

**Appendix H - Special Information on Fabricated Fittings**



Except for fittings produced to ASTM F1866, Spears® Fabricated Fittings conform to Spears® Manufacturing Company Special Engineering Specifications.

Not all of the Fabricated Fittings listed in this price schedule are carried in Spears® Distribution Center inventories. When ordering Fabricated Fittings, please check your servicing Distribution Center for availability. ALL ORDERS FOR NON-STOCKED Fabricated Fittings are NON-CANCELABLE and NON-RETURNABLE.

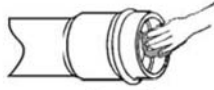
18" and larger Fabricated Fittings are available upon request. Please contact your servicing Spears® Regional Distribution Center for pricing and availability.

All 15" Fabricated Fittings shown as Class 63 are PIP O.D. Reducing fittings are 15" PIP O.D. x specified IPS size. Plastic Irrigation Pipe (PIP) and Iron Pipe Size (IPS) are not the same.

**Pipe Dimension Reference Chart**

Pipe Type	LH	80	100	125	CL 63	CL 100	SEWER	CL 125	CL 160	CL 200	40 DWV	80 DWV	SCH 40	SCH 80	C-900	
O.D. Size	PIP	PIP	PIP	PIP	IPS	IPS	PSM	IPS	IPS	IPS	IPS	IPS	IPS	IPS	CI	
SDR	91	51	41	32.5	64	41	35	32.5	26	21	—	—	—	—	DR 18	
4"	O.D.	4.130	4.130	4.130	4.130	4.500	4.500	4.215	4.500	4.500	4.500	4.500	4.500	4.500	4.800	
	I.D.	4.000	3.968	3.928	3.876	4.360	4.280	3.89	4.224	4.154	4.072	3.998	3.786	3.786	4.22	
	Wall	.065	.081	.101	.127	.070	.110	0.125	.138	.173	.214	.237	.337	.237	.337	267
	PSI	43	80	100	125	63	100	117.5	125	160	200	100	100	220	320	150
6"	O.D.	6.140	6.140	6.140	6.140	6.625	6.625	6.275	6.625	6.625	6.625	6.625	6.625	6.625	6.900	
	I.D.	6.000	5.898	5.840	5.762	6.417	6.301	5.742	6.217	6.115	5.993	6.031	6.031	5.709	6.08	
	Wall	.070	.121	.150	.189	.104	.162	0.18	.204	.255	.316	.280	.432	.280	.432	383
	PSI	43	80	100	125	63	100	117.5	125	160	200	100	180	280	150	
8"	O.D.	8.160	8.160	8.160	8.160	8.625	8.625	8.4	8.625	8.625	8.625	8.625	8.625	8.625	9.050	
	I.D.	7.984	7.840	7.762	7.658	8.355	8.205	7.665	8.095	7.961	7.805	7.943	7.565	7.943	7.565	7.97
	Wall	.088	.160	.199	.251	.135	.210	.024	.265	.332	.410	.322	.500	.322	.500	503
	PSI	43	80	100	125	63	100	117.5	125	160	200	100	100	160	250	150
10"	O.D.	10.200	10.200	10.200	10.200	10.750	10.750	10.5	10.750	10.750	10.750	10.750	10.750	10.750	11.100	
	I.D.	9.980	9.800	9.702	9.572	10.414	10.226	9.563	10.088	9.924	9.748	9.976	9.492	9.976	9.492	9.78
	Wall	.110	.200	.249	.314	.168	.262	0.3	.331	.413	.511	.365	.593	.365	.593	617
	PSI	43	80	100	125	63	100	117.5	125	160	200	100	100	140	230	150
12"	O.D.	12.240	12.240	12.240	12.240	12.750	12.750	12.5	12.750	12.750	12.750	12.750	12.750	12.750	13.200	
	I.D.	11.975	11.760	11.642	11.486	12.352	12.128	11.361	11.966	11.770	11.538	11.890	11.294	11.890	11.294	11.63
	Wall	.132	.240	.299	.377	.199	.311	0.36	.392	.490	.606	.406	.687	.406	.687	733
	PSI	43	80	100	125	63	100	117.5	125	160	200	100	100	130	230	150
14"	O.D.	14.280	14.280	14.280	14.280	*	*	*	*	14	14.000	14.000	14.000	14.000	15.3	
	I.D.	14.000	13.720	13.584	13.402	*	*	*	*	12.86	13.072	12.410	13.072	12.410	13.48	
	Wall	.140	.280	.348	.439	*	*	*	*	0.538	.438	.750	.438	.750	0.85	
	PSI	43	80	100	125	*	*	*	*	160	100	100	130	220	235	
15"	O.D.	15.300	15.300	15.300	15.300	*	*	15.3	*	*	*	*	*	*	*	
	I.D.	14.970	14.700	14.550	14.358	*	*	13.898	*	*	*	*	*	*	*	
	Wall	.165	.300	.375	.471	*	*	0.44	*	*	*	*	*	*	*	
	PSI	43	80	100	125	*	*	117.5	*	*	*	*	*	*	*	
16"	O.D.	*	*	*	*	*	*	*	*	16	16.000	16.000	16.000	16.000	17.4	
	I.D.	*	*	*	*	*	*	*	*	14.696	14.940	14.214	14.940	14.214	15.33	
	Wall	*	*	*	*	*	*	*	*	0.615	.500	.843	.500	.843	0.967	
	PSI	*	*	*	*	*	*	*	*	160	100	100	130	220	235	
18"	O.D.	18.360	18.701	18.701	18.701	*	*	18.000	18.701	18.000	18	18.000	18	18.000	19.5	
	I.D.	17.964	17.967	17.789	17.551	*	*	17.122	17.629	16.616	16.808	16.014	16.808	16.014	17.83	
	Wall	.198	.367	.456	.575	*	*	.439	0.536	.692	0.562	.937	0.582	.937	1.083	
	PSI	43	80	100	125	*	*	100	117.5	160	100	100	120	220	235	
20"	O.D.	20.400	*	*	*	*	*	20.000	*	20.000	20	20	20	20	21.6	
	I.D.	19.962	*	*	*	*	*	19.026	*	18.462	18.863	17.814	18.863	17.614	19.03	
	Wall	.219	*	*	*	*	*	.487	*	.769	0.533	1.031	0.533	1.031	1.2	
	PSI	43	*	*	*	*	*	100	*	160	100	100	120	220	235	
21"	O.D.	*	22.047	22.047	22.047	*	*	22.047	*	*	*	*	*	*	*	
	I.D.	*	21.183	20.971	20.691	*	*	20.783	*	*	*	*	*	*	*	
	Wall	*	.432	.538	.678	*	*	0.632	*	*	*	*	*	*	*	
	PSI	*	80	100	125	*	*	117.5	*	*	*	*	*	*	*	
24"	O.D.	*	24.803	24.803	24.803	*	*	24.000	24.8	24	24	24	24	24	25.800	
	I.D.	*	23.831	23.593	23.277	*	*	22.748	23.381	22.043	22.54	21.418	22.54	21.418	23.73	
	Wall	*	.486	.605	.763	*	*	.585	0.711	0.923	0.687	1.218	0.687	1.218	1.200	
	PSI	*	80	100	125	*	*	100	117.5	160	100	100	120	210	235	

\* Information Not Available

**GASKET INSTALLATION PROCEDURES***Figure 1**Figure 2**Figure 3*

1. Gasket area and pipe or spigot end should be clean and free of dirt and debris. **DO NOT** attempt to remove the formed-in gasket — *Figure 1*.
2. Lubricate the entire sealing surface of the gasket and the pipe or spigot end with a light coating of a suitable lubricant. Make sure the pipe or spigot end has a proper bevel to insure ease of installation — *Figure 2*.
3. Push the pipe or spigot end into the gasket bell while maintaining a straight alignment. The proper insertion depth is equal to the total gasket bell length minus one-half inch (1/2") — *Figure 3*.