

# Ovality correction

## DN 200 to 700

The contractor is responsible for analyzing and eliminating any risks during installation (especially the use of personal protective equipment).

Using a circometer, ensure that the outer diameter complies with the following values:

DN	Outside diameter OD (mm)	
	Nominal value	Limit deviations
200	222	+1/-3.0
250	274	+1/-3.1
300	326	+1/-3.3
350	378	+1/-3.4
400	429	+1/-3.5
450	480	+1/-3.6
500	532	+1/-3.8
600	635	+1/-4.0
700	738	+1/-4.3

Excerpt from EN 545 - Table 15

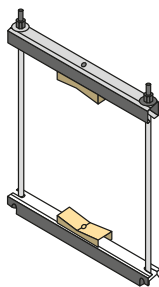
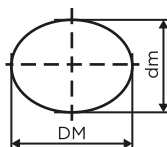
However, pipes may become oval-shaped due to transportation and handling, meaning that fittings cannot be assembled correctly.

### 1 CHECK THE OVALITY

$$\text{Ovality (\%)} = \frac{DM-dm}{DM+dm} \times 100$$

DM: maximum diameter measured

dm: minimum diameter measured



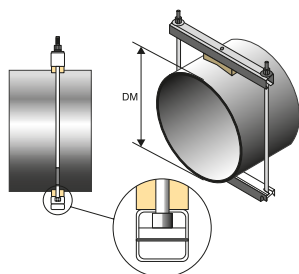
### TACKLE (ref. 244524)

- Two steel **bars** (top and bottom) fitted with movable pads
- Two **threaded rods** (right-hand thread)
- Two **Nylstop nuts + washers**

### 2 FIT

Fit the tackle according to the diagram.

The tackle can be set up 50 cm from the end of the pipe so that sleeves can be fitted.



### 3 TIGHTEN

Tighten the nuts by hand so that the tackle is stable.

With a size 30 spanner, **tighten** the nuts on the rods **alternately** and **gradually**.

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## 4 CHECK

**Check** that the spigot is perfectly round.

**Ensure** that the procedure has not damaged the cement lining.

## 5 ASSEMBLE

With the device still in position, **assemble** the joint.

The nuts must be kept tight while mounting the joint to compensate for any elastic deformation in the pipe.



*In case of a small diameter pipe, you can rotate the bars using the adjustable pads.*