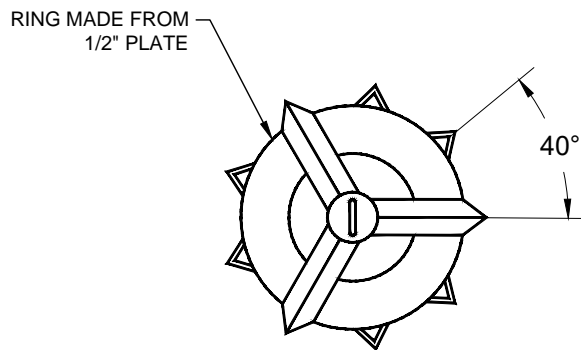
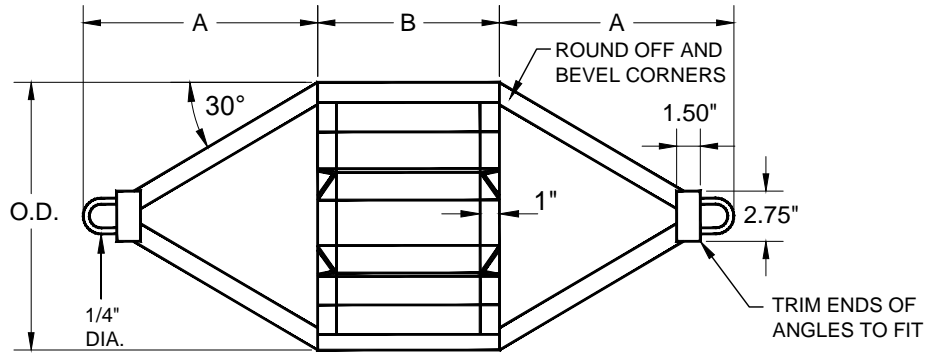


GO, NO-GO DEFLECTION TESTING MANDREL
 CONSTRUCTED FROM 1/2" - INCH ANGLE IRON



NOTE:
 AFTER WELDING IS COMPLETED, TRUE THE OUTSIDE
 DIAMETER DIMENSION FOR THE FULL LENGTH OF "B"
 TO (=/-) 0.010" BY TOOL AND LATHE OR GRINDING

SIZE	A (inch)	B (inch)	MANDREL OUTSIDE DIAMETER (in.) FOR 7 1/2% DEFLECTION			RING OUTSIDE DIAMETER (in.)			FOR STRAIGHT WALL-PVC	
			PSP DR 42	PSM DR 42	PSM DR 35	PSP DR 41	PSM DR 42	PSM DR 35	NOMINAL SIZE	MIN. I.D. OF PIPE
4	2.24	4	3.55		3.59	2.84		2.84	4	3.88
6	3.76	4	5.35		5.34	4.62		4.59	6	5.77
8	5.33	6	6.96	7.18	7.15	6.25	6.47	6.39	8	7.73
10	6.88	6	8.70	8.97	8.94	7.99	8.26	8.17	10	9.666
12	8.35	8	10.45	10.60	10.64	9.74	9.97	9.86	12	11.50
15	10.52	9	13.05		13.15				15	14.22
18	12.92	10			15.92				18	17.21
21	15.39	10			18.77				21	20.29
24	17.42	10			21.11				24	22.826
27	19.75	10			23.80				27	25.725

NOT TO SCALE

DATE: SEPT. 2020

STANDARD CONSTRUCTION DRAWING



TYPICAL MANDREL DETAIL

DRAWING NO.
 SAS-20