

## Cutting pipes

Halifax pipes can be easily cut by using a powered disc cutting tool, but please ensure the correct grade of cutting disc is employed suitable for cast iron. Always follow Health & Safety guidelines as recommended by the tool manufacturer.

## Flow capacities

Maximum flow capacity of Halifax pipes running 1/4 full in a vertical installation and running full at various gradients (litres/second).

Flow Capacities					
Size	Vertical	1:40	1:60	1:80	1:100
50	1.2	1.46	1.19	1.03	0.92
70	2.7	4.29	3.5	3.03	2.71
100	7.2	9.24	7.55	6.54	5.55
150	21.7	27.3	22.3	19.3	17.2
200	43.7	58.7	47.9	41.5	37.1
250	79.3	106	86.9	75.2	76.3
300	129	173	141	122	109

It is recommended that 100mm pipes have a minimum fall of 1:40 and 150mm pipes have minimum fall of 1:60.

## Weights and masses

European Standard BS EN 877 states that the nominal masses of finished products shall be given in the manufacturers catalogues when measured in accordance with the table below.

The masses of the finished products shall be checked by weighing to an accuracy of within:

Weights and Masses	
0.01kg	for masses up to 1kg
0.1kg	for masses greater than 1kg up to 20kg
0.5kg	for masses greater than 20kg up to 100kg
1.0kg	for masses greater than 100kg

Above ground soil and rainwater system

## Pipes

**External:** Two part epoxy coating (red-brown colour) with an average dry wall thickness of 40 microns

**Internal:** Two part epoxy coating (yellow ochre colour) with average dry wall thickness of 130microns

## Fittings

**External:** Two part epoxy coating (red-brown colour) with an average dry wall thickness of 70 microns

**Internal:** Two part epoxy coating (red-brown colour) with average dry wall thickness of 70microns

Pipe Weights and Dimensional Tolerances				
Nominal	Outside		Weight kg/m	
Bore mm	Dia. mm	Tolerance	Empty	Full
50mm	58	+2 / -1	5.2	7.3
70mm	78	+2 / -1	6.4	10.4
100mm	110	+2 / -1	9.8	19.1
150mm	160	+2 / -2	15.0	33.2
200mm	210	+2 / -2	23.7	55.2
250mm	274	+2.5 / -2.5	33.3	87.7
300mm	326	+2.5 / -2.5	43.2	120.8

## Internal coatings

Our coatings have been successfully tested for resistance to attack by salt spray, waste water, hot water cycling and solutions of acid at PH2 and alkalis at PH12 and conform to BS EN 877 1999.

Our internal quality control procedures ensure the integrity of the coating is maintained through process monitoring and final inspection of coating thickness and adhesion.