

## PRODUCER STATEMENT

**PRODUCT DESCRIPTION:** SN4 Fabricated 45 or 88° Junctions – SCJ

**PRODUCT CODE:** 704.XXX.YYY.ZZ      XXX = Mainway Size    YYY = Branch    Size ZZ = Angle

**PRODUCT SIZE(s):** Main-way sizes – 225mm, 300mm, 375mm and 475mm  
Branch sizes – 100mm, 150mm, 175mm, 225mm, 300mm, 375mm and 475mm

**PRODUCT STANDARD(s):** AS/NZS 1254:2010

### **PRODUCT HISTORY:**

**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:** (Purpose/Application)

Produced for use in storm water systems, SN4 fabricated SCJ junctions provide for the most efficient means of connecting new and existing storm water connections to a storm water system.

Strata Precision Plastics SN4 fabricated SCJ junctions have been manufactured to the requirements of AS/NZS 1254 using quality products made by New Zealand manufacturers. All sizes of junctions have been produced to ensure the ease of installation for the contractor as well as the hydraulic requirements of local authorities.

### **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 are a pipe belling machine, hot air tools and specially designed hole cutting equipment. 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. Iplex Pipelines, Marley or RX Plastics - uPVC Storm water SN4 manufactured & tested in accordance with AS/NZS 1254.2010
2. Dotmar Plastics – uPVC 6mm V-gauge welding rod

For glassed option

3. HS Composites - Glass strand mat, Polyester resin and Gel coat

### **EQUIPMENT USED:**

1. Factory band saw
2. Pipe belling machine

### **Strata Plastics**

P +64 7 846 7239  
F +64 7 846 7240  
E [info@strataplastics.co.nz](mailto:info@strataplastics.co.nz)  
W [www.strataplastics.co.nz](http://www.strataplastics.co.nz)

36 Tawn Place  
PO Box 5315  
Frankton • Hamilton 3242  
New Zealand

## **MANUFACTURING PROCESS:**

1. Receiving of standard uPVC pipe from pipe supplier. Pipe checked for correct type, quality and signed off.
2. Belling machine set up, checked, and made ready for belling of pipe in accordance with belling check sheet.
3. Pipe measured and cut to length. Placed on belling machine to complete SCJ belling process.
4. SCJ socket checked for spigot insertion length and ring housing tolerance.

## **Manufacturing of Fitting**

1. The main body is prepared for welding by buffing with the area around the joining point a light sanding disc. This is to allow for the application of the fibreglass coating (option) on completion of the welding process.
2. The branch is buffed using a light sanding disc to allow for application of the fibreglass coating. The spigot end of the branch is then shaped to a curvature like that of the main body diameter.
3. The branch is positioned on to the main body; the angle of the branch is checked to ensure this is correct. The outline of the branch is then traced on to the main body. The hole for the branch is then cut out around outline using a jig saw. The branch is then fixed to the main way using a tacking tip on our hot air welding 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. On completion of welding, the internal bore of the branch is lightly sanded to ensure the bore is smooth. A check of the fitting is made, and the manufacturing section of our QA form is initialled.
6. The fitting is then transferred for fibre glassing. The process followed is,
  - a. Glass strand mat is cut to sizes.
  - b. Polyester resin and hardener mixed to predetermined amounts.
  - c. Resin/Hardener mix applied to mat.
  - d. Glass strand mat is placed on fitting and moulded to shape using laying tool.
  - e. Fitting(s) are left to dry naturally in a controlled environment.
  - f. On completion of drying, all roughed edges are sanded off smooth.
  - g. Gel coat is applied to fibre glassed area and left to dry naturally in a controlled environment.
  - h. A check of the fitting is made and the product label is applied.
  - i. The fibre glassing section of the QA form initialled.
7. The finished item(s) are checked to ensure that all aspects of it are correct in accordance with AS/NZS 1254 and our QA form is signed off (twice) by the factory foreman and warehouse controller.

**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.

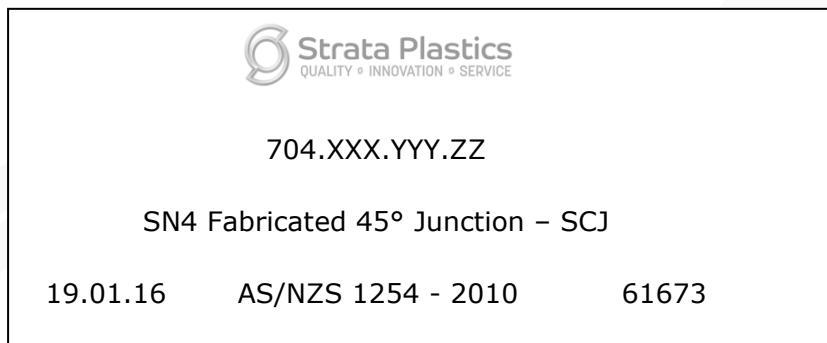
**INSTALLATION REQUIREMENTS:**

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:**

