



BS EN877 EPOXY CAST IRON

PIPES AND FITTINGS FOR DRAINAGE SYSTEM



仲賢行有限公司
CYH Limited



**BS EN877 Epoxy Cast Iron
Pipes and Fittings for Drainage System**



About Us

Wuan City Kun Yu Metal Products Co., Ltd.

Is a professional manufacturer of cast-iron drainage pipes and sets up in 2006, the enterprise covers a total area of 70,000 square meters, with an annual output of 20,000 tons of cast-iron drainage pipes and 10,000 tons of cast-iron pipe fittings.

Kun Yu factory has advanced production equipment and complete testing methods. The whole process is controlled strictly by inspection, so that the products can meet the standard requirements in chemical composition, mechanical properties, organization, hydraulic test, and other aspects, providing a reliable guarantee for the excellent quality of the products. The company adheres to the quality policy of sustainable development to create a green factory, in which "Quality is the basis of reputation, Technology, and Management are the basis of efficiency." and conscientiously implements the 1509001 quality management system standards. The product quality has reached the advanced level of 1506594, BS EN877, ASTMA888, GB/T12772, KSD4307, and multinational advanced level, exported to Hong Kong, United Kingdom, Germany, Russia, Norway, Sweden, and other regions.

At present, the main products of the Kun Yu factory are cast iron pipes and fittings. The drainage cast iron pipes



are produced by centrifugal casting with the hot mold method, special internal and external surface treatment, epoxy resin anti-corrosion coating, high-temperature drying coating, and other advanced technologies. The company has 15 centrifuge casting machines, 2 shot blasting machines, 2 sets of automatic cutting internal grinding machines, 7 sets of pipe grinding machines, more than 1500 kinds of pipe fitting molds, and a set of automatic horizontal production lines.

Quality testing equipment: tensile test machine, hardness test machine, carbon, and sulfur analyzer, and two sets of cold and hot water circulation equipment. The product has the characteristic of high strength and lightweight, and the installation is very convenient, thus can greatly accelerate the construction schedule; The product has a thin wall, uniform, smooth inside and outside;

Dense structure, no leakage, corrosion resistance, anti-seismic, antinoise, high-temperature resistance, simple construction and maintenance, reliable installation, long durability, and other advantages.

Wuan City Kun Yu Metal Products Co., Ltd. always adheres to the "sincere to the world's customers,

cast a global quality pipe" business purpose, dedicated to service and cooperating with domestic and foreign merchants.

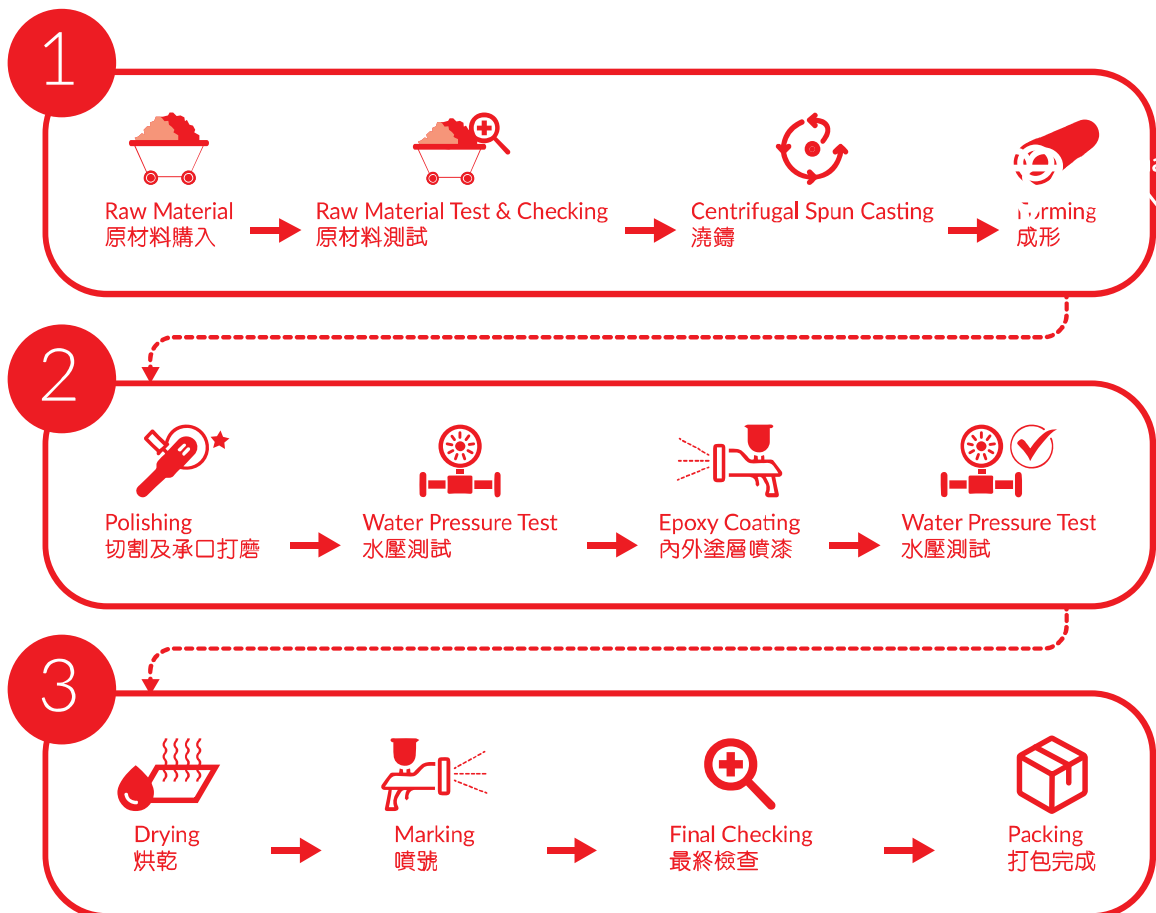
武安市坤鈺金屬製品有限公司，是專業生產鑄鐵排水管的企業。企業2006年建廠，總佔地面積70,000平方米，年產量鑄鐵排水管20,000噸、鑄鐵管件10,000噸，目前公司已擁有一批高技術、高素質、高服務的精銳團隊。

廠生產設備先進，檢測方法齊全。通過檢測進行嚴格的工序控制，使產品在化學成分、機械性能、水壓試驗等各方面均達到標準要求，為出廠產品的優良質量提供了可靠的保證。公司堅持“質量是信譽之基，技術和管理是效益之本。”的持續發展的質量方針，認真貫徹ISO9001質量管理體系標準之基，創建綠色工廠。產品質量均達到ISO6594、BS EN877、ASTMA888、GB/T12772、KSD4307等多國先進水平，出口香港、英國、德國、俄羅斯、挪威、瑞典等地區。

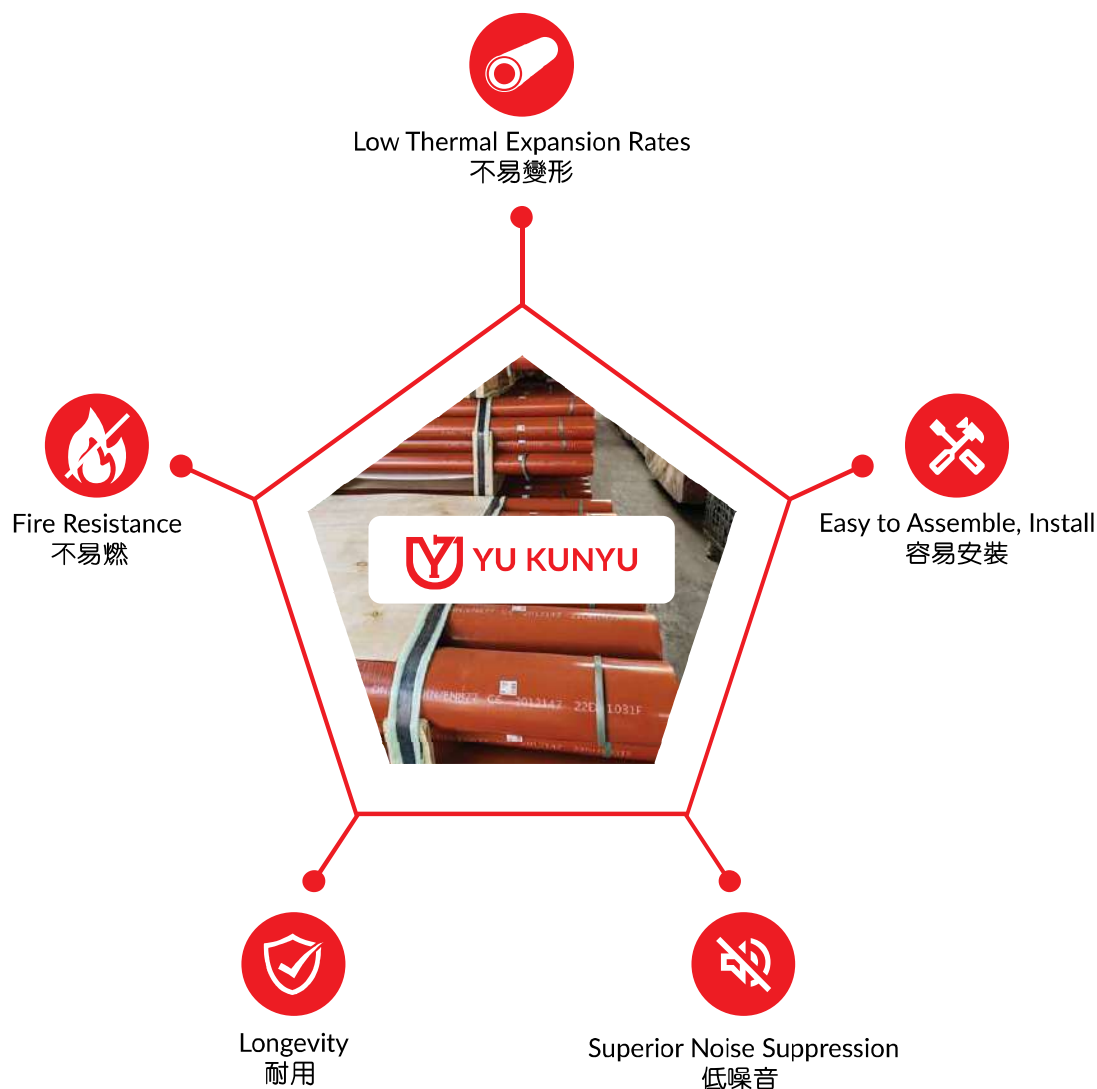
目前廠的經營產品主要為鑄鐵管和鑄鐵管件，生產的排水鑄鐵管採用了離心鑄造特殊的內外表面處理，環氧樹脂防腐層、高溫烘乾塗裝等先進工藝。公司現有離心機15台，攪丸機2台、自動切割內磨機2套，磨管機7台，管件模具達到1500多種，一整套自動水平生產線，質量檢測設備：光譜分析儀、耐鹽霧試驗機、測試拉力實驗機、硬度實驗機、碳硫分析儀，冷熱水循環設備兩套。

產品具有強度高重量輕的特點，安裝極為方便，因而可以大大加快施工進度。該產品具有壁薄、均勻、內外光滑、組織緻密，無滲漏、耐腐蝕、抗震、防噪音、耐高溫，施工及維護簡便，安裝可靠，耐久性長等優點。

Manufacturing and Inspection Procedure



Advantages of Product



Certificates



BSEN 877:1999+A1:2006&2021;
Kitemark Certificate;
ISO 9001;
Reaction to Fire—BSEN 13501-1 A2-s1,d0;
Electrical Continuity—BS 6087



SML Epoxy Cast Iron Drainage Systems for above Ground

Nominal Size (mm)	Size (Inch)	Outside Diameter D (mm)	Wall Thickness T (mm)		Length (mm)
			Nominal Value	Minimum Value	
50	2"	58	3.50	3.00	3,000
75	3"	83	3.50	3.00	
100	4"	110	3.50	3.00	
150	6"	160	4.00	3.50	
200	8"	210	5.00	4.00	
250	10"	274	5.50	4.50	
300	12"	326	6.00	5.00	

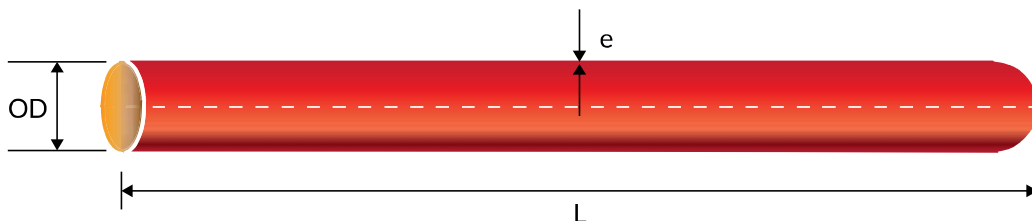
External Coating Thickness:
not less than 60µm

Internal Coating Thickness:
not less than 130µm



Body Marking:

YU KUNYU SML BSEN877 A2-s1, d0 (DN) x (Length) (Production Code)



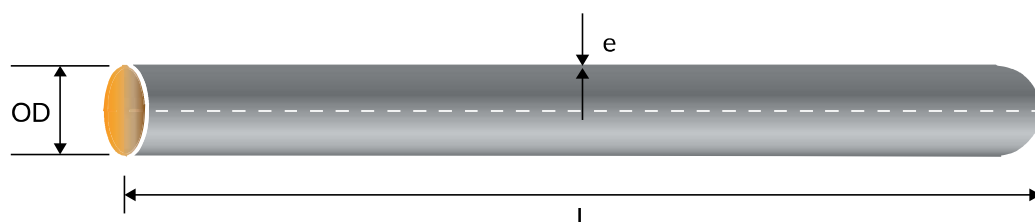
KML Epoxy Cast Iron Drainage Systems for Aggressive Waste Water

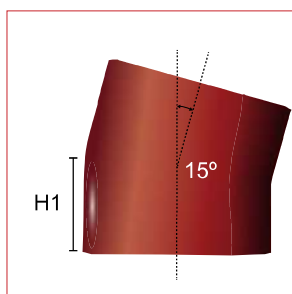
Nominal Size (mm)	Size (Inch)	Outside Diameter D (mm)	Wall Thickness T (mm)		Length (mm)
			Nominal Value	Minimum Value	
50	2"	58	3.50	3.00	3,000
75	3"	83	3.50	3.00	
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200	8"	210	5.00	4.00	
250	10"	274	5.50	4.50	
300	12"	326	6.00	5.00	



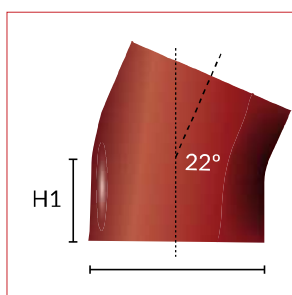
Body Marking:

YU KUNYU KML BSEN877 A2-s1, d0 (DN) x (Length) (Production Code)

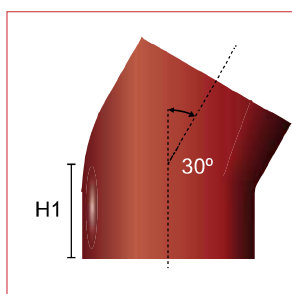




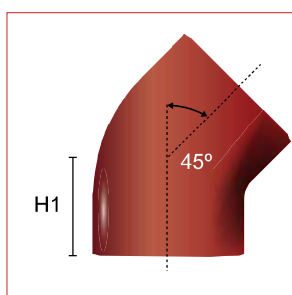
15° Bend		
Nominal Size (mm)	kg/pcs.	H1 (mm)
50	0.4	40
75	0.8	50
100	1.0	51
150	2.5	65



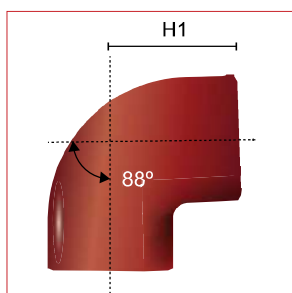
22° Bend		
Nominal Size (mm)	kg/pcs.	H1 (mm)
50	0.5	40
75	1.0	54
100	1.3	55
150	3.2	70
200	4.2	85



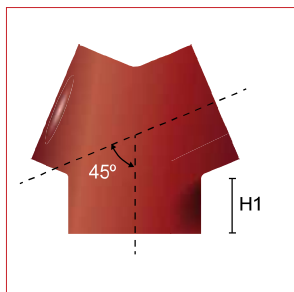
30° Bend		
Nominal Size (mm)	kg/pcs.	H1 (mm)
50	0.47	46
75	0.8	60
100	1.3	61
150	3.0	81
200	5.6	96



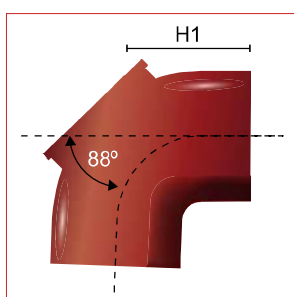
45° Bend		
Nominal Size (mm)	kg/pcs.	H1 (mm)
50	0.5	51
75	1.0	61
100	1.6	72
150	3.5	92
200	6.2	112
250	10.3	132
300	17.3	157



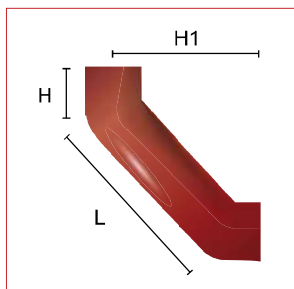
88° Bend		
Nominal Size (mm)	kg/pcs.	H1 (mm)
50	0.7	76
75	1.4	96
100	2.1	112
150	4.9	147
200	8.8	182
250	17.9	222
300	28.0	263



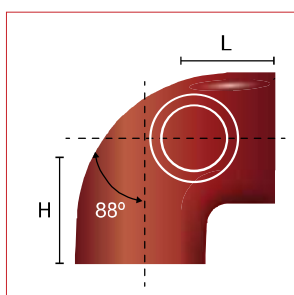
45° Bend With Round Door		
Nominal Size (mm)	kg/pcs.	H1 (mm)
50	1.0	60
75	1.7	76
100	2.6	83
150	7.0	112
200	13.8	140
250	25.5	182
300	39.8	206



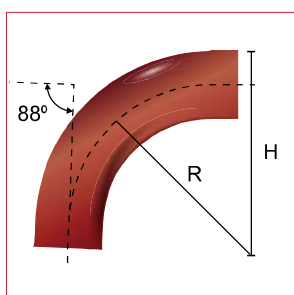
88° Bend With Round Door		
Nominal Size (mm)	kg/pcs.	H1 (mm)
50	1.1	76
75	2.2	95
100	3.4	110
150	7.0	150
200	14.3	182
250	26.3	222
300	41.5	263



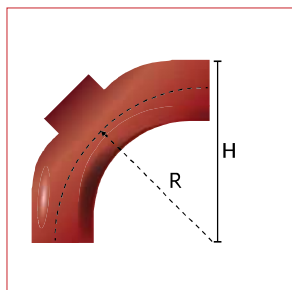
88° Double Bend				
Nominal Size (mm)	kg/pcs.	H (mm)	H1 (mm)	L (mm)
50	1.2	50	125	100
75	1.8	60	151	120
100	3.2	70	176	140
150	7.0	90	224	180



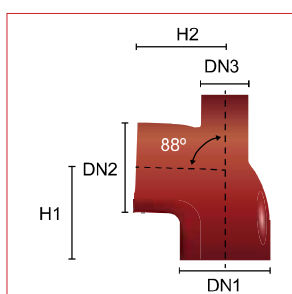
88° Vent Bend			
Nominal Size (mm)	kg/pcs.	H (mm)	L (mm)
100 x 50	2.9	92	92



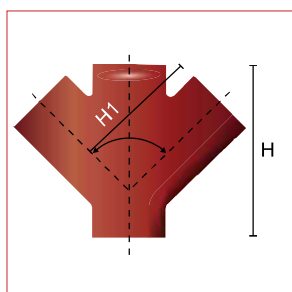
88° Long Radius Bend			
Nominal Size (mm)	kg/pcs.	H (mm)	R (mm)
75	3.6	293	250
100	5.4	270	230
100	7.5	426	400
150	9.8	280	230
150	19.5	620	600
200	19.5	349	300



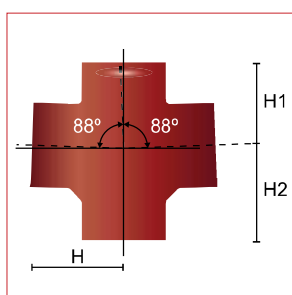
88° Long Radius Bend Access Door			
Nominal Size (mm)	kg/pcs.	H (mm)	R (mm)
100	7	230	150
100	9.5	470	400/450
150	16.2	435	400
150	21.5	635	600
200	23	445	400
200	36	645	600
250	49	557	500
250	56.5	650	600
300	84	660	600



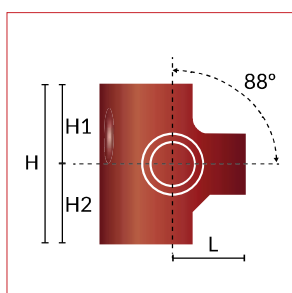
88° Bend With Foot Branch				
Nominal Size (mm)	kg/pcs.	H (mm)	H1 (mm)	H2 (mm)
(DN1xDN2xDN3) 100 x 50	2.5	204	113	114



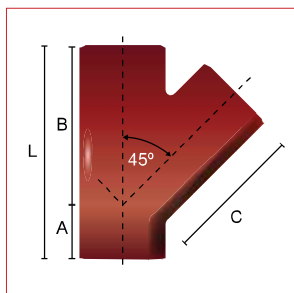
45° Double Branch (Cross)			
Nominal Size (mm)	kg/pcs.	H (mm)	H1 (mm)
100 x 50	2.7	204	167
100 x 100	5.3	263	192
150 x 100	9.0	298	242
150 x 150	10.8	360	269



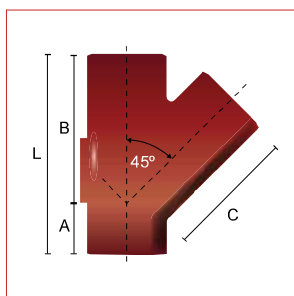
88° Double Branch (Cross)				
Nominal Size (mm)	kg/pcs.	H (mm)	H1 (mm)	H2 (mm)
100 x 50	2.2	107	102	80
100 x 100	3.4	122	111	121
150 x 100	7.1	146	114	134



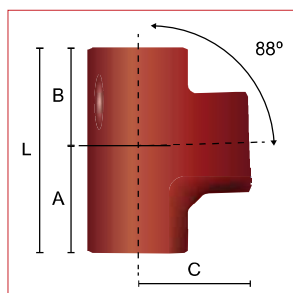
88° Elbow Tee					
Nominal Size (mm)	kg/pcs.	H (mm)	H1 (mm)	H2 (mm)	L (mm)
100 x 100	3.4	222	105	117	122
150 x 100	7.1	248	118	130	147



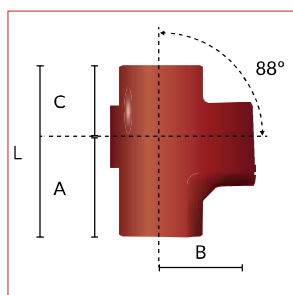
45° Single Branch					
Nominal Size (mm)	kg/pcs.	A (mm)	B (mm)	C (mm)	L (mm)
50 x 50	1.4	54	133	133	187
75 x 50	1.8	45	145	145	190
75 x 75	2.4	65	163	163	228
100 x 50	2.5	40	163	163	203
100 x 75	3.1	54	178	183	232
100 x 100	4.2	70	206	206	276
150 x 50	5.5	44	238	239	283
150 x 75	5.9	40	217	217	257
150 x 100	6.8	56	244	244	300
150 x 150	9.2	90	268	268	358
200 x 75	8.5	16	244	244	260
200 x 100	10.0	39	267	267	306
200 x 150	13.3	67	310	310	377
200 x 200	17.2	120	343	343	463
250 x 100	15.4	15	313	313	328
250 x 150	20.2	55	354	354	409
250 x 200	25.1	91	389	389	480
250 x 250	31.5	131	434	434	565
300 x 150	26.9	36	384	384	420
300 x 200	34.0	71	419	419	490
300 x 300	50.1	157	510	510	667



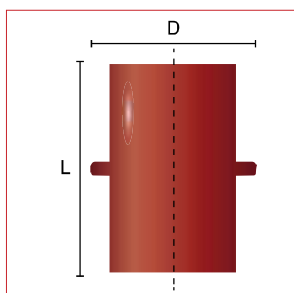
45° Branch With Round Door					
Nominal Size (mm)	kg/pcs.	A (mm)	B (mm)	C (mm)	L (mm)
75 x 75	3.0	65	163	163	228
100 x 50	3.6	54	160	160	214
100 x 75	4.5	62	198	198	260
100 x 100	5.3	69	206	206	276
150 x 100	8.0	46	236	232	282
150 x 150	10.4	92	264	264	356
200 x 100	11.0	36	275	275	311
200 x 150	14.0	76	302	302	378
200 x 200	16.4	116	343	343	460
250 x 250	40.0	129	432	432	561
300 x 300	57.2	157	500	510	656



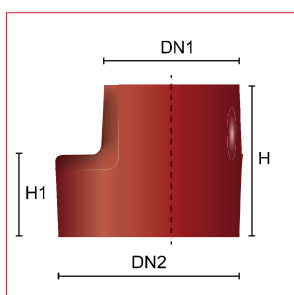
88° Single Branch					
Nominal Size (mm)	kg/pcs.	A (mm)	B (mm)	C (mm)	L (mm)
50 x 50	0.9	65	81	81	146
75 x 50	1.6	83	100	92	183
75 x 75	1.9	85	98	94	183
100 x 50	2.1	75	99	108	174
100 x 75	2.6	86	108	112	194
100 x 100	2.9	106	118	118	224
150 x 50	4.5	97	105	140	202
150 x 75	5.0	106	115	140	222
150 x 100	5.5	112	135	145	247
150 x 150	6.9	141	159	157	300
200 x 100	7.8	132	138	175	270
200 x 150	10.8	155	177	187	328
200 x 200	12.8	182	197	202	379
250 x 100	14.0	150	162	213	312
250 x 150	19.3	171	188	231	359
250 x 200	22.0	195	212	240	407
250 x 250	27.0	229	240	246	469
300 x 100	22.0	162	188	255	350
300 x 150	22.8	192	212	258	404
300 x 200	27.0	214	242	269	456
300 x 250	31.6	253	273	279	526
300 x 300	43.0	265	281	282	546



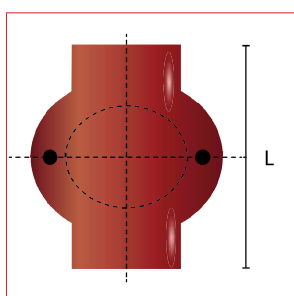
88° Branch with Round Door					
Nominal Size (mm)	kg/pcs.	A (mm)	B (mm)	C (mm)	L (mm)
50 x 50	1.3	81	81	63	144
75 x 50	2.0	95	92	88	183
75 x 75	2.9	131	132	90	222
100 x 50	3.8	103	107	108	211
100 x 75	3.8	114	111	90	204
100 x 100	4.5	172	152	102	274
150 x 100	7.5	142	146	137	279
150 x 150	11.0	205	189	146	351
200 x 100	10.5	163	171	148	311
200 x 150	13.6	185	187	168	353
200 x 200	16.0	197	204	182	378
250 x 150	27.5	225	230	213	438
250 x 200	26.5	217	231	235	448
250 x 250	31.0	243	243	225	468
300 x 200	33.6	267	265	252	520
300 x 300	45.5	270	270	265	535



Stack Support Pipe			
Nominal Size (mm)	kg/pcs.	D (mm)	L (mm)
50	1.3	59	202
75	1.8	83	202
100	2.3	110	202
150	4.0	160	202
200	6.0	210	202
250	12.5	275	303
300	24.0	326	303



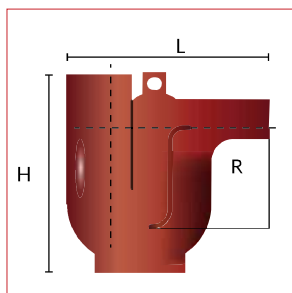
Reducer (Eccentric)			
Nominal Size (mm)	kg/pcs.	H1 (mm)	H (mm)
75 x 50	0.7	13	84
100 x 50	0.9	26	79
100 x 75	1.1	14	93
150 x 50	2.0	51	96
150 x 75	2.2	38	103
150 x 100	2.2	25	107
200 x 100	4.1	50	120
200 x 150	4.3	25	128
250 x 100	6.2	82	130
250 x 150	6.8	56	133
250 x 200	7.0	32	148
300 x 150	10.7	83	152
300 x 200	11.4	58	162
300 x 250	12.4	26	173



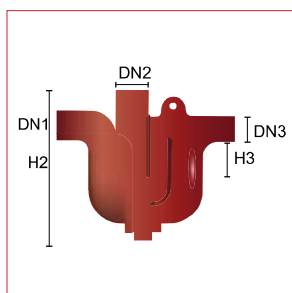
Short Pipe With Round Access Door		
Nominal Size (mm)	kg/pcs.	L (mm)
50	2.3	192
75	3.2	220



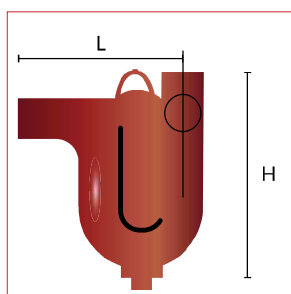
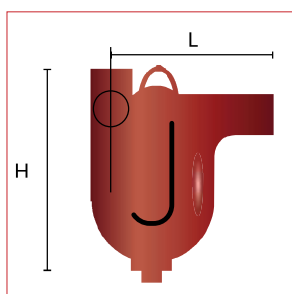
Short Pipe With Round Access Door		
Nominal Size (mm)	kg/pcs.	L (mm)
100	3.8	213
150	8.2	300
200	9.6	320
250	14.6	330
300	21.0	350



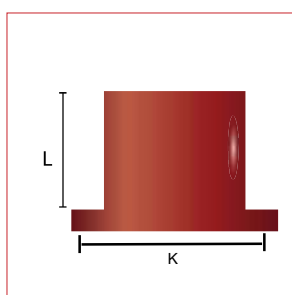
Anti-Siphon Trap With Door				
Nominal Size (mm)	kg/pcs.	H (mm)	R (mm)	L (mm)
50	3.3	253	80	156
75	9.1	292	85	200
100	11.5	370	85	265
150	35	617	157	300
200	54.1	741	235	502



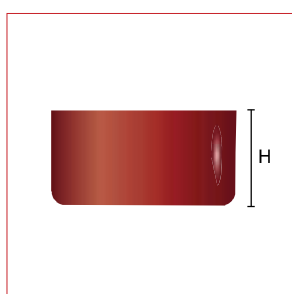
Anti-Syphonage Trap With Water Seal Replenishment Inlet -Type W					
Nominal Size (mm)	H1 (mm)	H2 (mm)	H3 (mm)	L1 (mm)	L2 (mm)
50	290	60	60	200	176



Anti-Syphonage Trap With Branch (Right or left inlet)		
Nominal Size (mm)	H (mm)	L (mm)
50	250	155

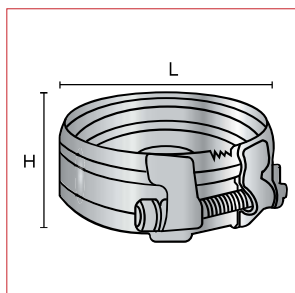


Connector With Flange			
Nominal Size (mm)	L (mm)	K (mm)	Bolts Number
75	150	180	8
100	150	220	8
150	150	240	8
200	150	295	12
250	150	355	12
300	150	410	12

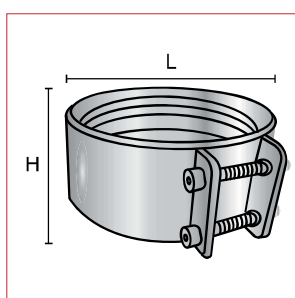


CAP		
Nominal Size (mm)	kg/pcs.	H (mm)
50	0.2	30
75	0.5	40
100	0.7	44
150	1.7	55
200	3.1	61
250	6.0	70
300	9.5	80

COUPLING

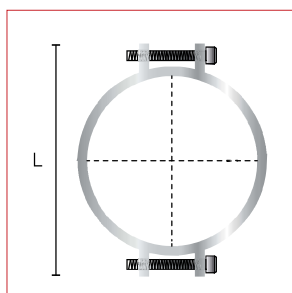


Rapid Coupling Type B (Single Bolt)		
Nominal Size (mm)	H (mm)	L (mm)
50	43	71
75	47	98
100	47	124
150	55	180
200	68	230



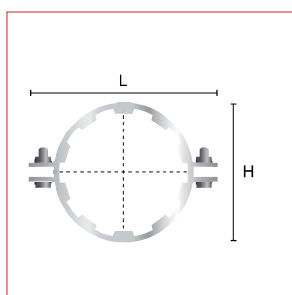
Type CHA Coupling (Multi Bolts)		
Nominal Size (mm)	H (mm)	L (mm)
50	58	71
75	58	96
100	58	123
150	71	173
200	83	223

COUPLING



Type CHA Coupling (Multi Bolts)

Nominal Size (mm)	L (mm)	Number of Bolts
250	287	8
300	339	8



GMS Grip Collar / Clamp

Nominal Size (mm)	H (mm)	L (mm)
75	95	185
100	95	215
150	100	270
200	135	317
250	160	390
300	190	455

** Hot-Dip Galvanized Grip Collar are available as per request.

YU KUNYU BS EN877 EPOXY CAST IRON PIPES & FITTINGS FOR DRAINAGE SYSTEM

CONDITIONS FOR INSTALLATIONS (COUPLING SECURED WITH GRIP COLLAR) :

Grip collars are made with very durable steel and are equipped with little claw like pieces all along the inside. They have to use for low pressure piping systems. They are available in a variety of different sizes and are commonly using by Epoxy coated pipes, which are slippery in nature. Grip collars will prevent pipes and fittings to slide or slip out of place and can increase the stability and withstand pressure of the piping system.

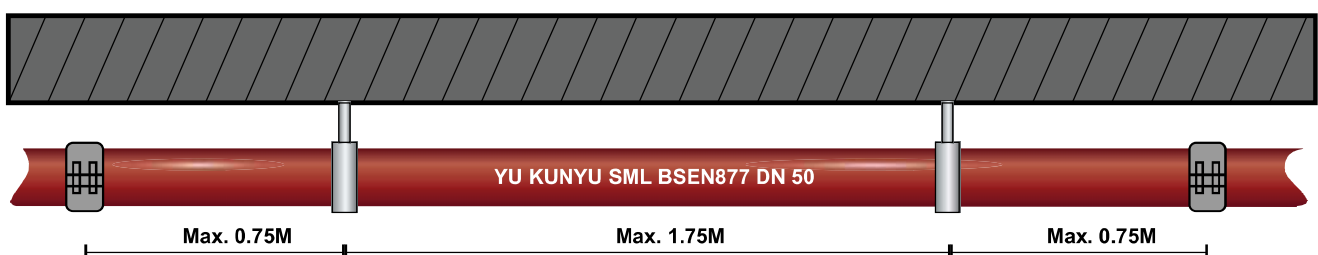
Whenever drainage pipework is exposed to an internal working pressure higher than 0.5 bars, grip collars are recommended to use if:

1. Pipes laid under the groundwater table;
2. Pipes running through several floors without outlets;
3. Pipes with the change of direction to address associated internal working forces produced.

Recommendations On Jointing, Handling ETC.

Horizontal Pipes

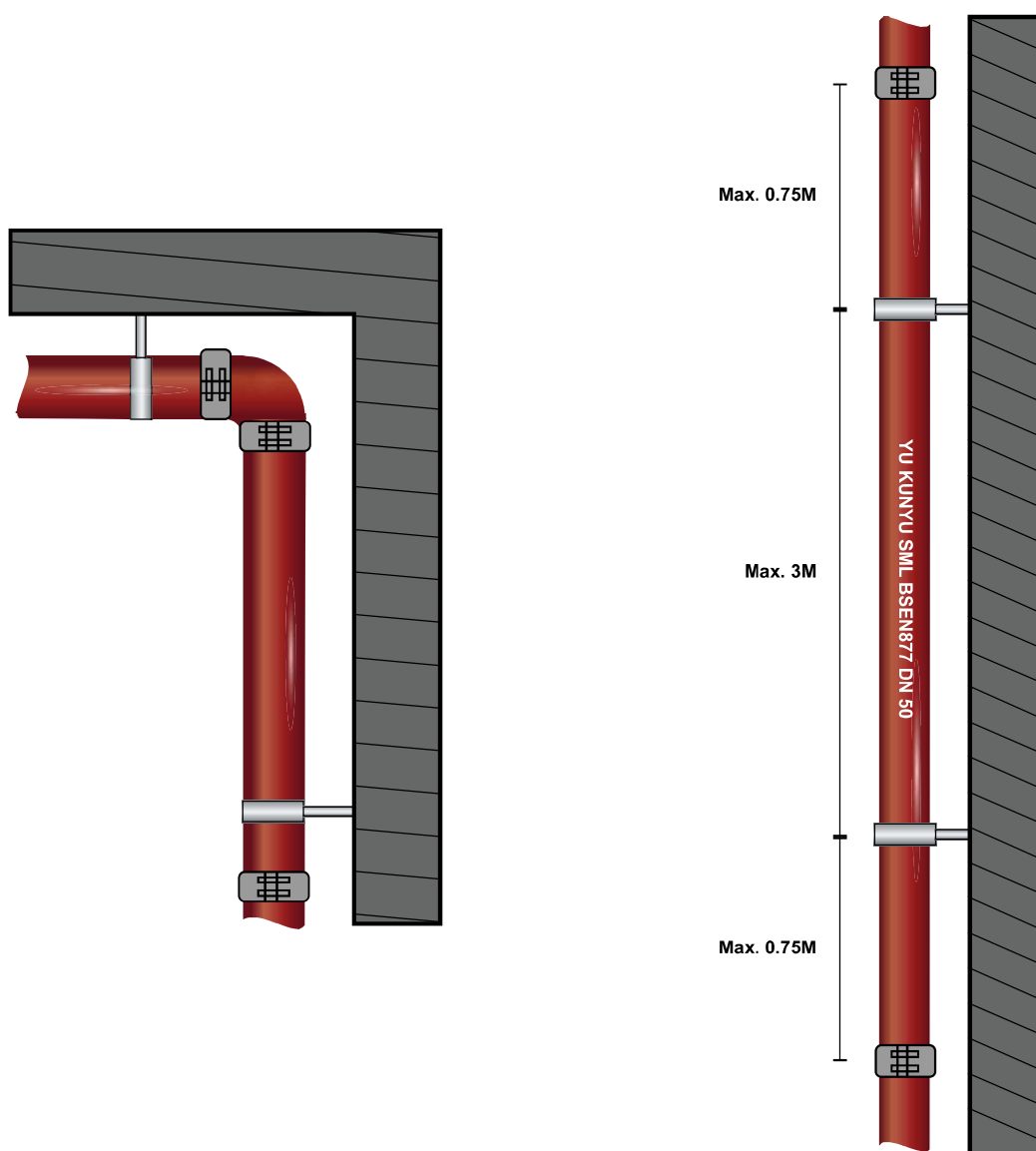
- For horizontal pipes longer than 2 m, two pipe brackets must be installed.
The distance between the brackets must not exceed 1.75 m.
- The distance between the pipe coupling at the pipe end and the bracket must not exceed 0.75 m.



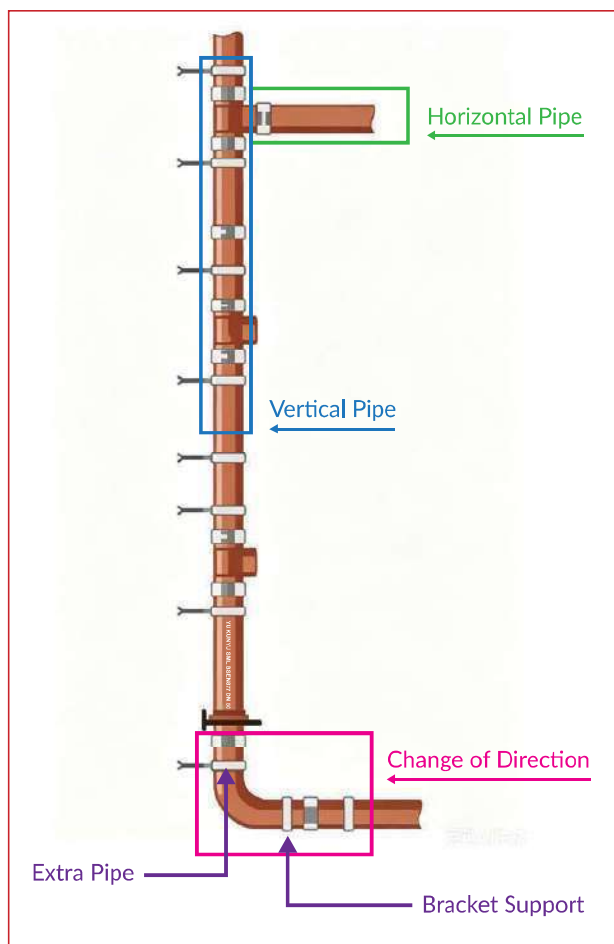
YU KUNYU BS EN877 EPOXY CAST IRON PIPES & FITTINGS FOR DRAINAGE SYSTEM

Vertical Pipes

- For vertical pipes shorter than 1 m, at least one pipe bracket must be installed.
- An additional pipe bracket should be provided at every bend or fitting connection to secure the joint. The bracket should also be averagedly distributed.
- For vertical pipes longer than 2 m, two pipe brackets must be installed. The distance between pipe brackets must not exceed 3 m. The distance between the coupling at the pipe end and the pipe bracket must not exceed 0.75 m.



YU KUNYU BS EN877 EPOXY CAST IRON PIPES & FITTINGS FOR DRAINAGE SYSTEM



Type of coupling	Size Range	Horizontal Pipe	Vertical Pipe	Change of Direction
Type B – (Single Screw S316 Stainless Steel)	50 - 200			 + 
Type CHA – (Multi Screw SS316 Stainless Steel)	250 - 300			 + 
High Pressure Coupling	50 - 300			

YU KUNYU BS EN877 EPOXY CAST IRON PIPES & FITTINGS FOR DRAINAGE SYSTEM

Recommendations On Jointing, Handling Repair Manual

Requirements for pipe cutting:



1. Cut the pipe according to the requirements, ensuring that the cutting is perpendicular to the axis of the pipe.
2. Carefully grind the cut end of the pipe to ensure the surface is smooth and even.



3. Apply the epoxy protective paint for a depth of minimum 10 mm from the pipe edge. Outer and inner pipe surfaces should also be painted.

4. Installation may only be proceeded after the epoxy protective paint has been fully dried.

YU KUNYU BS EN877 EPOXY CAST IRON PIPES & FITTINGS FOR DRAINAGE SYSTEM

Coupling installation guidelines:

1. Evenly install the coupling onto the required pipe or fitting. Ensure the gasket of the coupling should be tightly fitted to the end of the pipe or fitting.



2. Carefully inspect the joint to ensure the gasket is properly fitted. Then, using the same method to install the pipe or fitting on the other side.



3. Use an appropriate wrench or electric tool to securely tighten the screws on the coupling.



4. Ensure the stainless-steel shell of the coupling is completely fitted to the pipe or fitting.



5. Installation complete.

YU KUNYU BS EN877 EPOXY CAST IRON PIPES & FITTINGS FOR DRAINAGE SYSTEM

Grip Coupling installation guidelines:

1. Make sure the installation process of the coupling has been completed.



2. Place the Grip collar evenly around the installed coupling carefully.



3. Use an appropriate wrench or electric tool to securely tighten the screws on the coupling.



4. Use an appropriate wrench or electric tool to securely tighten the screws on the coupling
5. Make sure to tighten each screw evenly.



6. Ensure the Grip collar is completely fitted to the pipe or fitting.



7. Installation complete.



YU KUNYU BS EN877 EPOXY CAST IRON PIPES & FITTINGS FOR DRAINAGE SYSTEM

High Pressure Coupling Installation Guidelines

1. Place the High pressure coupling between the Pipe/ Fittings carefully.



2. Use an appropriate wrench or electric tool to securely tighten the screws on the coupling

3. Make sure to tighten each screw evenly



4. Installation complete.



Recommendations On Jointing, Handling ETC.



YU Epoxy touch-up paint

YU Epoxy paint is recommended to be applied to the system after pipes have been cut to suit project needs. It is a low-VOC, universal water-based epoxy amine-adduct primer in red color designed for mild to moderate industrial use, for instance, to coat incised surfaces of cast iron pipes.

For best corrosion protection, incised surfaces of cast iron pipes shall be cleaned thoroughly with burrs removed before being coated with 'YU' epoxy touch-up paint.

Outstanding Feature:

- Easy to use
- Epoxy Acrylic Resin
- Reddish Brown
- Anti-Corrosion





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