



Cork Plastics,
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CORK PLASTICS PRODUCT SPECIFICATION FOR 110mm PVC-U BLACK DUCTING

Material Requirements: Material used for the manufacture of 110mm CP Black Ducting must meet the requirements of the CP Quality Management System conditions for purchase and verification of raw material.

Manufacturing Process: This product is manufactured by Cork Plastics at its plant in Little Island, Cork in its extrusion department.

The following Dimensional Specifications are checked and recorded 3 times per 12 hour shift as part of the In-Process inspection procedures:-

Min. Wall Thickness = 2.20mm

Max. Wall Thickness = 3.0mm

Min. Outside Diameter = 110.00mm

Max. Outside Diameter = 110.40mm

Min Socket Length = 75mm

Standard Pipe Length = 6m. Bale Quantity = 124 x 6m

Weathering/ Colour fastness: Colour of the pipe is stable in Ireland and UK conditions for 6 months external storage



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Traceability: Each pipe fully traceable to - material used, time/shift, date of manufacture, extrusion line number

Visual Checks are carried out by Extrusion Operators and Technicians on - marking, surface, bore, chamfer, cut ends and socket on a continuous basis.

The following Laboratory tests are carried out on the product to the relevant specifications.

Resistance to Dichloromethane (Gelation Test) to EN 580

Impact Test (round the clock method) to EN 744

Reversion Test (150°C) to EN ISO 2505-2

Compression Test 200N @ 5% of ID to EN 50086-2-4

Above product must also meet all of the requirements of the BSI certified Cork Plastics Quality Management System.