

## PRODUCER STATEMENT

**PRODUCT DESCRIPTION:** PVC Floodgates

**PRODUCT CODE:** 588.XXX XXX – Size

**PRODUCT SIZE(s):** 100mm, 150mm, 175mm, 225mm, 300mm, 375mm and 475mm.

**APPLICABLE STANDARD:** Internal Standard

**PRODUCT LIFE:** By convention, plastics pipe systems are often designed on the basis of 50 years extrapolated test data. This is established international practise but is not intended to imply the service life of the drainage pipes is limited to 50 years. For correctly manufactured and installed systems, the actual life cannot be predicted, but can logically be expected to be well in excess of 100 years before major rehabilitation is required.

### **PRODUCT INFORMATION:**

Produced predominately for use in rural storm water systems, Strata Precision Plastics PVC floodgates provide for a price efficient means of preventing the back up of new and existing storm water systems.

### **METHOD OF CONSTRUCTION:**

The primary method of construction is made with tools and equipment that has been specifically designed to achieve an acceptable outcome for the construction of this product. The primary equipment used is standard factory machinery. All construction is done in a controlled factory environment at our Hamilton factory with a team of fabricators with over 60 years combined experience in the fabrication of Polyethylene and PVC products.

### **RAW MATERIALS:**

1. 100mm – Iplex Pipelines or Marley – DWV Plain Coupling
2. 150mm to 375mm Imported – Stormwater Plain Coupling
3. 475mm - Iplex Pipelines, Marley or RX Plastics - uPVC Rural Pipe. Manufactured & tested in accordance with internal standards.
4. Dotmar Plastics – 10mm and 12mm PVC Sheet – Swiss Grey. Manufactured & tested in accordance with European standards.
5. Mulford Plastics Ltd – 10mm Nylon bolts and nuts
6. Skellerup Industries Ltd - 12.7mm x 9.5mm EPDM Compound rubber strip

### **EQUIPMENT USED:**

1. CNC Router

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2. Band Saw

3. Hand Tools

### **MANUFACTURING PROCESS:**

1. Receiving of standard PVC sheet. Sheet checked for correct type, quality and signed off.
2. Sheet is measured and cut to size, including all outlet holes and bolts holes. All holes drilled to size using pre-made templates. On sizes above 100mm, the face is prepared for the adding of the sealing face by routing a predetermined groove around as required to seal the floodgate flap.
3. The pipe is cut to suit, and if required a SCJ socket is formed on one end. The pipe short is prepared for welding and positioned on the main body. The angle of the lay back is checked to ensure this is correct. The branch is then tacked to the main body using a tacking tip on our Leister hot air tool. The angle is again checked.
4. The welding process is then undertaken using a Leister hot air tool. The 6mm V-gauge welding rod is scraped to ensure deoxidising. A speed tip is also used on the Leister hot air gun to ensure evenness of contact.
5. All pre-cut and drilled plates assembled using templates.
6. Nylon bolts and nuts are positioned and tighten until plates are positioned correctly.
7. The EPDM rubber sealing strip is positioned and solvent welded to the PVC floodgate head walls pre-routed groove.
8. The finished item(s) are checked to ensure that all aspects of it are correct in accordance with house quality requirements with our QA form is signed off (twice) by the factory foreman and warehouse controller.

**MANUFACTURERS DETAILS:** Strata Precision Plastics 2013 Ltd

**MANUFACTURERS FACTORY'S:** 789 Te Rapa Street, Hamilton

**QUALITY MANAGEMENT:** Strata Precision Plastics are accredited by Telarc NZ as having a compliant Q-Base Quality Management System.

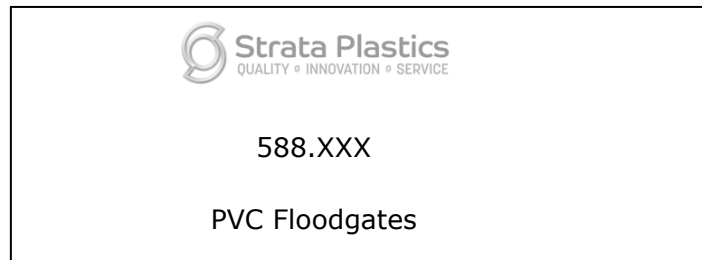
### **INSTALLATION REQUIREMENTS:**

Installation to be completed in accordance with the requirements of AS/NZS 2032:2006 and AS/NZS2566:2002. For installation of main pipeline other than PVC, i.e.: Concrete or Earthenware, extra attention must be taken to ensure the bonding of these two surfaces are achieved through the use of appropriate bonding materials i.e.: 2 Pot Epoxy Resin. For the connection to the PVC, normal procedures for the solvent cementing of pipes should be completed, including use of cleaner/primers. The use of stainless steel strapping or wire is also suitable to ensure compression is held on the joint to ensure no removal of contact between the two surfaces. Care must be taken not to over tighten causing structural damage to the pipe and the fitting.

### **MAINTENANCE REQUIREMENTS:**

In principle, there should be minimal requirement for the maintenance of this product where it has been installed correctly.

### **PRODUCT LABEL**



### **PRODUCT PHOTO &/or DRAWING:**



### **Glossary of Terms**

M&F	Male and Female ends
F&F	Female and Female ends
RRJ	Rubber Ring Joint
SCJ	Solvent Cement Joint
SN	Stiffness Nominal
SDR	Standard Dimensional Ratio
QA	Quality Assurance
DWV	Drain, Waste & Vent