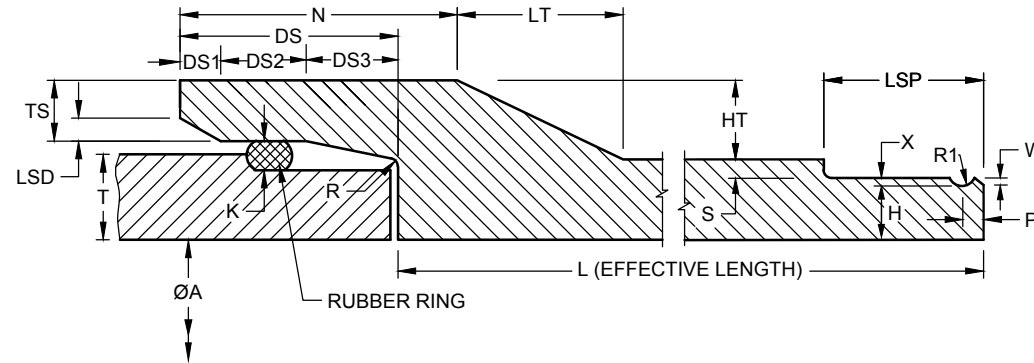


**Table 14 Spigot and Socket Dimensions of NP3 and NP4 Class Pipes  
(Rubber Ring Roll on Joint) from 80 to 900 mm Diameter  
( Clauses 6.3 and 8.2 )**



All dimensions in millimetres

Pipe Diameter $\phi A$	Rubber Ring Chord Diameter	Rubber Ring Internal Diameter	T	TS	DS	DS1	DS2	DS3	R	LSD	K	N	LT	HT	LSP	P	S	H	X	W	R1
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)	(10)	(11)	(12)	(13)	(14)	(15)	(16)	(17)	(18)	(19)	(20)	(21)	(22)
80	11	102	25	32.5	70	8	28	34	3	5.5	6.5	95	84	34	50	7	5.5	19.5	1	1	5.5
100	11	120	25	32.5	70	8	28	34	3	5.5	6.5	95	84	34	50	7	5.5	19.5	1	1	5.5
150	11	170	25	32.5	70	8	28	34	3	5.5	6.5	95	84	34	50	7	5.5	19.5	1	1	5.5
200	11	230	30	38	83	11	38	34	5	6.5	6.5	113	97	39.5	50	7	5.5	24.5	1	1	5.5
225	11	255	30	38	83	11	38	34	5	6.5	6.5	113	97	39.5	50	7	5.5	24.5	1	1	5.5
250	11	275	30	38	83	11	38	34	5	6.5	6.5	113	97	39.5	50	7	5.5	24.5	1	1	5.5
300	12	340	40	51	90	12	42	36	6	7	7	130	130	53	55	7.5	6	34	1	1	6
350	16	435	75	75	120	16	56	48	8	10	10	158	135	78	72	10	8	67	2	2	8
400	16	480	75	75	120	16	56	48	8	10	10	158	135	78	72	10	8	67	2	2	8
450	16	525	75	75	120	16	56	48	8	10	10	158	135	78	72	10	8	67	2	2	8
500	16	570	75	75	120	16	56	48	8	10	10	158	135	78	72	10	8	67	2	2	8
600	20	675	85	85	150	20	70	60	10	12	12	193	153	88.5	90	12	10	75	2	2	10
700	20	765	85	85	150	20	70	60	10	12	12	193	153	88.5	90	12	10	75	2	2	10
800	20	875	95	95	150	20	70	60	10	12	12	197	171	98.5	90	12	10	85	2	2	10
900	20	970	100	100	150	20	70	60	10	12	12	200	180	103.5	90	12	10	90	2	2	10

**Table 14 ( Concluded )**

NOTES

**1** Important dimensions of socket and spigot to be checked in socket and spigot pipes.

- a. Socket inside diameter each pipe
- b. Spigot outside diameter each pipe

The procedure for the inspection is given in **10** of IS 3597.

**2** Corners to be rounded off.

**3** Tolerances

Dimensions

T and HT

TS and H

DS2, DS3, LSP, K and S

Tolerances

Same as that of barrel wall thickness given in **8.2**

Half the tolerance on barrel wall thickness given in **8.2**

The tolerance, in mm, shall be given as below:

Chord Diameter	DS2	DS3	LSP	K	S
11	±2.0	±3.0	±4.00	±1.25	±0.75
12	±2.0	±3.0	±4.00	±1.25	±0.75
16	±2.5	±3.5	±5.00	±2.00	±1.25
20	±3.0	±4.0	±5.50	±2.25	±1.50

**4** In order to ascertain the correctness of mould, 5 percent of the pipes be randomly selected from each control unit and checked for all critical dimension.