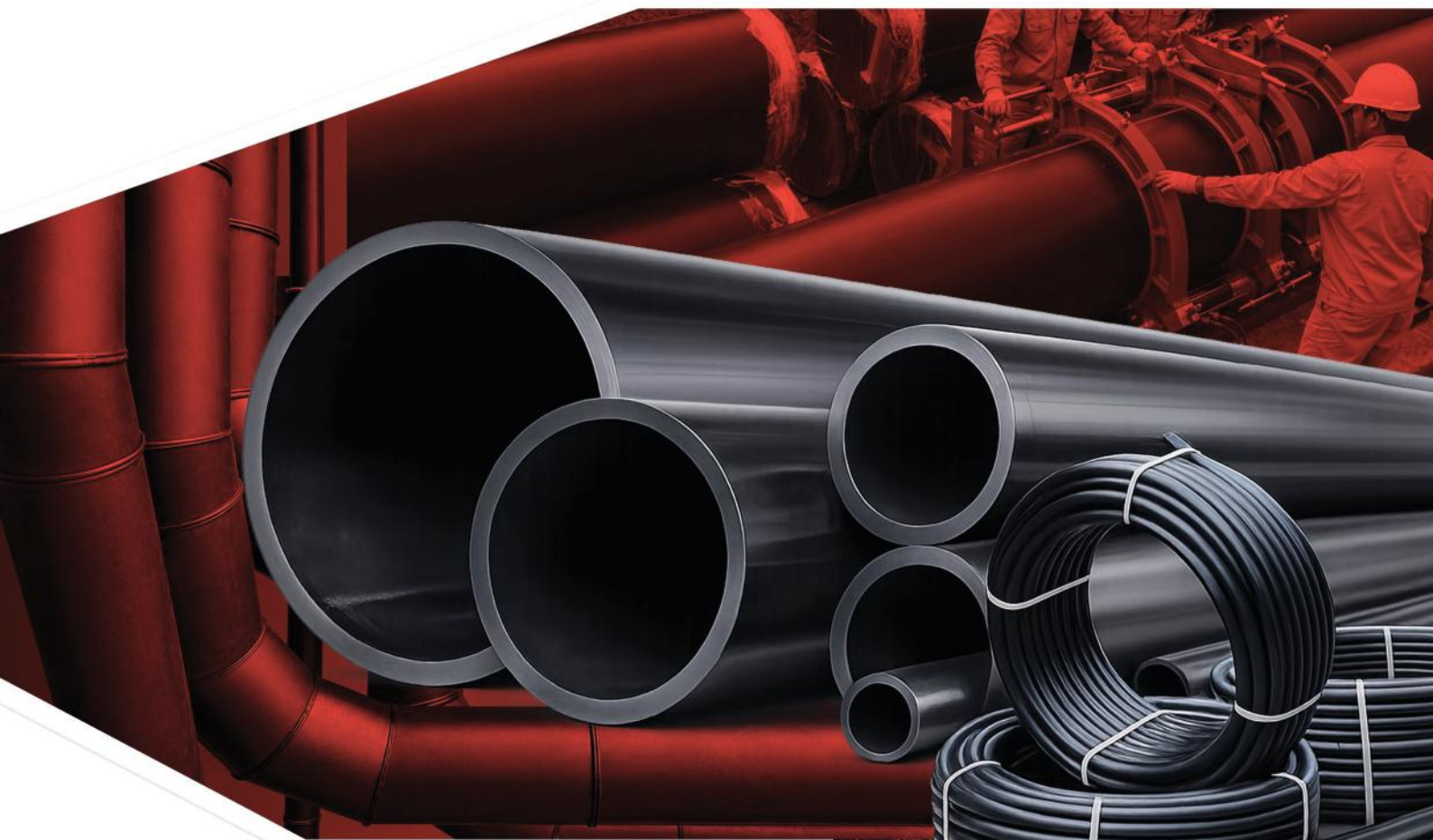




AtlantaHDPE

High Density Polyethylene Pipes & Fittings



Ease of Handling

High Chemical Resistance

Flexible

Lowest Flow Resistance

Tight Joints

Lightweight

Safe for Potable Water & Other Fluids

Impact Resistance



ADVANTAGES

Atlanta HDPE pipe offers a number of engineering advantages over conventional piping materials.



Ease of Handling

Atlanta HDPE pipe weighs considerably less than pipes made from conventional materials. Typically, it is only 1/4 to 1/10 the weight of cast iron, steel or concrete pipes used for the same service. This affords significant savings in transportation and installation by reducing manpower and equipment needs to a minimum.



Lightweight

Can be easily handled and installed because the weight of PE pipe is just 1/7 of steel pipes.



High Chemical Resistance

Atlanta HDPE pipe has replaced steel, stainless steel, cast iron and concrete piping where chemical or corrosion resistance is required. It is resistant to attack by acids, bases, salts and many hydrocarbon materials. In addition, even the most aggressive soil will not corrode Atlanta HDPE piping.



Safe for Potable Water and Other Fluids

Because Atlanta HDPE piping does not contaminate fluid with metallic ions, it is often used in the transportation of pure materials, including deionized water. Atlanta HDPE piping materials also meet with the approval of the Bureau of Product Standards for the transport of potable water.



Impact Resistance

PE pipes doesn't break up to -80°C.



Flexible

Atlanta HDPE pipe is flexible, providing ease of installation. It can be curved, snaked, inserted or laid along natural ground contours, thereby reducing installation costs and equipment requirements.



Abrasion Resistance

Atlanta HDPE pipe has smooth, tough interior surfaces which make it an excellent material for conveying a variety of abrasive slurries.



Lowest Flow Resistance

The smooth interior of this pipe provides for higher flow design factors. The Hazen-Williams water flow coefficient for Atlanta HDPE pipe is 150 to 155, and the Manning "n" value is approximately 0.009. Resistance to scaling and corrosion allows the pipe to maintain its excellent flow properties throughout service life.



Tight Joints

A choice of jointing systems is available depending upon the application and the size of the Atlanta HDPE pipe. These include butt fusion, electrofusion, socket fusion, extrusion welding, mechanical connectors and compression type fittings.

PHYSICAL PROPERTIES



PROPERTY	ASTM TEST	ACTUAL VALUE
Density, g/cm ²	D 1505	0.926
Melt Flow Rate g/10min (max)	ASTM P1238	1.0
Environmental Stress* Cracking Resistance, (Hrs.) Condition A, B & C	D 1693	> 1500
Tensile Strength, Mpa	ISO 6259	23
Toxicity	ISO 3114	Pb - Less than 0.005 mg/L Cd - Less than 0.001 mg/L Hg - Less than 0.0005 mg/L
Modulus of Elasticity, PSI	ASTM D 638	79,190
Carbon Black Thermal Stability (Oxidative Induction Time), min.	ISO 6964 ISO 13949	2.19 +0.25% 82.23
Melt Flow Rate Deviation, +/- 30%	ISO 1133	-6.25%
Elongation at Break, %	ISO 6259	768%

*Testing for this is not requested by ISO 4427

AVAILABLE WITH COLOR STRIPS



Plain Black

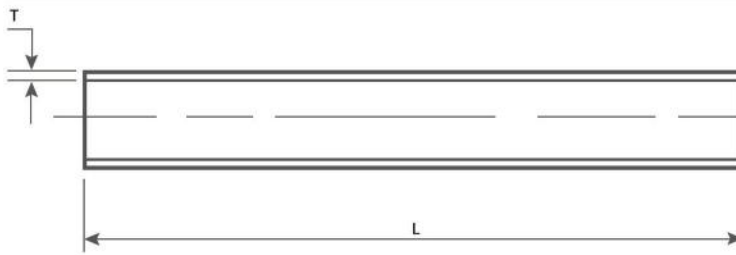


**Black with Blue Strips
for Water Distribution**



**Black with Orange Strips
for Water Drainage**

HDPE PIPE RANGE



APPLICATION: Potable Water Main Distribution and Service Connection System & Industrial Application.

STANDARD: Conforming to ISO R 161/1/ISO 3607 Series, SDR PR based on controlled Outside Diameter and in accordance to PNS ISO 4427-2002.

SIZES: 20mm to 630mm

JOINT METHOD: Butt Fusion, Flange Type, Compression Type, Electrofusion, Socket Fusion, Mechanical Fittings

NOMINAL SIZE	OUTSIDE DIAMETER	STANDARD LENGTH	SDR 9	SDR 11	SDR 13.6	SDR 17	SDR 21	SDR 26
			NOMINAL PRESSURE (PSI)					
			PN 20	PN 16	PN 12.5	PN 10	PN 8	PN 6.3
			290	232	181.25	145	116	87
in	mm	M	Thickness T (mm)	Thickness T (mm)	Thickness T (mm)	Thickness T (mm)	Thickness T (mm)	Thickness T (mm)
1/2	20	300	2.30	*1.90	*1.60	-	-	-
3/4	25	150	2.80	*2.30	*1.90	-	-	-
1	32	100	3.60	3.00	*2.40	*1.90	-	-
1-1/4	40	60	4.50	3.70	*3.00	*2.40	-	-
1-1/2	50	60	5.60	4.60	*3.70	*3.00	-	-
2	63	60	7.10	5.80	4.70	*3.80	-	-
2-1/2	75	60	8.40	6.80	5.60	4.50	-	-
3	90	6	10.10	8.20	6.70	5.40	4.30	**3.50
4	110	6	12.30	10.00	8.10	6.60	5.30	**4.20
6	160	6	17.90	14.60	11.80	9.50	7.70	**6.20
8	225	6	25.20	20.50	16.60	13.40	10.80	**8.60
10	280	6	31.30	25.40	20.60	16.60	13.40	**10.70
12	315	6	35.20	28.60	23.20	18.70	15.00	**12.10
14	355	6	39.70	32.20	26.10	21.10	16.90	**13.60
16	400	6	44.70	36.30	29.40	23.70	19.10	**15.30
18	450	6	50.30	40.90	33.10	26.70	21.50	**17.20
20	500	6	55.80	45.40	36.80	29.70	23.90	**19.10
22	560	6	62.22	50.80	41.20	33.20	**26.70	**21.40
24	630	6	70.00	57.20	46.30	37.40	**30.00	**24.10

Note: All (*) are based on our manufacturing standard.

** Subject for Availability

NEW HDPE LARGE DIAMETER SIZES

28	710	6	-	64.50	52.20	42.10	-	27.20
32	800	6	-	72.60	58.80	47.40	-	30.60
36	900	6	-	81.70	66.20	53.30	-	34.40
40	1000	6	-	90.20	72.50	59.30	-	38.20



Moulded 90° Elbow

NOMINAL SIZE	
mm	in
63	2
75	2-1/2
90	3
110	4
160	6
225	8
280	10
315	12
355	14
400	16



Moulded 45° Elbow

NOMINAL SIZE	
mm	in
63	2
75	2-1/2
90	3
110	4
160	6
225	8
280	10
315	12
355	14



Moulded End Cap

NOMINAL SIZE	
mm	in
63	2
75	2-1/2
90	3
110	4
160	6
225	8
280	10
315	12
355	14
400	16



Moulded Tee

NOMINAL SIZE	
mm	in
63	2
75	2-1/2
90	3
110	4
160	6
225	8
280	10
315	12
355	14
400	16



Moulded Wye

NOMINAL SIZE	
mm	in
63	2
75	2-1/2
90	3
110	4
160	6
225	8
280	10
315	12



Moulded Stub End

NOMINAL SIZE	
mm	in
63	2
75	2-1/2
90	3
110	4
160	6
225	8
280	10
315	12
355	14
400	16
450	18
630	24



Moulded Coupling Reducer

NOMINAL SIZE	
mm	in
75 x 50	2-1/2 x 1-1/2
75 x 63	2-1/2 x 2
90 x 40	3 x 1-1/4
90 x 50	3 x 1-1/2
90 x 63	3 x 2
90 x 75	3 x 2-1/2
110 x 40	4 x 1-1/4
110 x 50	4 x 1-1/2
110 x 63	4 x 2
110 x 75	4 x 2-1/2
110 x 90	4 x 3
160 x 50	6 x 1-1/2

NOMINAL SIZE	
mm	in
160 x 63	6x2
160 x 75	6 x 2-1/2
160 x 90	6x3
160 x 110	6x4
225 x 90	8 x 3
225 x 110	8 x 4
225 x 160	8x6
315 x 110	12 x 4
315 x 160	12x6
315 x 225	12 x 8
450 x 315	18 x 12



Moulded Tee Reducer

NOMINAL SIZE	
mm	in
75 x 50	2-1/2 x 1-1/2
75 x 63	2-1/2 x 2
90 x 40	3 x 1-1/4
90 x 50	3 x 1-1/2
90 x 63	3 x 2
90 x 75	3 x 2-1/2
110 x 40	4 x 1-1/4
110 x 50	4 x 1-1/2
110 x 63	4 x 2
110 x 75	4 x 2-1/2
110 x 90	4 x 3

NOMINAL SIZE	
mm	in
160 x 63	6x2
160 x 75	6 x 2-1/2
160 x 90	6x3
160 x 110	6x4
225 x 90	8 x 3
225 x 110	8 x 4
225 x 160	8x6
315 x 110	12 x 4
315 x 160	12x6
315 x 225	12 x 8
450 x 315	18 x 12



Moulded Wye Reducer

NOMINAL SIZE	
mm	in
110 x 63	4 x 2
110 x 90	4 x 3
160 x 90	6 x 4
315 x 110	12 x 4

FABRICATED - BUTT FUSION SERIES



Fabricated 60° Elbow

NOMINAL SIZE	
mm	in
20	1/2
25	3/4
32	1
40	1-1/4
50	1-1/2
63	2
75	2-1/2
90	3
110	4
160	6
225	8
280	12
315	10
355	14
400	16



Fabricated 90° Elbow

NOMINAL SIZE	
mm	in
20	1/2
25	3/4
32	1
40	1-1/4
50	1-1/2
63	2
75	2-1/2
90	3
110	4
160	6
225	8
280	12
315	10
355	14
400	16



Fabricated End Cap

NOMINAL SIZE	
mm	in
20	1/2
25	3/4
32	1
40	1-1/4
50	1-1/2
63	2
75	2-1/2
90	3
110	4
160	6
225	8
280	12
315	10
355	14
450	16
500	20
560	22
630	24



Fabricated Tee

NOMINAL SIZE	
mm	in
63	2
75	2-1/2
90	3
110	4
160	6
225	8
280	12
315	10
355	14
400	16



Fabricated Wye

NOMINAL SIZE	
mm	in
63	2
75	2-1/2
90	3
110	4
160	6
225	8
280	12
315	10
355	14
400	16



Fabricated Cross Tee Reducer

NOMINAL SIZE	
mm	in
110 x 75	4 x 2-1/2
110 x 90	4 x 3
160 x 110	6x4
225 x 160	8x6
280 x 160	10x6
280 x 225	10 x 8
315 x 225	12 x 8
315 x 280	12 x 10
355 x 280	14 x 10
355 x 315	14 x 12
400 x 315	16 x 12
400 x 355	16 x 14



Fabricated Tee Reducer

NOMINAL SIZE	
mm	in
110 x 75	4 x 2-1/2
110 x 90	4 x 3
160 x 110	6x4
225 x 160	8x6
280 x 160	10x6
280 x 225	10 x 8
315 x 225	12 x 8
315 x 280	12 x 10
355 x 280	14 x 10
355 x 315	14 x 12
400 x 315	16 x 12
400 x 355	16 x 14



Fabricated Wye Reducer

NOMINAL SIZE	
mm	in
110 x 75	4 x 2-1/2
110 x 90	4 x 3
160 x 110	6x4
225 x 160	8x6
280 x 160	10x6
280 x 225	10 x 8
315 x 225	12 x 8
315 x 280	12 x 10
355 x 280	14 x 10
355 x 315	14 x 12
400 x 315	16 x 12
400 x 355	16 x 14

90° Elbow


NOMINAL SIZE	
mm	in
20	1/2
25	3/4
32	1
40	1-1/4
50	1-1/2
63	2
75	2-1/2
90	3
110	4
160	6
315	12

45° Elbow


NOMINAL SIZE	
mm	in
20	1/2
25	3/4
32	1
40	1-1/4
50	1-1/2
63	2
75	2-1/2
90	3
110	4
160	6
315	12

Tee


NOMINAL SIZE	
mm	in
20	1/2
25	3/4
32	1
40	1-1/4
50	1-1/2
63	2
75	2-1/2
90	3
110	4
160	6
315	12

Tee Reducer


NOMINAL SIZE	
mm	in
25 x 20	3/4 x 1/2
32 x 20	1 x 1/2
32 x 25	1 x 3/4
40 x 20	1-1/4 x 1/2
40 x 25	1-1/4 x 3/4
40 x 32	1-1/4 x 1
50 x 20	1-1/2 x 1/2
50 x 25	1-1/2 x 3/4
50 x 32	1-1/2 x 1
50 x 40	1-1/2 x 1-1/4
63 x 20	2 x 1/2
63 x 25	2 x 3/4
63 x 32	2 x 1
63 x 40	2 x 1-1/4
63 x 50	2 x 1-1/2
75 x 63	2-1/2 x 2
90 x 40	3 x 1-1/4
90 x 50	3 x 1-1/2
90 x 63	3 x 2
110 x 40	4 x 1-1/4
110 x 50	4 x 1-1/2
110 x 63	4 x 2
110 x 90	4 x 3
160 x 50	6 x 1-1/2
160 x 63	6 x 2
160 x 90	6 x 3
160 x 110	6 x 4


Coupling

NOMINAL SIZE	
mm	in
20	1/2
25	3/4
32	1
40	1-1/4
50	1-1/2
63	2
75	2-1/2
90	3
110	4
160	6
225	8
280	10
315	12
355	14
400	16
450	18
500	20
560	22
630	24


End Cap

NOMINAL SIZE	
mm	in
32	1
40	1-1/4
50	1-1/2
63	2


Saddle

NOMINAL SIZE	
mm	in
75 x 63	2-1/2 x 2
90 x 63	3x2
110 x 63	4 x 3
160 x 110	6x4
315 x 160	12 x 4

**Male
Threaded Adaptor**



NOMIMAL SIZE	
mm	in
20	1/2
32	3/4
40	1
50	1-1/4
63	1-1/2
75	2
90	2-1/2
88	3
110	4
32 x 25	1x 3/4
40 x 32	1-1/4 x 1
40 x 50	1-1/4 x 1-1/2
50 x 40	1-1/2 x 1-1/4
50 x 63	1-1/2 x 2
63 x 50	2 x 1-1/2
63 x 75	2 x 2-1/2

**Female
Threaded Adaptor**



NOMIMAL SIZE	
mm	in
20	1/2
32	3/4
40	1
50	1-1/4
63	1-1/2
75	2
90	2-1/2
88	3
110	4
32 x 25	1x 3/4
40 x 32	1-1/4 x 1
40 x 50	1-1/4 x 1-1/2
50 x 40	1-1/2 x 1-1/4
50 x 63	1-1/2 x 2
63 x 50	2 x 1-1/2
63 x 75	2 x 2-1/2

Coupling



NOMIMAL SIZE	
mm	in
20	1/2
25	3/4
32	1
40	1-1/4
50	1-1/2
63	2
75	2-1/2
90	3
110	4

Coupling Reducer

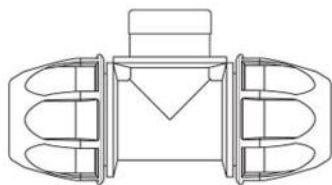


NOMIMAL SIZE	
mm	in
25 x 20	3/4 x 1/2
32 x 20	1 x 1/2
32 x 25	1 x 3/4
40 x 20	1-1/4 x 1/2
40 x 25	1-1/4 x 3/4
40 x 32	1-1/4 x 1
50 x 20	1-1/2 x 1/2
50 x 25	1-1/2 x 3/4
50 x 32	1-1/2 x 1
50 x 40	1-1/2 x 1-1/4
63 x 25	2 x 3/4
63 x 32	2x1
63 x 40	2 x 1-1/4
63 x 50	2 x 1-1/2
75 x 50	2-1/2 x 1-1/2
75 x 63	2-1/2 x 2
90 x 63	3x2
90 x 75	3 x 2-1/2
110 x 90	4x3

End Cap

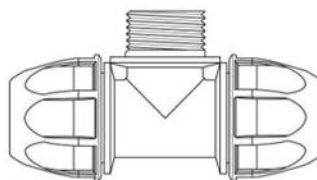


NOMIMAL SIZE	
mm	in
20	1/2
25	3/4
32	1
40	1-1/4
50	1-1/2
63	2
75	2-1/2
90	3
110	4



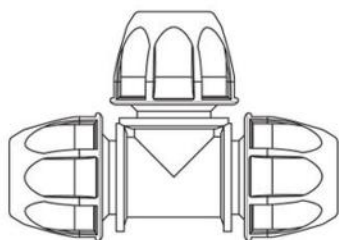
Female Tee Adapter

NOMINAL SIZE	
mm	in
20	1/2
25	3/4
32	1
40	1-1/4
50	1-1/2
63	2
75	2-1/2
90	3
110	4



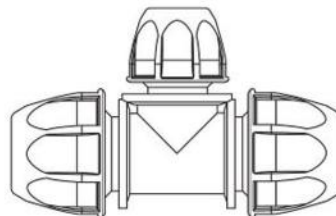
Male Tee Adapter

NOMINAL SIZE	
mm	in
20	1/2
25	3/4
32	1
40	1-1/4
50	1-1/2
63	2
75	2-1/2
90	3
110	4



Tee

NOMINAL SIZE	
mm	in
20	1/2
25	3/4
32	1
40	1-1/4
50	1-1/2
63	2
75	2-1/2
90	3
110	4



Tee Reducer

NOMINAL SIZE	
mm	in
25 x 20	3/4 x 1/2
32 x 20	1 x 1/2
32 x 25	1 x 3/4
40 x 25	1-1/4 x 3/4
40 x 32	1-1/4 x 1
50 x 25	1-1/2 x 3/4
50 x 32	1-1/2 x 1
50 x 40	1-1/2 x 1-1/4
63 x 32	2 x 1
63 x 40	2 x 1-1/4
63 x 50	2 x 1-1/2
75 x 50	2-1/2 x 1-1/2
75 x 63	2-1/2 x 2
90 x 63	3 x 2
90 x 75	3 x 2-1/2
110 x 63	4 x 2



90° Elbow

NOMINAL SIZE	
mm	in
20	1/2
25	3/4
32	1
40	1-1/4
50	1-1/2
63	2
75	2-1/2
90	3
110	4



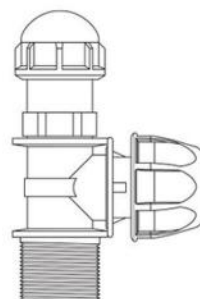
**90° Elbow
Male Elbow**

NOMINAL SIZE	
mm	in
20	1/2
25	3/4
32	1
40	1-1/4
50	1-1/2
63	2
75	2-1/2
90	3
110	4



Gate Valve

NOMINAL SIZE	
mm	in
20	1/2
25	3/4
32	1

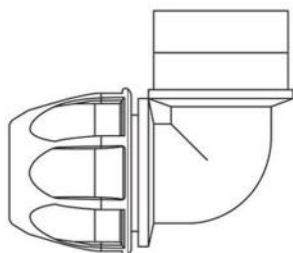


**Tapping Ferrule
(Threaded)**

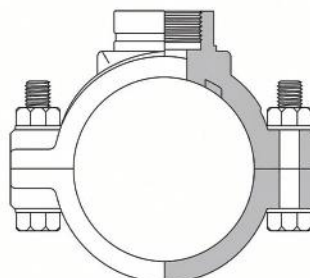
NOMINAL SIZE	
mm	in
32 x 20	1 x 1/2
32 x 25	1 x 3/4
32 x 32	1 x 1
40 x 40	1-1/4 x 1-1/2
40 x 25	1-1/4 x 3/4
40 x 32	1-1/4 x 1



90° Female Elbow



NOMINAL SIZE	
mm	in
20	1/2
25	3/4
32	1
40	1-1/4
50	1-1/2
63	2
75	2-1/2
90	3
110	4



Saddle Clamp

NOMINAL SIZE	
mm	in
25 x 20	3/4 x 1/2
32 x 20	1 x 1/2
32 x 25	1 x 3/4
32 x 32	1 x 1
40 x 20	1-1/4 x 1/2
40 x 25	1-1/4 x 3/4
40 x 32	1-1/4 x 1
50 x 20	1-1/2 x 1/2
50 x 25	1-1/2 x 3/4
50 x 32	1-1/2 x 1
63 x 25	2 x 3/4
63 x 40	2 x 1-1/4
75 x 20	2-1/2 x 1/2
75 x 25	2-1/2 x 3/4
75 x 32	2-1/2 x 1
75 x 40	2-1/2 x 1-1/4
75 x 50	2-1/2 x 1-1/2
90 x 20	3 x 1/2
90 x 25	3 x 3/4
90 x 32	3 x 1
110 x 20	4 x 1/2
110 x 25	4 x 3/4
110 x 32	4 x 1
110 x 40	4 x 1-1/4
110 x 50	4 x 1-1/2
110 x 63	4 x 2

PE - PE Connection



NOMINAL SIZE	
mm	in
20	1/2
25	3/4
32	1



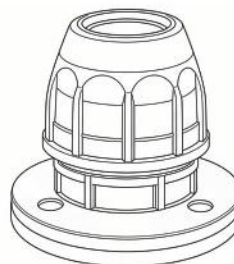
Rubber Gasket



O-Ring

Flange

NOMINAL SIZE	
mm	in
63	2
75	2-1/2





Atlanta BF Machine 160/4 + Handle

Technical Parameters	
Model	SHDS164A4
Welding Range (mm)	50, 63, 75, 90, 110, 125, 140, 160
Heating Plate Max Temp.	270°C
Heating Plate Surface Diff. (170°-250°C)	<+5°C
Operating Voltage	AC 220V
Heating Plate Power	1.5 kW
Milling Cutter Power	0.7 kW
Total Power	2.2 kW
Weight	48 kg



Atlanta BF Machine 200/4 + Handle

Technical Parameters	
Model	SHDS164A4
Welding Range (mm)	90, 110, 125, 140, 160, 180, 200
Heating Plate Max Temp.	270°C
Heating Plate Surface Diff. (170°-250°C)	<+5°C
Operating Voltage	AC 220V
Heating Plate Power	1.5 kW
Milling Cutter Power	0.7 kW
Total Power	2.2 kW
Weight	64 kg



Atlanta BF Machine SHD 250 Hydraulic

Technical Parameters	
Model	SHD 250
Welding Scope (mm)	63, 75, 90, 110, 125, 140, 160,
Highest Temperature Heating Plate	180, 200, 225, 250
Temperature of 170 ~250°C	270°C
Heating Plate Surface	<+5°C
Pressure Regulating Range	0 - 6.3 Mpa
Working Voltage	220V
Heating Plate Power	2 kW
Milling Power	1.1 kW
Hydraulic Power Station	0.75 kW
Lifting Power	none
Total Power	3.85 kW
Weight	143 kg



Atlanta BF Machine SHD 315 Hydraulic

Technical Parameters	
Model	SHD 315
Welding Scope (mm)	90, 110, 125, 140, 160, 180, 200,
Highest Temperature Heating Plate	225, 250, 280, 315
Temperature of 170 ~250°C	270°C
Heating Plate Surface	<+5°C
Pressure Regulating Range	0 - 6.3 Mpa
Working Voltage	220V
Heating Plate Power	2 kW
Milling Power	1.1 kW
Hydraulic Power Station	0.75 kW
Lifting Power	none
Total Power	4.85 kW
Weight	216 kg

Atlanta BF Machine SHD 450 Hydraulic
Technical Parameters

Model	SHD 450
Welding Scope (mm)	200, 225, 250, 280, 315, 355,
Highest Temperature Heating Plate	400, 450
Temperature of 170 ~250°C	270°C
Heating Plate Surface	<+7°C
Pressure Regulating Range	0 - 8 Mpa
Working Voltage	380V
Heating Plate Power	5.38 kW
Milling Power	1.5 kW
Hydraulic Power Station	1.5 kW
Lifting Power	0.25 kW (optional)
Total Power	8.38 kW
Weight	560 kg

Atlanta BF Machine SHD 630 Hydraulic
Technical Parameters

Model	SHD 630
Welding Scope (mm)	315, 355, 400, 450, 500, 560, 630
Highest Temperature Heating Plate	270°C
Temperature of 170 ~250°C	<+7°C
Heating Plate Surface	
Pressure Regulating Range	0 - 8 Mpa
Working Voltage	380V
Heating Plate Power	9.35 kW
Milling Power	1.5 kW
Hydraulic Power Station	1.5 kW
Lifting Power	0.25 kW (optional)
Total Power	12.35 kW
Weight	780 kg

Atlanta EF Machine SHD 3.5KW
Technical Parameters

Model	SHD 3.5KW
Input Voltage	48V±10%, 220V±20% or
Output Voltage	380V±20%
Output Power	46 - 65 Hz
Control Mode	8 - 135 VAC
	Constant Volt / Constant Current
	/ Constant Power
Recording Number of Data	500
Time Control Precision	≤±0.01%
Temperature Measuring Precision	+0.5°C
Data Output Port	Rs232
Packing Size (mm)	330 x 200 x 270

Atlanta EF Machine SHD 8KW
Technical Parameters

Model	SHD 8KW
Input Voltage	48V±10%, 220V±20% or
Output Voltage	380V±20%
Output Power	40 - 65 Hz
Control Mode	8 - 135 VAC
	Constant Volt / Constant Current
	/ Constant Power
Recording Number of Data	500
Time Control Precision	≤±0.01%
Temperature Measuring Precision	±0.5°C
Data Output Port	Rs232
Packing Size (mm)	330 x 200 x 270



Atlanta EF Machine SHD 12KW

Technical Parameters	
Model	SHD 12KW
Input Voltage	48V±10%, 220V±20% or 380V±20%
Output Voltage	46 - 65 Hz
Output Power	8 - 135 VAC
Control Mode	Constant Volt / Constant Current / Constant Power
Recording Number of Data	500
Time Control Precision	<±0.01%
Temperature Measuring Precision	±0.5°C
Data Output Port	Rs232
Packing Size (mm)	330 x 200 x 270

INSTALLATION

Butt Fusion Welding



1. Wipe pipe ends inside and out to remove dirt, oil, grease and other foreign materials.



2. Square the end of each pipe section to be fused by using the facing tool of the fusion machine. Remove cuttings and burrs from pipe ends.



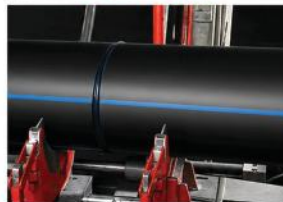
3. Check the line-up of pipe ends in the fusion machine to see that the pipe ends meet squarely and completely over the entire surface to be fused.



4. Insert the heater plate between the aligned pipe ends. Bring and hold the pipe ends in contact with the heater plate. Maintain contact and allow the pipe to heat and soften.



5. Remove heater plate from pipe end. Bring the heated pipe ends together with a firm pressure. Pressure is necessary to cause the heated material to flow together, thus giving a fusion bead flash around the entire circumference of the pipe.



6. Allow the joint to cool and solidify until the bead feels hard. Inspect the joint for a uniform non-porous appearance. If the joints appear faulty, simply cut the joints and repeat the procedure.

Push Fit Fitting Installation



1. **Cutting The Pipe**
Inspect and remove any damages found within the surface of the pipe. Cut the squarely with the use of a pipe cutter; Ensure that the end of the pipe is even & flat.



2. **Mark The Pipe To Ensure Its Insertion Depth**
Unscrew & loosen the nut in preparation for pipe insertion.



3. **Pipe Insertion**
Insert the pipe by pushing it into the fitting until the end of the pipe reaches the stopper, this must be done until the pipe can no longer be pushed inwards. Note: Check if the pipe is completely inserted within the fitting by inspecting the insertion depth marking.



4. **Tightening the Nut**
Carefully tighten the nut by twisting the nut clockwise.



5. **Fully Installed**
The whole installation process is complete. Check the pipe connection.

REAGENT	70°F (21°C)	140°F (60°C)
Acetic Acid* 1-10%	S	S
Acetic Acid* 10-60%	S	M
Acetic Acid* 80-100%	S	M
Acetone	M	U
Acrylic Emulsions*	S	S
Aluminum Chloride-Dilute	S	S
Aluminum Chloride Conc.	S	S
Aluminum Fluoride Conc.	S	S
Aluminum Sulfate Conc.	S	S
Alums (All Types) Conc.	S	S
Ammonia 100% Dry Gas	S	S
Ammonium Carbonate	S	S
Ammonium Chloride Sat'd	S	S
Ammonium Fluoride 20%	S	S
Ammonium Hydroxide 0.888 S.Q	S	S
Ammonium Metaphosphate Sat'd	S	S
Ammonium Nitrate Sat'd	S	S
Ammonium Ferrous Sulfate Sat'	S	S
Ammonium Sulfate Sat'd	S	S
Ammonium Sulfide Sat'd	S	S
Ammonium Thiocyanate Sat'd	S	S
Amyl Acetate	M	U
Amyl Alcohol* 100%	S	S
Amyl Chloride 100%	N	U
Aniline 100%	S	N
Antimony Chloride	S	S
Aqua Regia	U	U
Barium Carbonate Sat'd	S	S
Barium Chloride	S	S
Barium Hydroxide	S	S
Barium Sulfate Sat'd	S	S
Barium Sulfide Sat'd	S	S
Beer	S	S
Benzine	M	U
Benzene Sulfonic Acid*	S	S
Bismuth Carbonate Sat'd	S	S
Bleach Lye 10% Black Liquor	S	S
Borax Cold Sat'd	S	S
Boric Acid Dilute	S	S
Boric Acid Conc.	S	S
Bromic Acid 10%	S	S
Bromine Liquid 100%	S	U
Butanediol* 10%	M	S
Butanediol 60%	S	S
Butanediol* 100%	S	S
Butyl Alcohol* 100%	S	S
Calcium Bisulfide	S	S
Calcium Carbonate Sat'd	S	S
Calcium Chlorate Sat'd	S	S
Calcium Chloride Sat'd	S	S
Calcium Hydroxide	S	S
Calcium Hypochlorite Bich Sol.	S	S
Calcium Nitrate 50%	S	S
Calcium Sulfate	S	S
Camphor Oil	N	U
Carbon Dioxide 100% Dry	S	S
Carbon Dioxide 100% Wet	S	S
Carbon Dioxide Cold Sat'd	S	S
Carbon Disulphide	N	U
Carbon Monoxide	S	S
Carbon Tetrachloride	M	U
Carbonic Acid	S	S
Castor Oil* Conc.	S	S
Chloride Dry Gas 100%	S	M
Chloride Moist Gas	M	U

REAGENT	70°F (21°C)	140°F (60°C)
Chloride Liquid	M	U
Chlorobenzene	M	U
Chloroform	M	U
Chlorosulfonic Acid 100%	M	U
Chrome Alum Sat'd	S	S
Chromic Acid 20%	S	S
Chromic Acid Up to 50%	S	S
Chromic Acid and Sulfuric Acid	M	U
Cider*	M	U
Citric Acid Sat'd	S	S
Coconut Oil Alcohols*	S	S
Cola Concentrates*	S	S
Copper Chloride Sat'd	S	S
Copper Cyanide Sat'd	S	S
Copper Fluoride 2%	S	S
Copper Nitrate Sat'd	S	S
Copper Sulfate Dilute	S	S
Copper Sulfate Sat'd	S	S
Cottonseed Oil*	S	S
Cuprous Chloride Sat'd	S	S
Cyclohexanol*	S	S
Cyclohexanone*	M	U
Detergents Synthetic*	S	U
Developers, Photographic	S	S
Dextrin Sat'd	S	S
Dextrose Sat'd	S	S
Dibutylphthalate	S	M
Disodium Phosphate	S	S
Diazo Salts	S	S
Diethylene Glycol*	S	S
Diglycolic Acid*	S	S
Dimethylamine	M	U
Emulsions, Photographic*	S	S
Ethyl Acetate 100%	M	U
Ethyl Alcohol* 100%	S	S
Ethyl Alcohol* 35%	S	S
Ethyl Butyrate	S	U
Ethyl Chloride	M	U
Ethyl Ether	U	U
Ethylene Chloride	U	U
Ethylene Chlorohydrin	U	U
Ethylene Dichloride	M	U
Ethylene Glycol*	S	S
Ferric Chloride Sat'd	S	S
Ferric Nitrate Sat'd	S	S
Ferrous Chloride Sat'd	S	S
Ferrous Sulphate	S	S
Fish Solubles*	S	S
Fluboric Acid	S	S
Flourine	S	U
Fluosilicic Acid 32%	S	S
Fluosilicic Acid Conc.	S	S
Formaldehyde* 40%	S	N
Formic Acid* 0-20%	S	S
Formic Acid* 20-50%	S	S
Formic Acid* 100%	S	S
Fructose Sat'd	S	S
Fruit Pulp	S	S
Fuel Oil	S	U
Furfural 100%	M	U
Furfuryl Alcohol	M	U
Gallic Acid Sat'd	S	S
Gasoline	M	U
Gin	S	U
Glucose	S	S

REAGENT	70°F (21°C)	140°F (60°C)
Glycerine*	S	S
Glycol*	S	S
Glycolic Acid 30%	S	S
Grade Sugar Sat'd Aq.	S	S
Hexanol, Tert.*	S	S
Hydrobromic Acid 50%	S	S
Hydrocyanic Acid Sat'd	S	S
Hydrochloric Acid 10%	S	S
Hydrochloric Acid 30%	S	S
Hydrochloric Acid 35%	S	S
Hydrochloric Acid Conc.	S	S
Hydrofluoric Acid 40%	S	S
Hydrofluoric Acid 60%	S	S
Hydrofluoric Acid 75%	S	S
Hydrogen 100%	S	S
Hydrogen Bromide 10%	S	S
Hydrogen Chlorine Gas Dry	S	S
Hydrogen Peroxide 30%	S	S
Hydrogen Peroxide 90%	S	M
Hydrogen Phosphide 100%	S	S
Hydroquinone	S	S
Hydrogen Sulfide	S	S
Hypochlorus Acid Conc.	S	S
Inks*	S	S
Iodine (Alc. Sol.) Conc.	S	U
Lactic Acid 10%	S	S
Lactic Acid 90%	S	S
Latex	S	S
Lead Acetate Sat'd	S	S
Lube Oil	S	M
Magnesium Carbonate Sat'd	S	S
Magnesium Chloride Sat'd	S	S
Magnesium Hydroxide Sat'd	S	S
Magnesium Nitrate Sat'd	S	S
Magnesium Sulphate Sat'd	S	S
Mercuric Chloride Sat'd	S	S
Mercuric Cyanide Sat'd	S	S
Mercurous Nitrate Sat'd	S	S
Mercury	S	S
Methyl Alcohol 100%	S	S
Methyl Bromide	M	U
Methyl Chloride	M	U
Methyl Ethyl Ketone 100%	M	U
Methylsulfuric Acid*	S	S
Methylene Chloride 100%	M	U
Milk	S	S
Mineral Oils	S	U
Molasses Comm.	S	S
Nickel Chloride Sat'd	S	S
Nickel Nitrate Conc.	S	S
Nickel Sulfate Sat'd	S	S
Nicotine Dilute	S	S
Nicotinic Acid*	S	S
Nitric Acid 0-30%	S	S
Nitric Acid 30-50%	S	M
Nitric Acid 70%	S	M
Nitric Acid 95-98%	U	S
Nitrobenzene 100%	U	U
Octyl Cresol	S	U
Oils and Fats	S	U
Oleic Acid Conc.	S	U
Oleum Conc.	U	U
Orange Extract	S	S
Oxalic Acid Dilute	S	S
Oxalic Acid Sat'd	S	S

CHEMICAL RESISTANCE

REAGENT	70°F (21°C)	140°F (60°C)	REAGENT	70°F (21°C)	140°F (60°C)	REAGENT	70°F (21°C)	140°F (60°C)
Ozone 100%	S	U	Potassium Hydroxide 20%	S	S	Sodium Sulfide 25%	S	S
Perchloric Acid 10%	S	S	Potassium Hydroxide Conc.	S	S	Sodium Sulfide Sat'd Solution	S	S
Petroleum Ether	U	U	Potassium Nitrate Sat'd	M	S	Sodium Sulfite Sat'd	S	S
Phenol 90%	U	U	Potassium Perborate Sat'd	M	S	Stannous Chloride Sat'd Solution	S	S
Phosphoric Acid Up to 30%	S	S	Potassium Perchloride 10%	S	S	Stannic Chloride Sat'd	S	S
Phosphoric Acid Over 30%	S	S	Potassium Sulfate Conc.	S	S	Starch Solution* Sat'd	S	S
Phosphoric Acid 90%	S	S	Potassium Sulfide Conc.	S	S	Stearic Acid 100%	S	S
Phosphorous (Yellow) 100%	S	N	Potassium Sulfite Conc.	S	S	Sulfuric Acid 0-50%	N	S
Phosphorous Pentoxide 100%	S	N	Potassium Persulfate Sat'd	S	S	Sulfuric Acid 70%	S	M
Photographic Solutions	S	S	Propargyl Alcohol*	S	S	Sulfuric Acid 80%	S	U
Pickling Baths			Propyl Alcohol*	S	S	Sulfuric Acid 96%	M	U
Sulfuric Acid*	S	S	Propylene Dichloride 100%	S	S	Sulfuric Acid 98%	M	U
Hydrochloric Acid*	S	S	Propylene Glycol*	S	S	Sulfuric Acid Fuming	U	U
Sulfuric- Nitric*	S	U	Rayon Coagulating Bath*	S	S	Sulfurous Acid	S	S
Plating Solutions			Sea Water	S	S	Tallow	S	M
Brass	S	S	Selenic Acid	S	S	Tannic Acid* 10%	S	S
Cadmium*	S	S	Shortening*	S	S	Tanning Extracts Comm.	S	S
Chromium*	S	N	Silicic Acid	S	S	Tartaric Acid Sat'd	N	N
Copper*	S	S	Silver Nitrate Solution	S	S	Tetrahydrofurane	N	N
Gold*	S	S	Soap Solution* (Any Conc'n)	S	S	Titanium Tetrachloride Sat'd	S	N
Indium*	S	S	Sodium Acetate Sat'd	S	S	Toluene	M	U
Lead*	S	S	Sodium Benzoate 35%	S	S	Transformer Oil	S	M
Nickel*	S	S	Sodium Bicarbonate Sat'd	S	S	Trisodium Phosphate Sat'd	S	S
Rhodium*	S	S	Sodium Bisulfate Sat'd	S	S	Trichloroethylene	U	U
Silver*	S	S	Sodium Bisulfite Sat'd	S	S	Urea Up to 30%	S	S
Tin*	S	S	Sodium Borate	S	S	Urine	S	S
Zinc*	S	S	Sodium Bromide Dilute Solution	S	S	Vinegar Comm.	S	S
Potassium Bicarbonate Sat'd	S	S	Sodium Carbonate Conc.	S	S	Vanilla Extract*	S	S
Potassium Borate 1%	S	S	Sodium Carbonate	S	S	Wetting Agents*	S	S
Potassium Bromate 10%	S	S	Sodium Chlorate Sat'd	S	S	Whiskey*	S	N
Potassium Bromide Sat'd	M	S	Sodium Chloride Sat'd	S	S	Wines	S	S
Potassium Carbonate	S	S	Sodium Cyanide	S	S	Xylene	M	U
Potassium Chlorate Sat'd	S	S	Sodium Dichromate Sat'd	S	S	Yeast	S	S
Potassium Chloride Sat'd	S	S	Sodium Ferricyanide	S	S	Zinc Chloride Sat'd	S	S
Potassium Chromate 40%	S	S	Sodium Ferrocyanide Sat'd	S	S	Zinc Sulfate Sat'd	S	S
Potassium Cyanide Sat'd	S	S	Sodium Fluoride Sat'd	S	S			
Potassium Dichromate 40%	S	S	Sodium Hydroxide Conc.	S	S			
Potassium Ferricyanide Sat'd	S	S	Sodium Hypochlorite	S	S			
Potassium Ferrocyanide Sat'd	S	S	Sodium Nitrate	S	S			
Potassium Fluoride	S	S	Sodium Sulfate	S	S			

S - Satisfactory
U - Unsatisfactory
M - Marginal
N - Not Known

Some Reagents are marked with an asterisk (*). Although Atlanta HDPE Pipe is chemically resistant to these agents, excess temperatures and pressures can under certain conditions, lead to stress cracking. On Reagents marked marginal, chemical attacks will be recognized by a loss of physical properties of the pipe.

PROJECTS

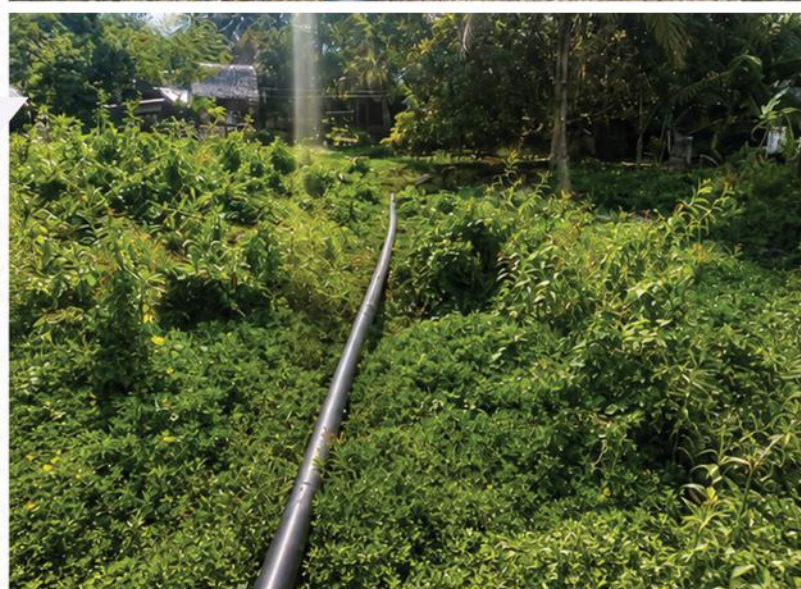
Perigrine Project Global City, Clark, Pampanga



Rockwell 205 Santolan Boni Serrano Ave., Quezon City



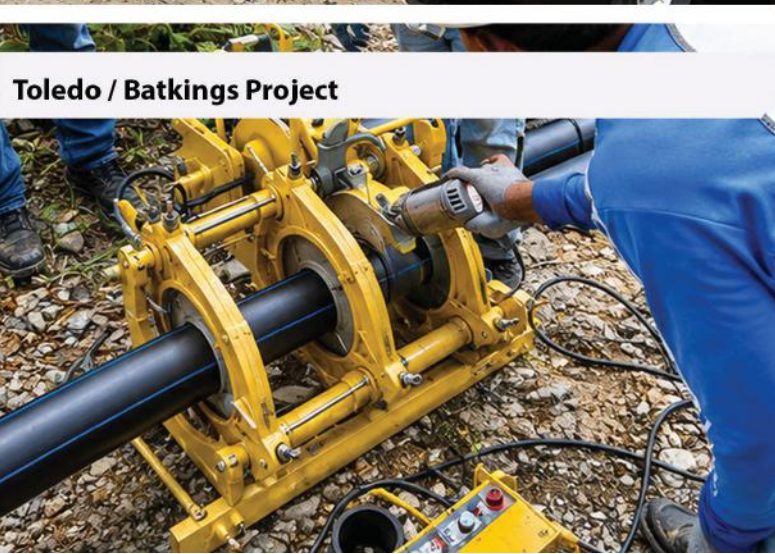
HDPE IRRIGATION SYSTEM Unisan, Quezon Province



Philippine Arena Albaquerque, Bulacan



Toledo / Batkings Project



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