

AMENDMENT NO. 1 NOVEMBER 2009  
TO  
IS 15265 : 2003 FLEXIBLE PVC PIPES OR POLYMER  
REINFORCED THERMOPLASTIC HOSES FOR SUCTION  
AND DELIVERY LINES OF AGRICULTURAL PUMPS —  
SPECIFICATION

*(Foreword, para 5)* — Substitute 'Annex G' for 'Annex F'.

*(Page 1, clause 2)* — Delete '12656 : 1989 Rubber or plastic hoses and tubing — Bending test' and insert the following:

12235 (Part 1) : 2004 Thermoplastics pipes and fittings — Methods of tests : Part 1 Measurement of dimensions (*first revision*)

*(Page 3, clause 6.6, lines 1 and 2)* — Substitute 'Annex E' for 'method A given in IS 12656'.

*(Page 3, clause 6.7, lines 1 to 6)* — Substitute the following for the existing:

'Requisite length of sample shall be conditioned in a cold chamber at a temperature of  $-10 \pm 2^{\circ}\text{C}$  for 5 hours. After conditioning for 5 hours the sample shall be removed from the cold chamber. The test must be started within 60 seconds from the time of removal of sample from the cold chamber and completed within 120 seconds from the time of removal of sample from the cold chamber. The test shall be carried out in accordance with method specified in Annex E and using a minimum radius of curvature(e) of 10 times the nominal bore. During the test hose shall not crack or fold or exhibit a kink and shall pass the proof test (*see 6.1*).'

*(Page 4, clause 6.8, line 1)* — Substitute 'Annex F' for 'Annex E'.

*(Page 8, Annex D)* — Insert the following 'Annex E' at the end:

**ANNEX E**  
(Clauses 6.6 and 6.7)

**BEND RADIUS TEST**

**E-1 APPARATUS**

The apparatus consists of two guide's — *A* and *B*, Guide *A* being fixed in a plane and Guide *B* being movable in that plane, parallel to, and in line with, Guide *A* (see Fig. 4).

**E-2 TEST PIECES**

**E-2.1 Types and Dimensions**

The test pieces shall consist either of complete manufactured lengths of hose or of suitable test lengths. If the manufactured length is shorter than the length required for the test, test pieces of adequate length (see E-4) shall be specially manufactured.

**E-2.2 Number**

Unless otherwise specified, two test pieces shall be tested.

**E-3 CONDITION OF TEST PIECES**

No test shall be carried out within 24 h of manufacture.

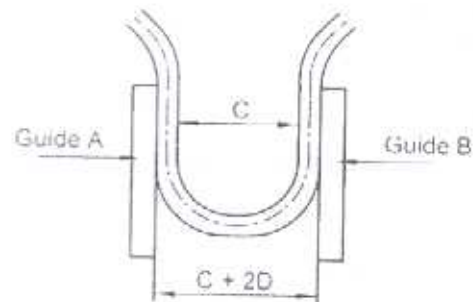


FIG. 1 TYPICAL APPARATUS FOR BEND RADIUS TEST

**E-4 PROCEDURE**

Determine the average external diameter  $D$ , of the hose by means of a suitable measuring instrument as specified in IS 12235 (Part 1).

Draw two parallel and diametrically opposite lines along the length of hose. If the hose has natural curvature, one of the lines shall be on the outside of the curve. On each of these lines, mark a distance of  $1.6 C + 2 D$  or 200 mm whichever is longer, where  $C$  is twice the minimum bend radius specified in the appropriate specification, so that the marked distances are exactly opposite. This will ensure a sufficient length for the bend test and adequate support of the hose.

Separate the Guides  $A$  and  $B$  to a distance slightly less than  $1.6 C + 2 D$ . Place the hose between the guides so that the ends of the marked distances are parallel to the ends of the guides and remain in this position while the guides are closed to a distance of  $C + 2 D$  (see Fig. 4).

Check that the hose on each side is supported to a length of not less than  $D$ .

(Page 9, Annex E) — Substitute 'ANNEX F' for 'ANNEX E' and renumber the other clauses accordingly.

(Page 10, Annex F) — Substitute 'ANNEX G' for 'ANNEX F'.

(CED 50)