



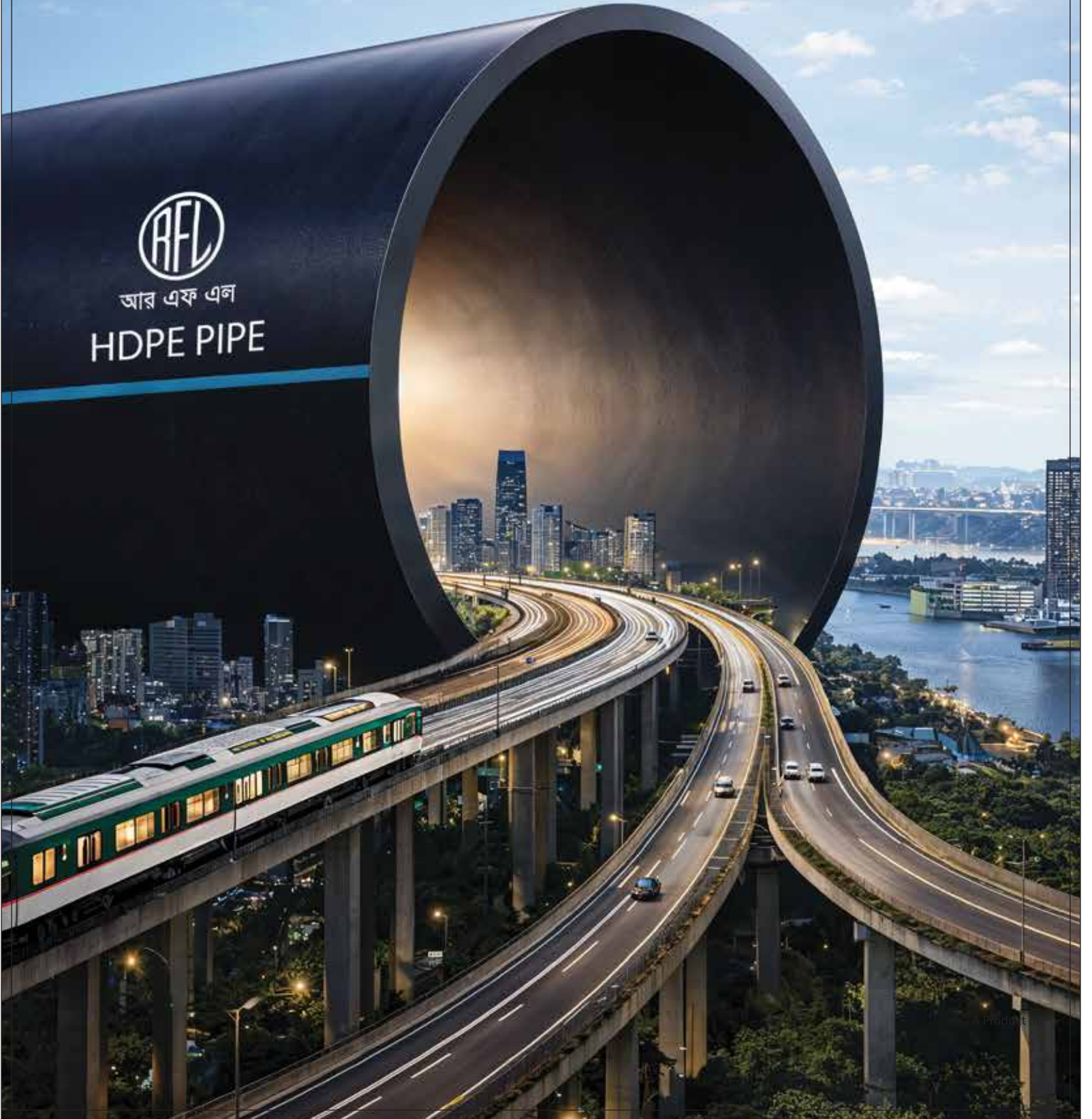
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HDPE

PIPE & FITTINGS
Industrial Piping Solution



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HDPE PIPE





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HDPE

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ABOUT US

RFL started its journey with Cast Iron (CI) products in 1981. The company was founded by Late Maj Gen Amjad Khan Chowdhury (rtd) whose main objective was to ensure pure water and affordable irrigation instruments for improving rural life. With the passage of time RFL expands its business in many other areas and now is one of the leading companies of Bangladesh in PVC Pipe, Metal Pipe, Door, Water Tank, Pump, Motor, Electronics Home Appliance, Fan, Light, Plastic Household, Melamine, Stationery, Bicycle, Furniture, Medical Equipment etc businesses. After meeting the demand of Bangladesh RFL also starts exporting to different countries of the world. RFL is very much hopeful to bear the flag of Bangladesh across the world with pride.

RFL has become a benchmark for competitors on the lines of quality by manufacturing premium quality products to give clients excellent services and true value for money. The unmatched products have given a big name in the domestic market. This is possible because the company is professionally managed and promoted by people who ensure creativity.

RFL Plastics currently utilizes 2500 molds through 350 machines having a growth rate of 40% over last year backed by own tooling facilities in the factory premises. The behind growth story of this brand is expansion & availability of innovative & affordable solution for household durables & utensils.

We are a very strong organization of 5000 employees dedicated to supplying customized and quality plastic products globally.



RFL HDPE Pipes



RFL HDPE Pipe Laying

What is Polyethylene?

When scientists first experimented with a reaction between ethylene and benzaldehyde using two thousand atmospheres of internal pressure, their experiment went askew when all the pressure escaped due to a leak in the testing container. On opening the tube they were stunned to find a white waxy substance that looked a lot like some form of plastic. After repeating the experiment, they discovered that the loss of pressure was not due to a leak at all, but was a result of the polymerization process. The residue polyethylene (PE) resin was a milky white, translucent substance derived from ethylene ($\text{CH}_2=\text{CH}_2$). Polyethylene was produced with low to high density.

Low-density polyethylene (LDPE) has a density ranging from 0.91 to 0.93 g/cm³. The molecules of LDPE have a carbon backbone with side groups of four to six carbon atoms attached randomly along the main backbone. LDPE is the most widely used of all plastics, because it is inexpensive, flexible, extremely tough, and chemical-resistant. LDPE is molded into bottles, garment bags, frozen food packages, and plastic toys.

High-density polyethylene (HDPE) has a density that ranges from 0.94 to 0.97 g/cm³. Its molecules have an extremely long carbon backbone with no side groups. As a result, these molecules align into more compact arrangements, accounting for the higher density. HDPE is stiffer, stronger, and less translucent than low-density polyethylene. HDPE is formed into car fuel tanks, packaging and of course piping.

With second generation (medium density PE80) the ESCR is improved by increasing the chain branching and lowering the density as much as possible. The creep resistance is decreased to its lowest possible value in order to optimize ESCR; the knee before 50 years @ 20°C disappeared, but the short-term resistance decreased due to the lower density.

In third generation (high density PE80 and PE100) ESCR is improved by branching only the long chains, thereby not decreasing the density (maintaining stiffness/creep resistance). Short chain branches inserted on the longer molecules ensure an efficient increase of the resistance to stress cracking in the long term, while creep resistance is maintained through high density (no branches on short chains that crystallize easily).

PE Classification ISO 4427 - 1996E.

Designation	Classification MRS (MPa)	Design Stress (MPa) Water
PE100	10,0	at 8,0
PE80	8,0	6,3
PE63	6,3	5,0
PE40	4,0	3,2
PE32	3,2	2,5



RFL HDPE Pipe 1400 mm

RFL HDPE Irrigation manufactures HDPE Pipe and corrugated plastic pipe for Pipe line networks of Gas, Liquid, Solids & Other applications.

What we refer to as HDPE pipe - also known as Poly Pipe, PE pipe or Polyethylene pipe - is manufactured by extrusion technology in sizes ranging from 16 mm to 1400 mm diameter.



1400 mm RFL HDPE Pipe Production

If you are looking for rugged dependability, light weight, long lasting service, trouble-free installation, flexibility, superior flow rates, high chemical resistant and extremely high corrosion resistance without compromising on efficiency RFL HDPE piping systems are the perfect solution.

If you want to know about this piping system, please contact us and we will gladly answer any of your questions.

Applications of RFL HDPE

Liquid	Gas	Solid	Other
Water Supply Drainage & Sewers Industrial Liquids, Chemicals Marine Works, Sea Intake and Outfall	Gas Piping Land-fill Gas Extractions Ventilation	Dredging Mining	Electrical Conduits Telecom Cable Ducts Manholes Culverts Geother- mal Heating Perforated Pipes

For over twenty-one years we have manufactured plastic pipe for a wide range of industrial, commercial and residential applications. Some of the more popular applications of our PE pipe include Gas pipes, Water mains, Sewers, Drainage and Cable duct.

Normally colours available in PE pipes

Sr. No.	Colour	Application	References
1.	Black	For Sewer	IS 14333
2.	Gray	For Treated effluent	General Practice
3.	Black with blue strips	For water supply	IS 4984
4.	Yellow, Orange	For gas distribution	IS 14885

Temperature Effect

HDPE pipes have a wide range of temperature application. RFL HDPE pipes perform well at temperatures ranging from -40°C to 45°C for pressure applications and upto 80°C for non-pressure gravity-flow applications. However for higher temperature applications, suitable pressure de-ratings should be applied.

Exposed to sunlight installation of RFL HDPE pipes will be subjected to temperature rise and fall during day and night which will cause pipe to change in length as it expands and contracts. Proper precautions should be taken for these linear expansions and contractions to avert damages to the pipe joints. System design should accommodate changes in the pipeline due to linear expansion or contraction. Expansion joints should not be used unless they are specially designed for HDPE pipe systems.

Temperature Rating Tables

Temp°C	Extrapolation limit years	Design Factor	RFL HDPE allowable operating pressure MAOP (m head water)							
			PN4	PN6.3	PN8	PN10	PN12.5	PN16	PN20	PN25
20	100	1	40	64	80	100	127	160	200	250
25	100	1.1	36	58	73	91	115	145	182	227
30	100	1.1	36	58	73	91	115	145	182	227
35	50	1.2	33	53	67	83	106	133	167	208
40	50	1.2	33	53	67	83	106	133	167	208
45	35	1.3	31	49	62	77	99	123	154	192
50	22	1.4	29	46	57	71	91	114	143	179
55	15	1.4	29	46	57	71	91	114	143	179
60	7	1.5	27	43	53	67	85	107	133	167
80	1	2	20	32	40	50	63	80	100	125

Temperature effect on HDPE pipe durability

RFL HDPE Pipe-Applications

Municipalities, Corporations & Metro Water

- Pumping Mains for Water
- Distribution Mains for Water
- Force Main for Sewer
- Gravity Main for Sewer
- House Service Connections
- Lining of old pipelines
- Horizontal Direction Drilling.
- Pipe Bursting - Replacement of old Pipes
- Dredging
- Storm Water Drain & Diversion

Utility Services

- Natural and LP Gas Distribution
- Untreated and Treated Effluent
- Electrical Cable Ducting
- Optical Fibre Cable Ducting
- Telecommunication Cable Ducting
- Waste Water Treatment
- Aeration and Odour Control Ducting
- Sea Intake & Out fall pipes
- Culverts, Storm Water Drains
- Power Plant : Boiler Blow-down
- Power Plant : Fly-Ash Slurry
- Power Plant: Fire Main
- Reverse Osmosis Pipeline

Mining Industry

- Leach Lines
- Coal Decant Systems
- Mine Drainage
- Coal Tailings
- Slurry and Sludge Transport
- De-watering
- Dust Suppression
- Sand Stowing
- Fire Hydrant Systems

Industry

- Pulp & Paper
- Chemical Process Lines
- Corrosive Liquids
- Water Treatment
- Marine In-take & Out-fall
- Fertilizers
- Rice Mills

Irrigation

- Drip Irrigation
- Lift Irrigation
- Gated Pipe Irrigation
- Sprinkler Irrigation

Landfill

- Leachate Collection & Transportation
- Methane Collection & Transportation



RFL HDPE Pipe 1400 mm



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RFL HDPE Pipe Dimension Chart as per ISO 4427:2007 Standard

				SDR 6		SDR 7.4		SDR 9		SDR 11	
				S 2.5		S 3.2		S 4		S 5	
PE 100						PN 25		PN 20		PN 16	
Nominal Size	Diameter, mm		Ovality	Wall Thickness, mm							
	dn Min	dn Max	Max	e Min	e Max	e Min	e Max	e Min	e Max	e Min	e Max
16	16.00	16.30	1.20	3.00	3.40	2.30	2.70	2.00	2.30	-	-
20	20.00	20.30	1.20	3.40	3.90	3.00	3.40	2.30	2.70	2.00	2.30
25	25.00	25.30	1.20	4.20	4.80	3.50	4.00	3.00	3.40	2.30	2.70
32	32.00	32.30	1.30	5.40	6.10	4.40	5.00	3.60	4.10	3.00	3.40
40	40.00	40.40	1.40	6.70	7.50	5.50	6.20	4.50	5.10	3.70	4.20
50	50.00	50.40	1.40	8.30	9.30	6.90	7.70	5.60	6.30	4.60	5.20
63	63.00	63.40	1.50	10.50	11.70	8.60	9.60	7.10	8.00	5.80	6.50
75	75.00	75.50	1.60	12.50	13.90	10.30	11.50	8.40	9.40	6.80	7.60
90	90.00	90.60	1.80	15.00	16.70	12.30	13.70	10.10	11.30	8.20	9.20
110	110.00	110.70	2.20	18.30	20.30	15.10	16.80	12.30	13.70	10.00	11.10
125	125.00	125.80	2.50	20.80	23.00	17.10	19.00	14.00	15.60	11.40	12.70
140	140.00	140.90	2.80	23.30	25.80	19.20	21.30	15.70	17.40	12.70	14.10
160	160.00	161.00	3.20	26.60	29.40	21.90	24.20	17.90	19.80	14.60	16.20
180	180.00	181.10	3.60	29.90	33.00	24.60	27.20	20.10	22.30	16.40	18.20
200	200.00	201.20	4.00	33.20	36.70	27.40	30.30	22.40	24.80	18.20	20.20
225	225.00	226.40	4.50	37.40	41.30	30.80	34.00	25.20	27.90	20.50	22.70
250	250.00	251.50	5.00	41.50	45.80	34.20	37.80	27.90	30.80	22.70	25.10
280	280.00	281.70	9.80	46.50	51.30	38.30	42.30	31.30	34.60	25.40	28.10
315	315.00	316.90	11.10	52.30	57.70	43.10	47.60	35.20	38.90	28.60	31.60
355	355.00	357.20	12.50	59.00	65.00	48.50	53.50	39.70	43.80	32.20	35.60
400	400.00	402.40	14.00	-	-	54.70	60.30	44.70	49.30	36.30	40.10
450	450.00	452.70	15.60	-	-	61.50	67.80	50.30	55.50	40.90	45.10
500	500.00	503.00	17.50	-	-	-	-	55.80	61.50	45.40	50.10
560	560.00	563.40	19.60	-	-	-	-	62.50	68.90	50.80	56.00
630	630.00	633.80	22.10	-	-	-	-	70.30	77.50	57.20	63.10
710	710.00	716.40	0.00	-	-	-	-	79.30	87.40	64.50	71.10
800	800.00	807.20	0.00	-	-	-	-	89.30	98.40	72.60	80.00
900	900.00	908.10	0.00	-	-	-	-	102.00	112.00	81.70	90.00
1000	1000.00	1009.00	0.00	-	-	-	-	113.33	125.00	90.20	99.40
1200	1200.00	1210.80	-	-	-	-	-	-	-	-	-
1400	1400.00	1412.60	-	-	-	-	-	-	-	-	-



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SDR 13.6		SDR 17		SDR 21		SDR 26		SDR 33		SDR 41	
S 6.3		S 8		S 10		S 12.5		S 16		S 20	
PN 12.5		PN 10		PN 8		PN 6		PN 5		PN 4	
Wall Thickness, mm											
e Min	e Max	e Min	e Max	e Min	e Max	e Min	e Max	e Min	e Max	e Min	e Max
-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-
2.00	2.30	-	-	-	-	-	-	-	-	-	-
2.40	2.80	2.00	2.30	-	-	-	-	-	-	-	-
3.00	3.50	2.40	2.80	2.00	2.30	-	-	-	-	-	-
3.70	4.20	3.00	3.40	2.40	2.80	2.00	2.30	-	-	-	-
4.70	5.30	3.80	4.30	3.00	3.40	2.50	2.90	-	-	-	-
5.60	6.30	4.50	5.10	3.60	4.10	2.90	3.30	-	-	-	-
6.70	7.50	5.40	6.10	4.30	4.90	3.50	4.00	-	-	-	-
8.10	9.10	6.60	7.40	5.30	6.00	4.20	4.80	-	-	-	-
9.20	10.30	7.40	8.30	6.00	6.70	4.80	5.40	-	-	-	-
10.30	11.50	8.30	9.30	6.70	7.50	5.40	6.10	-	-	-	-
11.80	13.10	9.50	10.60	7.70	8.60	6.20	7.00	-	-	-	-
13.30	14.80	10.70	11.90	8.60	9.60	6.90	7.70	-	-	-	-
14.70	16.30	11.90	13.20	9.60	10.70	7.70	8.60	-	-	-	-
16.60	18.40	13.40	14.90	10.80	12.00	8.60	9.60	-	-	-	-
18.40	20.40	14.80	16.40	11.90	13.20	9.60	10.70	-	-	-	-
20.60	22.80	16.60	18.40	13.40	14.90	10.70	11.90	-	-	-	-
23.20	25.70	18.70	20.70	15.00	16.60	12.10	13.50	9.70	10.80	7.70	8.60
26.10	28.90	21.10	23.40	16.90	18.70	13.60	15.10	10.90	12.10	8.70	9.70
29.40	32.50	23.70	26.20	19.10	21.20	15.30	17.00	12.30	13.70	9.80	10.90
33.10	36.60	26.70	29.50	21.50	23.80	17.20	19.10	13.80	15.30	11.00	12.20
36.80	40.60	29.70	32.80	23.90	26.40	19.10	21.20	15.30	17.00	12.30	13.70
41.20	45.50	33.20	36.70	26.70	29.50	21.40	23.70	17.20	19.10	13.70	15.20
46.20	51.10	37.40	41.30	30.00	33.10	24.10	26.70	19.30	21.40	15.40	17.10
52.20	57.60	42.10	46.50	33.90	37.40	27.20	30.10	21.80	24.10	17.40	19.30
58.80	64.80	47.40	52.30	38.10	42.10	30.60	33.80	24.50	27.10	19.60	21.70
	73.00	53.30		42.90	47.30	34.40	38.30	27.60	30.50	22.00	24.30
72.50	79.90	59.30	65.40	47.70	52.60	38.20	42.20	30.60	33.50	24.50	27.10
		67.90	74.80	57.20	63.10	45.90	50.60	36.70	40.45		
		82.40	90.80	66.70	73.50	53.50	59.00	42.90	47.30		

PLB Optical Fibre Cable Ducts



RFL HDPE - PLB Optical Fibre Cable Ducts

- Co-Extrusion process was developed in-house by RFL HDPE in their R&D facility during 1993.
- RFL HDPE Ducts (permanently lubricated) is the result of innovative development in co-extrusion by RFL HDPE
- It is the versatile and unique solution for High Speed Air Blowing (HSAB) of Optical Fibre Cable (OFC).
- RFL HDPE Cable Ducts are manufactured with state-of-the-art machinery using latest processing technology and fulfill the performance requirement of National & International specifications.
- Common Sizes 32/25, 40/33, 50/43, , 63/54
- Approved vendor and supplier to Fiber@Home in india and Summit communications Ltd, ICT Ministry and aslo many customers in other countries as well. Capable of manufacturing tailor-made as per specifications to suit customer's requirements.
- Supplied in coils of various lengths up to diameter 63mm.
- Supplied with pre-inserted PP rope on request.

RFL HDPE Self Lubricated HDPE Duct

RFL HDPE manufacture RFL HDPE SLB HDPE Duct which is the latest innovation from their R&D. RFL HDPE SLB HDPE ducts are manufactured with high performing virgin HDPE material with the inner surface of the duct self lubricated by homogenous construction to give a smooth finish and low co-efficient of friction. RFL HDPE SLB HDPE Ducts have the same constructional stability and strength as that of RFL HDPE Silicoat™ HDPE Duct and can withstand the pressure during HSAB as well as traffic load.



RFL HDPE Micro Duct

RFL HDPE Ribbed Walled Duct

MAXIMA Ducts can also be supplied with inner lubricated area in ribbed form. Ribbed Wall is ideal for pulling or jetting cable, thus reducing surface contact with cable during installation. It is available in various sizes and colours.

RFL HDPE Micro Ducts are specifically made for installation in the existing (new or old, empty or preoccupied) HDPE ducts by blowing, jetting or pulling technique. The ducts can be bunched & blown in various combinations & colors thus allowing extra channels for future cabling needs & increased pathway. Its low sliding friction aids in easier blowing & jetting of Micro-ducts & allows longer pulling distance thus increasing duct integrity resulting in quality installation at lower cost.

RFL HDPE Micro-ducts are available in 5mm, 7mm, 8mm, 10mm, 12 mm & 14mm OD with different wall-thicknesses with multiples ways. Micro ducts are available with permanently lubricated smooth inner wall or ribbed inner wall.

RFL HDPE Butt Fusion Molded Fittings

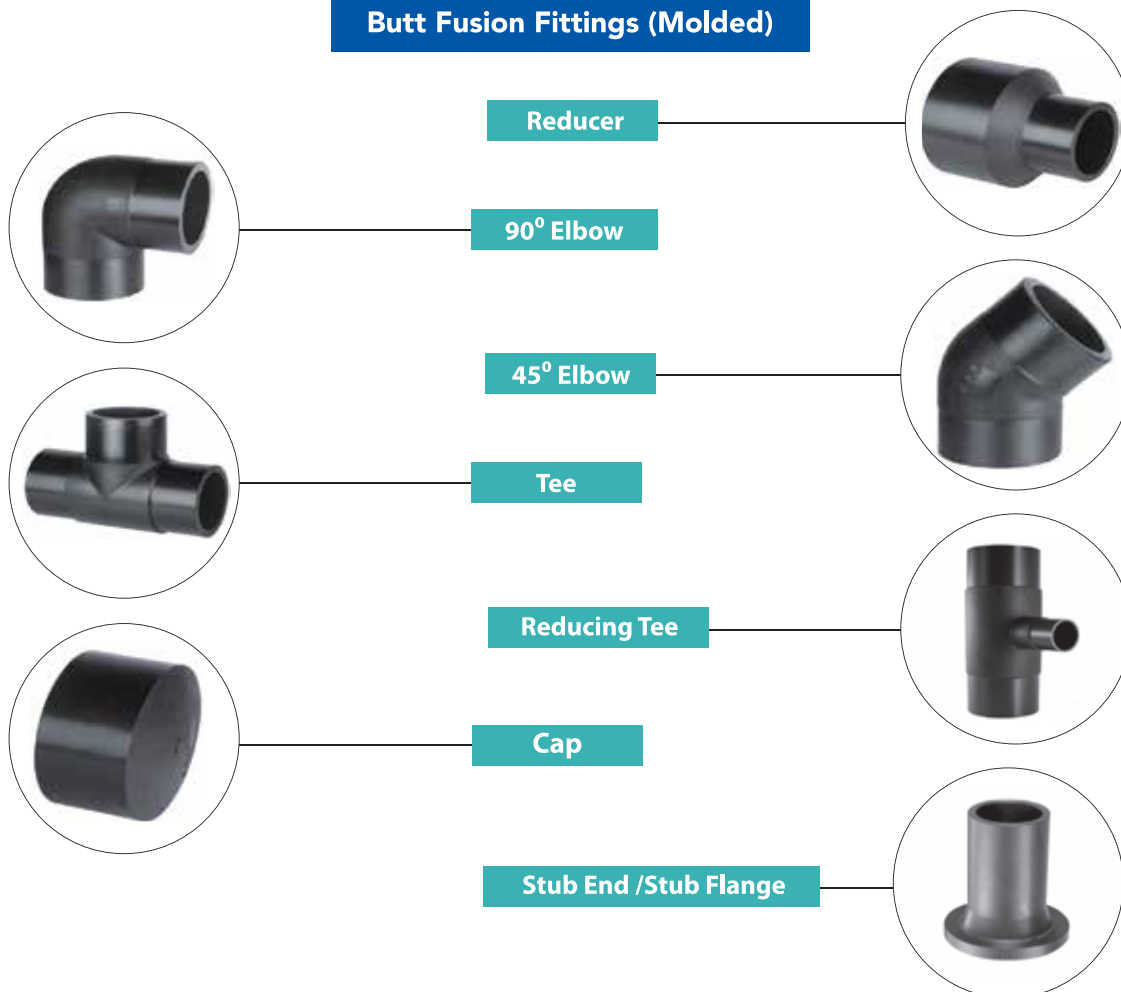
Features

- **Material:** PE 100
- **Size:** 75 mm through 1400mm availability
- **Pressure Rating:** 1.0Mpa, 1.25Mpa, 1.6Mpa or other nominal pressures available upon request
- **Standard:** ISO 4427-3, EN 12201-3 BS EN 12201-3 AS/NZS 4129 BS 6920
- **Color:** Blue all size
 Black (dn 110 or above)
 Other colors are also available upon request
- **Joint:** Joining pipe and butt joint fittings by butt fusion joint

Advantages

- **Non-toxic:** No heavy metal additives, would not be covered with dirt or contaminated by Bacterium
- **Corrosion resistance:** Resist chemical matters and electron chemical corrosion
- **Low installation cost:** Light weight and ease of installation can reduce installation costs
- **High flow capacity:** Smooth interior walls results in low pressure loss and high volume
- **Longevity:** More than 50 years under proper use.

Butt Fusion Fittings (Molded)





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RFL HDPE Electro Fusion Fittings

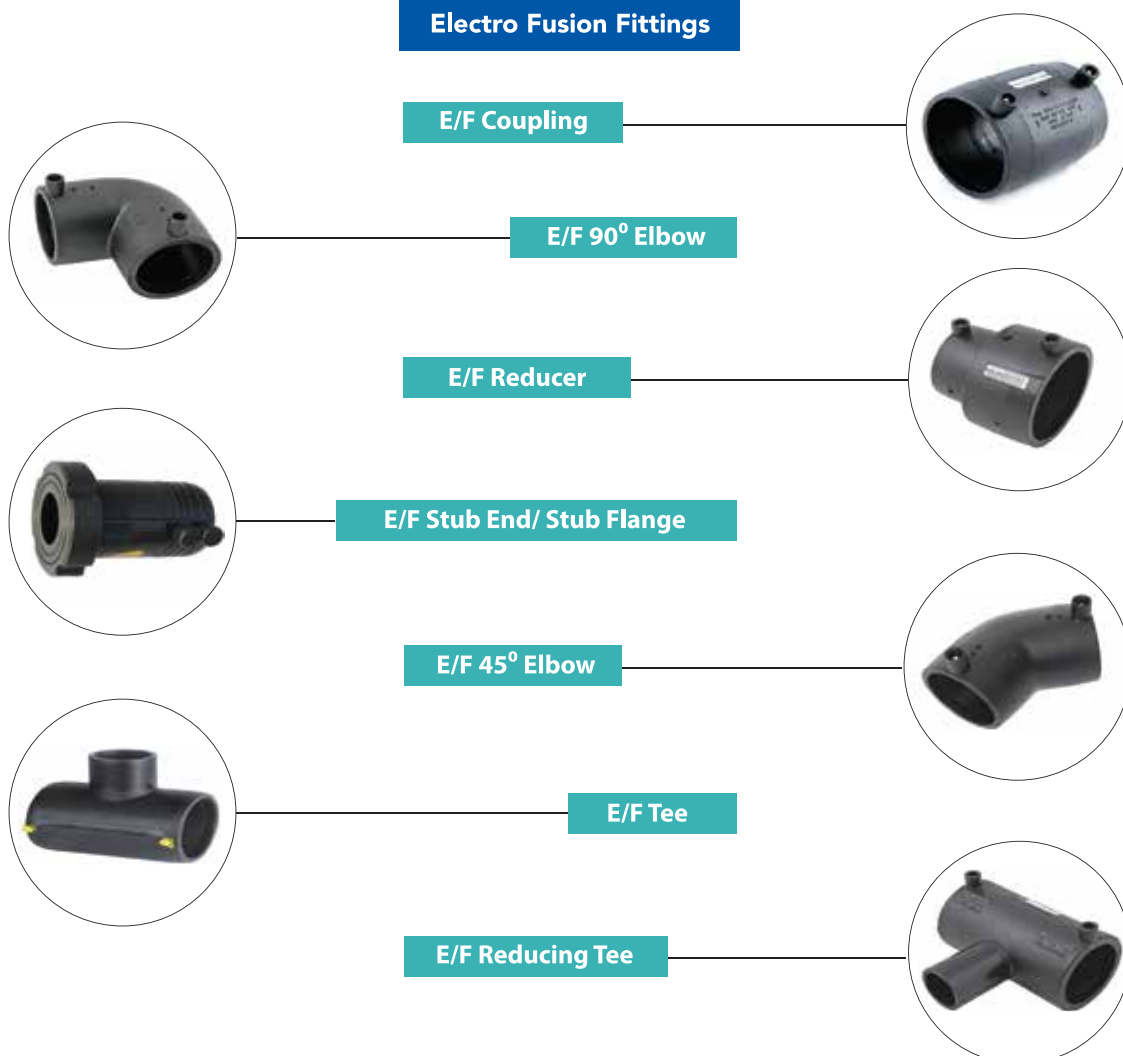
Features

- **Material** : PE 100
- **Size** : 20 mm through 1400mm (upto) availability
- **Pressure Rating** : 1.6Mpa or other nominal pressures available upon request
- **Standard** : ISO 4427-3, EN 12201-3 BS EN 12201-3 AS/NZS 4129 BS 6920
- **Color** : Blue, Black & Other colors are available upon request
- **Joint** : Joining pipe and electro fittings by electro fusion joint

Advantages

- **Non- toxic** : No heavy metal additives, would not be covered with dirt or contaminated by Bacterium
- **Corrosion resistance** : Resist chemical matters and electron chemical corrosion
- **Low installation cost** : Light weight and ease of installation can reduce installation costs
- **High flow capacity** : Smooth interior walls results in low pressure loss and high volume
- **Longevity** : More than 50 years under proper use.

Electro Fusion Fittings





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RFL HDPE Butt Fusion Fabricated Fittings

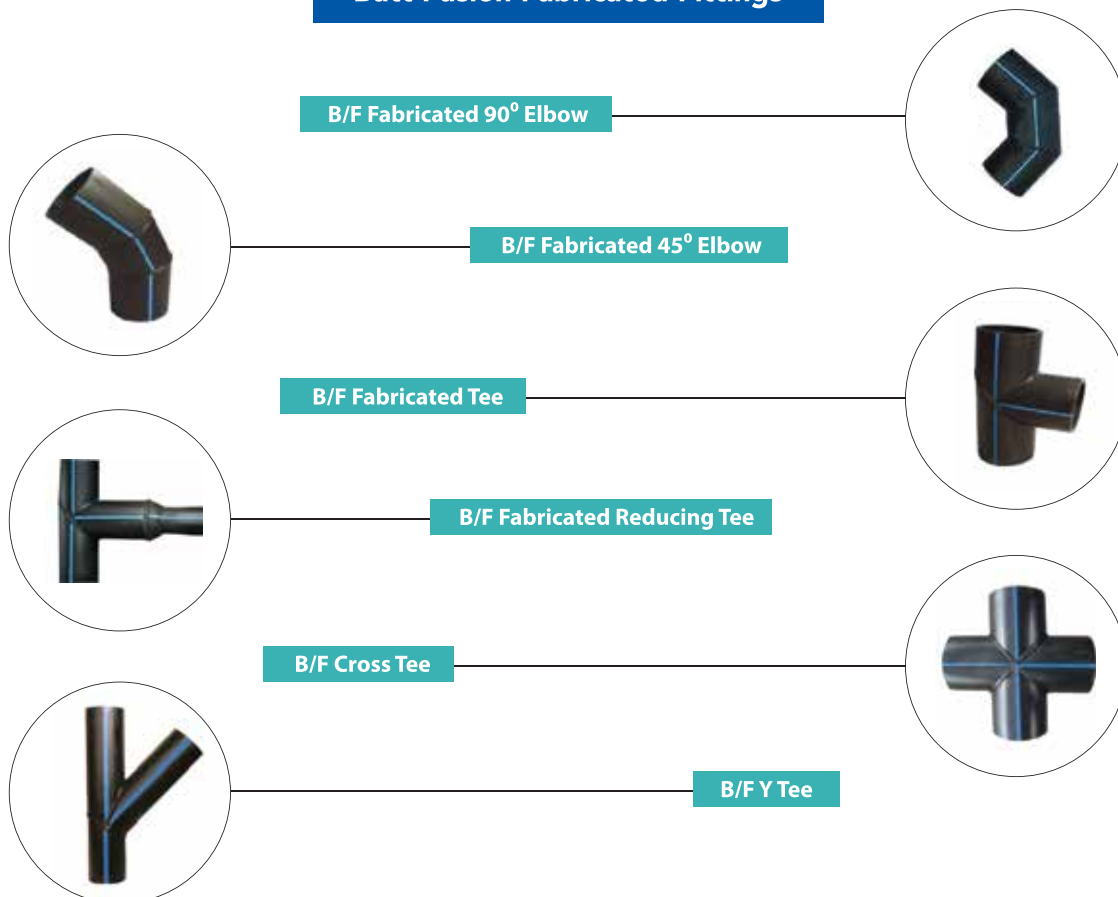
Features

- **Material** : PE 100
- **Size** : 75 mm through 1400mm availability
- **Pressure Rating** : 0.6Mpa, 1.0Mpa, 1.6Mpa or other nominal pressures available upon request
- **Standard** : ISO 4427-3, EN 12201-3 BS EN 12201-3 AS/NZS 4129 BS 6920
- **Color** : Blue, black with blue stripes or others color available upon request
- **Angles** : Various angels available upon request
- **Joint** : Joining pipe and fabricated fittings by butt fusion joint

Advantages

- **Non- toxic** : No heavy metal additives, would not be covered with dirt or contaminated by Bacterium
- **Corrosion resistance** : Resist chemical matters and electron chemical corrosion
- **Low installation cost** : Light weight and ease of installation can reduce installation costs
- **High flow capacity** : Smooth interior walls results in low pressure loss and high volume
- **Longevity** : More than 50 years under proper use.

Butt Fusion Fabricated Fittings



RFL HDPE Compression Fittings and Saddle Clamp

Fields of Application

RFL HDPE Compression fittings and clamp saddles are designed specifically for connecting polyethylene pipes with an outside diameter of 20-200 mm (135mm for clamp saddles). They are fully compatible with all PELD, PEHD, PE 40, and PE80 & PE 100 Pipes complying with EN 12201, ISO 4427, ISO 14236, ISO 13460 and DIN 8074. They are normally used to convey drinking water and liquids at pressure up to 16 bars for generic applications. The quality of the materials used makes these fittings resistance to etching to by numerous chemical substances and to UV-rays. The RFL HDPE universal fitting can be used to connect systems using HDPE metric piping with existing pipes made of any material with external material diameter of 20-63 mm.

Standards

Fittings and saddles

Complying with UNI 9561, UNI9562, DIN 8076-3, ISO 14236, ISO 13460

Threads

Complying with 1807/1, DIN 2999, BS 21

Available Size:

20 mm, 25 mm, 32 mm, 40 mm, 50 mm & 63 mm all compression fittings are PN-16

Quality certifications

RFL HDPE fittings have been tested and approved by all the leading certification agencies.
RFL HDPE quality system is ISO 9001:2015 certified.

OPERATING TEMPERATURES

Fittings and clamp saddles are not suitable for use with hot water for the limits dictated by the use of polyethylene pipes.

RFL HDPE operating temperatures refer to the use of polyethylene pipes. It is therefore necessary to refer to the regulations applicable in the country of use. The fittings and clamp saddles can with stand temperatures below 0-c. The table below shows the maximum operating pressure during continuous operation (PFA) with changes in temperature. It the liquid conveyed is water, in compliance with EN 805, EN 12201, and ISO 13761.

Operating T[C]	<20	25	30	35	40	45
PFA[bar]	16	14.9	13.9	12.6	11.8	10.8
PFA[bar]	10	9.3	8.7	8	7.4	6.7



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Compression Fittings



Saddle Clamp

Ferrule Tee



Female Union Ball Valve



Female Coupler



Male Adaptor



Female Adaptor



Compression Tee



Male Elbow



90° Joint Elbow



Assembly Instruction

Compression fittings 20mm-63mm



01
Cut the pipe squarely using special pipe cutting tools or circular or band saw. It is advisable to use a guide box to ensure a square cut.



02
Eliminate any burrs and bevel the end of the pipe to facilitate easy assembly and to prevent to damage to the fitting gasket. The outer surface of the pipe must be free from imperfection where the body of the fittings makes contact with the pipe.



03
Unscrew the blue nut and put it into pipe followed by the white clamping ring. Make sure the clamping ring is in the correct position, with largest diameter facing the fitting.



04
Press the pipe axially into the fitting, past the gasket until it touches the internal register inside the fitting body.



05
Tighten the ring nut by hand and then use the torque wrench provided. The ring must be tight, but it does not need to reach the end of the fitting body.

Compression fittings 75mm-110mm



01
Cut at 90degree the pipe extremity to be connected and eliminate possible flashes.



02
Unscrew of 3-4 turns the fitting nut and make sure that the OR and the blocking bush are in the highlight position.



03
Introduce the pipe into the fitting till reaching the three ribs in the inside wall of the body.



04
Screw the nut up to the end using a belt or chain wrench.



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Assembly Instruction

Clamp saddles –Alternative procedure



01 Select the hole points and make sure that the external surface of the pipe is free from any impurity; put the gasket into the indentation of the saddle seat.



02 Position the bottom part of the saddle on the chosen point and couple the upper part, then insert the screws from below and tighten the nuts one by one.



03 Drill a hole in the pipe wall, be careful not to damage the thread and the O-



04 Use a marker to draw a reference line on the pipe to allow re-installing the saddle, unscrew the nuts and remove the saddle.



05 Drill the hole in the pipe wall being careful not to damage the other side of the pipes and remove the scraps.



06 Assemble the saddle according to the marked line, to keep the hole in the same axis with the saddle's screw hole.

RFL HDPE Pipe Joint Standard

(Butt Fusion Joint)

Step: (Use Butt Fusion Welding Machine)



01

Prepare:

Prepare the necessary tools.



02

Clamp and clean:

Clamp down the pipe on the jig, clean up the joint part, mill the joint sides, and then adjust the joint parts to make the misplacement less than 10% of the wall thickness.



03

Heat:

Put the heating panel.



04

Join:

Remove the heating panel after finishing heating, join the two heating parts swiftly, increase pressure up to the fusion-joint pressure and keep until it cools down.



05

Complete:

Butt Fusion Joint is completed.



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HDPE

PIPE & FITTINGS

RFL HDPE Butt Fusion Welding Standard

Size	PN	SDR	Heater Plate Temperature	Heating Time	Jointing Gauge Pressure	Cooling Time	Bead Width, mm	
mm			°C	Sec	Mpa	Sec	Min	Max
90	10	17	220	90	1.5-2.0	180	8	15
160	10	17	220	240	2.5-3.0	240	9	16
250	10	17	220	240	2.5-3.0	240	10	17
400	10	17	220	600	3.0-3.5	600	15	24
500	10	17	220	600	4.0-4.5	1500	16	25
710	10	17	220	2580	6.0-6.5	2580	20	30
900	10	17	220	780	6.5-7.0	3180	22	35
1200	8	21	220	900	6.5-7.0	3600		



Butt Fusion Welding



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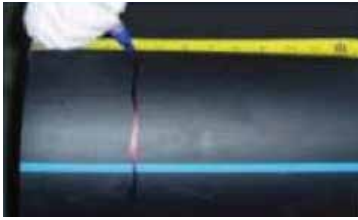
HDPE

PIPE & FITTINGS

RFL HDPE Pipe Joint Standard

(Electro Fusion Joint)

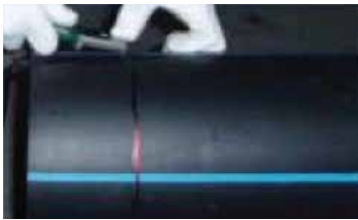
Step: (Use Electro Fusion Welding Machine)



01

Clean and mark

- Clean up the connection part, mark the inserting depth.



02

Scrape

- Scrape and polish the joint.



03

Align and restrain the fittings to the pipes.



04

Apply electric current

- Apply electric current to the fittings; the joining parts will be heated and melted, turn off the current when there is melt flowing in the observation hole.



05

Cool

- Cool without movement or pressure.

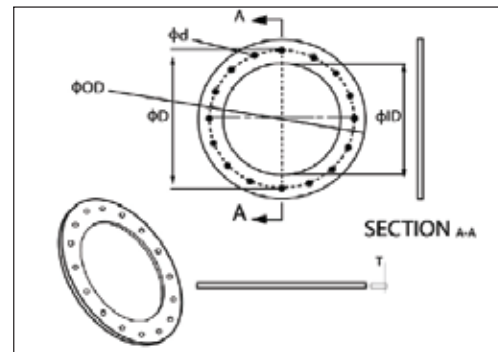


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HDPE

PIPE & FITTINGS

RFL HDPE Dredging Solution



RFL HDPE Dredging Pipe

Flange ring specification								Bolt specification
S/L No	Size	GI Ring Plate ϕOD (mm)	GI Ring Plate ϕID (mm)	GI Ring Plate thickness T (mm)	Total number of hole (Nos)	Hole Diameter ϕd (mm)	Hole to Hole center distance ϕD (mm)	Nut-Bolt size mm (Half thread with washer)
1	315mm (12")	430	322	18 \pm 1	12	22	390	M20X160
2	450mm (16")	572	460	20 \pm 1	16	22	530	M20X180
3	500mm (18")	646	510	25 \pm 2	20	25	605	M24X200
4	560mm (20")	712	570	25 \pm 2	20	28	664	M24X200
5	630mm (22")	780	650	25 \pm 2	24	30	730	M24X200
6	710mm (26")	880	730	25 \pm 2	24	30	830	M24X235



RFL HDPE Dredging Floater

Product Range Information
Size: 315, 400, 450, 500, 560, 630, 710 (mm)



Rubber Hose

Product Range Information
Size: 400, 450, 500, 550, 600, 650, 700, 750, 800, 850, 900 (mm)



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HDPE

PIPE & FITTINGS

RFL HDPE Pipe For Firefighting Line



Specifications

Usage: Firefighting line

Size: 20mm to 1400mm.

Pressure: 0.5MPa, 0.6MPa, 0.8MPa, 1.0MPa
1.25MPa, 1.6MPa, 2.0MPa.

Standard: ISO4427, EN12201, AS4130 etc.

Color: Black or customized.

RFL HDPE Pipe For Gas Line



Specifications

Material: PE 100

Pressure Rating: PN \leq 0.5MPa, PN \leq 1.6MPa
PN \leq 0.5 MPa & PN \leq 0.7 MPa

Size: 20 mm through 1000mm availability

Standard: ISO4437

Colors: Yellow, Black with yellow stripes
other colors upon request

Form supplied: • 6 meter straight length (dn>63).

• 50 or 100 meter coil length (dn20~ dn>63).

• Others form are also available upon request.

Advantages:

- **Corrosion resistant:** Resist chemical matters and electron chemical resistance
- **Low flow resistance:** Smooth interior walls and low friction
- **Excellent flexibility:** Can be supplied in coil
- **Easy installation:** Light weight & handed friendly
- **Longevity:** Can work more than 50 years under proper use
- **Various joint availability:** Butt fusion joint, electro fusion joint & transition joint
- **Recycled & environment- friendly**



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HDPE

PIPE & FITTINGS

Laboratory Test Arrangement



Moisture Content Test



COF Test



Hydrostatic Pressure Test



Impact Test



Acetone Test



Carbon Black Content Test



Crush Resistance Test



Density Test



Dumbbell Cutter



ESCR Test



Heat Reversion Test



Melt Flow Index Test



OIT Test



Opacity Test



Particle Analyzer Test



Sulphated Ash Content Test



Tensile & Compressive Test



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HDPE

PIPE & FITTINGS

Work Experience with RFL HDPE



RFL HDPE 800 mm Dredging Pipe at BIWTA Project



Tea Garden, Chittagong chooses RFL HDPE Pipe



RFL HDPE Pipe used at Padma Bridge.



RFL HDPE 1000 mm pipe used in BMDA Godagari,Rajshahi



The Purbachall New Town (RAJUK) Project takes trust on RFL HDPE Pipe to transfer Potable water.



RFL HDPE Pipe used at DWASA ICB 2.7, 2.10, 2.11 Potable water Project



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HDPE

PIPE & FITTINGS

Our Achievement



Sustainable Management System Inc.
Certificate of Registration
This is to certify that, the
Management Systems of
RFL Plastics Limited
Site 01: Pran Industrial Park, Bagpara, Palash, Narsingdi-1610, Bangladesh
Site 02: Shawghat, Bhulta, Rugganj, Narayanganj-1462
Site 03: Murapara, Rugganj, Narayanganj-1464
has been assessed and registered against the provision of
ISO 45001:2018
Occupational Health and Safety Management Systems
for the following scope
Manufacturing, Sales & Marketing of uPVC, PP-R, cPVC, HDPE Pipe & Fittings, Hose Pipes, Mat, Kitty Kap, all types of Tape, Water Tanks, Wooden and Laminated Board Furniture & Metal Furniture

Initial Issue Date	: 03-Jun-20	Registration Number	: SMS-20223580
Current Issue Date	: 20-Jan-25	Certificate Number	: SMS-MSC-22480
Valid Till	: 26-Nov-26	EA Code	: 14
2nd Surveillance Due Date	: 27-Oct-25	Exclusion	: N/A
Re-certification Due Date	: 27-Oct-26	Issue No	: 03

Approved By: 
 President & CEO





This is an accredited certificate authorized for issue by Accreditation Service for Certifying Bodies LLC who has assessed Sustainable Management System Inc. against defined criteria and in cognizance of ISO 17021:2015 'Conformity Assessment - Requirements for bodies providing audit and certification of management systems. This certificate is only valid when confirmed by the register listed in the International Register of Quality Assessed Organizations and Sustainable Management System Inc. The validity of this certificate can be checked at www.Irqao.com and www.smscert.com/certificate-check

This certificate is the property of Sustainable Management System Inc.
 277 Cherry Street, Suite-12N, New York, New York 10002, United States of America
 E-mail: info@smscert.com, web: www.smscert.com

1.02 January 2020

ISO 45001: 2018



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HDPE

PIPE & FITTINGS

Our Achievement

যন্ত্রকৌশল বিভাগ
বাংলাদেশ প্রকৌশল বিশ্ববিদ্যালয়
ঢাকা-১০০০, বাংলাদেশ
D22267
12 APR 2022

Department of Mechanical Engineering
Bangladesh University of Engineering and Technology
Dhaka-1000, Bangladesh

TEST REPORT OF HDPE PIPE 12 April 2022

CLIENT : জনাব মাসুদুল আলম
নির্বাহী প্রকৌশলী
সাজের-কোম্পানী ওয়েলফেয়ার প্রাইভেট
ঢাকা ওয়াশা, ভাটুরা, সাজের, ঢাকা।

E-MAIL : ee.skwp.dwasa@gmail.com

CLIENT'S REFERENCE : Memo No. 48.05.0000.626.07.019.21-174; Dated: 27.03.2022

UNIVERSITY REFERENCE : BRTC NO. 1102-59053/ME/21-22; Dated: 29.03.2022

SAMPLES SUPPLIED :
1. 110 mm dia. HDPE Pipe
2. 160 mm dia. HDPE Pipe
3. 200 mm dia. HDPE Pipe
4. 250 mm dia. HDPE Pipe

BRAND NAME : RFL Plastics Limited.

TEST CONDUCTED BY : DEPARTMENT OF MECHANICAL ENGINEERING BUET.

TEST RESULT

DIMENSION TEST
Standard Used: ISO 4427

Sample ID	Outside dia. (mm)			Wall thickness (mm)			Standard Dimension Ratio	Remarks
	Max.	Min.	Avg.	Max.	Min.	Avg.		
110 mm dia. HDPE Pipe	110.70	110.60	110.65	7.22	6.75	6.99	17	OK
160 mm dia. HDPE Pipe	161.00	160.40	160.70	10.52	9.86	10.09	17	OK
200 mm dia. HDPE Pipe	201.20	200.12	200.66	13.06	12.60	12.83	17	OK
250 mm dia. HDPE Pipe	251.25	250.15	250.70	15.66	14.95	15.32	17	OK

TEST OF COLOR
Standard used: ISO 4427

Sample ID	Observation	Remarks
110 mm dia. HDPE Pipe	Black with blue stripes	Conforms to color code of drinking water supply pipe
160 mm dia. HDPE Pipe	Black with blue stripes	Conforms to color code of drinking water supply pipe
200 mm dia. HDPE Pipe	Black with blue stripes	Conforms to color code of drinking water supply pipe
250 mm dia. HDPE Pipe	Black with blue stripes	Conforms to color code of drinking water supply pipe

TEST OF OVALITY
Standard Used: ISO 4427

Sample ID	Observation	Specified Ovality	Remarks
110 mm dia. HDPE Pipe	0.10	≤ 2.2	OK
160 mm dia. HDPE Pipe	0.60	≤ 3.2	OK
200 mm dia. HDPE Pipe	1.08	≤ 4.0	OK
250 mm dia. HDPE Pipe	1.10	≤ 5.0	OK

SHORT-TERM HYDROSTATIC PRESSURE TEST
Standard Used: ISO 4427


Sample ID	Test Temp. and Duration	Applied Pressure (Bar)	Observations	Remarks
110 mm dia. HDPE Pipe	20°C, 100 hr.	15.5	No leakage was observed	OK
160 mm dia. HDPE Pipe	20°C, 100 hr.	15.5	No leakage was observed	OK
200 mm dia. HDPE Pipe	20°C, 100 hr.	15.5	No leakage was observed	OK
250 mm dia. HDPE Pipe	20°C, 100 hr.	15.5	No leakage was observed	OK

Page 1/2

880-2-9965638, 55167100, 55167228-57/7230, 7232, Fax : +880-2-58613046, 9665622, Email : headme@me.buet.ac.bd

BUET Certificate

Our Achievement

 **DHAKA ENVIRONMENTALLY SUSTAINABLE WATER SUPPLY PROJECT**
DHAKA WATER SUPPLY & SEWERAGE AUTHORITY
DESWSP, DHAKA WASA

Memo No. : 46.113.618.00.00.G-104(Vol-1)/DESWSP/376 Date : 06-01-2016

To
The Team Leader
Management Supervision Consultant (MSC)
Banosree, Rampura
Dhaka-1219.


Subject: HDPE Test Report (PE-100)

Reference No : 46.113.618.00.00.G-104(Vol-1)/DESWSP/1210, Date: 04-11-2015
Reference No : 46.113.618.00.00.G-104(Vol-1)/DESWSP/247, Date : 19-11-2015

Dear Sir,

With reference to this above vide memo No. 46.113.618.00.00.G-104(Vol-1)/DESWSP/247, Date: 19-11-2015, the PMU office received the test report of HDPE pipe from BRTC, BUET which is found satisfactory (enclosed). The testing of HDPE Pipe is conducted by BRTC, BUET. This is for your further necessary action.

With Best Regards


(Md. Mahmudur Islam)
Superintending Engineer & Project Director
DESWSP, DWAS
Dhaka.

Enclosed : As stated.

Copy to :

- ✓ Contract Manager, ICB-02.7, (RPL-FSL-CRFG-JV)
- SE & DPD-2, DESWSP, DWASA
- Office Copy

WASA Bhaban (8 th floor), 98, Kazi Nazrul Islam Avenue, Kawran Bazar, Dhaka-1215, Bangladesh
Tel : 88-02-8185095. www.deswsp-dwasa.com, e-mail: pddeswsp@gmail.com

DHAKA WASA
Phone : 9665636, 9665650-80/7230, 7232; Fax : 880-2-8613046, 9665622, 9665638; Email : headme@me.buet.ac.bd

DWASA Certificate



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HDPE

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Certificate

Client Name and address

RFL Plastics Limited
 HO: PRAN-RFL Center, 105 Middle Badda, GPO BOX# 83, Dhaka-1212, Bangladesh
 Site 1: Pran Industrial Park, Bagpara, Polash, Narsingdi-1610, Bangladesh
 Site 2: Murapara, Rugganj, Narayangonj-1464, Bangladesh
 Site 3: Saoghat, Vulta, Rugganj, Narayangonj-1462, Bangladesh

Standard

ISO 9001:2015 Quality Management System

INSPECT has assessed and approved the compliance of the relevant organization with the requirements of the above-mentioned standard within the relevant scope.

Scope

Manufacturing, Sales & Marketing of uPVC, PPR, cPVC, HDPE Pipe & Fittings, Hose Pipes, Water Tanks, Wooden and Laminated Board Furniture & Metal Furniture.

IAF/Category Code: 14-23
 Initial issue date: 07.Nov.2019
 Issue date of this certificate: 28.Oct.2025
 Validity of this certificate: 06.Nov.2028
 Recertification date: 06.Nov.2028
 Certificate No: 22.05.534-QM

The validity period of the certificate is 3 years
 This organization was certified by a different CB before a certain date
 INSPECT is accredited by International Accreditation Service (IAS)
 To verify the validity of this certificate please visit: www.inspect.com.tr
 The validity of this certificate depends on the success of surveillance assessments

INSPECT CERTIFICATIONS USA LLC
 9700 MG RD, SUITE 200
 www.inspect.com.tr







General Manager

ISO 9001:2015



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HDPE
PIPE & FITTINGS

Our Achievement

inspect
Certificate

Client Name and address

RFL Plastics Limited
 HO: PRAN-RFL Center, 105 Middle Badda, GPO BOX# 83, Dhaka-1212, Bangladesh
 Site 1: Pran Industrial Park, Bagpara, Polash, Narsingdi-1610, Bangladesh
 Site 2: Murapara, Rugganj, Narayangonj-1464, Bangladesh
 Site 3: Saoghat, Vulta, Rugganj, Narayangonj-1462, Bangladesh

Standard

ISO 14001:2015 Environmental Management System

INSPECT assessed and approved that related firm meets the requirements of the designated standard at related scope

Scope

Manufacturing, Sales & Marketing of Wooden, Laminated Board & Metal Furniture (Chair-Table, High Bench with Long Bookshelf, Low Bench) Plastic/Co polymer Plastic Furniture, uPVC, PPR, cPVC, HDPE Pipe & Fittings, Hose Pipes and Water Tanks.

IAF/Category Code: 14-23
 Initial issue date: 08.Apr.2021
 Issue date of this certificate: 01.Apr.2024
 Validity of this certificate: 31.Mar.2027
 Recertification date: 31.Mar.2027
 Certificate No: 22.05.534-EM

INSPECT is accredited by International Accreditation Service (IAS) United States Of America
 To verify the validity of this certificate please visit: www.inspect.com.tr
 The validity of this certificate is depend on the success of surveillance assessments

Inspect International Certification and Inspection Co. Ltd
www.inspect.com.tr





General Manager

ISO 14001: 2015



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Industrial Piping Solution

A Product of



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Hotline (Call Charge Free)

0800 7777 777

 /RFL-Pipe-and-Fittings

PRAN Center, 105 Pragati Sarani, Middle Badda, Dhaka 1212, Bangladesh

Phone : 02222281792, Fax : 88-02-8837464

E-mail : rfl@prangroup.com Web : www.rflpipes.com