PVC Performance Engineered & Tested



SPEARS® Schedule 80 PVC product designs combine years of proven experience with computer generated stress analysis to yield the optimum physical structure and performance for each fitting. Material reinforcement is uniformly placed in stress concentration areas for substantially improved pressure handling capability. Resulting products are subjected to numerous verification tests to assure obtaining the very best PVC fittings available.

1/4" Through 14" Availability

Spears® comprehensive line of PVC injection molded fittings and extruded pipe offers a variety of configurations in sizes 1/4" through 14". Schedule 80 fittings are manufactured to ASTM D 2467 and pipe is produced to ASTM D 1785. Spears® exclusive CL150 Flanges are produced in sizes 1/2" - 18" with ANSI B16.5 bolt patterns, plus numerous Unions, Saddles, Transition and Specialty fittings in a variety of sizes.

Exceptional Chemical & Corrosion Resistance

Unlike metal, PVC fittings and pipe never rust, scale, or pit, and will provide many years of maintenance-free service and extended system life.

High Temperature Ratings



PVC thermoplastic can handle fluids at service temperatures up to 140°F (60°C), allowing a wide range of process applications, including corrosive fluids.

Lower Installation Costs

Substantially lower material costs than steel alloys or lined steel, combined with lighter weight and ease of installation, can reduce installation costs by as much as 60% over conventional metal systems.

Higher Flow Capacity

Smooth interior walls result in lower pressure loss and higher volume than conventional metal fittings.

Additional Fabricated Configurations through 36"

Extra large, hard-to-find, and custom configurations are fabricated from NSF® Certified pipe. Fittings are engineered and tested to provide full pressure handling capabilities according to Spears® specifications.

Advanced Design Specialty Fittings

Spears® wide range of innovative, improved products include numerous metal-to-plastic transition fittings and unions with Spears® patented special reinforced (SR) plastic threads.

PVC Valves

SPEARS® PVC Valve products are available for total system compatibility and uniformity.

PVC Sample Engineering Specifications

All PVC Schedule 80 pipe and fittings shall be produced by Spears® Manufacturing Company from PVC Type I, cell classification 12454, conforming to ASTM Standard D 1784. All PVC injection molded Schedule 80 fittings and extruded pipe shall be Certified for potable water service by NSF International. All Schedule 80 fittings shall be manufactured in strict compliance to ASTM D 2467 and Schedule 80 pipe shall be manufactured in strict compliance to ASTM D 1785. All fabricated fittings shall be produced in accordance with Spears® General Specifications for Fabricated Fittings. All PVC flanges shall be designed and manufactured to meet CL150 bolt pattern per ANSI Standard B16.5 and rated for a maximum internal pressure of 150 psi, non-shock at 73°F.

Suitable for Oil-Free air handling to 25 psi, not for distribution of compressed air or gas
Due to Material Cost Variations, Prices Subject to Change. Check On-line Catalog @ www.spearsmfg.com
Spears® Manufacturing Company

The information contained in this publication is based on current information and Product design at the time of publication and is subject to change without notification. Our ongoing commitment to product improvement may result in some variation. No representations, guarantees or warranties of any kind are made as to its accuracy, suitability for particular applications or results to be obtained therefrom. For verification of technical data or additional information not contained herein, please contact Spears® Technical Services Department [West Coast: (818) 364-1611 — East Coast: (678) 985-1263].

General Information

Recommendations For Installers And Users

Plastic piping systems should be ENGINEERED, INSTALLED and OPERATED in accordance with ESTABLISHED DESIGN AND ENGINEERING STANDARDS AND PROCEDURES for plastic piping systems. Suitability for the intended service application should be determined by the installer and/or user prior to installation of a plastic piping system. PRIOR TO ASSEMBLY, all piping system components should be inspected for damage or irregularities. Mating components should be checked to assure that tolerances and engagements are compatible. Do not use any components that appear irregular or do not fit properly. Contact the appropriate manufacturer of the component product in question to determine usability. Consult all applicable codes and regulations for compliance prior to installation.

Solvent Weld Connections — Use quality solvent cements and primers formulated for the intended service application, pipe size and type of joint. While the pipe and fitting materials may be compatible with the intended medium, the solvent cement may not be. Consult the manufacturers for suitability of use. Read and follow the cement and primer manufacturers' applications and cure time instructions thoroughly. Be sure to use the correct size applicator.

Threaded Connections — Use a quality grade thread sealant. WARNING: SOME PIPE JOINT COMPOUNDS OR PTFE PASTES MAY CONTAIN SUBSTANCES THAT COULD CAUSE STRESS CRACKING TO PLASTIC. Spears® Manufacturing company recommends the use of Spears® BLUE 75™ Thread Sealant which has been tested for compatibility with Spears® products. Please follow the sealant manufacturers' application/installation instructions. Choice of an appropriate thread sealant other than those listed above is at the discretion of the installer. 1 to 2 turns beyond FINGER TIGHT is generally all that is required to make a sound plastic threaded connection. Unnecessary OVERTIGHTENING will cause DAMAGE TO BOTH PIPE AND FITTING.

Standards and Specifications



Molded Schedule 80 PVC products are manufactured to ASTM D 2467 for use with pipe manufactured to ASTM D 1785. Certain products carry reduced pressure handling capability and have maximum internal pressure ratings at 73°F noted.

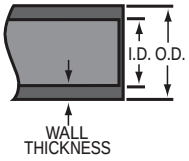
Fabricated Schedule 80 PVC pressure fittings (part numbers ending with "F") are manufactured to Spears® specifications for use with pipe manufactured to ASTM D 1785. General Specifications for Standard Fabricated Fittings for additional information.

All specified Schedule 80 PVC products are manufactured from materials certified by NSF® for use in potable water service.

"Lead Free" low lead certification – unless otherwise specified, all Spears® Schedule 80 fittings specified here-in are certified by NSF International to ANSI/NSF® Standard 61, Annex G and is in compliance with California's Health & Safety Code Section 116825 (commonly known as AB1953) and Vermont Act 193. Weighted average lead content <=0.25%. Spears® PVC Pipe, Fittings and Valves have always been lead-free and Certified by NSF International for use in potable water systems. Spears® offers a wide range of lead-free specialty fittings and transition adapters for plumbing applications. However, certain brass threaded adapter fittings for applications that are not intended to convey water for human consumption through drinking or cooking are still produced and available.

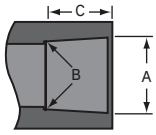
ASTM STANDARD DIMENSIONS

SCHEDULE 80 PIPE DIMENSIONS ASTM D 1785



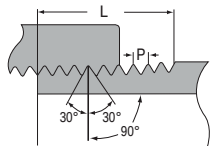
Nominal Pipe Size In.	Mean Outside Diameter In.	O. D. Tolerance In.	Minimum Wall Thickness In.
1/8	0.405	± 0.004	0.095
1/4	0.540	± 0.004	0.119
3/8	0.675	± 0.004	0.126
1/2	0.840	± 0.004	0.147
3/4	1.050	± 0.004	0.154
1	1.315	± 0.005	0.179
1-1/4	1.660	± 0.005	0.191
1-1/2	1.900	± 0.006	0.200
2	2.375	± 0.006	0.218
2-1/2	2.875	± 0.007	0.276
3	3.500	± 0.008	0.300
4	4.500	± 0.009	0.337
5	5.563	± 0.010	0.375
6	6.625	± 0.011	0.432
8	8.625	± 0.015	0.500
10	10.750	± 0.015	0.593
12	12.750	± 0.015	0.687

SCHEDULE 80 SOCKET DIMENSIONS ASTM D 2467



Nominal Size In.	Diameter			Socket Length Minimum C
	Entrance A	Bottom B	Tolerance A	
1/8	0.417	0.401	± 0.004	0.500
1/4	0.552	0.536	± 0.004	0.625
3/8	0.687	0.671	± 0.004	0.750
1/2	0.848	0.836	± 0.004	0.875
3/4	1.058	1.046	± 0.004	1.000
1	1.325	1.310	± 0.005	1.125
1-1/4	1.670	1.655	± 0.005	1.250
1-1/2	1.912	1.894	± 0.006	1.375
2	2.387	2.369	± 0.006	1.500
2-1/2	2.889	2.868	± 0.007	1.750
3	3.516	3.492	± 0.008	1.875
4	4.518	4.491	± 0.009	2.250
5	5.583	5.553	± 0.010	2.625
6	6.647	6.614	± 0.011	3.000
8	8.655	8.610	± 0.015	4.000
10	10.780	10.735	± 0.015	5.000
12	12.780	12.735	± 0.015	6.000
14	14.030	13.985	± 0.015	7.000

AMERICAN NATIONAL STANDARD TAPER PIPE THREADS (NPT) ANSI B1 .20.1 ASTM F 1498



Nominal Size In.	Threads Per Inch	Effective Thread Length L	Pitch Of Thread P
1/8	27	0.2639	0.03704
1/4	18	0.4018	0.05556
3/8	18	0.4078	0.05556
1/2	14	0.5337	0.07143
3/4	14	0.5457	0.07143
1	11-1/2	0.6828	0.08696
1-1/4	11-1/2	0.7068	0.08696
1-1/2	11-1/2	0.7235	0.08696
2	11-1/2	0.7565	0.08696
2-1/2	8	1.1375	0.12500
3	8	1.2000	0.12500
4	8	1.3000	0.12500
5	8	1.4063	0.12500
6	8	1.5125	0.12500
8	8	1.7125	0.12500



STANDARD COMPARISONS

SPEARS® IPS-to-Metric transition unions are listed by nominal size. The chart below compares nominal and actual* pipe O.D. for each size according to the designated standard.

JIS K6741 (mm)		DIN 8062 (mm)		ASTM D1785 (in.)		NPT—ANSI B1.20.1** Tapered Thread		BSP—BS21,DIN 2999,ISO 7/1 Thread	
Nominal	Actual*	O.D.	Actual*	Nominal	Actual*	Designation	Threads/in.	Designation	Threads/25.4mm
16	22	15	20	1/2	.840	1/2	14	1/2	14
20	26	20	25	3/4	1.050	3/4	14	3/4	14
25	32	25	32	1	1.315	1	11.5	1	11
30	38	38	40	1-1/4	1.660	1-1/4	11.5	1-1/4	11
40	48	40	50	1-1/2	1.900	1-1/2	11.5	1-1/2	11
50	60	50	63	2	2.375	2	11.5	2	11
75	89	80	90	3	3.500	3	8	3	11
100	114	100	110	4	4.500	4	8	4	11

*Specified dimension, certain tolerances apply **NPT and BSP have different thread angles and not compatible.

Suitable for Oil-Free air handling to 25 psi, not for distribution of compressed air or gas
Spears® Manufacturing Company
Due to Material Cost Variations, Prices Subject to Change. Check On-line Catalog @ www.spearsmfg.com

Schedule 80 Fittings

Injection Molded Dimensions Referencesces:

G = (LAYING LENGTH) intersection of center lines to bottom of socket/thread; 90° elbows, tees, crosses; ± 1/32 inch.
H = Intersection of center lines to face of fitting; 90° elbow tees, crosses; ± 1/32 inch.
J = Intersection of center lines to bottom of socket/thread; 45° elbows; ± 1/32 inch

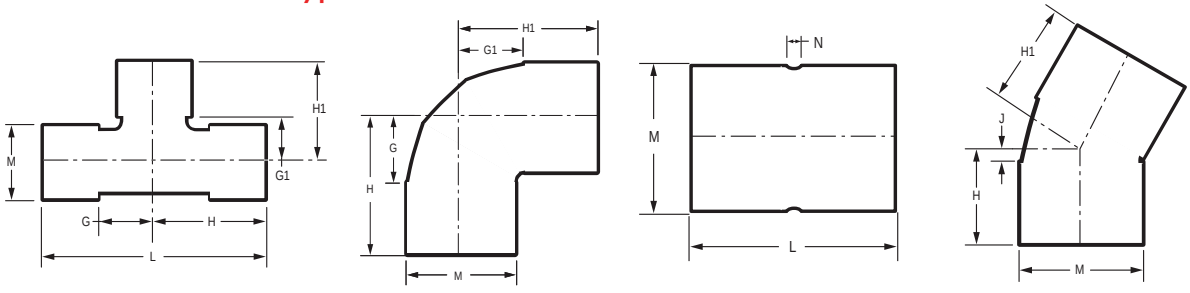
L = Overall length of fittings; ± 1/16 inch.
H = Outside diameter of socket/thread hub; ± 1/16 inch.
N = Socket bottom to socket bottom; couplings; ± 1/16 inch
W = Height of cap; ± 1/16 inch.

Fabricated Dimension References:

G = (LAYING LENGTH) intersection of center lines to bottom of socket/thread; 90° elbows, tees, crosses ± 1/4 inch; 14" & larger ± 1/2 inch.
H = Intersection of center lines to face of fitting; 90° elbows ± 1/4 inch, 14" & larger ± 3/4 inch; wyes ± 1/2 inch; tees, crosses ± 1/4 inch; 14" & larger ± 1/2 inch.
J = Intersection of center lines to bottom of socket/thread; 45° elbows; ± 1/4 inch; 14" & larger ± 1/2 inch.

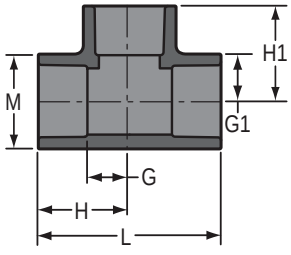
L = Overall length of fittings; ± 1/2 inch; 14" & larger ± 1 inch; wyes ± 1 inch.
M = Outside diameter of socket/thread hub; ± 1/4 inch.
N = Socket bottom to socket bottom; couplings; ± 1/2
W = Height of cap; ± 1/4 inch.

Typical Fabricated Dimension References



TEE

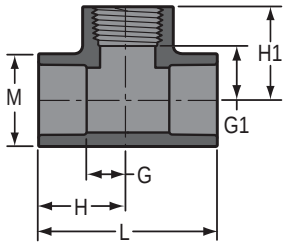
Socket x Socket x Socket



Part Number	Size	G	G1	H	H1	L	M	Approx. Wt. (Lbs.)
801-002	1/4	5/16	5/16	31/32	31/32	1-15/16	27/32	.04
801-003	3/8	15/32	15/32	1-1/4	1-1/4	2-1/2	31/32	.06
801-005	1/2	19/32	19/32	1-15/32	1-15/32	2-15/16	1-3/16	.11
801-007	3/4	21/32	21/32	1-11/16	1-11/16	3-13/32	1-13/32	.16
801-010	1	7/8	7/8	2	2	4	1-3/4	.27
801-012	1-1/4	1-1/32	1-1/32	2-9/32	2-9/32	4-19/32	2-3/32	.39
801-015	1-1/2	1-3/16	1-3/16	2-9/32	2-9/32	5-1/8	2-3/8	.52
801-020	2	1-7/16	1-7/16	2-15/16	2-15/16	5-7/8	2-7/8	.80
801-025	2-1/2	1-3/4	1-3/4	3-1/2	3-1/2	7-1/32	3-15/32	1.46
801-030	3	2-1/16	2-1/16	3-31/32	3-31/32	7-15/16	4-5/32	2.16
801-040	4	2-1/2	2-1/2	4-3/4	4-3/4	9-1/2	5-1/4	3.52

TEE

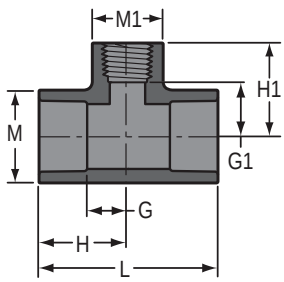
Socket x Socket x Fipt



Part Number	Size	G	G1	H	H1	L	M	Approx. Wt. (Lbs.)
802-002	1/4	5/16	3/8	15/16	15/16	1-29/32	7/8	.05
802-005	1/2	19/32	21/32	1-15/32	1-11/32	2-15/16	1-3/16	.14
802-007	3/4	5/8	5/8	1-19/32	1-13/32	3-3/16	1-13/32	.14
802-010	1	11/16	3/4	1-13/16	1-5/8	3-13/16	1-13/16	.23
802-012	1-1/4	13/16	1-1/16	2-3/32	1-15/16	4-5/32	2-3/32	.34
802-015	1-1/2	29/32	1-1/4	2-11/32	2-5/32	4-11/16	2-3/8	.49
802-020	2	1-9/32	1-15/32	2-13/16	2-13/32	5-21/32	2-7/8	.77
802-030	3	1-31/32	2-1/8	3-3/4	3-17/32	7-15/32	4-5/16	2.31
802-040	4	2-11/32	2-21/32	4-5/8	4-5/32	9-7/32	5-9/32	3.37
802-060F	6	3-3/4	8-5/8	6-3/4	10-1/8	13-11/2	7-5/8	14.19
802-080F	8	4-13/16	10-13/16	8-13/16	12-9/16	17-11/16	9-11/16	25.92

REDUCING TEE

Socket x Socket x Fipt



Part Number	Size	G	G1	H	H1	L	M	M1	Approx. Wt. (Lbs.)
802-101	3/4x3/4x1/2	19/32	25/32	1-19/32	1-7/16	3-7/32	1-13/32	1-3/16	.14
802-130	1x1x1/2	7/16	29/32	1-9/16	1-5/8	3-1/8	1-23/32	1-7/16	.18
802-131	1x1x3/4	21/32	13/16	1-13/16	1-17/32	3-5/8	1-23/32	1-3/8	.21
802-166	1-1/4x1-1/4x1/2	7/16	1-1/8	1-11/16	1-27/32	3-3/8	2-3/32	1-3/16	.26
802-167[1]	1-1/4x1-1/4x3/4	7/8	1-23/32	2-1/8	2-7/16	4-7/32	2-3/32	1-3/4	.40
802-168	1-1/4x1-1/4x1	27/32	1-1/32	2-3/32	1-29/32	4-7/32	2-3/32	1-11/16	.33
802-209[1]	1-1/2x1-1/2x1/2	11/16	1-9/16	2-3/32	2-9/32	4-5/32	2-11/32	1-13/32	.40
802-210[1]	1-1/2x1-1/2x3/4	7/8	1-27/32	2-1/4	2-19/32	4-1/2	2-3/8	1-11/16	.51
802-211	1-1/2x1-1/2x1	27/32	1-9/32	2-1/4	2-3/32	4-15/32	2-3/8	1-11/16	.41
802-212	1-1/2x1-1/2x1-1/4	1-1/32	1-5/32	2-7/16	2-3/32	4-27/32	2-3/8	2-1/16	.47
802-247[1]	2x2x1/2	1/2	1-1/2	2	2-7/32	4	2-7/8	1-3/16	.45
802-248	2x2x3/4	5/8	1-3/8	2-1/8	2-3/32	4-1/4	2-7/8	1-3/8	.47

[1] Outlet sized with bushing

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