



EMPIREWEST, INC.

PO Box 521

Springville, Utah 84663

(801) 812-2818

(801) 812-2823 Fax

(800) 829-3742 Toll Free

www.empire-west.com

info@empire-west.com

DUCTILE IRON FLANGED PIPING TECHNICAL DATA

Ductile iron to be used for flanged piping or grooved for Victaulic type couplings shall be new and unused pipe, minimum wall thickness class 53 per AWWA C151.75 or ANSI A21.51-1975 centrifugally cast in metal mold molds, thin cement lined unless otherwise specified..

As a standard practice, ductile iron pipe shall be furnished with ductile iron screwed flanges. Flanges shall conform to the respective chemical and physical properties specified for gray iron and ductile iron fittings in ANSI A21.10 or AWWA C110 and shall be drilled in accordance with CL125 ANSI B.16.1-1948 or CL250 ANSI B.16.6-1944.

Wall rings (seep rings) installed on flanged ductile iron piping shall be one piece mild steel with a minimum thickness of 1/4 inch and minimum flange of 2 inches.

FABRICATION PROCEDURE

Ductile iron piping shall be cut to length and grooved both ends or threaded with an American standard iron pipe taper thread as per ANSI B2.1. Flanges shall be screwed on tight and sealed with an epoxy to seal tightly and prevent leakage. Bolt holes shall be aligned by mechanical means to assure perfect alignment of the two flanges. On flange by plain end piping, the plain end shall be machine cut so that the end is square and the face of pipe is smooth and flat. Permissible length variance from specified length shall be +/- 1/16 inch.

Grooving dimensions are the same for any one pipe O.D. regardless of pipe class and pressure rating.



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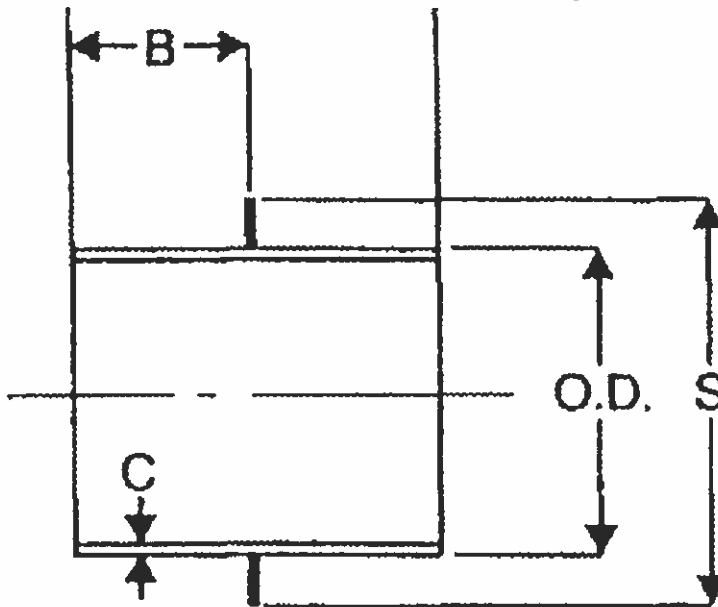
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OUTFALL #1
18" x 36" PE x PE w/SR 6" F.E.



P.E. x P.E.

B = 6"

C = .44"

OD = 19.50"

S = 23.10"



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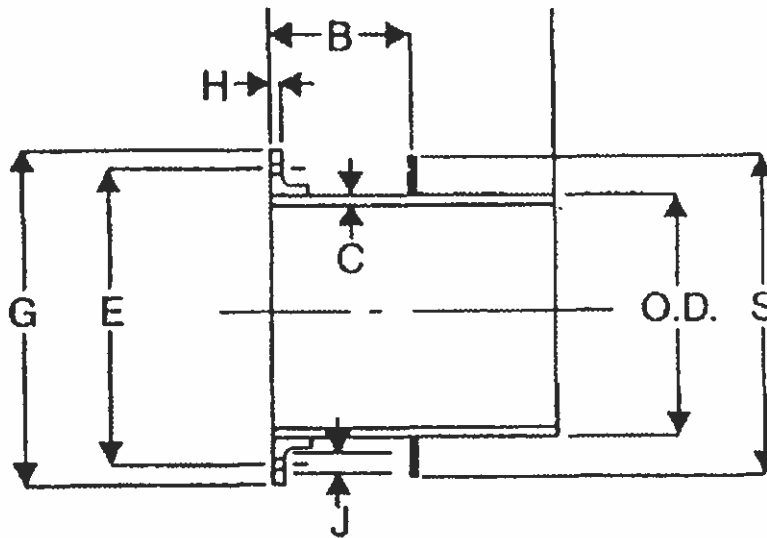
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OUTFALL #2
4x16 F x PE w/SR 8" FFF



FLG. x P.E.

$$B = 8"$$

$$C = .32"$$

$$E = 7.50"$$

$$G = 9.00"$$

$$H = .82" - 1.06"$$

$$J = .75"$$

$$OD = 4.80"$$

$$S = 7.40"$$



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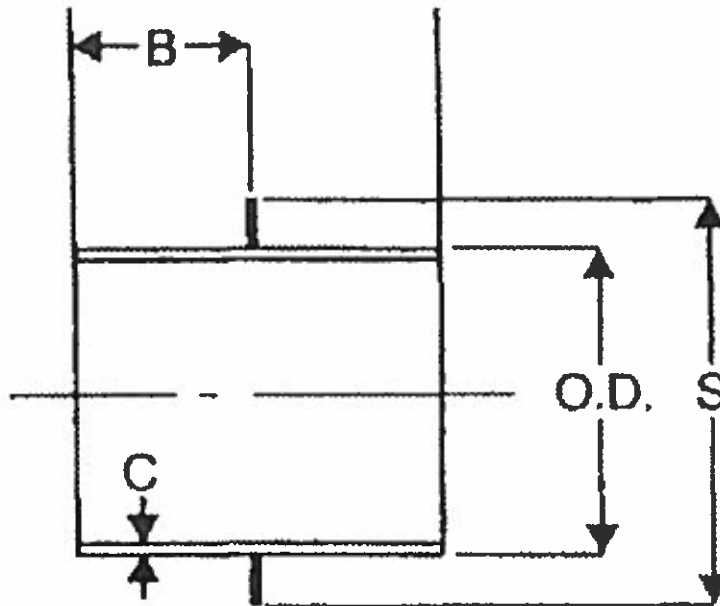
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OUTFALL # 3,4
10" x 30" PE x PE w/SR 6" FE



P.E. x P.E.

B = 6"

C = .38"

OD = 11.10"

S = 14.10"



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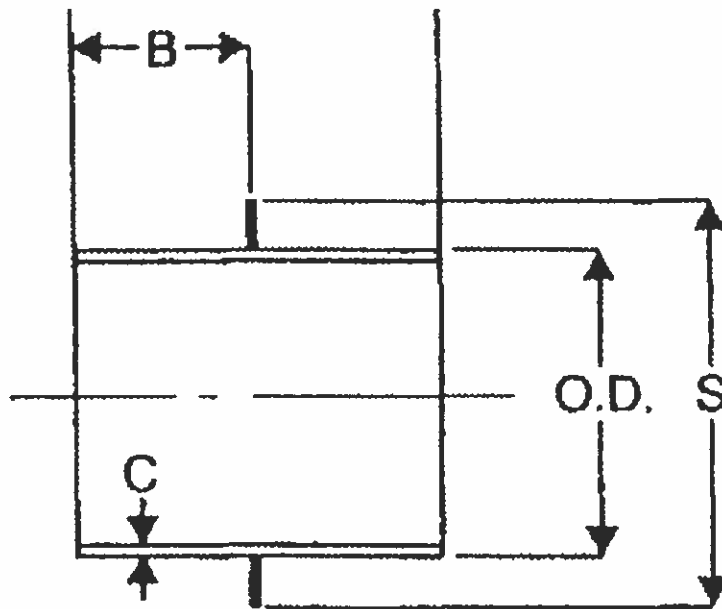
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Headtank #1

12" x 36" PE x PE w/ SR 6" FE



P.E. x P.E.

B = 6"

C = .40"

OD = 13.20"

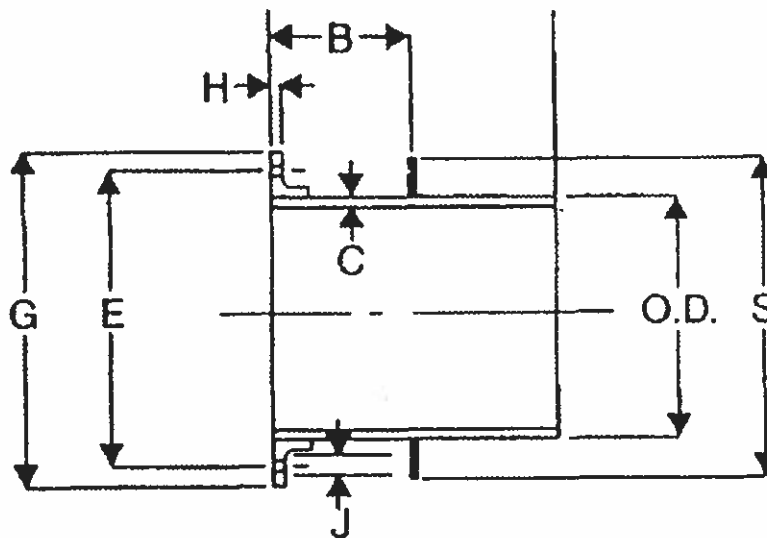
S = 16.25"



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Head tank #2
12" x 36" FLG. x P.E. w/ SR 1'6" FFF



FLG. x P.E.

$$B = 1'6"$$

$$C = .40"$$

$$E = 17.00"$$

$$G = 19.00"$$

$$H = 1.37"$$

$$J = 1.00"$$

$$OD = 13.20"$$

$$S = 16.25"$$

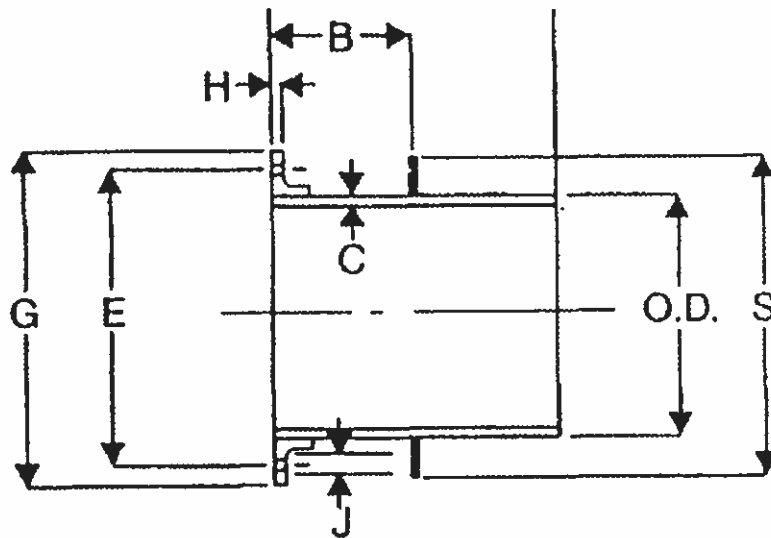


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Headtank #3

18"x36" FxPE w/ SR 1'6" FFF



FLG. x P.E.

B = 1'6"

C = .44"

E = 22.75"

G = 25.00"

H = 1.75"

J = 1.25"

OD = 19.50"

S = 23.10"



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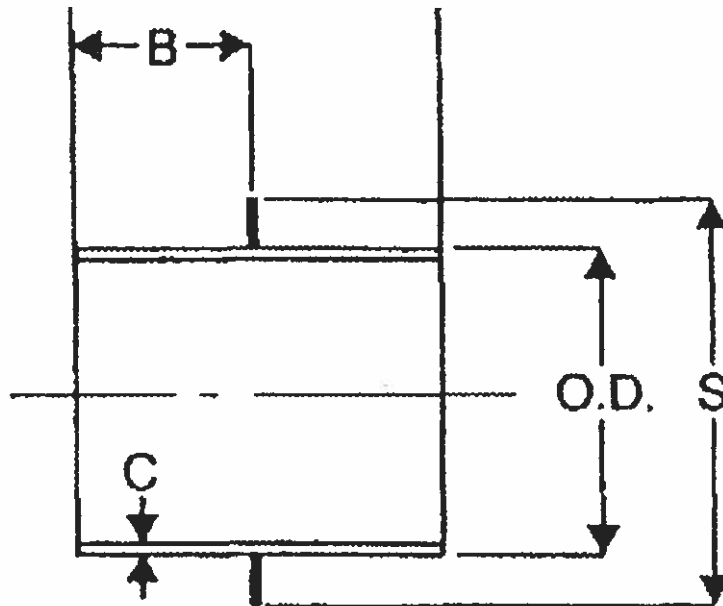
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Hatchery #1,2,3

12"x36" P x P w/ SR 6" FE



P.E. x P.E.

$$B = 6''$$

$$C = .40''$$

$$OD = 13.20''$$

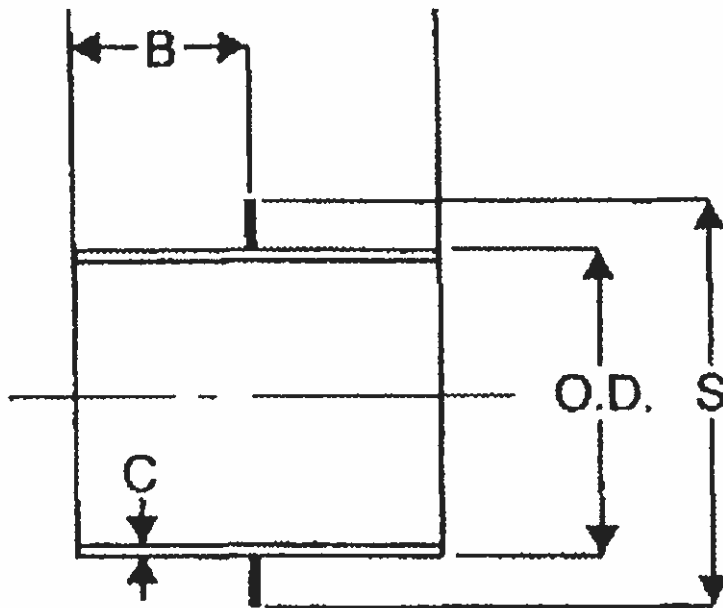
$$S = 16.25''$$



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Hatchery # 4,5
10"x36" P x P w/ SR 6" FE



P.E. x P.E.

$$B = 6"$$

$$C = .38"$$

$$OD = 11.10"$$

$$S = 14.10"$$



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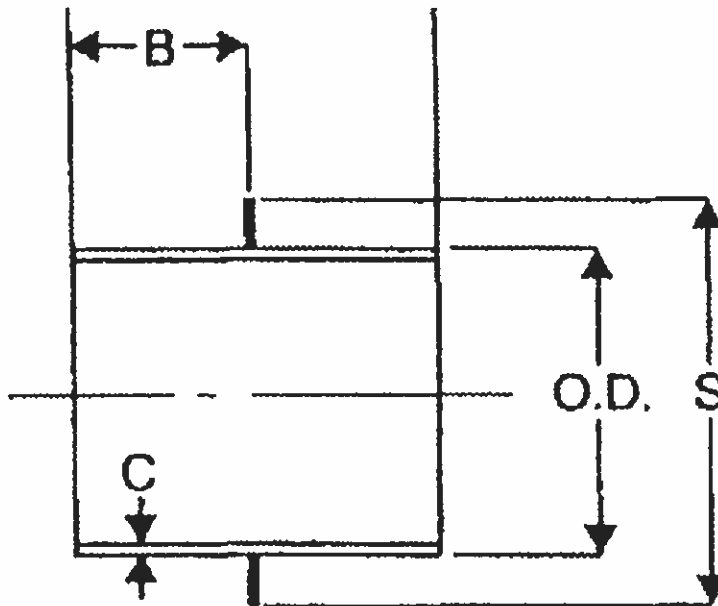
(800) 829-3742 Toll Free

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Hatchery #6

6" x 36" P x P w/ SR 6" FE



P.E. x P.E.

B= 6"

C= .34"

OD= 6.90"

S= 9.50"



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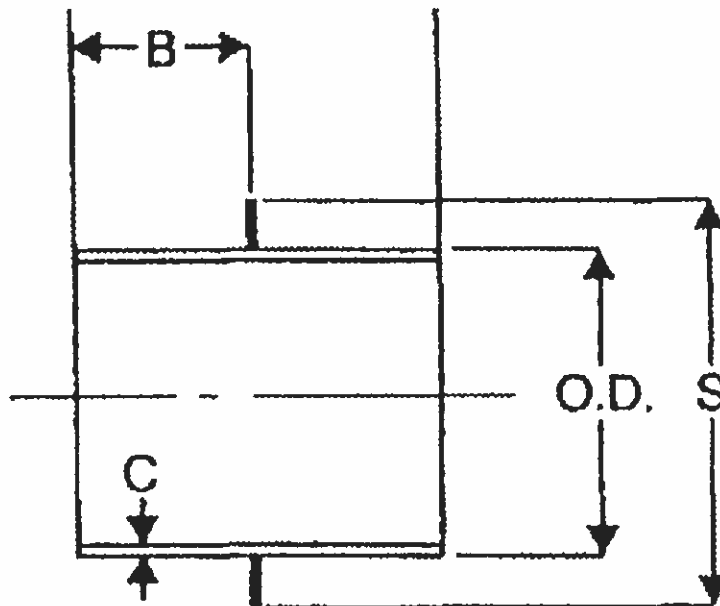
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Hatchery #7

4x36 P x P w/ SR 6" FE



P.E. x P.E.

B = 6"

C = .32"

OD = 4.80"

S = 7.40"



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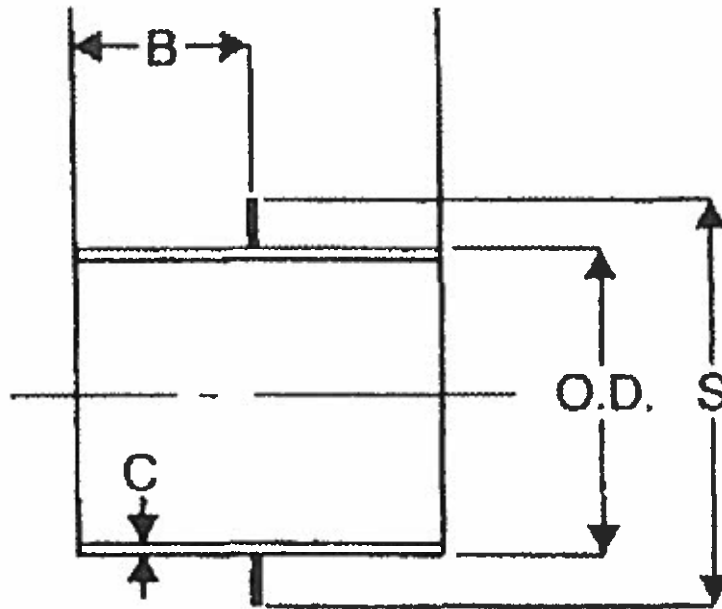
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Hatchery #8

8" x 36" P x P w/ SR 6" FE



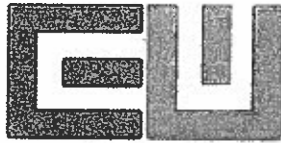
P.E. x P.E.

B = 6"

C = .36"

OD = 9.05"

S = 12.00"



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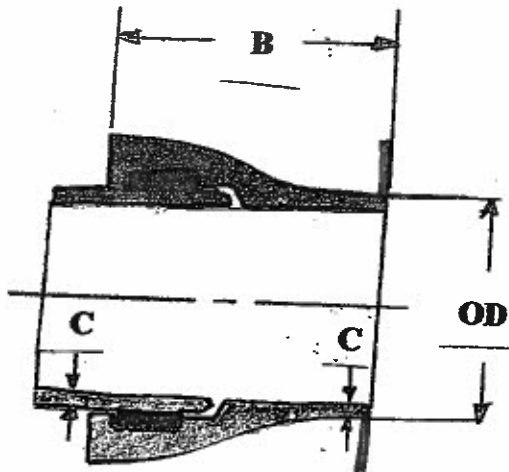
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Hatchery # 9, 10, 11, 12, 13, 14, 15, 16

10x24 HxP w/SR 6" FFB

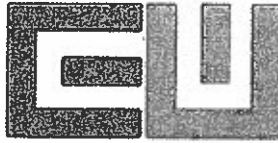


PUSH ON JOINT DUCTILE IRON PIPE

$$B = 6"$$

$$C = .38"$$

$$OD = 11.10"$$



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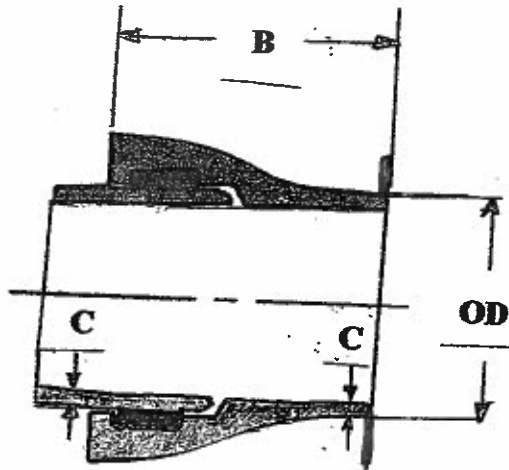
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Hatchery # 17,18

6x24 HxP w/ SR 6" FFB



PUSH ON JOINT DUCTILE IRON PIPE

B = 6"

C = .34"

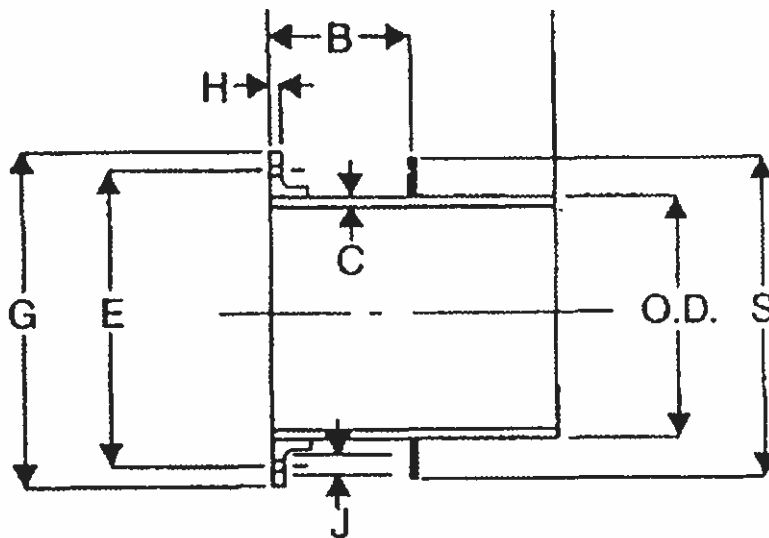
OD = 6.90"



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Hatchery #19
8" x 30" FxP w/ SR 12" FFF



FLG. x P.E.

B = 12"

C = .36"

E = 11.75"

G = 13.50"

H = 1.24"

J = .875"

OD = 9.05"

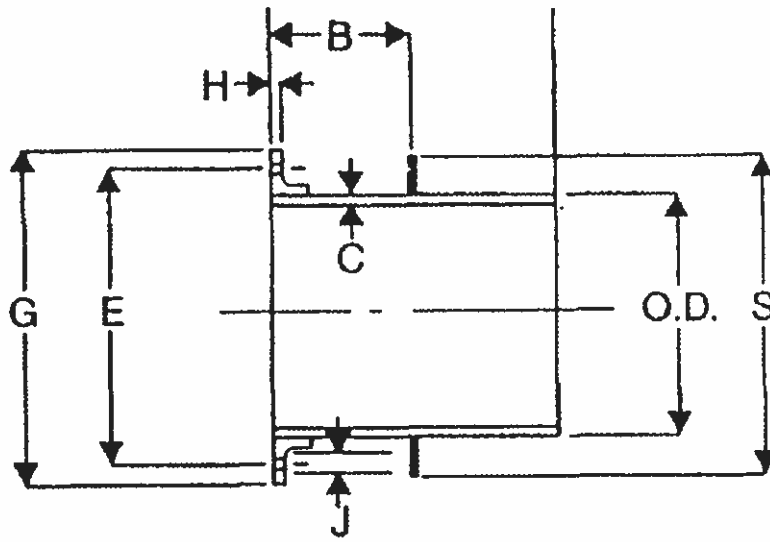
S = 12.00"



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Hatchery # 20, 21
6"x30" FxP w/ SR 12" FFF



FLG. x P.E.

B = 12"

C = .34"

E = 9.50"

G = 11.00"

H = 1.12"

J = .875"

OD = 6.90"

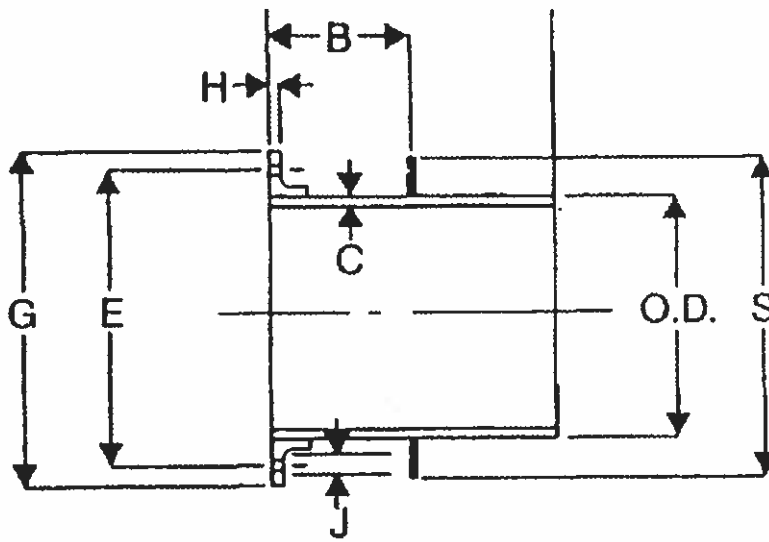
S = 9.50"



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Hatchery #22
4x30 FxP w/SR 12" FFF



FLG. x P.E.

B = 12"

C = .32"

E = 7.50"

G = 9.00"

H = 1.00"

J = .75"

OD = 4.80"

S = 7.40"



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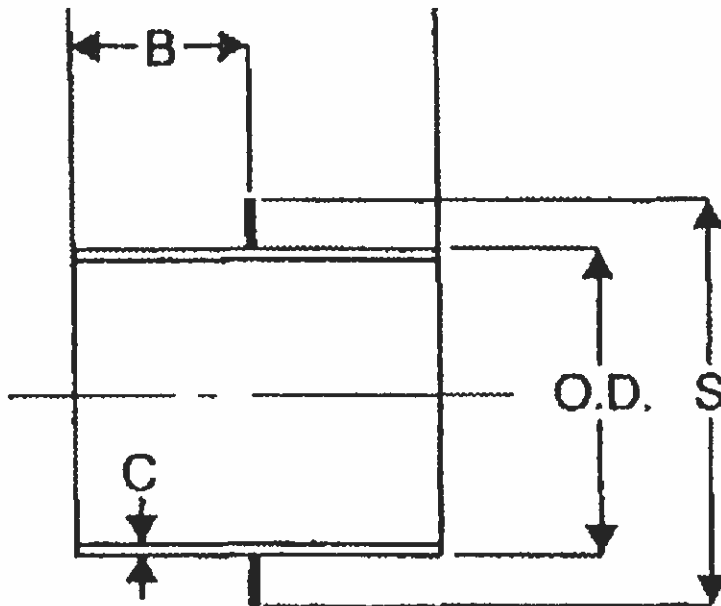
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Hatchery #23
10x36 P x P w/ SR 6" FE



P.E. x P.E.

B= 6"

C= .38"

OD= 11.10"

S= 14.10"



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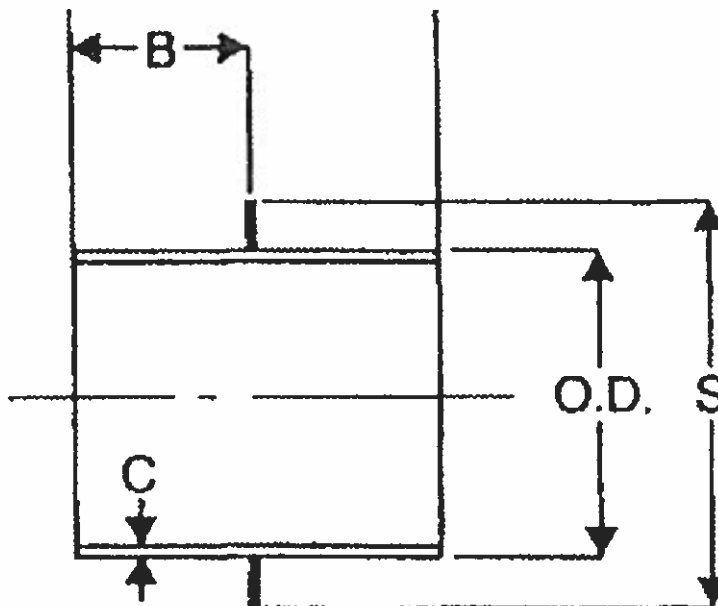
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Hatchery # 24

12x36 P x P w/ SR 6" FE



P.E. x P.E.

B = 6"

C = .40"

OD = 13.20"

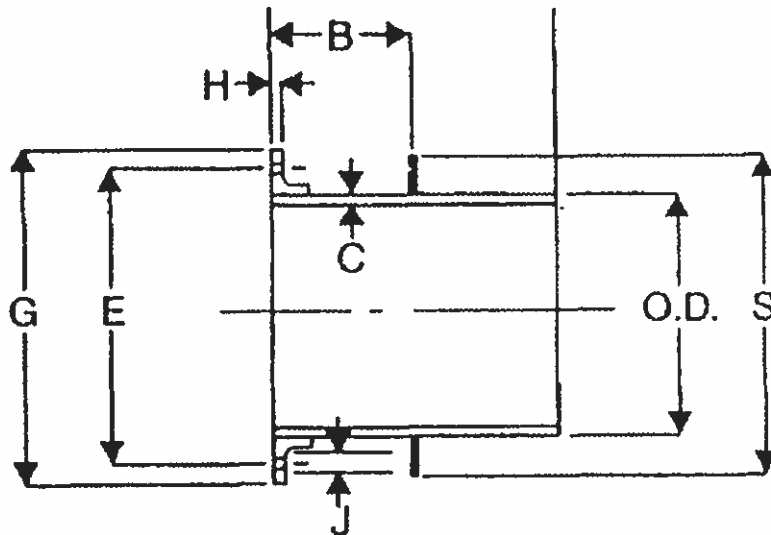
S = 16.25"



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Clarifier # 1,2,3,4,5,6
4x16 FxP w/ SR 8" FFF



FLG. x P.E.

B = 8"

C = .32"

E = 7.50"

G = 9.00"

H = 1.06"

J = .75"

OD = 4.80"

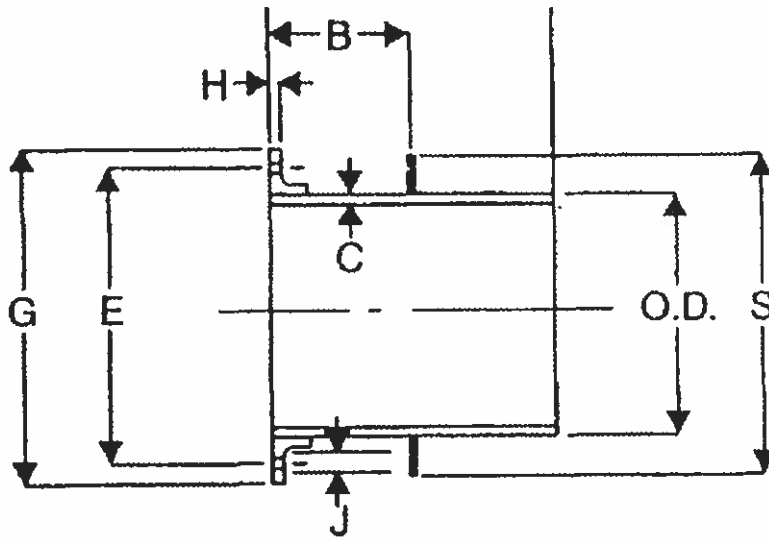
S = 7.40"



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Clarifier # 7,8
4x36 FxP w/ SR 8" FFF



FLG. x P.E.

$$B = 8"$$

$$C = .32"$$

$$E = 7.50"$$

$$G = 9.00"$$

$$H = 1.06"$$

$$J = .75"$$

$$OD = 4.80"$$

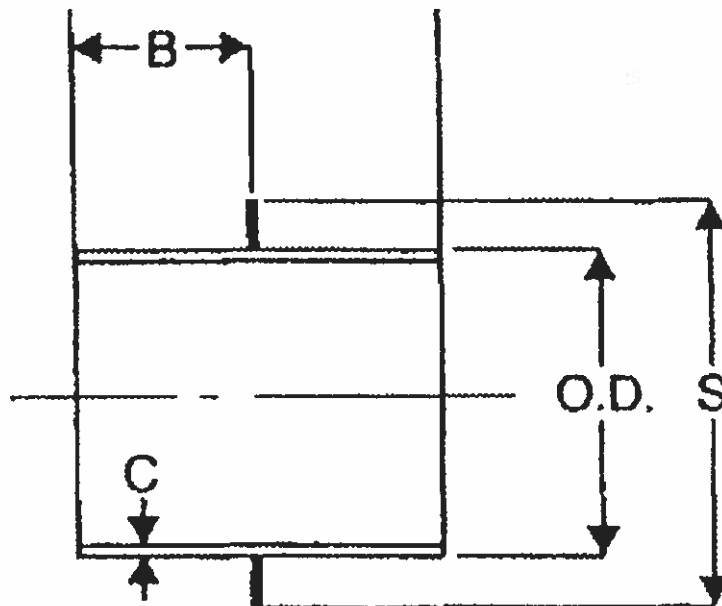
$$S = 7.40"$$



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Clarifier # 9,10
4x36 P x P w/ SR 8" FE



P.E. x P.E.

$$B = 8"$$

$$C = .32"$$

$$OD = 4.80"$$

$$S = 7.40"$$



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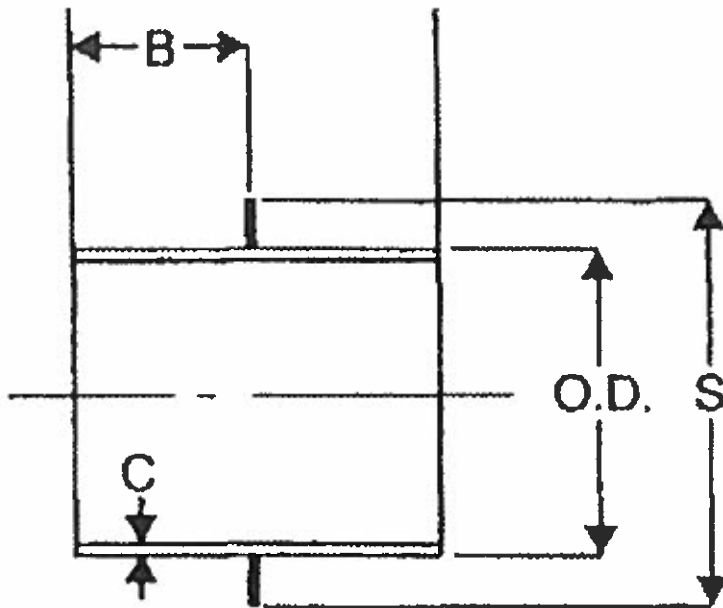
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Clarifier # 11, 12

12x36 P x P w/ SR 5" FE



P.E. x P.E.

$$B = 5"$$

$$C = .40"$$

$$OD = 13.20"$$

$$S = 16.25"$$



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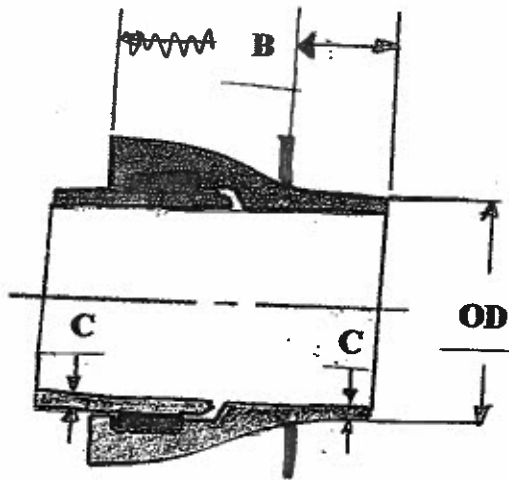
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Clarifier # 13.14

8" x 48" H x P w/ SR 6" From Plain End



PUSH ON JOINT DUCTILE IRON PIPE

B =

C = .36"

OD = 9.05"