



National Standards Authority of Ireland

IRISH STANDARD

**I.S. 59:1953**

ICS 91.140.80

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**PRESSED STEEL RAINWATER GOODS**

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STATUTORY INSTRUMENTS

S.I. No. 388 of 1953

STANDARD SPECIFICATION

(PRESSED STEEL RAINWATER  
GOODS) ORDER, 1953

IRISH STANDARD 59 : 1953

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STANDARD SPECIFICATION  
(PRESSED STEEL RAINWATER GOODS) ORDER, 1953

I, SEAN F. LEMASS, Minister for Industry and Commerce, in exercise of the power conferred on me by subsection (3) of section 20 of the Industrial Research and Standards Act, 1946 (No. 25 of 1946), hereby order as follows :—

1. This Order may be cited as the Standard Specification (Pressed Steel Rainwater Goods) Order, 1953.

2.—(1) The specification set forth in the Schedule to this Order is hereby declared to be the standard specification for Pressed Steel Rainwater Goods.

(2) The said standard specification may be cited as Irish Standard 59 : 1953 or as I.S. 59 : 1953.

SCHEDULE

SCOPE

1. This specification deals with rainwater pipes, gutters, fittings and accessories made from sheet steel and galvanised after fabrication. Two grades of thickness are specified, *viz.*, light grade and medium grade. Light grade rainwater goods are intended for use on sheds, outhouses, etc. Medium grade rainwater goods are intended for use on buildings where greater durability is required.

MATERIAL

2. The material used in the manufacture of the pipes, gutters, fittings and accessories shall be black mild steel sheet which shall withstand without fracture being bent cold through 180° either by pressure or by blows, until the internal radius is not greater than one and a half times the thickness of the material.

WORKMANSHIP

3. The finished pipes, gutters, fittings and accessories shall be true and smooth. They shall be in all respects sound and free from imperfections. The ends shall be finished square to the axes.



Pipes shall be circular in cross-section. The barrels shall be made from a single piece of material. The sockets may be made from a separate piece joined to the barrel by welding. Pipes and pipe fittings shall be made with a seamed or welded joint.

Gutters shall be semi-circular in cross-section and shall be made from a single piece of material.

All holes shall be punched before galvanizing.

#### DIMENSIONS OF PIPES AND PIPE FITTINGS

4. *Nominal Sizes* : The nominal sizes of pipes and pipe fittings, expressed in terms of the internal diameter, shall be 2 inches, 2½ inches and 3 inches.

*Diameter* : The internal diameter at any point shall not deviate from the nominal size by more than  $\frac{1}{16}$  inch.

*Thickness* : The thickness of sheet steel used for light grade pipes and pipe fittings shall be 20 B.G. (0.0392 in.) and for medium grade pipes and pipe fittings 14 B.G. (0.0785 in.).

*Length* : The overall lengths of pipes shall be 6 ft. 3 in. and 3 ft. 3 in. A tolerance of  $\pm \frac{1}{4}$  in. shall be allowed on the overall length of any pipe, but the average length of a batch of pipes shall be not less than 6 ft. 3 in., or 3 ft. 3 in., as the case may be.

*Sockets* : The depth of sockets shall be 3 in., and the internal diameter shall be such that the spigot can be inserted for the full depth of the socket. The internal diameter of the socket shall be greater than the pipe diameter by  $\frac{1}{8}$  in., in the case of light grade and  $\frac{3}{16}$  in., in the case of medium grade pipes and fittings.

*Ears* : The sockets of light grade pipes and fittings shall have ears. The sockets of medium grade pipes and fittings shall be manufactured with and without ears. Ears shall be of steel of not less thickness than that of the metal of the pipe or fitting. They shall be securely attached to the socket before galvanizing and shall be provided with holes of  $\frac{3}{8}$  in. diameter. The depth of the ear shall be such as to maintain the socket at a distance of 1½ in. from a flat surface as indicated in Fig. 1.

*Holderbats* : Holderbats for securing medium grade pipes without ears shall be of mild steel and shall be of the type and dimensions given in Fig. 2. The spike shall be securely riveted to the collar. Each holderbat shall be provided with two galvanized bolts and nuts as shown in the figure.

Holderbats shall be galvanized.

*Offsets, elbows and shoes* : Other dimensions of offsets, square elbows, obtuse elbows and shoes shall be as indicated in Figs. 3, 4, 5 and 6.



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