

# BLUELINE PE80 Polyethylene Pressure Pipe

**Compliance:** Manufactured in accordance with AS/NZS 4130 “PE Pipes for Pressure Applications” using pre-compounded materials conforming to AS/NZS 4131 “PE Compounds for Pressure Pipes and Fittings”.

(Standards Mark Licence number SMK20400.)

**Product Code:** 2500 Series

**Description:** Metric series PN12.5 polyethylene pressure pipe in the size range 20mm – 63mm OD, manufactured from PE80 polyethylene (MDPE)

Pipe is coloured blue with black tri-stripes and is available in coils of 25, 50 and 100 metres.

**Joining:** BlueLine can be joined using mechanical compression fittings complying with AS/NZS 4129 such as the Plasson brand. BlueLine can also be joined by butt fusion welding or electrofusion couplings.

**Applications:**

- Water distribution for town, rural and irrigation projects
- Rider mains for urban water supply
- Cold water plumbing reticulation
- Household water connections from the main supply
- Compressed air lines

**Fusion Welding Procedure:** Refer to the PIPA Guidelines for butt fusion and electrofusion welding procedures – [www.pipa.com.au](http://www.pipa.com.au).

**Fusion Weld Testing:** Tensile testing of fusion welds to be in accordance with ISO/DIS 13953.

**Design & Installation:** BlueLine pipe should be installed in accordance with the following Standards:

- **Buried Structural Design:**  
AS/NZS 2566 Part 1 and Supplement “Buried Flexible Pipelines – Structural Design”
- **Detailed Installation and Site Pressure Testing:**  
AS/NZS 2566 Part 2 “Installation”  
AS/NZS 2033 Installation of polyethylene pipe systems

**Limitations:** BlueLine pipe should not be used:

- As a conductor for earthing electrical appliances
- All fire rated applications
- Exposure to direct sunlight in service (except black pipe)
- Pressure pipes in continuous services up to 60°C internal or external temperature, where provision for pressure derating has not been made
- Without adequate support to the pipe in above ground and below ground applications
- Where working pressure and surge pressure exceeds the nominated pressure rating of the pipe
- Where incorrect depth of cover is applied.
- Without adequate support to the pipe both in above ground and below ground applications
- Without adequate thrust support
- Where depth of cover is less than:
  - 300mm where pipeline is not subject to vehicular loadings
  - 450mm where pipeline is subject to vehicular loadings not in roadways
  - 600mm where pipeline is subject to vehicular loading in sealed roadways

- 750mm where pipeline is subject to vehicular loading in unsealed roadways
- 750mm where pipeline is subject to construction equipment loadings
- Without provision for fatigue design, to accommodate dynamic stresses where appropriate (in accordance with published PIPA guidelines)
- Where working pressure plus surge/cyclic pressure exceeds the nominated pressure performance rating of the pipe

Pressure Class			PN12.5 SDR11	
Nominal Size DN	Min O.D. (mm)	Max O.D. (mm)	Mean Wall (mm)	Mean ID (mm)
20	20.0	20.3	2.0	16.1
25	25.0	25.3	2.5	20.1
32	32.0	32.3	3.1	25.9
40	40.0	40.4	3.9	32.4
50	50.0	50.5	4.9	40.4
63	63.0	63.6	6.1	51.1



BlueLine pipe and Plasson Line 7 compression fittings used for a water service connection off a PVC-O main to a residential property near Wanaka.



Coil of DN 63 PN 12.5 BlueLine polyethylene pipe on site, near Lake Wanaka.