



Catalog 2025

Cast iron solutions that
contribute to the comfort, safety
and durability of buildings



Safe
& forever
circular

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Committed to sustainability and product excellence

For 150 years, we have been designing, manufacturing and supplying high-quality drainage systems for residential and commercial buildings and engineering structures.

We work exclusively with cast iron, a noble and durable material, of which we are a specialist and leader.

As a **leading manufacturer**, we claim excellence in our processes, products and services.

As a **responsible manufacturer**, we are at the forefront of sustainable performance to help reduce the carbon footprint of the construction sector.

As an **innovative manufacturer**, we put all our creative audacity into developing new, more specific and more efficient technologies, to deliver better products for your future needs.

Our strength is in our people

Our corporate culture attracts and develops the talents of the people in our teams over time.



We forge the technical competence that pushes us to the forefront of everything we do.

Pam Building believes in nurturing and proves it by integrating young graduates, through its practice of apprenticeship and development.

- **Our commercial** approach transforms us into providers of technical solutions to exceed our customers' expectations.
- **Our team** provides excellent service and technical support during the design, implementation of a project.
- **Our project managers** ensure daily follow-up in the field to guarantee the best possible conditions for implementation.

Pam Building was built on the strength of its people, established in **3 major countries: France, England and Germany**, and servicing the world

Over **400** employees

Sales in more than **50** countries

+38: our indicator « Employee Net Promoter » that reflects the number of staff willing to become Ambassadors of the company (on a scale of -100 to +100)

2 manufacturing sites for our products:

- Bayard sur Marne in France
- Telford in England

35% female managers

1st business in the cast iron industry to have published a third-party validated Environmental Product Declaration (EPD)

1/3 internships and work-study contracts converted to full employment contracts

Quality, energy, and environment management system



Committed to reducing our impact on the environment

Our 2030 objectives vs 2017



Some key actions to achieve our targets:

- **Innovation:** The Agilium® range launched in 2023 enable a reduction of CO₂ emissions by 20% compared with the standard range
- **Production:** An electric power furnace is in project for 2028-2030 at our Bayard-sur-Marne plant
- **Purchasing:** Maintain our green electricity supply in our Telford plant where there is already an electric furnace

At the heart of the circular economy, Pam Building's DNA is in the recycling of waste metal

Our products are made up of 99% recycled materials (mostly ferrous metal scrap), which can be recycled over and over again.

Durable, reliable and long-lasting, cast iron has a bright future ahead of it as a simple and sustainable system approach that gives your building project an intelligent reuse of materials.

In a year, we recycle the equivalent of 18 000 cars on average.

Safe
& forever
circular

Committed to the safety and durability of buildings

Our cast iron solutions and systems help to ensure the comfort, safety and durability of the most demanding residential and commercial buildings.

Their exceptional characteristics allow them to contribute to **HQE**, **BREEAM**, **LEED** and other international environmental certifications.



BREEAM®



01

Building solutions & references

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UAE Pavilion
EXPO 2020 -
Dubai - UAE

01. Building solutions & references

Hotels



Hotels are very special buildings since for a short time they act as a second home for the travellers. Customers therefore expect hotels to be restful and relaxing places. The higher the hotel is rated the higher the specifiers' requirements are concerning safety and comfort.



Wastewater and rainwater drainage systems are needed to maintain a peaceful and safe environment, requiring strong and durable materials, with minimal maintenance.



Safe, totally watertight and silent in operation, our cast iron drainage solution is the top choice for wastewater drainage systems in hotels. Combining top-quality products and unrivaled longevity, our systems help maintain the sustainable and comfortable environment your building projects require.



Worldwide references

EUROPE

Premier Palace Hotel - Kyiv - Ukraine
City Of Dreams Mediterranean - Limassol, Cyprus
Ayia Napa Marina Villas - Ayia Napa Marina, Cyprus
One & Only Aesthesis Resort - Glyfada, Athens, Greece
St Regis Hotel - Kula Belgrade, Serbia

ASIA

Rixos Tersane Hotel - Istanbul, Turkey
Radisson Hotel - Bursa, Turkey
Shangri-La Island Hotel - Honk Kong, China
Sofitel Singapore City Center - Singapore, Singapore

MIDDLE-EAST

Jabal Omar Development Company, Phase 4 - Makkah, KSA

AFRICA

Royal Mansour - Casablanca, Morocco
Sofitel Thalassa Hotel - Staoueli, Algeria



High-rise Buildings



Cast iron drainage solutions are essential for high-rise buildings. They offer a unique combination of safety, comfort, and practicality. In terms of fire safety, cast iron is one of the best solution due to its exceptional resistance to high temperatures: it does not melt or emit toxic fumes, significantly reducing risks in the event of a fire and ensuring superior protection for building occupants.



Beyond safety, cast iron excels in providing acoustic comfort. Its density and vibration-absorbing properties effectively minimize the noise of fluid circulation, creating a quieter and more pleasant indoor environment. This is particularly important in high-rise buildings where maintaining a high standard of living comfort is essential.



Moreover, our cast iron systems are designed for straightforward installation and minimal maintenance. Their robustness and durability translate to fewer repairs and replacements over time, leading to significant long-term cost savings. The modular design allows for quick and efficient installation, simplifying the work for construction teams and minimizing disruptions for building occupants. By choosing Pam Building's cast iron solutions, you can ensure reliability, safety, and lasting comfort in their projects.

Worldwide references

EUROPE

Lake View Residences - Tirana, Albania
Kula Belgrade - Belgrade, Serbia
Downtown One - Tirana, Albania
Vodno Telecommunication Tower - Skopje, North Macedonia

ASIA

Capital Towers - Moscow, Russia
Ziraat Bank Financial Center - Istanbul, Turkey
Trilliant - Tashkent, Uzbekistan
Central Bank of Azerbaijan - Baku, Azerbaijan

MIDDLE-EAST

Seef Lusail Residential Development Plots D3&D4 - Lusail, Qatar

AFRICA

Tour Attijari Wafabank - Casablanca, Maroc
BADR Bank Headquarters - Algiers, Algeria
F Tower - Abidjan, Cote d'Ivoire
CFC Tower - Casablanca, Morocco



Healthcare facilities



Our cast iron drainage solutions are a game-changer for healthcare facilities. The PAM GLOBAL Plus range is specifically designed for aggressive effluents, providing exceptional resistance to chemicals and corrosion thanks to its advanced interior coating. This ensures reliable and long-lasting performance, even in the most demanding environments where drainage systems can be exposed to corrosive substances.

For engineering firms and construction companies, the long lifespan of Pam Building's cast iron solutions translates into significant lifecycle cost savings. The robustness of cast iron guarantees long-term stability and reliability, reducing the need for frequent repairs and replacements. This durability is a key advantage for projects that require sustainable and cost-effective solutions.

Installers will appreciate the ease of installation and low maintenance requirements of our cast iron drainage systems. The modular design allows for quick and efficient setup, simplifying the installation process and minimizing disruptions on-site. By choosing Pam Building's cast iron solutions, you ensure a reliable, durable, and cost-effective drainage system that meets the highest standards of safety and performance, making it the ideal choice for your next project.

Worldwide references

EUROPE

Onassis Cardiac Surgery Center - Athens, Greece
Grange University Hospital - Wales, UK
CHU ABYME - Guadeloupe, France
Princesse Grace Hospital - Monaco
Clínica Universitaria de Navarra - Madrid, Spain
Children's Hospital - Helsinki, Finland

ASIA

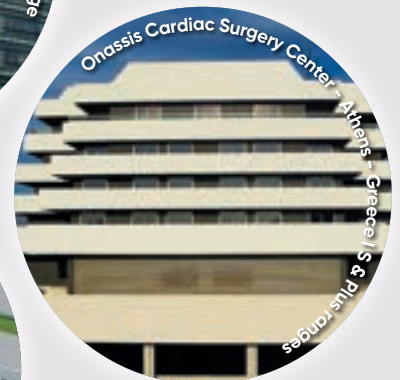
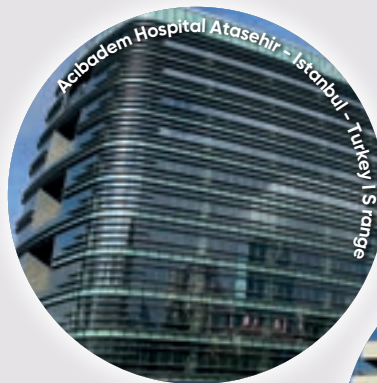
Acıbadem Hospital Atasehir - Istanbul, Turkey
Bozüyük State Hospital - Bilecik, Turkey

MIDDLE-EAST

Sidra Hospital - Doha, Qatar

AFRICA

CHU - Agadir, Morocco
Military Hospital - Tamanrasset, Algeria
CHU Tangier - Tangier, Morocco



Cultural & leisure facilities



Cast iron drainage solutions are indispensable for cultural institutions, offering unmatched acoustic comfort and low maintenance costs. The density and vibration-damping properties of cast iron significantly reduce noise from fluid movement, creating a quieter and more serene environment. This is particularly important in museums, theaters, and galleries, where maintaining a peaceful atmosphere is essential for both visitors and staff.

For engineering firms and construction companies, the long-term benefits of Pam Building's cast iron solutions are clear. The durability and robustness of cast iron ensure a long lifespan, minimizing the need for frequent repairs and replacements. This translates into significant lifecycle cost savings, making it a cost-effective choice for cultural projects that require sustainable and reliable infrastructure.

Installers will appreciate the ease of installation and low maintenance requirements of our cast iron drainage systems. The modular design allows for quick and efficient setup, simplifying the installation process and minimizing disruptions to daily operations. By choosing Pam Building's cast iron solutions, cultural institutions can ensure a reliable, durable, and cost-effective drainage system that meets the highest standards of performance and preserves the integrity of these important spaces.

Worldwide references

EUROPE

Athens Music Hall - Athens, Greece
Santiago Bernabéu Stadium - Madrid, Spain
The Pyramid of Tirana - Tirana, Albania
Munch Museum - Oslo, Norway

ASIA

New Atatürk Cultural Center - Istanbul, Turkey
Istanbul Museum of Modern Arts - Istanbul, Turkey
Kai Tak Sports Park - Hong Kong, China
Shaw Auditorium - Hong-Kong, China
11 Skies Commercial Complex - Hong Kong, China

MIDDLE-EAST

UAE Pavillion EXPO 2020 - Dubai, UAE
Oasis Mall - Doha, Qatar

AFRICA

Berraki Stadium - Algier, Algeria
Arribat Mall Center - Rabat, Morocco
Grand Theatre Rabat - Rabat, Morocco



Airports



Pam Building's cast iron drainage solutions are essential for airports, providing unmatched durability, safety, and efficiency. Airports require robust infrastructure to handle high traffic and demanding conditions, and our cast iron pipes deliver just that. Their exceptional strength and resistance to wear and tear ensure long-lasting performance, reducing the need for frequent repairs and replacements. This reliability is crucial for maintaining smooth operations in such a critical environment.

For engineering firms and construction companies, the benefits of Pam Building's cast iron solutions are clear. The superior acoustic properties of cast iron significantly reduce noise from fluid movement, contributing to a quieter and more comfortable environment for passengers and staff. This is particularly important in airports, where maintaining a calm atmosphere is essential for traveler experience and operational efficiency.

Installers will appreciate the ease of installation and low maintenance requirements of our cast iron drainage systems. The modular design allows for quick and efficient setup, minimizing disruptions to airport operations. Additionally, the low maintenance needs of cast iron systems translate into significant cost savings over the lifecycle of the installation. By choosing Pam Building's cast iron solutions, airports can ensure a reliable, durable, and cost-effective drainage system that meets the highest standards of performance and safety.

Worldwide references

EUROPE

Geneva Airport - Geneva, Switzerland
Athens Airport Extension - Athens, Greece
International Airport Terminal 3 - Frankfurt, Germany
Manchester Airport Terminal 2 - Manchester, UK

ASIA

Çukurova Airport - Mersin, Turkey
Domodedovo Airport - Moscow, Russia
Hong Kong Airport Terminal 2 Extension, China
Changi Airport Terminal 4 - Singapore, Singapore
Ahmad Yani Airport New Terminal - Semarang, Indonesia

MIDDLE-EAST

Muscat International Airport - MC 5 - Muscat, Oman

AFRICA

CHU - Agadir, Morocco
Military Hospital - Tamanrasset, Algeria
CHU Tangier - Tangier, Morocco
Ahmed Ben Bellah International Airport - Oran, Algeria



Infrastructures



Cast iron drainage solutions, particularly our ITINERO® range, are essential for infrastructure projects such as bridges and viaducts. These projects demand materials that can withstand extreme conditions and heavy loads, and our ITINERO® pipes are engineered to meet these rigorous requirements. Their exceptional strength and durability ensure long-lasting performance, reducing the need for frequent repairs and replacements. This reliability is crucial for maintaining the integrity and safety of critical infrastructure.

For engineering firms and construction companies, the benefits of Pam Building's ITINERO® cast iron solutions are clear. The robust nature of cast iron provides superior resistance to environmental stressors, including temperature fluctuations and mechanical impacts. This makes ITINERO® pipes

ideal for infrastructure projects that require materials capable of enduring harsh conditions while maintaining structural integrity over time.

Installers will appreciate the ease of installation and low maintenance requirements of our ITINERO drainage systems. The modular design allows for quick and efficient setup, minimizing disruptions to construction schedules and reducing labor costs. Additionally, the low maintenance needs of cast iron systems translate into significant cost savings over the lifecycle of the installation. By choosing Pam Building's ITINERO® solutions, infrastructure projects can ensure a reliable, durable, and cost-effective drainage system that meets the highest standards of performance and safety.

Worldwide references

EUROPE

Central Greece Motorway E65 Bridges, Greece
Athens Metro - Athens, Greece
Mont Blanc Tunnel - Haute-Savoie, France
Tournon Viaduct - Savoie, France
Kula Vodno - Skopje, North Macedonia

ASIA

Gayrettepe - Istanbul Airport Metro - Istanbul, Turkey
Eurasia Tunnel - Istanbul, Turkey

MIDDLE-EAST

Doha Metro - Doha, Qatar
Step Project - Abu Dhabi, UA

AFRICA

TGV Train Station - Kenitra, Morocco

OCÉANIE

Dumbea Bridge - Noumea, New Caledonia
Cross Yarra Rail Tunnel - Melbourne, Australia



02

Our services

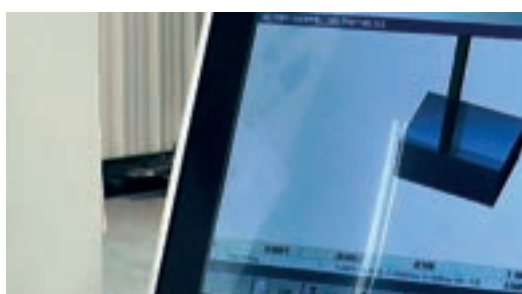
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Technical Support

Design studies

We help our customers define the most optimised network for **epams®**, **ITINERO®** or **ELIXAIR®** systems, our technical support team designs solutions and provides drawings and bills of quantities.



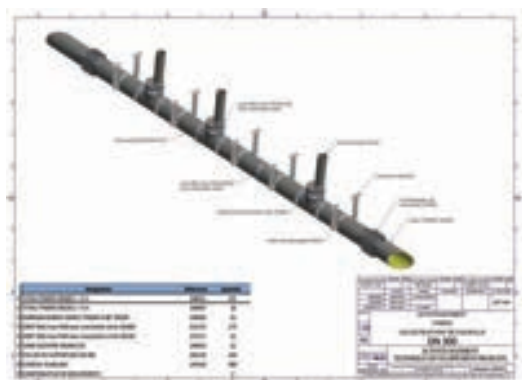
Rainwater on flat roofs project **epams®**

Send us:

- Your drawings in DWG format (roof, levels, section views, etc.)
- The general rainfall intensity of your country (in mm/hr or l/s.m²).

You will receive a response concerning the feasibility and an initial design study*.

*Full studies are conditional upon the final order of the materials.



Bridges & tunnels projects **ITINERO®**

Send us:

- The drawing of the bridge
- The drainage location (outlet and collector) in DWG format. We will provide you with:
 - A design recommendation
 - The discharge system's set-up
 - A bill of quantities.

We will support you with the system's complete design.



Heat exchanger project **ELIXAIR®**

Send us your project and we will be able to help you with the supply of:

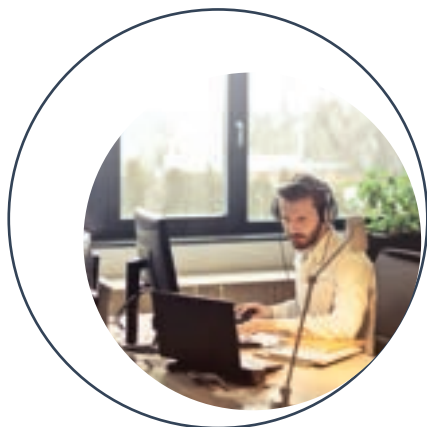
- Your earth-to-air heat exchanger
- The bill of quantities
- The heat energy saved in winter
- The cooling energy saved in summer.

Estimate your project

Send us the drawing of the discharge system's location with details of the pipe diameters in the following formats: DWG (preferred), RVT or PDF.

Based on general plumbing rules, **we will provide you with the general bill of quantities including the numbers of the parts, and the references to order.**

Technical expertise & installation recommendations



Our service portfolio is fully aligned with the new expectations of MEP consultants and contractors working on safe, comfortable and durable building projects.

In addition to our recommendations in this catalog, if you have any questions, you can **ask our experts on the following topics:**

- **Acoustics**
- **Fire protection**
- **Technical and functional advice** (see "Design & Recommendations" section)
- **Environmental building certifications.**

Bespoke development



Upon request, Pam Building can provide special designs of fittings outside the ranges offered in our catalog*.

Send us your details and we will provide a response concerning the feasibility within two days.

The latest example is the 125 x 100 x 100 mm Double Branch, which is now available in our product range.

*Sales to order only

CONTACT

tcbatiment.sgpm@saint-gobain.com

+33 (0)3 66 88 19 47

02. Our services

BIM

Pam Building aims to ease the burden on developers, specifiers and contractors in the early stages of construction by providing two levels of BIM library and supporting information.

The new releases include a full-data objects library, a platform that provides supporting information and free individual BIM files for all products and systems.

These include an EN 877 "Generic Cast Iron" content package for use in the early design stages, with parametric model fittings, and standard geometric settings. The files contain only the most vital information, reducing the time and effort required to create early stage plans. These "data-light" designs can also be overwritten with the full data specification libraries without issue, speeding up later stages of development that require more detailed plans, streamlining the transition from design to as-built work flow.

Pam Building Libraries are designed to aid data transmission between the consultants and the Main Contract MEP design engineers, creating a leaner process that reduces design time.

By providing small file sizes for the generic content, it will facilitate early stage specification in BIM and speed up the whole planning process; this in turn will create measurable cost and time savings for our customers.

Pam Building has been developing BIM Level 2 libraries in Revit for its domestic use (S), siphonic rainwater (epams®) and intensive use (Plus) ranges.



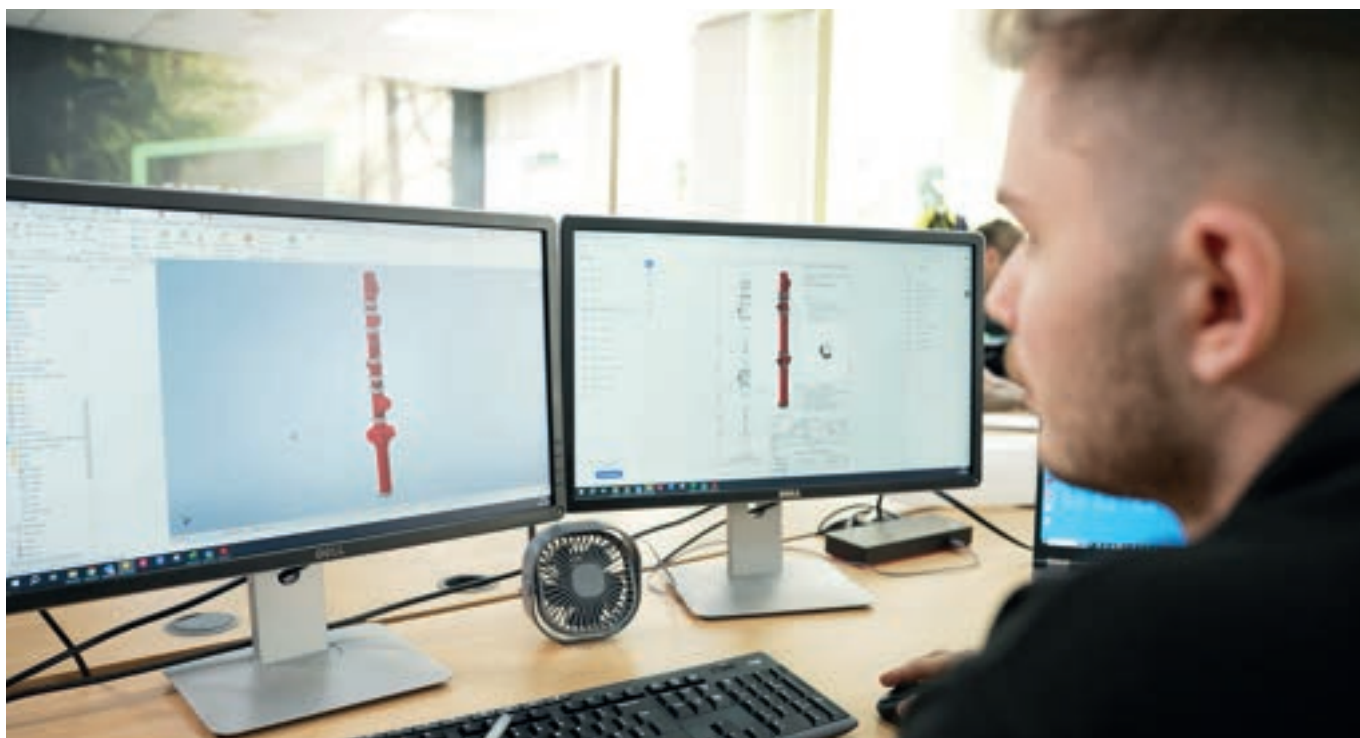
- New registration required to keep up to date with new/revised content
- Full parametric pipe systems generic and full data
- Access to guidance videos and «how to?» FAQs



Contact our technical support team:

tcbatiment.sgpam@saint-gobain.com

+33 (0)3 66 88 19 47



EN 877 CAST IRON GENERIC LIBRARY

Generic cast iron content

- Full range of cast iron fittings
- All families have 'real geometry'
- Generic coupling with 'fixing zone' visibility
- All fittings have constrained couplings which can be turned on/off
- No 'manufacturer' data
- All files are light at 500 KB max



PAM CAST IRON LIBRARY

Full data content

- Minor modifications to project design stages
- Time saving design for main contract BIM Engineers

Customer services

We sell products all over the world

With 150 years of experience in worldwide export sales, our international organization obtains all our customers' feedback which we need to help us constantly improve our products and services.

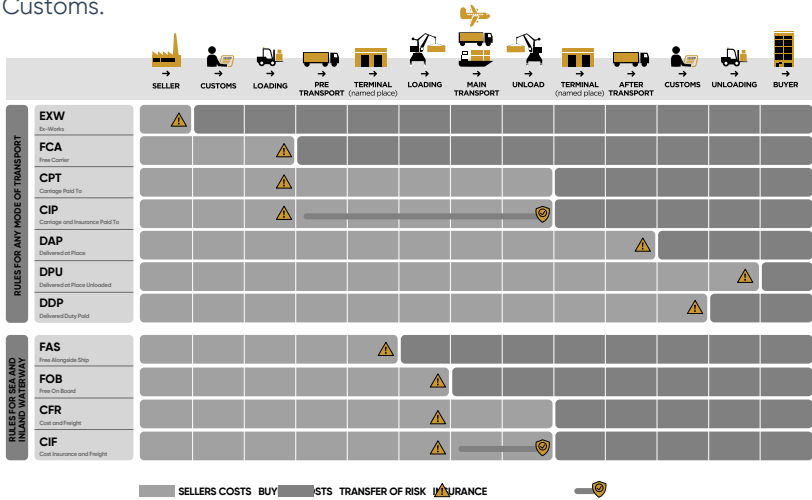


We provide logistics services

Every day, Pam Building ships a wide range of products to provide its customers with complete, operational solutions wherever they are.

Depending on your needs and practices, you can either manage the transport yourself or we can quote you in accordance with the Incoterms you wish to contract with us.

To speed up the process, we have signed an agreement with French Customs.



Our customer service teams will be happy to help!

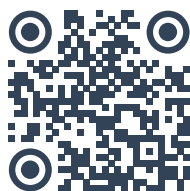
To optimize its customer service, Pam Building has an integrated network of subsidiaries, agents and distributors which can rely on dynamic and experienced technical sales teams to provide excellent customer support.

From 8:30 am – 5:30 pm (French time):
Tel: +33 3 83 80 76 50/53/54
Fax: +33 3 83 80 76 57

Digital service

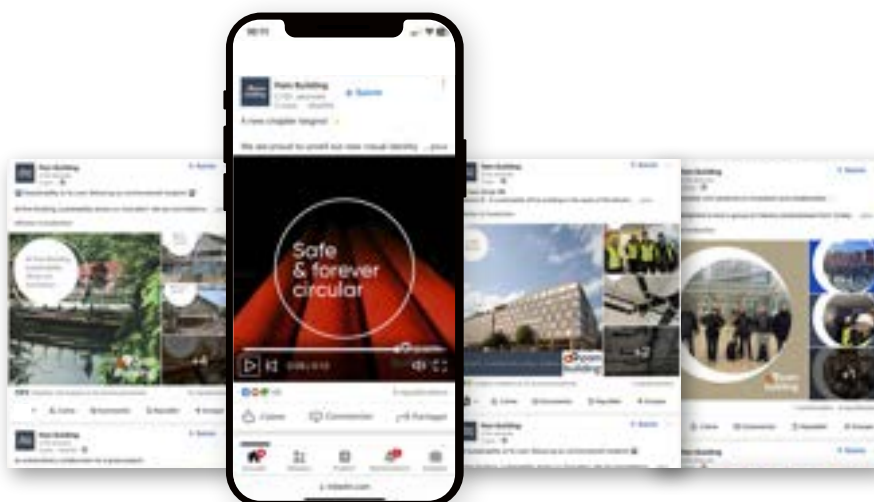
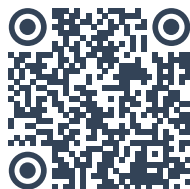
Website

Find all your answers and product information on www.pambuilding.com



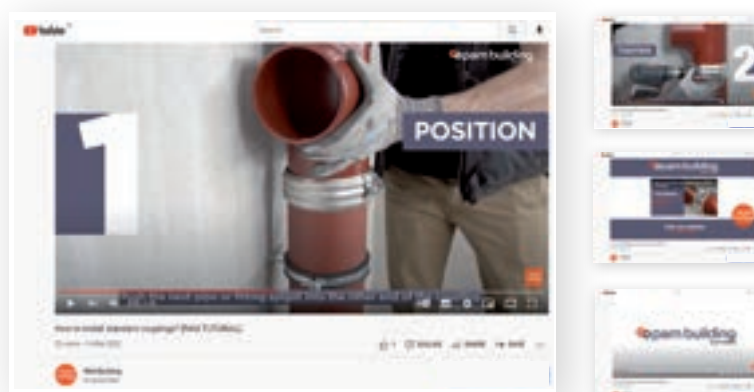
in LinkedIn

Follow the latest news from Pam Building



Youtube

Learn more about us and our products, their installation, and maintenance



03

Product catalog

Wastewater

- Domestic use: PAM GLOBAL[®] S & AGILIUM[®] 25
- Intensive use: PAM GLOBAL[®] Plus & AGILIUM[®] Zn 50–63

Infrastructure

- ITINERO[®] 66

Rainwater

- Gravity system: Residential Type R 71
- Siphonic system: epams[®] 76

Couplings, collars & connectors 84

Earth-to-air exchanger

- Elixair[®] 95

Supporting & fixing systems 96

Accessories 100





We develop
and produce
complete cast
iron drainage
systems

Domestic Use

S range



The standard range for the transportation of fluid waste and rainwater through buildings.



Recommended use

Domestic effluents: grey water, black water and rainwater

- Commercial, public and residential buildings, particularly medium- to high-rise buildings which require robust and safe solutions for basements and lower levels to vertical risers: Offices, shopping centers, housing, airports, hotels, public buildings, stadiums



Certified performance

- Compliant with standard EN 877
- Guaranteed performances by quality marks delivered by third party



Easy maintenance & installation

- **Ease of installation** due to the mechanical couplings assembled with simple tools
- **Adaptable to all configurations** with available accessories connecting cast iron with other materials
- **Limited maintenance operations** thanks to the technical and mechanical properties of cast iron.



Fire safety

- Reaction to fire: Euroclass A1
- Fire resistance: up to 240minutes depending on the configuration (generally requires no special fire protection saving time and costs)



Chemical & corrosion resistance

- Hot water resistance: 24 h at 95°C
- Thermal cycle resistance: 1,500 cycles between 15°C and 93°C
- Chemical resistance for $2 \leq \text{pH} \leq 12$



Acoustic comfort

- $L_{sc,A} < 10$ dB (A) according to EN 14366 with flow rate of 2l/s



Environment

- Recycled content: 99%
- Fully recyclable

Coatings

- **External coating:** Red-brown, acrylic primer paint, average dry film thickness 40 μm .
- **Cast iron** Made with the De Lavaud process
- **Internal coating** Two-component ochre-coloured epoxy coating, average dry film thickness of 130 μm .



Domestic Use

AGILIUM®



Pam Building launches a new drainage solution that reduces its environmental impact and facilitates the daily work of installers. An innovation that is part of our eco-design approach.



Recommended use

Domestic use: Wastewater, rainwater, runoff water, hot effluents

→ Commercial, public and residential buildings, particularly medium- to high-rise buildings which require robust and safe solutions for basements and lower levels to vertical risers: Offices, shopping centers, housing, airports, hotels, public buildings, stadiums



Certified performance

→ Compliant with standard EN 877
→ Guaranteed performances by quality marks delivered by third party



Easy maintenance & installation

30% weight reduction of the pipes and 15% for the fittings compared to standard range: a 3m Agilium® DN100 pipe weighs just 17 kg, compared to 24 kg for the standard range.

Due to their exceptional mechanical properties, cast iron drainage systems prevent the worry of untimely and costly repairs.

Possibility to:

→ Mix Agilium® pipes with fitting
→ Mix pipes of the standard range with Agilium® fittings
→ Use most standard joints
→ Keep most of the reservations for standard range with Agilium®



Fire safety

→ Reaction to fire: Euroclass A1
→ Fire resistance: up to 240 minutes depending on the configuration (generally requires no special fire protection saving time and costs)



Acoustic comfort

→ $L_{sc} \leq 13 \text{ dB(A)}$ & $L_{A_s} = 46 \text{ dB(A)}$ according to EN 14366 with flow rate of 2l/s

**30%
LIGHTER**
Vs our standard
range





Environment



Agilium® is our first eco-design, in line with our environmental roadmap. Our solution is made from **recycled materials** and is **fully recyclable**.



Less CO₂ emissions compared to our current ranges



The plumbing package represents less than 5% of a building's CO₂ emissions (data from life cycle analysis), according to a sensitivity study conducted in France by the Bastide Bondoux, Pouget and Tribu design offices, on a 4-story office building (4,000 m²).



This performance is validated by comparing our new Agilium® **Environmental Product Declaration (EPD)** with the one previously available on the environdec database (www.environdec.com).

AGILIUM®

30% lighter than standard pipes

20% less CO₂

99% recycled material & **fully** recyclable



FOR PLUMBERS

- Easier to carry with a **weight reduction of 30%**
- Faster to install with **less time spent** on pipe handling



FOR DESIGN OFFICES

- More agility with a **space-saving** in increasingly more constrained spaces



FOR PROJECT OWNERS

- Better environmental compliance with a **20% reduction in carbon emissions**



Domestic use

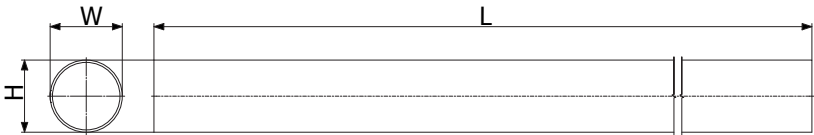
All dimensions are in mm.

Pipes / S range & Agilium®



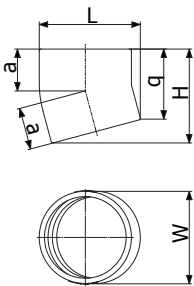
DN	L	H	W	Weight (kg)	Product code
50	3000	58	58	12.5	156361
75	3000	83	83	18.3	156550
100	3000	110	110	16.8	283723
135	3000	135	135	24.8	283724
150	3000	160	160	30.5	283725
200	3000	210	210	46.8	283726
250	3000	274	274	66,4	283727
300	3000	326	326	86.7	283728
400	3000	429	429	179.5	157171

For dimensions over DN400 please contact us.
PAM GLOBAL S - Agilium®



Bends / Short radius bends

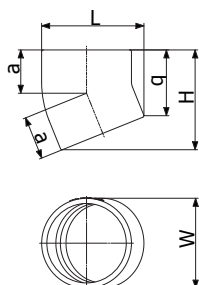
15°



DN	L	H	W	a	q	Weight (kg)	Product code
50	66	80	58	40	66	0.4	155752
75	93	99	83	45	78	0.68	176702
100	121	112	110	50	83	1	155816
125	148	134	135	60	99	1.7	155870
150	173	148	160	65	108	2.5	155903
200	227	184	210	80	129	4.6	155932
250	300	240	274	100	138	9.5	157071

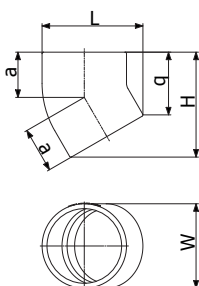
Bends / Short radius bends

22°



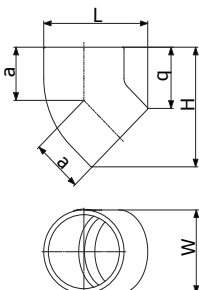
DN	L	H	W	a	q	Weight (kg)	Product code
50	70	88	58	40	66	0.45	288104
75	97	105	83	47	74	0.8	288105
100	126	125	110	54	84	1.3	288106
125	152	143	135	61	92	1.9	288107
150	179	162	160	69	102	2.6	288108
200	233	200	210	83	122	4.4	288109
250	300	240	274	100	138	9.5	157071

30°



DN	L	H	W	a	q	Weight (kg)	Product code
50	76	97	58	45	69	0.5	155753
75	102	114	83	50	73	0.8	176703
100	132	136	110	60	81	1.3	155817
125	160	164	135	70	96	2	155871
150	189	188	160	80	108	3	155904
200	243	229	210	95	124	5.4	155933
250	309	270	274	110	133	9.7	155948
300	367	322	326	130	159	15.5	155960
400	478	369	429	184	173	26	170731

45°



DN	L	H	W	a	q	Weight (kg)	Product code
50	84	106	58	50	65	0.6	155751
75	112	132	83	60	73	0.9	176704
100	139	149	110	65	72	1,2	283867
125	167	175	135	75	80	2,1	285291
150	194	197	160	83	85	3,0	285292
200	253	254	210	106	106	5,4	285293
250	324	319	274	130	125	10	155947
300	387	380	326	155	149	18.3	155959
400	540	573	429	247	270	34.4	288110


PAM GLOBAL S - Agilium®

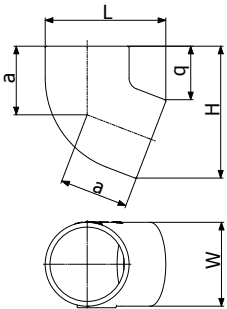
Domestic use

All dimensions are in mm.

Bends / Short radius bends


68°

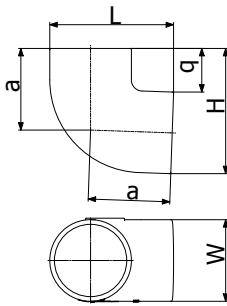




DN	L	H	W	a	q	Weight (kg)	Product code
50	104	123	58	65	70	0.8	155750
75	131	149	83	80	72	1	176705
100	159	176	110	90	74	1.8	155814
125	188	205	135	105	80	3	155868
150	219	237	160	120	89	4.1	155901
200	277	295	210	145	99	8	288111

88°



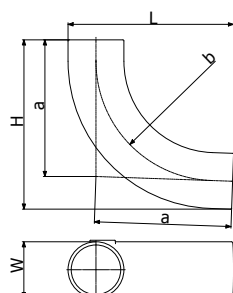


DN	L	H	W	a	q	Weight (kg)	Product code
50	104	107	58	75	49	0.8	155749
75	138	140	83	95	57	1.4	176706
100	166	169	110	110	59	2.2	283868
125	194	197	135	125	62	2.9	285294
150	227	230	160	145	70	4.3	285295
200	288	291	210	180	81	8.1	155930
250	360	363	274	223	89	13.5	288112
300	427	431	326	280	105	27.7	288113
400	644	651	429	466	223	59	288114

PAM GLOBAL S - Agilium®

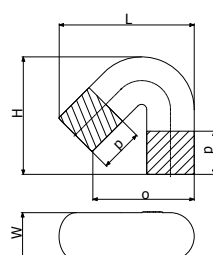
Bends / Long radius bends

88°



DN	L	H	W	a	q	Weight (kg)	Product code
100	330	330	110	269	230	4.2	288115
150	349	349	160	274	210	8	288116

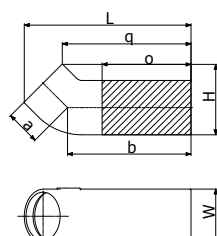
135°



DN	L	H	W	a	q	Weight (kg)	Product code
100	314	272	110	236	100	4.5	155818

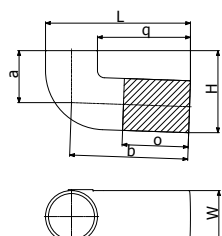
Bends / Long tail bends

45°



DN	L	H	W	a	b	o	q	Weight (kg)	Product code
100	338	143	110	250	250	180	260	3.5	155824

88°

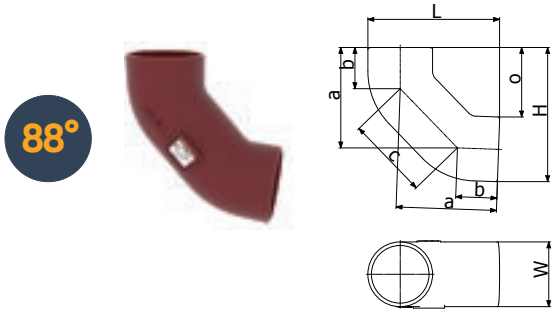


DN	L	H	W	a			q	Weight (kg)	Product code
100	305	165	110	110	250	140	195	3.7	155823

Domestic use

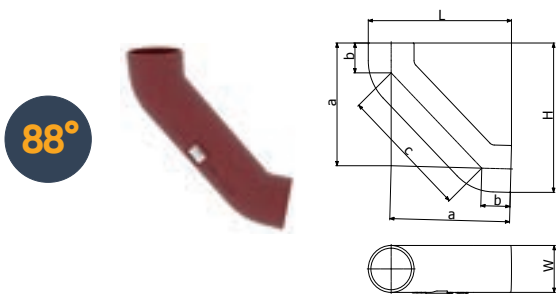
All dimensions are in mm.

Bends / Double bends



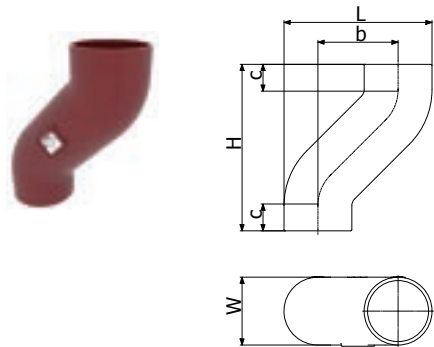
DN	L	H	W	a	b	c	o	Weight (kg)	Product code
50	148	148	58	121	50	100	148	1	155754
75	183	183	83	145	60	120	183	1.5	176707
100	228	228	110	170	70	140	228	2.8	155819
125	265	265	135	195	80	160	265	4.4	155872
150	303	303	160	219	90	180	303	6.3	155905

Bends / Long tail double bends



DN	L	H	W	a	b	c	Weight (kg)	Product code
100	346	346	110	291	70	312	4.8	155820
125	376	376	135	308	80	322	6.1	155873
150	406	406	160	326	90	334	9.0	155906

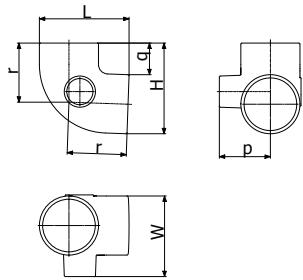
Bends / Offsets



DN	L	H	W	b	c	Weight (kg)	Product code
100	175	205	110	65	70	2	155812
	240	270	110	130	70	3.7	155821

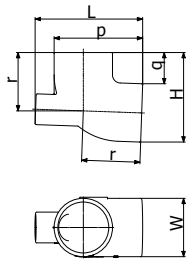
Bends / Vented bends

88°

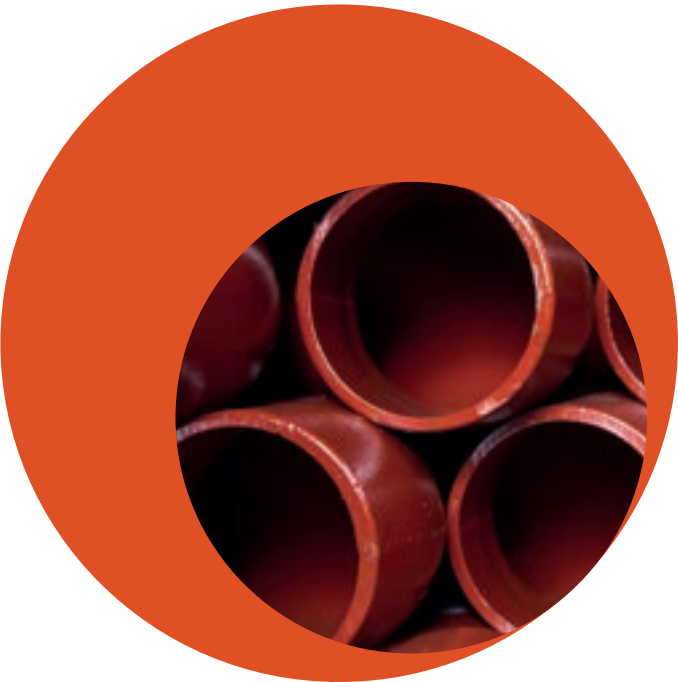


RADIAL									
DN	Ventilation	L	H	W	p	q	r	Weight (kg)	Product code
100	Radial	166	169	150	95	59	110	2.15	157581

88°



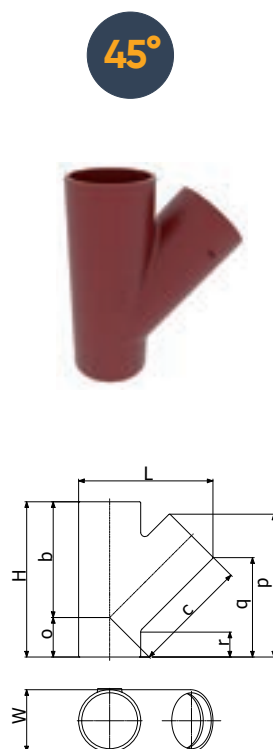
AXIAL									
DN	Ventilation	L	H	W	p	q	r	Weight (kg)	Product code
100	Axial	166	169	150	95	59	110	2.15	157581



Domestic use

All dimensions are in mm.

Branches / Single branches



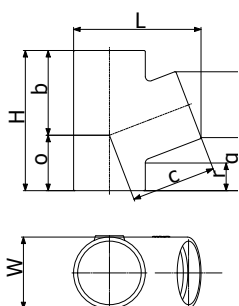
DN	dn	L	H	W	b	c	o	p	q	r	Weight (kg)	Product code
75	50	156	180	83	135	135	45	161	120	43	1.6	173786
	75	179	215	83	155	155	60	198	140	40	2.2	173787
100	50	191	200	110	165	165	35	172	131	47	2.4	155828
	75	214	235	110	170	170	50	209	151	46	3.2	173788
	100	238	275	110	205	205	70	253	175	45	4	283869
125	50	218	205	135	185	185	20	170	130	44	3.2	155877
	75	237	240	135	195	200	45	215	156	51	4.2	176716
	100	261	280	135	220	220	60	245	177	47	5	285296
	125	284	320	135	240	240	80	296	201	49	5.2	285297
150	75	265	255	160	210	220	35	220	161	54	5.1	176733
	100	287	295	160	240	240	55	262	185	54	5.8	285358
	125	307	325	160	255	255	70	298	202	52	7.4	285298
	150	323	355	160	265	265	90	333	219	53	7.9	285299
200	75	303	260	210	240	240	20	218	159	64	7.4	176734
	100	340	310	210	265	265	40	275	198	67	9.3	285300
	125	360	340	210	280	280	55	310	215	64	11.6	155936
	150	383	375	210	300	300	75	353	240	66	12.3	285301
	200	418	455	210	340	340	115	428	280	68	17.1	285302
250	100	398	330	274	315	315	15	276	198	72	13.6	155949
	125	420	370	274	335	335	35	318	223	75	17.8	155950
	150	440	405	274	350	350	55	358	245	75	22	155951
	200	486	480	274	390	390	90	440	291	75	22.4	155952
	250	537	580	274	430	430	130	530	335	70	29	155956
300	100	445	350	326	345	345	5	287	208	88	18.9	155961
	125	464	360	326	360	360	15	316	221	80	22.7	155962
	150	487	415	326	380	380	35	359	246	81	28	155963
	200	547	485	326	415	440	70	454	305	81	31	155964
	250	588	580	326	465	465	115	540	347	80	37.6	155965
	300	634	660	326	505	505	155	661	431	115	46.3	155968
400	300	728	660	429	555	555	105	620	389	86	56.4	288118
	400	820	835	429	645	645	190	795	492	101	98	288119

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For dimensions over DN400 please contact us.

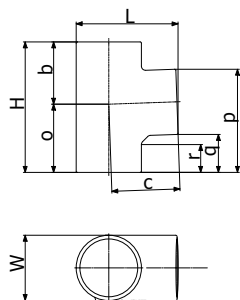
Branches / Single branches

68°



DN	dn	L	H	W	b	c	o	p	q	r	Weight (kg)	Product code
50	50	118	145	58	80	80	55	117	65	37	1	288122
75	75	158	180	83	110	110	70	149	72	37	2	288123
100	100	195	220	110	130	130	85	189	87	50	2.8	155856
125	125	235	255	135	155	155	100	220	95	50	4.5	156811
150	150	276	295	160	180	180	115	256	108	55	6.5	156929
200	200	352	365	210	225	225	140	321	125	63	12	157027

88°

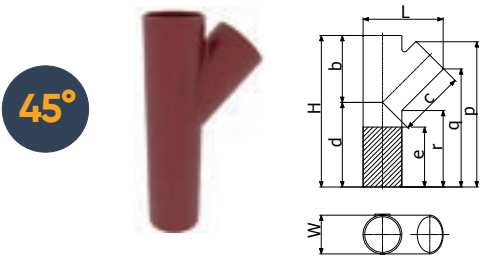


DN	dn	L	H	W	b	c	o	p	q	r	Weight (kg)	Product code
50	50	110	145	58	66	80	79	111	53	31	1	155767
75	50	132	160	83	75	90	85	117	59	42	1.5	176718
	75	138	180	83	85	95	95	140	57	37	1.6	176719
100	50	161	170	110	76	105	94	127	69	45	2	155827
	75	166	190	110	90	110	100	145	62	40	2.4	176720
	100	172	220	110	105	115	115	174	64	41	2.8	283870
125	50	188	180	135	82	120	98	131	73	51	2.6	155876
	75	194	205	135	100	125	105	151	68	48	2.9	176722
	100	199	235	135	110	130	125	184	74	48	4.2	155880
	125	205	260	135	123	135	137	209	74	48	5	155894
150	50	221	200	160	100	140	100	134	76	51	3.9	155908
	75	221	220	160	105	140	115	161	78	55	4.4	176723
	100	227	245	160	115	145	130	190	80	52	5.6	155911
	125	232	275	160	128	150	147	220	85	56	6.1	155913
	150	237	300	160	142	155	158	243	83	55	6.7	156925
200	100	282	270	210	125	175	145	206	96	64	8.8	288125
	200	288	365	210	180	185	193	296	86	67	11	288126
250	250	366	455	274	228	243	240	375	101	77	19.5	288127
300	300	434	530	326	265	265	265	437	111	87	35	288128
400	400	616	684	429	314	370	370	595	165	90	67	170732

Domestic use

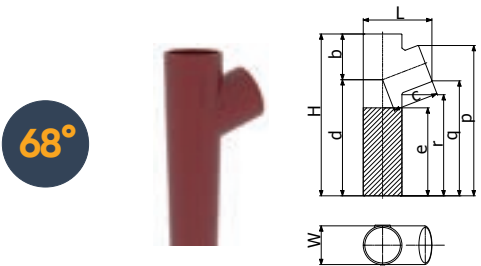
All dimensions are in mm.

Branches / Long tail single branches



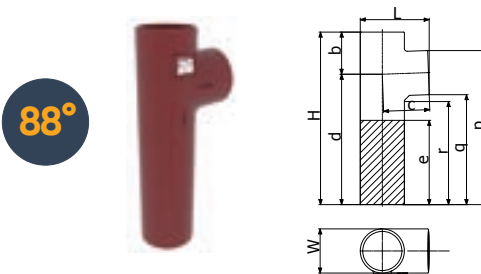
DN	dn	L	H	W	b	c	d	e	p	q	r	Weight (kg)	Product code
100	100	238	430	110	205	205	225	170	424	346	241	5.3	288117

Hatch patterned area in the drawings shows the max. cutting length.



DN	dn	L	H	W	b	c	d	e	p	q	r	Weight (kg)	Product code
100	100	195	460	110	130	130	330	250	430	328	290	4.8	288121

Hatch patterned area in the drawings shows the max. cutting length.



DN	dn	L	H	W	b	c	d	e	p	q	r	Weight (kg)	Product code
100	100	177	430	110	105	115	325	210	274	269	254	4.7	155861

Hatch patterned area in the drawings shows the max. cutting length.

Branches / Short double branches



DN	dn	L	H	W	b	c	d	p	q	r	Weight (kg)	Product code
100	100	346	260	110	190	190	70	243	165	46	5.3	283871
125	100	387	280	135	220	220	60	254	177	50	6.3	288131
	125	421	305	135	240	240	65	285	190	45	7.9	288132
150	100	394	280	160	225	225	55	252	174	54	7.3	288133
	150	488	355	160	265	265	90	334	277	55	11.8	288134



DN	dn	L	H	W	b	c	d	p	q	r	Weight (kg)	Product code
50	50	178	145	58	85	85	60	118	64	35	1.2	156437
75	75	234	180	83	110	110	70	149	72	36	2.3	156546
100	100	281	220	110	130	130	85	189	87	50	3.4	288135
125	125	336	255	135	155	155	100	220	95	51	5.5	288136
150	150	392	295	160	180	180	115	256	108	55.7	8.2	288137

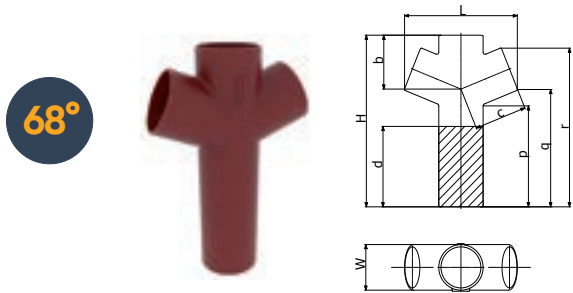


DN	dn	L	H	W	b	c	d	p	q	r	Weight (kg)	Product code
100	50	212	170	110	76	105	94	127	69	45	2.2	155825
	75	220	190	110	90	110	100	145	62	40	2.7	179685
	100	243	230	110	105	120	115	179	69	49	3.7	155858
125	100	263	235	135	115	135	130	184	74	48	4.5	155874
150	100	294	245	160	115	145	130	190	80	52	5.9	155907

Domestic use

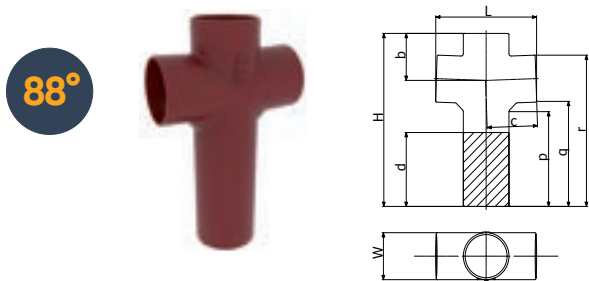
All dimensions are in mm.

Branches / Long tail double branches



DN	dn	L	H	W	b	c	d	p	q	r	Weight (kg)	Product code
100	100	280	414	110	130	130	284	244	281	383	6.3	176896

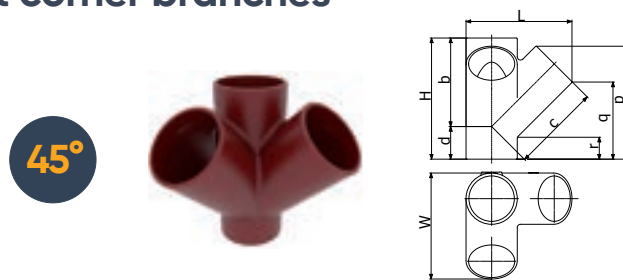
Hatch patterned area in the drawings shows the max. cutting length



DN	dn	L	H	W	b	c	d	p	q	r	Weight (kg)	Product code
100	100	243	405	110	110	120	295	222	244	354	5.9	176883

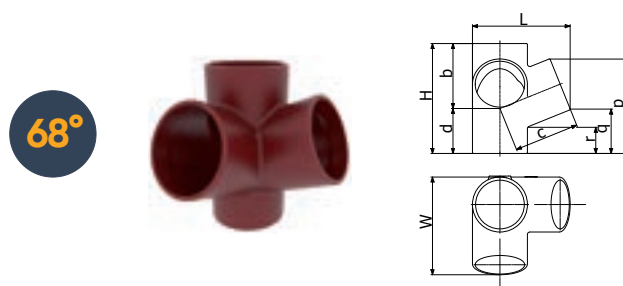
Hatch patterned area in the drawings shows the max. cutting length

Branches / Short corner branches



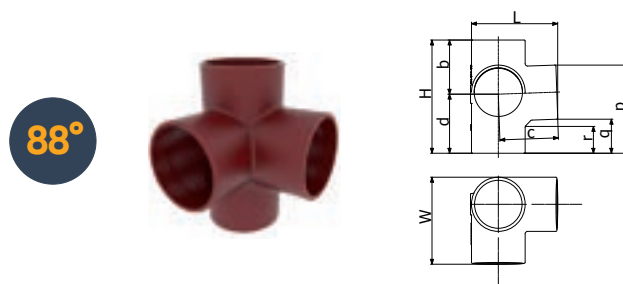
DN	dn	L	H	W	b	c	d	p	q	r	Weight (kg)	Product code
100	100	227	260	227	190	190	70	242	166	46	5.2	156716

Hatch patterned area in the drawings shows the max. cutting length



DN	dn	L	H	W	b	c	d	p	q	r	Weight (kg)	Product code
75	75	158	180	158	110	110	70	149	72	36	2.1	156548
100	100	195	220	195	130	130	90	189	87	50	3.5	156714

Hatch patterned area in the drawings shows the max. cutting length



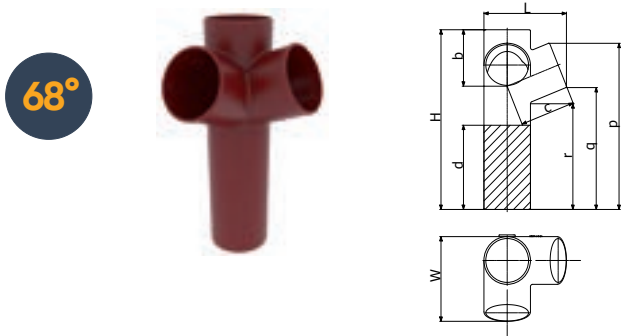
DN	dn	L	H	W	b	c	d	p	q	r	Weight (kg)	Product code
75	75	137	180	136	85	95	95	140	57	36	2	179682
100	75	165	190	165	90	110	100	145	62	40	2.8	179683
	100	177	230	177	105	120	115	179	69	44	2.8	155860
125	100	199	235	199	110	130	125	184	74	48	4.3	155889
150	100	227	245	227	115	145	130	190	80	52	5.3	155919

Hatch patterned area in the drawings shows the max. cutting length

Domestic use

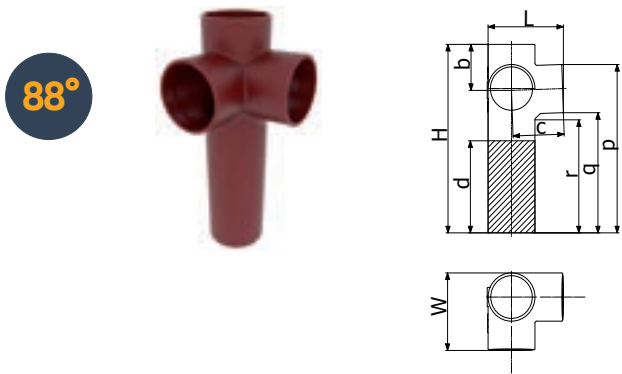
All dimensions are in mm.

Branches / Long tail corner branches



DN	dn	L	H	W	b	c	d	p	q	r	Weight (kg)	Product code
100	100	195	414	195	130	130	284	383	244	281	5.1	176943

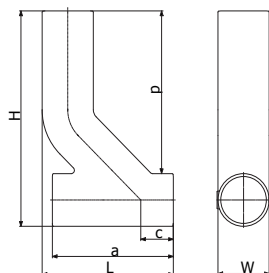
Hatch patterned area in the drawings shows the max. cutting length



DN	dn	L	H	W	b	c	d	p	q	r	Weight (kg)	Product code
100	100	177	430	177	105	115	325	379	244	269	5.3	155862

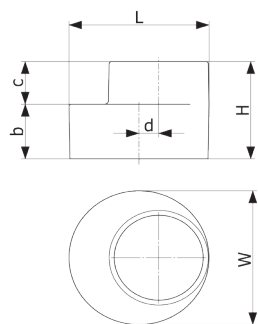
Hatch patterned area in the drawings shows the max. cutting length

Branches / Single long arm branches



DN	dn	L	H	W	a	c	p	Weight (kg)	Product code
100	100	282	450	110	260	70	340	6	288120

Tapped pipes / Reducers



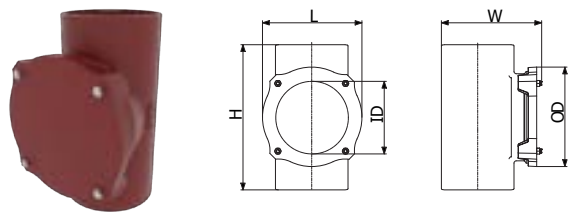
DN	dn	L	H	W	b	c	d	Weight (kg)	Product code
75	50	83	80	83	47	30	13	0.65	176727
100	50	110	80	110	45	30	26	0.9	155764
	75	110	90	110	45	45	14	1	176728
125	50	135	85	135	50	30	39	1.5	155765
	75	135	95	135	52	35	26	1.3	176730
	100	135	95	135	50	40	13	1.6	155842
150	50	160	95	160	55	30	51	1.9	155766
	75	160	100	160	57	35	39	1.9	176732
	100	160	105	160	60	40	25	2	155843
	125	160	110	160	60	45	13	2	155892
200	100	210	115	210	70	40	50	3.6	155844
	125	210	120	210	70	45	38	3.8	155893
	150	210	125	210	65	60	25	3.4	155922
250	100	274	125	274	82	45	82	6	288102
	150	274	135	274	82	50	57	6.3	155923
	200	274	145	274	80	60	32	6.9	155942
300	150	326	150	326	97	50	83	11	155924
	200	326	160	326	95	60	58	10.2	155943
	250	326	170	326	95	70	26	10.7	155955
400	300	429	200	429	100	100	52	19.6	288103

For dimensions over DN400 please contact us.

Domestic use

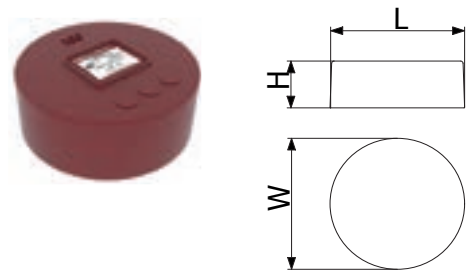
All dimensions are in mm.

Access Fittings / Access pipes



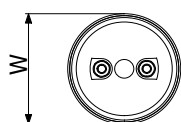
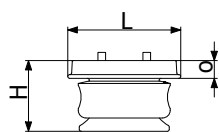
Round door								
DN	dn	H	W	ID	OD	Weight (kg)	Number of bolts	Product code
50	105	190	93	53	105	2.3	2	179191
75	134	220	115	78	134	3.2	2	179647
100	159	260	139	104	159	5	2	179192
125	202	280	202	152	202	7.0	3	280010
150	243	320	226	180	243	9.8	4	280012
200	243	360	277	180	243	12.9	4	280013
250	274	380	362	180	243	18.7	4	280014
300	326	400	413	180	243	25	4	280015

Access Fittings / Blank ends



DN	L	H	W	Weight (kg)	Product code
50	58	30	58	0.25	155747
75	83	35	83	0.45	176700
100	110	40	110	0.8	155809
125	135	45	135	1.2	155865
150	160	50	160	1.7	155898
200	210	60	210	3.2	155928
250	274	70	274	5.9	155945
300	326	80	326	10	155957

Access Fittings / Expansion plugs



DN	L	H	W	o	Weight (kg)	Screw	Product code
50	62	47	62	14	0.22	M8x30	288095
75	90	71	90	20	0.6	M8x50	176715
100	118	77	118	23	1.2	M8x60	288096
125	143	77	143	24	1.7	M8x60	288097
150	168	73	168	22	2.4	M10x45	288098
200	220	87	220	26	5	M10x60	288099
250	284	100	284	44	6.2	M10x70	288100
300	336	100	336	44	9	M10x70	288101

See p.132 for information on resistance to accidental pressure.
Expansion plugs with bleeding valve are available on request for
DN 125/DN 150 and DN 200 (for watertightness tests)



Domestic use

All dimensions are in mm.

Traps and ventilation / Traps



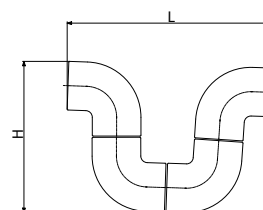
DN	L	H	W	c	d	e	f	g	o	p	q	r	s	Access*	Weight	Product code
50	190	240	58	60	182	68	122	68	143	39	33	112	201	EP 50	2.5	288148
75	264	282	80	60	200	93	172	93	150	52	13	162	230	TS 50	4.6	176714
100	325	381	110	100	282	110	215	110	216	55	15	216	326	TS 50	7.9	288149
125	390	435	134	100	316	130	260	130	238	63	12	266	372	TS 75	10.7	288150
150	470	482	160	100	348	145	325	145	257	65	8	340	417	TS 125	16.9	288151

Bottom cleaning access: EP by expansion plug / TS by tight sheet Designed for rainwater networks. The arrows stamped on the cast iron body show the flow direction.



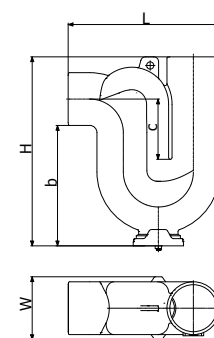
DN	L	H	W	c	d	e	f	g	o	p	r	s	Weight (kg)	Product code
200	600	590	210	100	420	180	400	200	300	80	415	510	34.3	288152

Hatch patterned area in the drawings shows the max. cutting length.

DN ≥ 250Installation with
88° bends

DN	L	H
250	900	725
300	1070	860

Traps and ventilation / Anti-syphon traps with bottom access doors

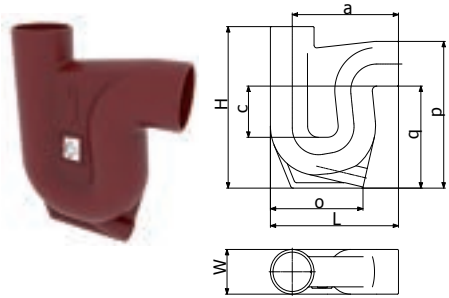
**DN >
100 - 150**

DN	L	H	W	b	c	Weight (kg)	Product code
100	316	382	110	316	350	9.2	179013
150	412	531	160	412	470	24.8	156916

Domestic use

All dimensions are in mm.

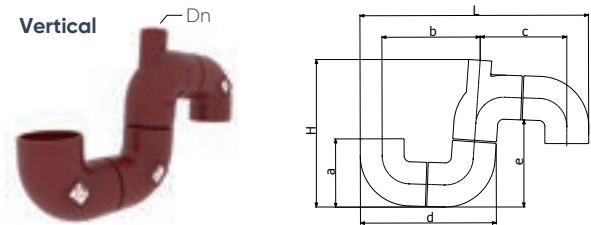
Traps and ventilation / Anti-syphon traps with side access door*



DN	L	H	W	a	c	o	p	q	Weight (kg)	Product code
50	165	230	58	136	80	130	213	155	2.8	288146
75	240	300	83	199	80	181	273	190	4.8	288147

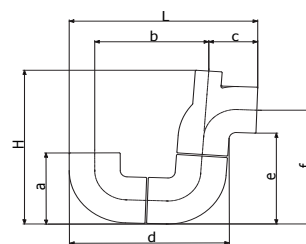
*With brass closing Suitable for all wastewater drainage systems, the Anti-Syphon Trap is particularly well-suited to systems without secondary ventilation. It ensures the retention of a water seal within the body of the trap to prevent odors traveling backwards through the system and fouling the atmosphere around sinks, washbasins, baths, rainwater outlets, etc. The Anti-Syphon Trap works by preventing the siphoning effect of a heavy discharge through the system. It does this through the internal partition within the trap allowing the air to bypass the water, thus breaking the vacuum created by the discharge water.

Traps and ventilation / Vertical vented traps



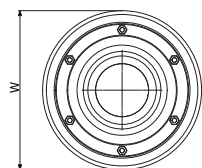
DN	Outlet	L	H	a	b	c	d	e	f	Weight (kg)
100	Vertical	575	371	163	236	229	342	228	-	8.81
100	Horizontal	399	371	163	236	108	342	228	283	6.55

The vertical outlet version consists of 3 x product code: 155813 and 1 x product code: 156585. The horizontal outlet consists of 1 x product code: 156585 and 2 x product code: 155813.



DN	Dn	Product code
100	-	155813
100	50	156585

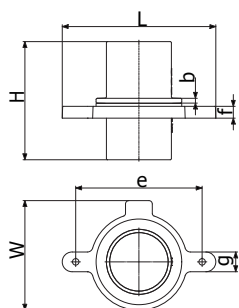
Traps and ventilation / Roof penetrators



DN	L	H	W	a	b	Weight (kg)	Product code
75	286	60	286	135	135	6.1	205922
100	324	60	324	158	246	6.6	205924
125	349	60	349	188	271	6.6	205925

DN	Product code EPDM gasket	Weight (kg)	Product code NBR gasket	Weight (kg)
75	179894	0.2	179895	0.2
100	207320	0.3	207319	0.3
125	207335	0.3	207334	0.3

Stack support



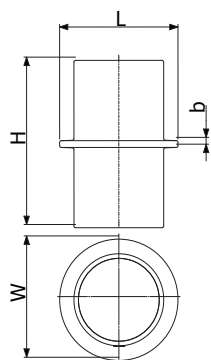
DN	L	H	W	b	e	f	g	Ø Ext	Weight (kg)	Product code
50	195	220	108	8	150	17	30	108	2.5	288138
75	218	220	133	8	175	19	30	133	3.1	288139
100	259	220	162	8	214	20	32	162	4.3	288140
125	275	220	187	8	228	20	32	197	5.4	288141
150	300	220	222	8	255	22	32	222	7.2	288142
200	362	220	278	8	310	22	36	278	10.5	288143
250	444	300	354	8	394	25	40	354	19.1	288144
300	498	300	406	8	448	30	40	406	26.5	288145
400	600	340	508	10	550	30	50	508	43.9	On request

03. Product catalog

Domestic use

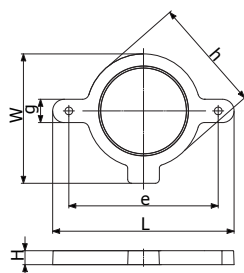
All dimensions are in mm.

Stack support / Pipe



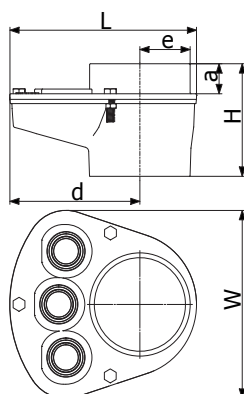
DN	L	H	W	b	Weight (kg)	Product code
50	87	220	87	8	1.3	288091
75	118	220	118	8	1.8	288092
100	145	220	145	8	2.4	288093
125	170	220	170	8	3.2	288094

Stack support / Bracket



DN	L	H	W	e	g	h	Weight (kg)	Product code
50	195	17	108	150	30	108	1	179217
75	218	19	133	175	30	133	1.2	176713
100	259	20	162	214	32	162	1.6	179219
125	275	20	187	228	32	187	1.7	179220

Special fittings / Manifold connector

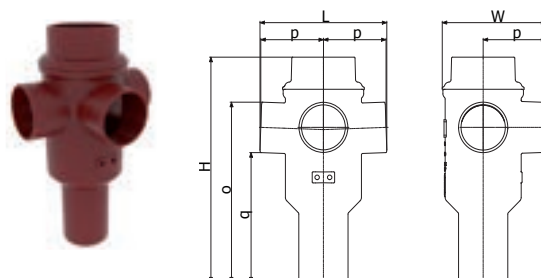


DN	L	H	W	a	d	e	Weight (kg)	Product code
100	204	125	200	43	142	62	3.2	175626
150	265	165	290	70	184	81	6.1	175629

The multi-waste manifold simplifies waste plumbing by grouping all associated pipework from various sources such as sinks, basins, bidets, urinals and showers to one internal point above the finished floor level. See p.150 for installation details.

Special fittings / Single stack branch

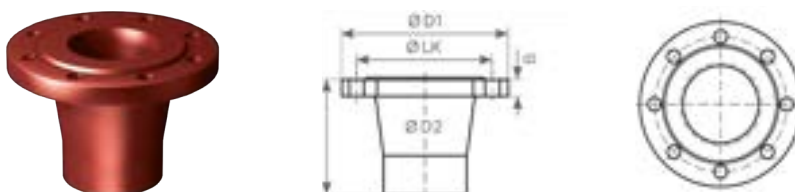
Branches for single downpipe with 2 to 3 inlets – combined networks



DN	Lateral adjustments	L	H	W	o	p	q	Weight (kg)	Product code
100	3 consecutive DN 100 at 90°	280	490	230	392	140	282	11	288129
	2 DN 100 at 90°	230	490	230	392	140	282	10.4	177236
	2 DN 100 at 180°	280	490	180	392	140	282	10.8	177235

Special fittings / Flanges

Connector with PN10 flange



DN	Dimensions (mm)				8 HOLES for screw size	Weight	Art Number
100	220	131	24	180	M16	6	155840
125	250	156	26	210	M16	8	155890
150	285	184	26	240	M20	10	155920
200	340	235	26	295	M20	15	155941

Delivered without screw or gasket

Intensive use

Plus range

High-performance solution designed to withstand intensive use.



Recommended use

- Above- and below-ground applications when exposed to hot and/or aggressive discharge. When installed below ground in aggressive environments it is highly resistant to external stresses.
- Hospitals, laboratories and collective kitchens



Certified performance

- Compliant with standard EN 877
- Guaranteed performances by quality marks delivered by third party



Easy maintenance & installation

- **Long-lasting operational safety** thanks to the robustness and stiffness (around 700 kN.m) of cast iron and the use of flexible mechanical couplings
- **Ease of installation** due to mechanical couplings assembled with simple tools



Fire safety

- Reaction to fire: Euroclass A2, s1-d0
- Fire resistance up to 240 minutes depending on the configuration (generally requires no special fire protection, saving time and costs)



Chemical & corrosion resistance

- Hot water resistance: 24 h at 95°C
- Thermal cycle resistance: 1500 cycles between 15°C and 93°C
- Chemical resistance for $2 \leq \text{pH} \leq 13$: up to 80°C (check resistance for more than 30 different effluents in the tables on p.56 and 57)
- External coating corrosion resistance test to neutral salt spray according to standard NF-EN ISO 9227_2017: 2500 hours.



Acoustic comfort

- $L_{sc,A} < 10$ dB (A) according to EN 14366 with flow rate of 2l/s



Environment

- Recycled content: 99%
- Fully recyclable

Coatings

- **External coating:** Grey, acrylic primer paint, average dry film thickness of 40 µm
- **Anti-corrosive layer:** zinc coating of 130 g/m²
- **Cast iron:** Made with the De Lavaud process
- **Internal coating:** Two-component ochre-coloured epoxy coating applied in two layers, average dry film thickness of 250 µm



Fittings: Externally and internally coated with a grey powder epoxy to an average thickness of 300 µm.

pam building

PAM GLOBAL® Plus

DN EN 877

CE

A2-s1, d0

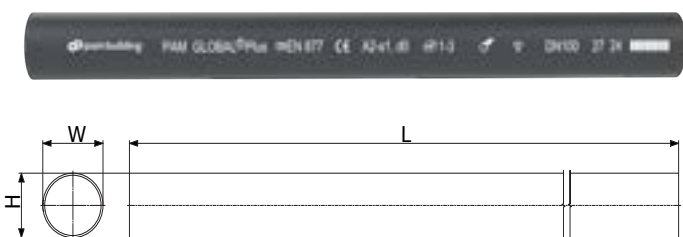
NF 1-3



DN100

27

Pipes



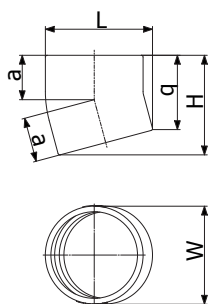
PAM GLOBAL® Plus

DN	L	H	W	Weight (kg)	Product code
50	3000	58	58	12.7	155302
75	3000	83	83	18.6	176787
100	3000	110	110	24.8	155348
125	3000	135	135	34.9	155391
150	3000	160	160	41.6	155413
200	3000	210	210	68.4	155447
250	3000	274	274	98.6	155475
300	3000	326	326	128.3	155492
400	3000	429	429	179.5	155508

For dimensions over DN400 please contact us.

Bends / Short radius bends

15°




DN	L	H	W	a	q	Weight (kg)	Product code
50	66	80	58	40	66	0.4	155202
75	93	99	83	45	78	0.68	176781
100	121	112	110	50	83	1	155237
125	148	134	135	60	99	1.7	155262
150	173	148	160	65	108	2.5	155278
200	227	184	210	80	129	4.6	173774
400	455	284	429	100	181	21.4	on request

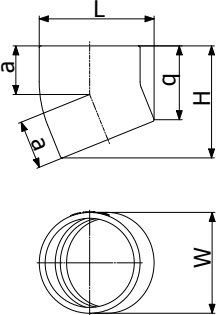
Intensive use

All dimensions are in mm.

Bends / Short radius bends


22°

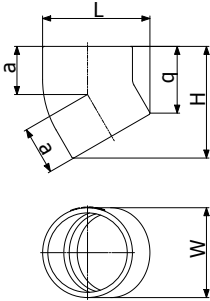




DN	L	H	W	a	q	Weight (kg)	Product code
50	70	88	58	40	66	0.45	155308
75	97	105	83	47	74	0.8	155327
100	126	125	110	54	84	1.3	288071
125	152	143	135	61	92	1.9	155396
150	179	162	160	69	102	2.6	288072
200	233	200	210	83	122	4.4	155455
250	300	240	274	100	138	9.5	155482


30°

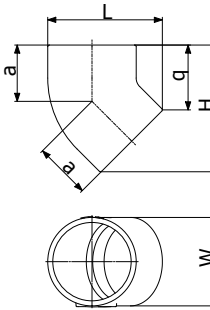




DN	L	H	W	a	q	Weight (kg)	Product code
50	76	97	58	45	69	0.5	155203
75	102	114	83	50	73	0.8	176782
100	132	136	110	60	81	1.3	155238
125	160	164	135	70	96	2	155263
150	189	188	160	80	108	3	155279
200	243	229	210	95	124	5.4	179335

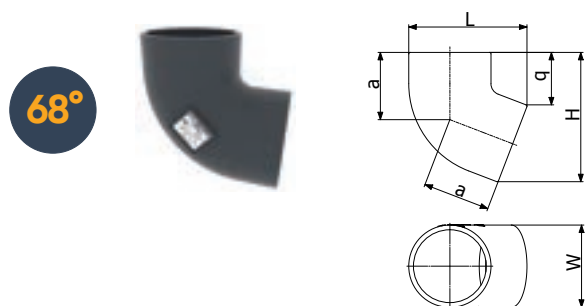
45°



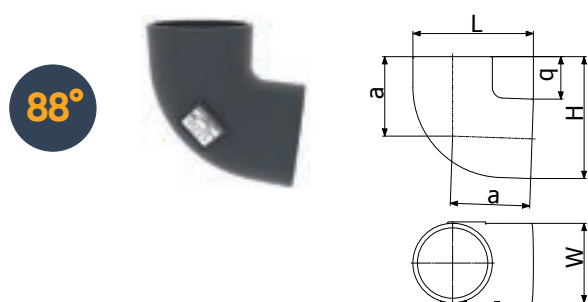


DN	L	H	W	a	q	Weight (kg)	Product code
50	84	106	58	50	65	0.6	155201
75	112	132	83	60	73	0.9	176735
100	142	158	110	70	80	1.6	155236
125	171	184	135	80	89	2.1	155261
150	199	210	160	90	97	3.2	155277
200	256	262	210	110	113	5.3	155289
250	324	319	274	130	125	10	288073
300	387	380	326	155	149	18.3	288074
400	540	573	429	247	270	34.4	155509

Bends / Short radius bends

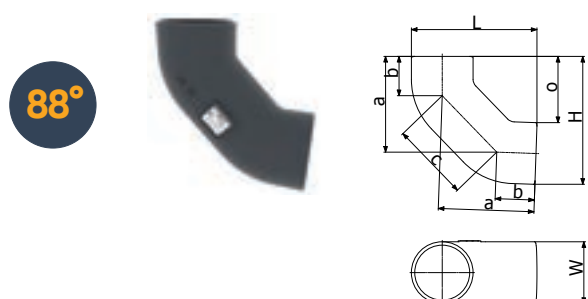


DN	L	H	W	a	q	Weight (kg)	Product code
50	104	123	58	65	70	0.8	155200
75	131	149	83	80	72	1	176736
100	159	176	110	90	74	1.8	155235
125	188	205	135	105	80	3	155260
150	219	237	160	120	89	4.1	155276
200	277	295	210	145	99	7.8	155452



DN	L	H	W	a	q	Weight (kg)	Product code
50	104	107	58	75	49	0.8	155199
75	138	140	83	95	57	1.4	176737
100	166	169	110	110	59	2.2	155234
125	194	197	135	125	62	2.9	155259
150	227	230	160	145	70	4.3	155275
200	288	291	210	180	81	8.1	288075
250	360	363	274	223	89	13.5	155479
300	427	431	326	280	105	27.7	155496
400	644	651	429	466	223	59	on request

Bends / Double bends

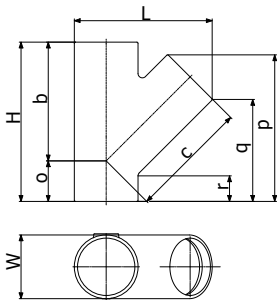


DN	L	H	W	a	b	c	o	Weight (kg)	Product code
50	148	148	58	121	50	100	148	1	235800
75	183	183	83	145	60	120	183	1.5	235801
100	228	228	110	170	70	140	228	2.8	288076

Intensive use

All dimensions are in mm.

Branches / Single branches



DN	dn	L	H	W	b	c	o	p	q	r	Weight (kg)	Product code
50	50	144	185	58	135	135	50	165	124	36	1.35	155213
75	50	156	180	83	135	135	45	161	120	43	1.6	176740
	75	179	215	83	155	155	60	198	140	40	2.2	176742
100	50	191	200	110	165	165	35	172	131	47	2.4	155245
	75	214	235	110	170	170	50	209	151	46	3.2	176743
	100	238	275	110	205	205	70	253	175	45	4	155255
125	50	218	205	135	185	185	20	170	130	44	3.2	155264
	75	237	240	135	195	200	45	215	156	51	4.2	176784
	100	261	280	135	220	220	60	254	177	47	5	155267
	125	284	320	135	240	240	80	296	201	49	5.2	155271
150	75	265	255	160	210	220	35	220	161	54	5.1	176785
	100	287	295	160	240	240	55	262	185	54	5.8	155281
	125	307	325	160	255	255	70	298	202	52	7.4	155282
	150	323	355	160	265	265	90	333	219	53	7.9	155285
200	100	340	310	210	265	265	40	275	198	67	9.3	155291
	125	360	340	210	280	280	55	310	215	64	11.6	155292
	150	383	375	210	300	300	75	353	240	66	12.3	155293
	200	418	455	210	340	340	115	428	280	68	17.1	155295
250	150	440	405	274	350	350	55	358	245	75	22	208730
	200	486	480	274	390	390	90	440	291	75	22.4	288077
	250	537	580	274	430	430	130	530	335	70	29	288078
300	250	588	580	326	465	465	115	540	347	80	37.6	288079
	300	634	660	326	505	505	155	661	431	115	46.3	288080
400	300	728	660	429	555	555	105	620	389	86	56.4	155510
	400	820	835	429	645	645	190	795	492	101	98	on request

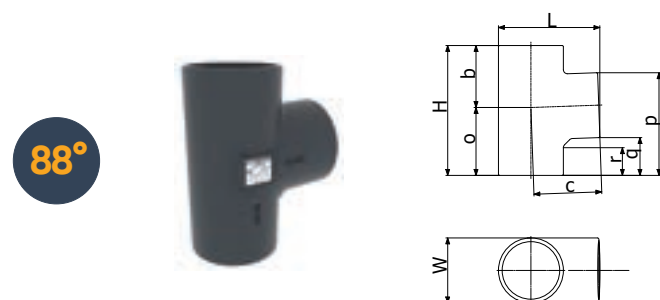
For dimensions over DN400 please contact us.

Branches / Single branches



DN	dn	L	H	W	b	c	o	p	q	r	Weight (kg)	Product code
50	50	118	145	58	80	80	55	117	65	37	1	155315
75	75	158	180	83	110	110	70	149	72	37	2	155343
100	100	195	220	110	130	130	85	189	87	50	2.8	288081
125	125	235	255	135	155	155	100	220	95	50	4.5	155408
150	150	276	295	160	180	180	115	256	108	55	6.5	155441
200	200	352	365	210	225	225	140	321	126	63	12	155469

For dimensions over DN400 please contact us.



DN	dn	L	H	W	b	c	o	p	q	r	Weight (kg)	Product code
50	50	110	145	58	66	80	79	111	53	31	1	155212
75	50	132	160	83	75	90	85	117	59	42	1.5	176744
	75	138	180	83	85	95	95	140	57	37	1.6	176745
100	50	161	170	110	76	105	94	127	69	45	2	155244
	75	166	190	110	90	110	100	145	62	40	2.4	176746
	100	172	220	110	105	115	115	174	64	41	2.8	155253
125	100	199	235	135	110	130	125	184	74	48	4.2	173022
	125	205	260	135	123	135	137	209	74	48	5	288082
150	100	227	245	160	115	145	130	190	80	52	5.6	288225
	150	237	300	160	142	155	158	243	83	55	6.7	288083
200	200	388	365	210	172	183	193	296	86	67	11	288084
250	250	366	455	274	228	243	240	375	101	77	19.5	288085
300	300	434	530	326	265	265	265	437	111	87	35	155505
400	400	616	684	429	314	370	370	595	165	90	67	on request

For dimensions over DN400 please contact us.

Intensive use

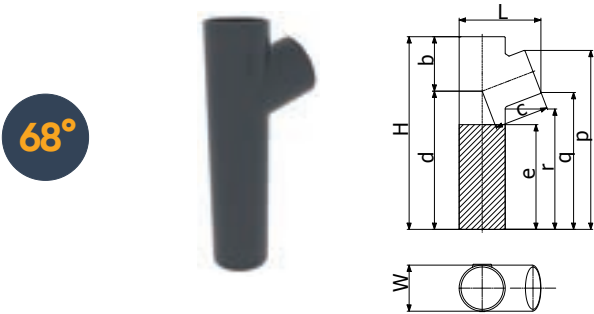
All dimensions are in mm.

Branches / Long tail single branches



DN	dn	L	H	W	b	c	d	e	p	q	r	Weight (kg)	Product code
100	100	238	430	110	205	205	225	170	424	346	241	5.3	155381

Hatch patterned area in the drawings shows the max. cutting length



DN	dn	L	H	W	b	c	d	e	p	q	r	Weight (kg)	Product code
100	100	195	460	110	130	130	330	250	430	328	290	4.8	155388

Hatch patterned area in the drawings shows the max. cutting length

Branches / Short double branches



DN	dn	L	H	W	b	c	d	p	q	r	Weight (kg)	Product code
100	100	346	260	110	190	190	70	243	165	46	5.3	288086
125	125	421	305	135	240	240	65	285	190	45	7.9	288087
150	150	488	355	160	265	265	90	334	277	55	11.8	155445



DN	dn	L	H	W	b	c	d	p	q	r	Weight (kg)	Product code
50	50	178	145	58	85	85	60	118	64	35	1.2	155317
75	75	234	180	83	110	110	70	149	72	36	2.3	155345
100	100	281	220	110	130	130	85	189	87	50	3.4	155383
125	125	336	255	135	155	155	100	220	95	51	5.5	155410
150	150	392	295	160	180	180	115	256	108	57	8.2	155444

Intensive use

All dimensions are in mm.

Branches / Short corner branches



DN	dn	L	H	W	b	c	d	p	q	r	Weight (kg)	Product code
100	100	227	260	227	190	190	70	242	166	46	5.2	155387

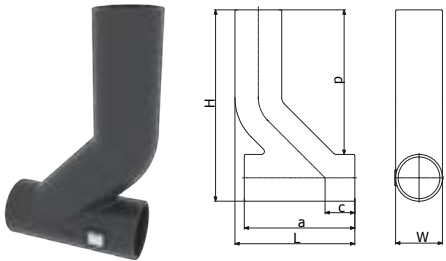
Hatch patterned area in the drawings shows the max. cutting length



DN	dn	L	H	W	b	c	d	p	q	r	Weight (kg)	Product code
75	75	158	180	158	110	110	70	149	72	36	2.1	155346
100	100	195	220	195	130	130	90	189	87	50	3.5	155386

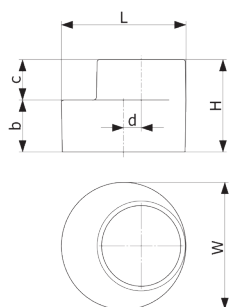
Hatch patterned area in the drawings shows the max. cutting length

Branches / Single long arm branches



DN	dn	L	H	W	a	c	p	Weight (kg)	Product code
100	100	282	450	110	260	70	340	61	155389

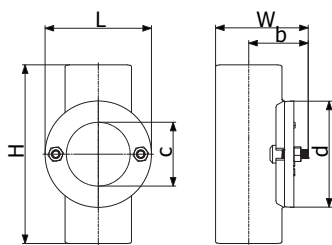
Tapped pipes / Reducers



DN	dn	L	H	W	b	c	d	Weight (kg)	Product code
75	50	83	80	83	47	30	13	0.65	176747
100	50	110	80	110	45	30	26	0.9	155209
	75	110	90	110	45	35	14	1	176748
125	50	135	85	135	50	30	39	1.5	155210
	75	135	95	135	52	35	26	1.3	176749
	100	135	95	135	50	40	13	1.6	155250
150	50	160	95	160	55	30	51	1.9	155211
	75	160	100	160	57	35	39	1.9	176750
	100	160	105	160	60	40	25	2	155251
	125	160	110	160	60	45	13	2	155269
200	100	210	115	210	70	40	50	3.6	155252
	125	210	120	210	70	45	38	3.8	155270
	150	210	125	210	65	50	25	3.4	155284
250	100	274	125	274	82	45	82	6	155377
	150	274	135	274	82	50	57	6.3	288066
	200	274	145	274	80	60	32	6.9	288067
300	150	326	150	326	97	50	83	11	288068
	200	326	160	326	95	60	58	10.2	288069
	250	326	170	326	95	70	26	10.7	288070
400	300	429	200	429	100	100	52	19.6	155504

For dimensions over DN400 please contact us.

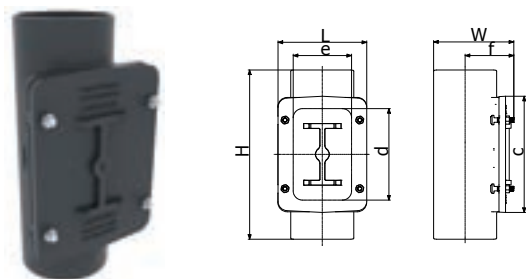
Access Fittings / Access



Round door								
DN	L	H	W	b	c	d	Weight (kg)	Product code
50	105	190	93	53	105	2.3	2.3	179348
75	134	220	115	78	134	3.2	3.2	179648
100	159	260	139	104	159	5	5	179350

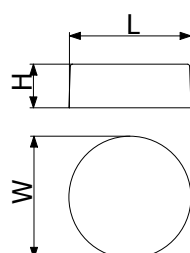
Intensive use

All dimensions are in mm.



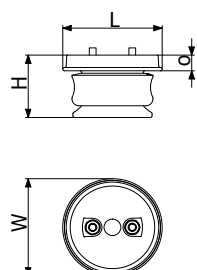
Rectangular door									
DN	L	H	W	c	d	e	f	Weight (kg)	Product code
125	190	370	169	255	225	125	101	10.3	179352
150	215	395	192	280	250	150	112	14.5	179353
200	262	435	242	330	330	200	137	22	179354

Access Fittings / Blank ends



DN	L	H	W	Weight (kg)	Product code
50	58	30	58	0.25	155197
75	83	35	83	0.45	176783
100	110	40	110	0.8	155231
125	135	45	135	1.2	155257
150	160	50	160	1.7	155273
200	210	60	210	3.2	155287
250	274	70	274	5.9	288060
300	326	80	326	10	288061

Access Fittings / Expansion plugs

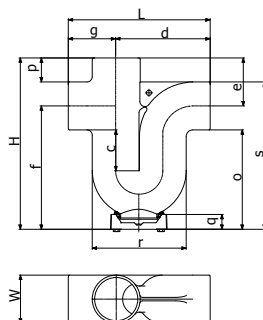


DN	L	H	W	o	Weight (kg)	Screw	Product code
50	62	47	62	14	0.22	M8x30	288062
75	90	71	90	20	0.6	M8x50	288063
100	118	77	118	23	1.2	M8x60	288064
125	143	77	143	24	1.7	M8x60	155392
150	168	73	168	22	2.4	M10x45	288065
200	220	87	220	26	5	M10x60	155450

See p.132 for information on resistance to accidental pressure. Expansion plugs with bleeding valve are available on request for DN 125/DN 150 and DN 200 (for watertightness tests)

Traps and ventilation / Traps

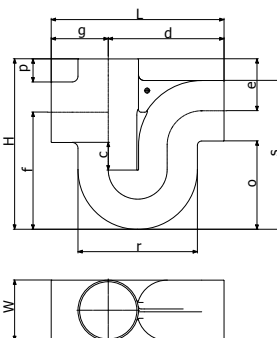
< DN 200



DN	L	H	W	c	d	e	f	g	o	p	q	r	s	Access*	Weight	Product code
50	190	240	58	60	182	68	122	68	143	39	33	112	201	EP 50	2.5	288088
75	264	282	80	60	200	93	172	93	150	52	13	162	230	TS 50	4.6	176739
100	325	381	110	100	282	110	215	110	216	55	15	216	326	TS 50	7.9	288089
125	390	435	134	100	316	130	260	130	238	63	12	266	372	TS 75	10.7	155404
150	470	482	160	100	348	145	325	145	257	65	8	340	417	TS 125	16.9	288090

Bottom cleaning access: EP by expansion plug / TS by tight sheet
Designed for rainwater networks. The arrows stamped on the cast iron body show the flow direction.

DN 200



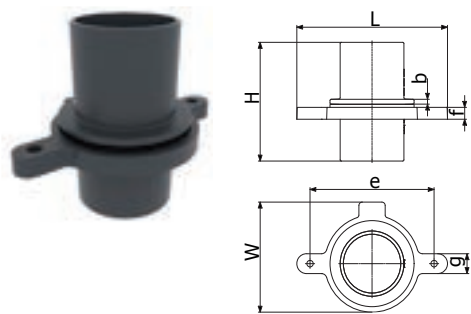
DN	L	H	W	c	d	e	f	g	o	p	r	s	Weight (kg)	Product code
200	600	590	210	100	420	180	400	200	300	80	415	510	34.3	155464

Hatch patterned area in the drawings shows the max. cutting length

Intensive use

All dimensions are in mm.

Stack support



DN	L	H	W	b	e	f	g	Ø Ext	Weight (kg)	Product code
50	195	220	108	8	150	17	30	108	2.5	212273
75	218	220	133	8	175	19	30	133	3.1	211041
100	259	220	162	8	214	20	32	162	4.3	171912
125	275	220	187	8	228	20	32	197	5.4	211042
150	300	220	222	8	255	22	32	222	7.2	171914
300	498	300	406	8	448	30	40	406	26.5	208264
400	600	340	508	10	550	30	50	508	43.9	on request



Intensive use

AGILIUM[®] Zn range

High-performance solution designed to withstand external stresses due to climate exposures (ultraviolet radiation, saline mist, condensation, freezing-thawing cycles and pollution).



Recommended use

Domestic use: Wastewater, rainwater, runoff water, hot effluents

→ Coastal areas, directly or indirectly exposed to climatic stresses polluted or confined atmospheres (cellars, crawl spaces), exposition to external aggressions during manufacturing processes and condensation.



Certified performance

→ Compliant with standard EN 877
→ Guaranteed performances by quality marks delivered by third party



Easy maintenance & installation

→ **Long-lasting operational safety** thanks to the robustness and stiffness (around 700 kN.m) of cast iron and the use of flexible mechanical couplings
→ **Ease of installation** due to mechanical couplings assembled with simple tools



Fire safety

→ Reaction to fire: Euroclass A2, s1-d0
→ Fire resistance up to 240 minutes depending on the configuration (generally requires no special fire protection, saving time and cost)



Chemical & corrosion resistance

→ Hot water resistance: 24 h at 95°C
→ Thermal cycle resistance: 1500 cycles between 15°C and 93°C
→ Chemical resistance for $2 \leq \text{pH} \leq 13$: up to 80°C (check resistance for more than 30 different effluents in the tables on p.56 and 57)
→ External coating corrosion resistance test to neutral salt spray according to standard NF-EN ISO 9227_2017: 3500 hours.



Acoustic comfort

$L_{sc,A} < 10 \text{ dB (A)}$ according to EN 14366 with flow rate of 2l/s



Environment

→ Recycled content: 99%
→ Fully recyclable

Coatings

- **External coating:** Red-brown, acrylic primer paint, average dry film thickness 40 μm
- **Anti-corrosive layer:** ame-applied zinc metal coating of 260 g/m² on average
- **Cast iron:** Made with the De Lavaud process
- **Internal coating:** Two-component ochre-coloured epoxy coating, average dry film thickness of 130 μm



Fittings: Externally and internally coated in red epoxy to an average thickness of 70 μm .

AGILIUM[®] Zn range

All dimensions are in mm.

Pipes

AGILIUM[®] Zn

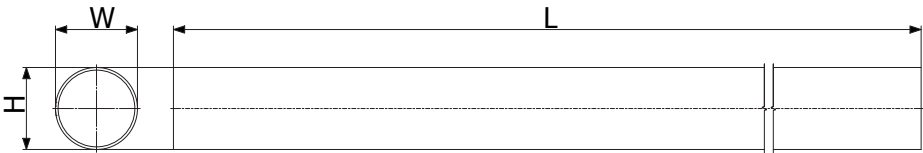


DN	L	H	W	Weight (kg)	Product code
100	3000	110	110	17.1	288629
125	3000	135	135	25.1	288630
150	3000	160	160	30.9	288631
200	3000	210	210	47.3	288632
250	3000	274	274	67.1	288633
300	3000	326	326	87.5	288634

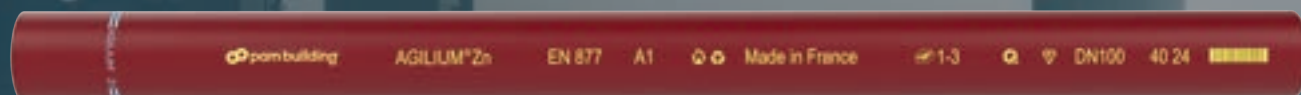
For dimensions over DN 300 please contact us.

SMU Zn

DN	L	H	W	Weight (kg)	Product code
50	3000	58	58	12.6	241706
75	3000	83	83	18.5	241708



For details of the fittings to be used with **Agilium[®] Zn** pipes, please contact us.



We have high performing solutions for your most demanding projects



Infrastructures

ITINERO®

A solution that meets the high drainage technical demands of infrastructure projects, factors in the specificities of a project and guarantees excellent performance to accommodate different stress levels (weather onstraints or exposures).



Recommended use

Suitable for many bridge and tunnel designs and adapted to renovation projects
Collecting and draining surface water from bridges, tunnels and viaducts, for new builds or renovation projects.
Long lifetime with high resistance to climatic stresses due to the zinc coating and low thermal expansion coefficient of cast iron



Certified performance

- Compliant with standard EN 877
- Guaranteed performances by quality marks delivered by third party NF, GeG et Kitemark



Easy maintenance & installation

- Low maintenance due to the best in class resistance to shocks and crushing
- Easy to install due to mechanical couplings assembled with simple tools.



Chemical & corrosion resistance

- Hot water resistance: 24 h at 95°C
- Thermal cycle resistance: 1,500 cycles between 15°C and 93°C
- Chemical resistance for $2 \leq \text{pH} \leq 12$
- External coating corrosion resistance test to neutral salt spray according to standard NF-EN ISO 9227_2017: 4500 hours.



Environment

- Recycled content: 99%
- Fully recyclable

Coatings

- **External coating:** Grey (approximate RAL 7030), epoxy coating, average dry film thickness of 80 µm
- **Anti-corrosive:** zinc coating of 260 g/m² (about 40 µm)
- **Cast iron:** Made with the De Lavaud process
- **Internal coating:** epoxy coating, average dry film thickness of 130 µm



Fittings: Externally and internally coated with a mat grey powder epoxy (approximate RAL 7030), to an average thickness of 300 µm.

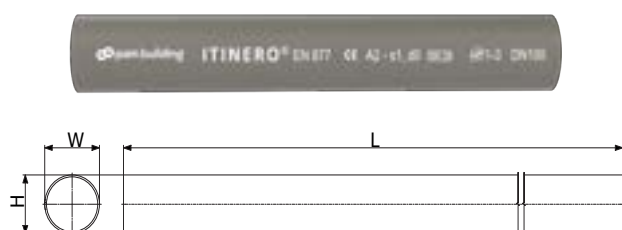
pam building

ITINERO® EN 877

CE A2 - s1, d0
DIN EN

NF1-3 DN100

Pipes

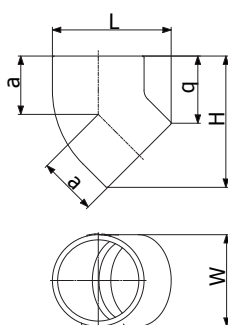


ITINERO®

DN	L	H	W	Weight (kg)	Product code
100	3000	110	110	24.6	277898
125	3000	135	135	34.7	277845
150	3000	160	160	41.4	277862
200	3000	210	210	68.1	277863
250	3000	274	274	98.2	277864
300	3000	326	326	127.9	277865
400	3000	429	429	179.5	277866
500	3000	532	532	247.6	277846
600	3000	635	635	325.5	277847

Bends / Short radius bends

45°



DN	L	H	W	a	q	Weight (kg)	Product code
100	142	158	110	70	80	1.6	277899
125	171	184	135	80	89	2.1	277827
150	199	210	160	90	97	3.2	277867
200	256	262	210	110	113	5.3	277868
250	324	319	274	130	125	10	277869
300	387	380	326	155	149	18.3	277870
400	540	573	429	247	270	34.4	277871
500	730	678	532	318	350	52	277861
600	788	821	635	350	370	111	277852

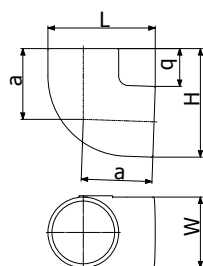
03. Product catalog

ITINERO®

All dimensions are in mm.

Bends / Short radius bends

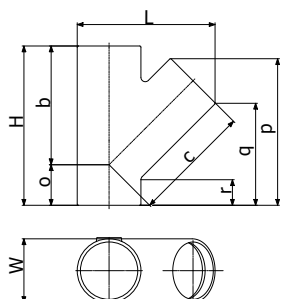
88°



DN	L	H	W	a	q	Weight (kg)	Product code
100	166	169	110	110	59	2.2	277905
125	194	197	135	125	62	2.9	277826
150	227	230	160	145	70	4.3	277879
200	288	291	210	180	81	8.1	277880
250	360	363	274	223	89	13.5	277881
300	427	431	326	280	105	27.7	277882
400	644	651	429	466	223	59	277896

Branches / Single branches

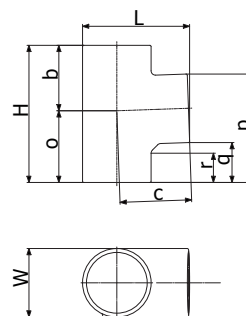
45°



DN	dh	L	H	W	b	c	o	p	q	r	Weight (kg)	Product code
125	100	261	280	135	220	220	60	254	177	47	5	277830
	125	284	320	135	240	240	80	296	201	49	5.2	277832
150	100	287	295	160	240	240	55	262	185	54	5.8	277835
	125	307	325	160	255	255	70	298	202	52	7.4	277836
	150	323	355	160	265	265	90	333	219	53	7.9	277837
200	100	340	310	210	265	265	40	275	198	67	9.3	277838
	125	360	340	210	280	280	55	310	215	64	11.6	277839
	150	383	375	210	300	300	75	353	240	66	12.3	277883
	200	418	455	210	340	340	115	428	280	68	17.1	277884
250	100	398	330	274	315	315	15	276	198	72	13.6	277914
	125	420	370	274	335	335	35	318	223	75	17.8	277911
	150	440	405	274	350	350	55	358	245	75	22	277885
	200	486	480	274	390	390	90	440	291	75	22.4	277886
	250	537	580	274	430	430	130	530	335	70	29	277887
300	100	445	350	326	345	345	5	287	208	88	18.9	277915
	125	464	360	326	360	360	15	316	221	80	22.7	277909
	150	487	415	326	380	380	35	359	246	81	28	277913
	200	547	485	326	415	440	70	454	305	81	31	277908
	250	588	580	326	465	465	115	540	347	80	37.6	277888
	300	634	660	326	505	505	155	661	431	115	46.3	277889
400	300	728	660	429	555	555	105	620	389	86	56.4	277890
500	300	861	720	532	635	680	85	680	448	114	86	277907
600	300	965	725	635	687	751	38	683	452	115	100	277850

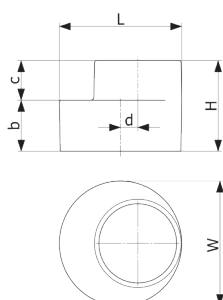
Branches / Single branches

88°



DN	dn	L	H	W	b	c	o	p	q	r	Weight (kg)	Product code
300	300	434	530	326	265	265	265	437	111	87	35	278355
400	300	590	650	429	297	370	353	529	203	121	58	278356

Tapped pipes / Reducers



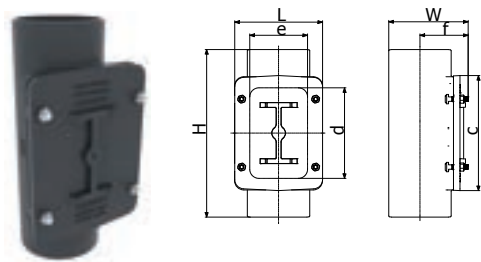
DN	dn	L	H	W	b	c	d	Weight (kg)	Product code
125	100	135	95	135	50	40	13	1.6	277822
150	100	160	105	160	60	40	25	2	277900
	125	160	110	160	60	45	13	2	277872
200	100	210	115	210	70	40	50	3.6	277823
	125	210	120	210	70	45	38	3.8	277831
	150	210	125	210	65	50	25	3.4	277873
250	150	274	135	274	82	50	57	6.3	277874
	200	274	145	274	80	60	32	6.9	277875
300	150	326	150	326	97	50	83	11	277876
	200	326	160	326	95	60	58	10.2	277877
	250	326	170	326	95	70	26	10.7	277840
400	300	429	200	429	100	100	52	19.6	277878
500	400	532	200	532	100	100	52	28.9	277860

03. Product catalog

ITINERO®

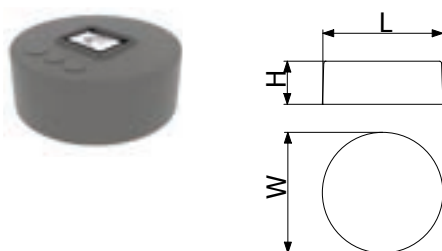
All dimensions are in mm.

Access Fittings / Access



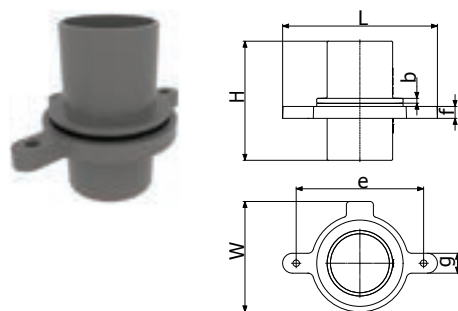
Rectangular door										
DN	L	H	W	c	d	e	f	Weight (kg)	Product code	
100	160	340	138	230	200	100	83	7.6	277857	
125	190	370	169	255	225	125	101	10.3	277858	
150	215	395	192	280	250	150	112	14.5	277859	
200	262	435	242	330	300	200	137	22	277916	
250	330	540	307	380	350	260	170	38.5	277917	
300	380	610	358	430	400	310	195	50	277918	

Access Fittings / Blank ends



DN	L	H	W	Weight (kg)	Product code
100	110	40	110	0.8	277819
125	135	45	135	1.2	277825
150	160	50	160	1.7	277901
200	210	60	210	3.2	277902
250	274	70	274	5.9	277903
300	326	80	326	10	277904
400	429	98	429	21	277895

Stack support



DN	L	H	W	b	e	f	g	Ø Ext	Weight (kg)	Product code
100	259	220	162	8	214	20	32	162	4.3	277906
150	300	220	222	8	255	22	32	222	7.2	277891
200	362	220	278	8	310	22	36	278	10.5	277892
250	444	300	354	8	394	25	40	354	19.1	277893
300	498	300	406	8	448	30	40	406	26.5	277894
400	600	340	508	10	550	30	50	508	43.9	277897

Rainwater drainage

Gravity system

Residential (type R)



A solution that will give additional value to the buildings due to its round or fluted aesthetic appearance.

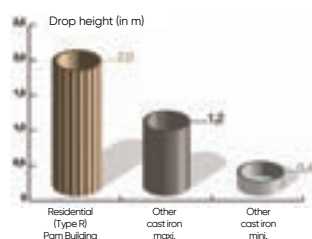


Certified performance

Compliant with standard EN 12056-3

Long lifetime with high resistance to climatic stresses due to the zinc coating and the low thermal expansion coefficient of cast iron

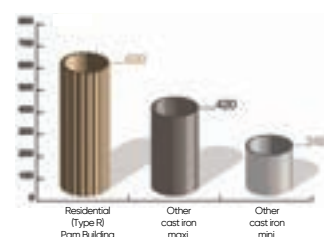
Shock resistance



The test consists of dropping a mass of 2.75 kg on a descent at increasing heights until it breaks or cracks.

The average height of the fall for residential (Type R) is 2 to 5 times higher than for other products. Up to an average drop height of 2m, the Residential (Type R) deforms while the other products have cracked.

Crushing resistance



Easy maintenance & installation

Low maintenance due to the best in class resistance to shocks and crushing
Ease of installation due to the push-fit assembly system.

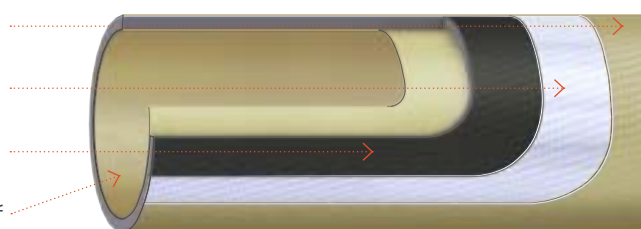


Environment

- Recycled content: 99%
- Fully recyclable

Coatings

- **External coating:** light beige colour (RAL 7032), water-based coating of 40 µm
- **Anti-corrosive layer:** flame-applied zinc metal coating of 130 g/m² on average
- **Cast iron:** Made with the De Lavaud process
- **Internal coating:** water-based coating of 40 µm



Fittings: Cathaphoresis 70 µm + water-based coating 60 µm.

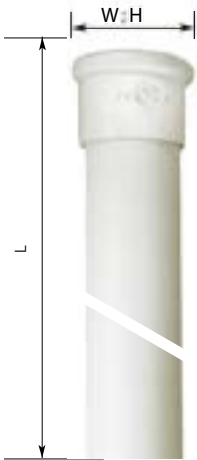
Gravity Systems

Residential (Type R)

All dimensions are in mm.

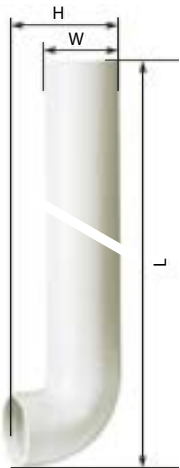
Round downpipes / Straight

All our Residential (Type R) downpipes and fittings are delivered with their couplings



DN	L	H	W	Weight (kg)	Product code
75	1 m	107	107	6.9	155536
	2 m	107	107	12.9	155539
100	1 m	134	134	9.2	155595
	2 m	134	134	17.2	155599
125	1 m	162	162	12.9	155662
	2 m	162	162	24.2	155666

Round downpipes / Bended



DN	L	H	W	Weight (kg)	Product code
75	1 m	154	107	7.6	155572
	2 m	154	107	13.6	155574
100	1 m	177	134	10.1	155640
	2 m	177	134	18.1	155643
125	1 m	206	162	14.2	155700
	2 m	206	162	25.5	155702

Fittings / Round downpipes bends

With socket

45°



DN	L	H	W	Weight (kg)	Product code
75	162	210	116	2.2	155557
100	186	226	145	3.2	155622
125	215	250	173	4.6	155684

68°



DN	L	H	W	Weight (kg)	Product code
75	148	122	115	2	155555*
100	210	185	144	3.5	155619
125	242	198	173	5.1	155681

*Availability: Contact us

Offsets / Round

E=75

Offset with socket



DN	L	H	W	Weight (kg)	Product code
100	202	311	144	4.3	155630

E=150

Offset with socket



DN	L	H	W	Weight (kg)	Product code
100	277	317	144	4.1	155626

Gravity Systems

Residential (Type R)

All dimensions are in mm.

Decorative rainwater head



DN	L	H	W	Weight (kg)	Product code
75	385	260	260	12.5	156510
100	385	260	274	13.8	156656
125	385	260	289	14.1	156792

Accessories / Couplings



For downpipes and shoes		
DN	Weight (kg)	Product code
75	0.03	155566
100	0.04	155632
125	0.05	155694



For bends and offsets		
DN	Weight (kg)	Product code
75	0.07	261497
100	0.09	261498
125	0.11	261499

Gargoyle / For roadsides (Profile A)



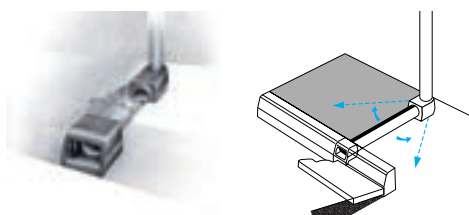
DN	Entitled	L	H	W	Weight (kg)	Product code
75	Shoe	196	57	140	3.1	157373
100	Shoe	196	57	140	2.8	157377
100	Head	150	65	162	2.5	157379

Gargoyle / For pavements (Profile T)



DN	Entitled	L	H	W	Weight (kg)	Product code
75	Shoe	191	110	140	3.9	157374
100	Shoe	191	110	140	3.6	157378
100	Head	162	130	162	4.4	157382

Gargoyle / Shoe to head connector



DN	Entitled	Weight (kg)	Product code
DN 75	PAM GLOBAL Plus pipe	18.8	176787
DN 100	PAM GLOBAL Plus pipe	25.1	155348
120 X 40	Rectangular pipe	21	157385

Siphonic roof drainage



The epams® siphonic roof drainage system is designed for the rapid evacuation of large volumes of water from flat roofs: gymnasiums, shopping centers, airports, and warehouses. Its high flow rate and fewer downpipes compared to conventional gravity systems make it ideal for buildings that require efficient and reliable water drainage solutions.

TWO TYPES OF OUTLETS



CAST IRON OUTLET

- Suitable for all type of roofs
- Ideal for car parks and high traffic environment.

Application field:

- Concrete or metal roofs
- Flat roofs with synthetic membranes
- Metal gutters and valleys
- Car park terraces



STAINLESS STEEL OUTLET

- Suitable for environments exposed to corrosion (sea, pollution, etc.).
- Ideal for green roofs.

Application field:

- Concrete or metal roofs
- Flat roofs with synthetic membranes
- Metal gutters and downspouts
- Roofs protected by gravel or vegetation

ACCESSORIES



- **WITH STEEL PLATE**
All flat roofs



- **FOR FLEXIBLE PVC MEMBRANE**
Non accessible roofs and/or with equipment zones, and waterproofed by PVC-P membranes



- **WITH FLANGE**
Extra thick metal gutters or valleys as well as roofs waterproofed by synthetic membranes.



- **TO BE WELDED**
Gutters or metal roof valleys



- **GREEN ROOFS**
Ensures efficient drainage and seamless integration with vegetated surfaces



Certified performance

- **EN 877:** Cast iron pipes and fittings, their couplings and accessories for the evacuation of water from buildings.
- **Technical Assessment** System under French Technical Approval epams® 5.2/14-2386_V2



Easy maintenance & installation

- Reduced installation time and labor costs.
- Reduced maintenance costs: The integrated grating and anti-vortex mechanism allow for quick removal and reassembly, facilitating easy intervention and maintenance.

epams[®] STAINLESS STEEL

Outlets to be welded



DN	DE (mm)	Capacity l/s	Surface drainage (m²)	Weight (kg)	Product code
50	58	13	260	6.2	171283
75	83	23	460	6.5	171284
100	110	26	520	7.2	171285
125*	135	26*	520	9.1	172850

Stainless steel body, including M10 bolts, Aluminum grating
 *The advantage of the DN 125 outlet is in the "gutters" application where the water cover height can exceed 55 mm (see French Technical Approval 5.2/ 14-2386_V2) *This outlet is the basis for the next three outlets, on which various elements are grafted depending on the application field.

Outlets with flange



DN	DE (mm)	Capacity l/s	Surface drainage (m²)	Weight (kg)	Product code
50	58	13	260	5.4	171288
75	83	23	460	5.7	171289
100	110	26	520	6.4	171290
125*	135	26*	520	8.3	172871

Stainless steel body, including M10 bolts, Aluminum grating, Aluminum flange
 *The advantage of the DN 125 outlet is in the "gutters" application where the water cover height can exceed 55 mm (see French Technical Approval 5.2/ 14-2386_V2) *This outlet is the basis for the next three outlets, on which various elements are grafted depending on the application field.

Outlets with steel plate



DN	DE (mm)	Capacity l/s	Surface drainage (m²)	Weight (kg)	Product code
50	58	13	260	6.4	171081
75	83	23	460	6.7	171267
100	110	26	520	7.4	171305
125*	135	26*	520	9.3	172874

Stainless steel body, including M10 bolts, Aluminum grating, Stainless steel plate 500 x 500 mm
 *The advantage of the DN 125 outlet is in the "gutters" application where the water cover height can exceed 55 mm (see French Technical Approval 5.2/ 14-2386_V2) *This outlet is the basis for the next three outlets, on which various elements are grafted depending on the application field.

03. Product catalog



All dimensions are in mm.

Outlets for flexible pvc membranes

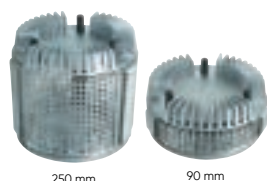


DN	DE (mm)	Capacity l/s	Surface drainage (m²)	Weight (kg)	Product code
50	58	13	260	6.8	171286
75	83	23	460	7.1	171287
100	110	26	520	7.7	171263
125*	135	26*	520	9.6	172876

Stainless steel body, including M10 bolts, Aluminum grating Laminat-steel
PVC plate - 500 x 500 mm

*The advantage of the DN 125 outlet is in the "gutters" application where the water cover height can exceed 55 mm (see French Technical Approval 5.2/ 14-2386_V2) *This outlet is the basis for the next three outlets, on which various elements are grafted depending on the application field.

Accessories / Elevating kits



Description	Height	Product code
Elevating device + anti-vortex	90	171291
Elevating device + anti-vortex	250	171292

Accessories / Anchoring steel plate



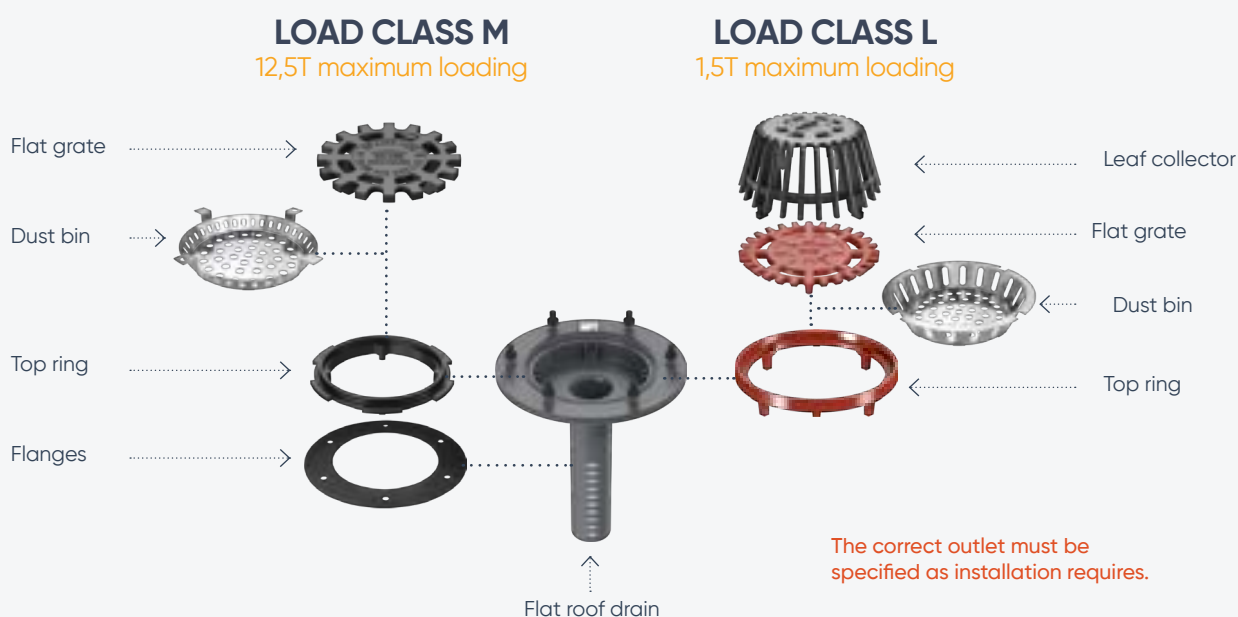
Description	Product code
Anchoring steel plate	172431

Accessories / Nuts & screws

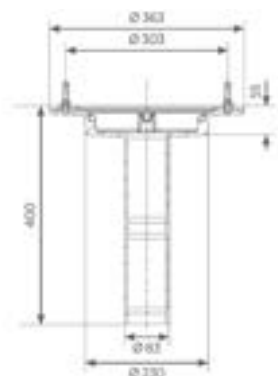
Description	Weight (kg)	Product code
Valid for all DN	0.01	171295



Cast iron roof drainage system for car parks



Cast iron flat roof outlet DN75



Components	Dimensions	Weight (kg)	Product code
Outlet	Outlet* Ø 363 length 400 mm	12,80	260901

*Please select the required accessories

- With loose and fixed flange for clamping roofing membranes
- Cast iron
- Length: 400 mm
- Connection pipe with scale can be shortened individually (if necessary, apply cut edge protection)
- Nominal capacity: siphonic system (24 l / s)

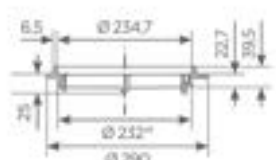
03. Product catalog



All dimensions are in mm.

Cast iron top rings

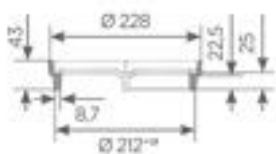
M CLASS



Dimensions	Weight (kg)	Product code
Ø 290	2,50	179886

- Cast iron
- With fastening thread M 6
- Stacking height: 23 mm

L CLASS



Dimensions	Weight (kg)	Product code
Ø 228	0,90	179883

- Cast iron
- Stacking height: 25 mm

Cast iron flat grates

M CLASS



Dimensions	Weight (kg)	Product code
Ø 234	4,30	179885

- Cast iron
- Accessible
- Incl. 2 single-bolts M 6 x 18 (ISO 4762)

L CLASS

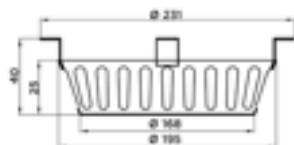


Dimensions	Weight (kg)	Product code
Ø 217	1,60	179882

- Cast iron
- Only for accessible roofs

Dust bin

M CLASS



Dimensions	Weight (kg)	Product code
Ø 195 height 40	0,50	208865

→ For top ring and flat grating class M

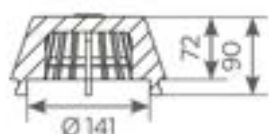
L CLASS



Dimensions	Weight (kg)	Product code
Ø 213 height 41	0,90	198351

→ For class L attachment ring and flat grating
→ Only for accessible roofs

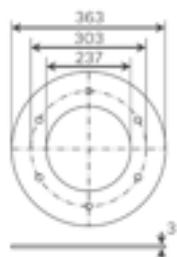
Polyamide leaf collector



Dimensions	Weight (kg)	Product code
Height 70	0,20	179881

→ Made of polyamide for collecting gravel and leaves
→ Also for inspection chambers

Gasket insert

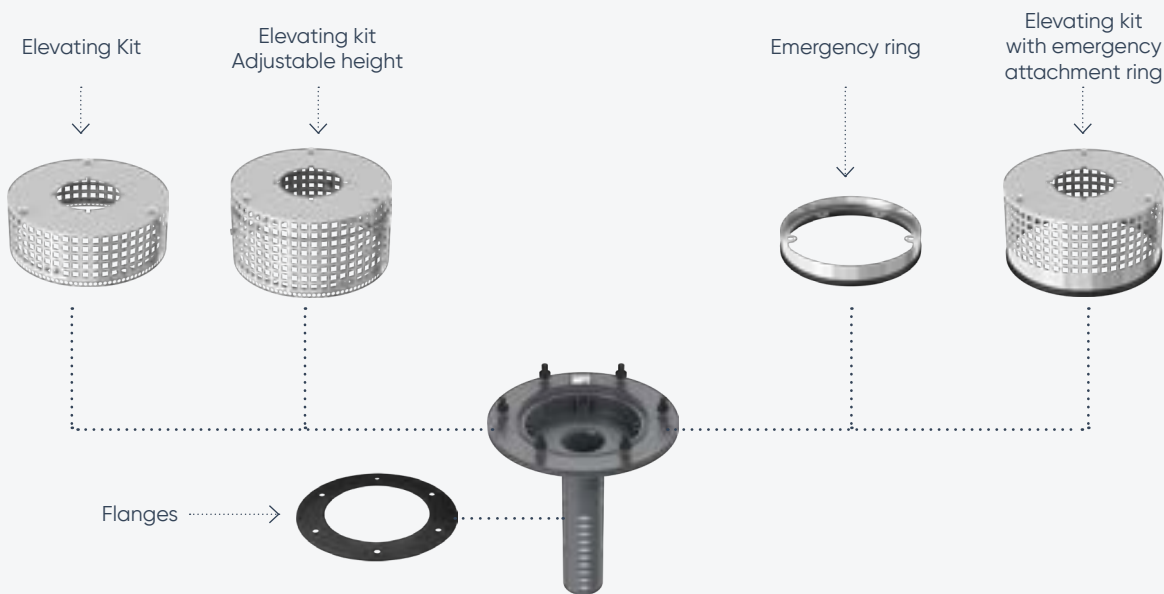


Material	Dimensions	Weight (kg)	Product code
EPDM	Ø 363 x Ø 237 x 3	0,10	179892
NBR	Ø 363 x Ø 237 x 3	0,10	179893

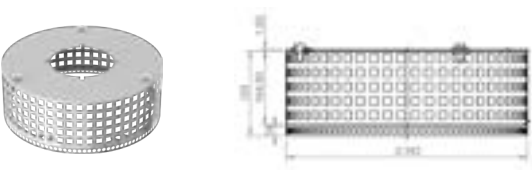
→ For flat roof drainage 2 gasket inserts are required per flange



Green roofs and emergency installations



Elevating kit

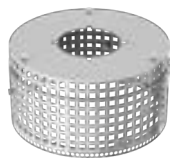


Dimensions	Weight (kg)	Product code
Ø 342 height 120	2,70	198347

Also available in other heights or closed at the top

- Stainless steel (material 1.4301)
- To be used with leaf collector basket: leaf catcher not included in the scope of delivery
- Polyamide

Elevating kit – Adjustable height

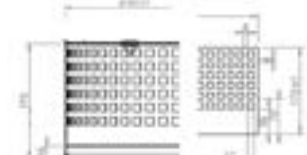


Dimensions	Weight (kg)	Product code
Ø 342 height 120	3	228975

Also available in other heights or closed at the top

- Stainless steel (material 1.4301)
- Emergency attachment ring 60 mm (incl. seal)
- For emergency drainage system
- To be used with polyamide leaf trap

Elevating kit

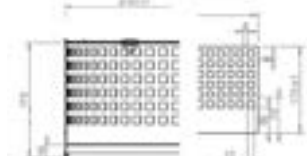


Dimensions	Weight (kg)	Product code
Ø 342 height 180	3,5	226181

Also available in other heights or closed at the top

- Stainless steel (material 1.4301)
- Emergency attachment ring 60 mm (incl. seal)
- For emergency drainage system
- To be used with polyamide leaf trap

Emergency ring

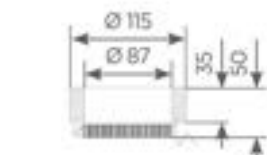


Dimensions	Weight (kg)	Product code
Ø 354 height 60	1	182672

Also available in other heights or closed at the top

- With seal
- Stainless steel (material 1.4301)
- For an emergency drainage system

Track heater



DN	Weight (kg)	Product code
75	0,50	179880

Also available in other heights or closed at the top

Coupling range

We provide a large range of couplings to match all building specifications. Our products are available in different versions to withstand all types of effluents, pressures and external stresses.

PAM R



"R" for Repair: this coupling is particularly suited to repairs and retrofits. It is installed in two separate parts.

Major benefits

- Compliant with EN 877
- Full opening strap particularly suited to renovation projects.

Material

- Main material W5 (AISI 316L)
- Gasket EPDM.

Pressure resistance

- Exceeds the EN 877 requirements:
- DN 50 to 125: 10 bar
 - DN 150 to 200: 5 bar.

PAM Rapid



The single-bolt PAM Rapid coupling allows fast and reliable installation. It ensures optimized watertightness, pressure and corrosion resistance.

Major benefits

- Compliant with EN 877
- Ease of installation
- Suitable for projects with effluents containing solvents, hydrocarbons (i.e. car parks), due to the availability of the NBR version (nitrile gasket).

Material

- Main material W2 or W5 (AISI 316L)
- Gasket EPDM or NBR.

Pressure resistance

- Exceeds the EN 877 requirements:
- DN 50 to 125: 10 bar
 - DN 150 to 200: 5 bar
 - DN 250 to 300: 3 bar.

PAM HP Flex



PAM HP FLEX couplings withstand up to 10 bar of hydrostatic pressure for most diameters. These couplings are used for straight runs where the pressures can occur.

Major benefits

- Compliant with standard EN 877
- The solution for large-diameter networks (>300 mm)

Material

- Main material: W4 (AISI 304) or W5 (AISI 316L)
- Gasket: EPDM or NBR.

Pressure resistance

- Exceeds the EN 877 requirements:
- DN 100 to 400: 10 bar
 - DN 500 and DN 600: 6 bar.

PAM HP Grip



In sections where end thrust efforts have to be addressed, the autogrip couplings are alternative solutions for securing junctions whilst addressing pressure. The PAM HP GRIP couplings are self-anchored couplings with built-in claw rings.

Major benefits

- Compliant with standard EN 877
- The 2-in-1 solution: coupling and grip collar with only one product
- Particularly suited to epams® installation.

Material

- Main material: W4 (AISI 304) or W5 (AISI 316L)
- Gasket: EPDM or NBR.

Pressure resistance

- Exceeds the EN 877 requirements:
- DN 100 to 400: 10 bar
 - DN 500 and DN 600: 6 bar.

Coupling main features

A coupling is made of several components: casing, screws, barrel and gasket as described in the drawing.



Several grades of steel

We follow a global material designation* for steel components of the coupling described in the following table.

		DIN	AISI
W2	Screw and nut	Coated steel class 8.8	
	Barrels	1.4510	430Ti
	Casing or strap	1.4510	430Ti
W4	Screw	1.4404	316L
	Barrels	1.4401	316
	Casing or strap	1.4301	304
W5	Screw	1.4404	316L
	Barrels	1.4401	316
	Casing or strap	1.4404	316L

*Please refer to datasheet for specific information as some material may differ depending on the coupling design.

Couplings, Collars & Connectors

All dimensions are in mm.






















Elastomeric gaskets

The choice of the elastomeric gasket is related to the nature of the effluent.

EPDM: EPDM rubber is suitable for most types of effluents.
NBR: Nitrile Butadiene Rubber is recommended for wastewater and runoff water liable to contain hot mineral oil, solvents or hydrocarbons. They are recommended for infrastructure applications.

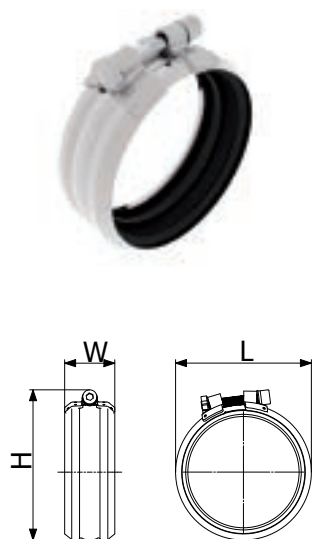
Coupling selection guide



		Type of network				
		Aerial network	In concrete	External stresses*	Buried network	Infrastructure
Type of effluent	Wastewater	S range   		Zn range  	ITINERO®  	ITINERO®  
	Rainwater					
	Aggressive effluents	Plus range   		Plus range  	Plus range  	
	Hydrocarbon runoff water	Plus range   			ITINERO®  	

*ie. Climate exposure; pollution, sea-side

Standard couplings



Standard version W2

technical specifications:

→ Strap, clamps:
1.4510 /11 (AISI 430Ti / 439)

All stainless steel version W5

technical specifications:

→ Strap, clamps:
1.4404 / 1.4571 (AISI 316 L/316Ti)
→ Screw and nut: austenitic
stainless steel A4-70 or AISI 316

PAM RAPID-S / PAM RAPID INOX

DN	L	H	W	Weight (kg)	PAM RAPID-S W2	PAM RAPID INOX W5
50	70	80	42	0.1	210424	185635
75	90	103	42	0.12	210426	207819
100	125	139	48	0.18	210427	185636
125	147	161	56	0.28	210428	207820
150	172	187	56	0.32	210429	207831
200	223	240	70	0.6	210430	185637
250	290	315	95	1.1	228759	228773
300	350	375	95	1.25	228771	228775

The PAM Rapid is designed for full tightening with "zero gap", there is no need to check the torque. For DN 250 and 300, apply the following torque:
25 N.m.

PAM RAPID INOX with NBR gasket (Nitrile coupling)

DN	L	H	W	Weight (kg)	PAM RAPID NBR GASKET W5
50	70	80	42	0.1	212705
75	90	103	42	0.12	212708
100	125	139	48	0.18	212709
125	147	161	56	0.28	212710
150	172	187	56	0.32	212711
200	223	240	70	0.6	212712
250	290	315	95	1.1	212713
300	350	375	95	1.25	212714

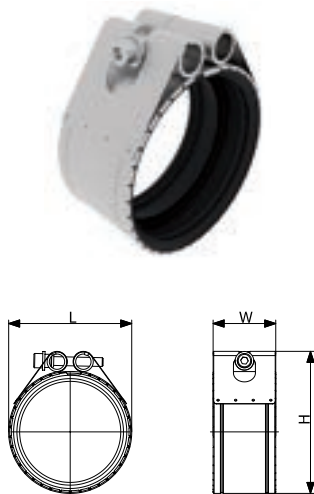
For wastewater liable to contain hot oil, solvents or hydrocarbons, it is recommended to use couplings equipped with specific NBR gaskets.

Couplings, Collars & Connectors

All dimensions are in mm.

All stainless steel

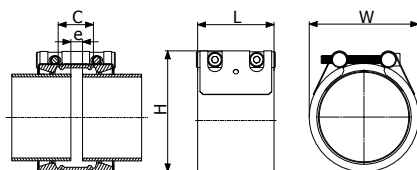
- Strap: austenitic stainless steel – 1.4404/1.4571 (AISI 316L/316Ti)
- Barrels: austenitic stainless steel –1.4404/1.4571 (AISI 316/316L/316Ti)
- Screw: stainless steel A4-70, with anti-seizing coating. (thrust collar: AISI 316/316L)
- Sealing gasket: EPDM



PAM R («R» for repair)

DN	L	H	W	Weight (kg)	Product code
50	67	86	50	0.18	233899
75	91	110	50	0.2	233900
100	118	137	58	0.29	233901
125	147	166	58	0.31	233902
150	167	186	58	0.36	233903
200	223	242	58	0.47	233904

High pressure couplings



PAM HP FLEX-S (W4)

Type W4

- Casing: 1.4301 / AISI 304
- Screws: 1.4404 / AISI 316L
- Barrels: 1.4401 / AISI 316
- Strengthening plate: 1.4301 / AISI 304
- Sealing gasket: EPDM or NBR

DN	L	H	W	c	e	Pressure Resistance bar	Torque Nm	Screw	Weight (kg)	Product code	
										EPDM	NBR
100	89	150	133	42	5	10	25	M8	1.6	278442	278451
125	114	177	155	67	5	10	25	M10	2.3	278443	278452
150	114	202	181	67	5	10	25	M10	2.5	278444	278453
200	114	252	242	67	5	10	25	M10	3.2	278445	278454
250	114	316	295	67	5	10	25	M10	3.5	278446	278455
300	144	414	352	81	5	10	40	M10	9.5	278447	278456
400	144	516	458	81	5	10	80	M10	9	278448	278457
500	144	619	561	81	5	6	80	M10	11	278449	278458
600	144	721	663	81	5	6	80	M10	13	278450	278459

PAM HP FLEX-INOX (W5)

Type W5

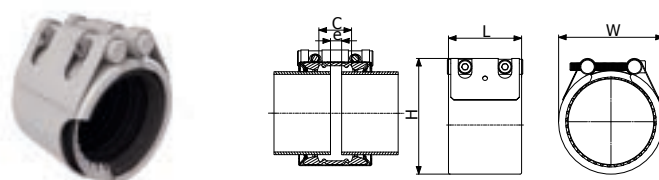
- Casing: 1.4404 / AISI 316L
- Screws: 1.4404 / AISI 316L
- Barrels: 1.4401 / AISI 316
- Strengthening plate: 1.4404 / AISI 316L
- Sealing gasket: EPDM or NBR

DN	L	H	W	c	e	Pressure Resistance bar	Torque Nm	Screw	Weight (kg)	Product code	
										EPDM	NBR
100	89	150	133	42	5	10	25	M8	1.6	278478	278487
125	114	177	155	67	5	10	25	M10	2.3	278479	278488
150	114	202	181	67	5	10	25	M10	2.5	278480	278489
200	114	252	242	67	5	10	25	M10	3.2	278481	278490
250	114	316	295	67	5	10	25	M10	3.5	278482	278491
300	144	414	352	81	5	10	40	M10	9.5	278483	278492
400	144	516	458	81	5	10	80	M10	9	278484	278493
500	144	619	561	81	5	6	80	M10	11	278485	278494
600	144	721	663	81	5	6	80	M10	13	278486	278495

Couplings, Collars & Connectors

All dimensions are in mm.

Gripped high pressure couplings



PAM HP GRIP-S (W4)

Type W4

- Casing: 1.4301 / AISI 304
- Screws: 1.4404 / AISI 316L
- Barrels: 1.4401 / AISI 316
- Strengthening plate: 1.4301 / AISI 304
- Sealing gasket: EPDM or NBR
- Grips: 1.4310 / AISI 301Z

DN	L	H	W	c	e	Pressure Resistance bar	Torque Nm	Screw	Weight (kg)	Product code	
										EPDM	NBR
100	89	156	139	16	8	10	25	M10	1.4	278460	278469
125	114	192	166	24	8	10	60	M12	2.6	278461	278470
150	114	218	191	24	8	10	85	M16	3.2	278462	278471
200	114	269	241	24	8	10	60	M16	5.0	278463	278472
250	114	357	304	24	8	10	80	M16	8.6	278464	278473
300	114	410	357	24	8	10	80	M16	10.0	278465	278474

PAM HP GRIP-INOX (W5)

Type W5

- Casing: 1.4404 / AISI 316L
- Screws: 1.4404 / AISI 316L
- Barrels: 1.4401 / AISI 316
- Strengthening plate: 1.4404 / AISI 316L
- Sealing gasket: EPDM or NBR
- Grips: 1.4310 / AISI 301

DN	L	H	W	c	e	Pressure Resistance bar	Torque Nm	Screw	Weight (kg)	Product code	
										EPDM	NBR
100	89	156	139	16	8	10	25	M10	1.4	278496	278505
125	114	192	166	24	8	10	60	M12	2.6	278497	278506
150	114	218	191	24	8	10	85	M16	3.2	278498	278507
200	114	269	241	24	8	10	60	M16	5.0	278499	278508
250	114	357	304	24	8	10	80	M16	8.6	278500	278509
300	114	410	357	24	8	10	80	M16	10.0	278501	278510
400	142	499	473	63	10	10	160	M16	10.3	269446	-
500	146	603	575	63	10	6	160	M16	16.9	269447	-
600	146	711	683	63	10	6	160	M16	19.6	269448	-

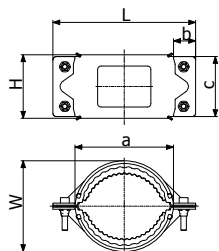
PAM HP GRIP-INOX (W5) SLIM

DN	L	H	W	c	e	Pressure Resistance bar	Torque Nm	Screw	Weight (kg)	Product code	
										EPDM	NBR
100	65	144	131	27	8	10	25	M10	0.79	286086	278469
125	65	165	152	27	8	10	30	M12	0.9	286087	278470
150	85	207	189	38	8	10	45	M16	2	286088	278471

Grip collars / For couplings

Pressure resistance

- DN 50-125: 10 bar
- DN 150-200: 5 bar
- DN 250-300: 3 bar

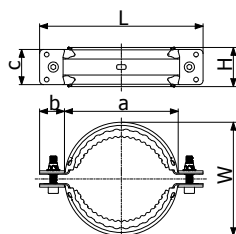


DN	L	H	W	a	b	c	Wrench dimension	Weight (kg)	Product code
50	132	76	88	88	22	72	6	0.45	221261
75	155	78	105	105	25	73	6	0.53	221268
100	211	93	145	145	33	88	6	0.9	220750
125	229	93	165	165	32	88	6	1	221269
150	260	102	196	196	32	96	6	1.2	221270
200	316	118	252	252	32	115	8	1.7	221271
250	394	140	318	318	38	131	8	2.3	227039
300	447	140	371	371	38	131	8	2.5	227040

Grip collars / For expansion plugs

Pressure resistance

- DN 50-125: 10 bar
- DN 150-200: 5 bar



DN	L	H	W	a	b	c	Wrench dimension	Weight (kg)	Product code
50	132	47	88	88	22	43	6	0.33	222092
75	155	47	105	105	25	41	6	0.4	222127
100	211	50	145	145	33	45	6	0.6	221563
125	229	54	165	165	32	49	6	0.7	222129
150	260	56	196	196	32	51	6	0.9	222131
200	316	64	252	252	32	60	8	1.2	222133

Totally versatile,
the PAM grip collar
is compatible with
all the Pam Building
designed couplings
or those of equivalent
shape.

Couplings, Collars & Connectors

All dimensions are in mm.

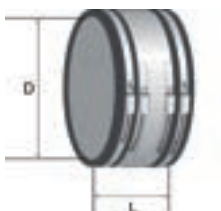
Connectors / Stepping rings

For connection to other materials refer to the table on p.171.

DN	L	H	DE*	Weight (kg)	Other Materials	Product code
50	57	20	50	0.02	HDPE and PVC	156399
75	83	22	63	0.06	HDPE	156495
		25	77	0.03	PVC	156494
100	110	25	91	0.1	PVC	156635
			100	0.05	HDPE	156555
125	135	25	125	0.06	HDPE and PVC	156778
200	208	35	200	0.15	HDPE and PVC	157000
250	272	35	250	0.45	HDPE and PVC	157085

* External diameters of other materials.

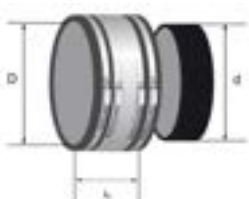
Connectors / Adapting collars



DN	D min.*	D max.*	L	Weight (kg)	Product code
75	75	90	100	0.4	255300
100	100	115	100	0.7	155002
100	110	121	120	0.7	TXB10NP01
125	130	150	120	1	TXB12NLOG
150	150	175	120	1	TXB15NM0J
200	200	225	150	1.5	TXB20NL0K
300	310	335	190	2.9	TXB30NN02

* minimum / maximum external diameter of the pipes to be connected.

Connectors / Adapting collars and Stepping rings



DN	D min.*	D max.*	d min.*	d max.*	L	Weight (kg)	Product code
200	200	225	192	201	150	1.9	TXB20NN0K

Connectors / Adapting joints



DN	D min.*	D max.*	d min.*	d max.*	L	Weight (kg)	Product code
150	150	170	130	145	120	0.8	155003
200	170	193	210	235	150	1.5	155004

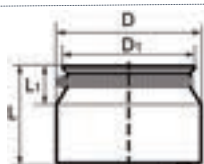
* minimum / maximum external diameter of the pipes to be connected.
All dimensions are in mm

Connectors / EPDM plugs



DN	1 st aperture Ø	2 nd aperture Ø	3 rd aperture Ø	Weight (kg)	Product code
with stainless steel collar					
50	32 or 40 or 42	-	-	0.1	156394
75	(32 or 40) or (42 or 50)	-	-	0.2	156492
100	32 or 40 or 42	32	-	0.3	156628
without stainless steel collar					
100	(32 or 40) or 42	(32 or 40) or (42 or 50)	(32 or 40) or (42 or 50) or 54	0.4	156629

Connectors / PAM Konfix



DN	D1	D	Ext. Ø Connecting pipe	L1	L	Insert depth	Weight (kg)	Product code
50	50	72	40-56	20	58	35	0.1	155759
75	82	92	56-75	22	72	45	0.16	180852
100	100	126	102-110	28	90	57	0.3	155833
125	125	151	125	36	106	65	0.7	155883

Transitional connectors DN 50-125 are designed for connecting the cast iron S and Plus ranges to other materials, whether steel or plastic. The connections with these flexible connectors are easy and safe: one pre-cut lid and a lip seal inside (see figure). EPDM and hose clamp made of chrome steel no. 1.4016.

Couplings, Collars & Connectors

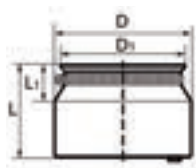
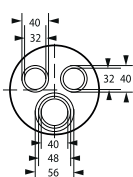
All dimensions are in mm.

Connectors / PAM Konfix Multi



DN	D1	D	Ext. Ø Connecting pipe	L1	L	Insert depth	Weight (kg)	Product code
100	108	134	32-56	36	91	40	0.3	176811

For connecting up to three 32-56 mm pipes made out of other materials to a cast iron pipe system DN 100. EPDM and hose clamp made of chrome steel no. 1.4016.

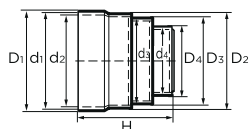


Connectors / PAM Multiquick

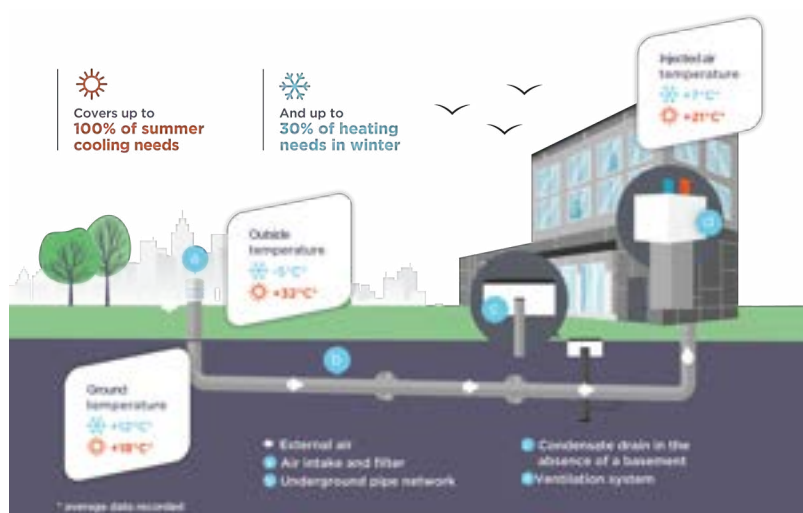


DN	Ø D1	Ø D2	Ø D3	Ø D4	Ø d1	Ø d2	Ø d3	Ø d4	H	Weight (kg)	Product code
100x70	117	111	101	81	108	104	94	74	107	0.15	176812

The Multiquick connector DN 100x70 allows connections between other materials with an outside diameter from 72 to 110 mm, to our cast iron range DN 100 with a maximum outside diameter of 115 mm. There are several pre-cut options. EPDM and hose clamp made of chrome steel no. 1.4016.



Earth-to-air exchanger



The ELIXAIR® system by Pam Building is an innovative earth-to-air heat exchanger (EAHX) designed to enhance thermal comfort in buildings.

By utilizing buried ductile iron pipes, ELIXAIR® efficiently warms fresh air in winter and cools it in summer, providing significant energy savings. Its robust construction ensures durability and resistance to ground and traffic loads, while maintaining excellent air tightness and indoor air quality. ELIXAIR® is a sustainable solution that combines safety, efficiency, and long-lasting performance, making it ideal for various building types.



Recommended use

- Public buildings
- Commercial and industrial buildings
- Farm buildings



Certified performance

System under French Technical Approval
14.5/14-2056_V1 CSTB



Environment

Energy savings thanks to the complete system and the high thermal conductivity of ductile iron



Major Benefits

- Resistance to ground loading and traffic: ductile iron pipe systems can be buried deep without damage, also under areas which are driven over or car parks
- Withstands rustic laying conditions allowing backfill with the extracted materials
- Excellent air tightness due to High Pressure or Standard couplings working under compression
- Durability: as for all buried systems, strength and long-lasting properties are key factors to avoiding premature replacements.

Send us your project and we will be able to help you with the supply of:

- Your earth-to-air heat exchanger
- The bill of quantities
- The heat energy saved in winter
- The cooling energy saved in summer



CONTACT OUR TECHNICAL SUPPORT

✉ tcbatiment.sgpm@saint-gobain.com

☎ +33 (0)3 66 88 19 47

Supporting & Fixing systems

All dimensions are in mm.

Brackets / 802 collars



Quick hooking
thanks to the opening

DN	Nut	Tightening screw	α	Weight (kg)	Product code
50	M8	Screw M6 (Key of 10)	11	0.08	251138
75	M8	Screw M6 (Key of 10)	11	0.1	251188
100	M8	Screw M8 (Key of 13)	11	0.19	251189
125	M8	Screw M8 (Key of 13)	11	0.23	251177
150	M8	Screw M8 (Key of 13)	11	0.25	251178
200	M10	Screw M8 (Key of 13)	14	0.46	255005
250	M10	Screw M8 (Key of 13)	14	0.68	255006
300	M10	Screw M8 (Key of 13)	14	0.79	255007

In galvanised steel. Distance between pipe and wall: 1 cm.

Brackets / Suspension hooks 101

Fixing settings

→ Ease of fixation
thanks to a 4 cm
opening in the
upper part of the
hook



Reduced bearing surface

→ Recesses to address
wall roughness

Automatic set up

→ Level marking
on the hook that
represents the
waterline

DN	Weight (kg)	Product code
50	0.04	255008
75	0.05	255009
100	0.08	255010
125	0.11	255011
150	0.16	255012
200	0.33	255013
250	0.45	255014

Brackets / Suspension hooks 401



Quick hooking
thanks to the opening

DN	Tightening screw	α	Weight (kg)	Product code
50	M8	0.12	251179	251138
75	M8	0.14	251180	251188
100	M8	0.16	251191	251189
125	M10	0.25	251192	251177
150	M10	0.3	251193	251178
200	M10	0.4	251194	255005
250	M12	0.8	251195	255006
300	M12	1	251196	255007

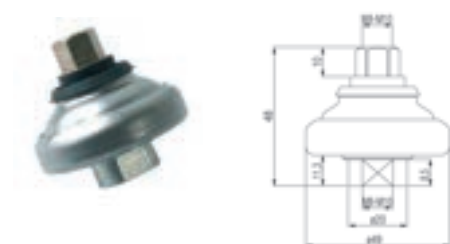
Brackets / Rubber-lined steel



Quick hooking
thanks to the opening

DN	Nut	Tightening screw	α	Weight (kg)	Product code
50	M8/10	Screw M6 (Key of 10)	24	0.1	251197
75	M8/10	Screw M6 (Key of 10)	24	0.3	251198
100	M8/10	Screw M8 (Key of 13)	25	0.3	251199
125	M8/10	Screw M8 (Key of 13)	25	0.4	251200
150	M10	Screw M8 (Key of 13)	18	0.6	251201
200	M10	Screw M8 (Key of 13)	19	1.6	251202
250	M12/16	Screw M12 (Key of 19)	41	1.8	251203
300	M12/16	Screw M12 (Key of 19)	41	2.9	251204

Acoustic dampener / PAM Acoustic

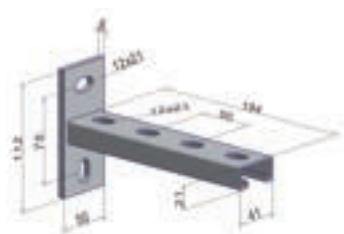


DN	Weight (kg)	Product code
50 to 100	0.11	205113

Supporting & Fixing systems

All dimensions are in mm.

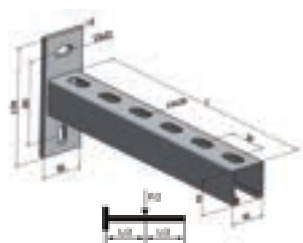
Cantilever arms / 41-21-2 LG 200 - DN 50 and 75 galvanised steel



DN	L	F*	Weight (kg)	Product code
50/75	200	150	0.5	251209

* F: Maximum load for 2 arms, when applied at mid-length of the arm (L/2), in daN

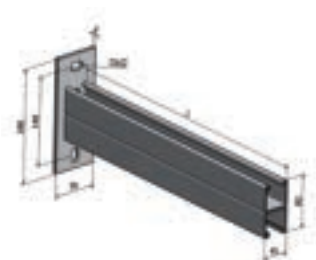
Cantilever arms / 41-41-2 LG 300 - DN 100 to 150 galvanised steel



DN	L	F*	Weight (kg)	Product code
100/125/150	300	300	0.9	251210

* F: Maximum load for 2 arms, when applied at mid-length of the arm (L/2), in daN

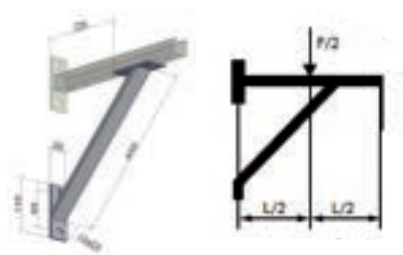
Cantilever arms / 41-82-2 LG 450 - DN 200 to 300 galvanised steel



DN	L	F*	Weight (kg)	Product code
200/250/300	450	500	2.4	251211

* F: Maximum load for 2 arms, when applied at mid-length of the arm (L/2), in daN

Cantilever arms / Reinforcement 41/82/2 LG 450 galvanised steel



DN	L	F*	Weight (kg)	Product code
200/250/300	450	800	2.4	251212

* F: Maximum load for 2 arms, when applied at mid-length of the arm (L/2), in daN

Cantilever arms / Fixation bolts

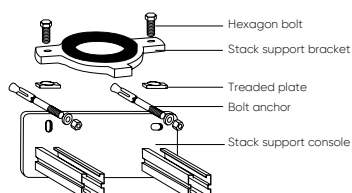


DN		Weight (kg)	Product code
Cantilever arm 50 to 200 Reinforcement fixation	M12x60	0.02	251208
Cantilever arm 250 and 300	M16 x70	0.03	252587

Stack support fixing kit



Galvanised zinc in combination with stack support bracket



DN	Description	Kit contents	Plate dimension	Hole spacing / Rail axial dimension	Hole ø	Weight (kg)	Product code
50	FRK 50 SET	1 x Stack support console 262 SP45 1 x Stack support bracket DN 50 or DN 75 2 x Hexagon bolt M12x35	100x205x6	150	14 x 24	3.66	235621
75	FRK 75 SET	2 x Threaded plate GWP 45/12 Z 2 x Bolt anchor BZ 12-30/125 M 12	100x225x6	170	14 x 24	3.94	235622
100	FRK 100 SET	1 x Stack support console 315 SP45 1 x Stack support bracket DN 100 or DN 125 2 x Hexagon bolt M12x35	100x269x8	214	14 x 24	5.35	235623
125	FRK 125 SET	2 x Threaded plate GWP 45/12 Z 2 x Bolt anchor BZ 12-30/125 M 12	100x283x8	228	14 x 24	5.53	235624

Accessories

Tools / Exact saw machine



Description	DN	Product code
Exact PipeCut + Bevel 170E machine	50-150	280632
Disc bevel x 140 (Exact PipeCut + Bevel 170E)	50-150	280633
Disc cut x 140 (Exact PipeCut + Bevel 170E)	50-150	280634

Paints and protections / Touch-up paint «EXTREM 1» red



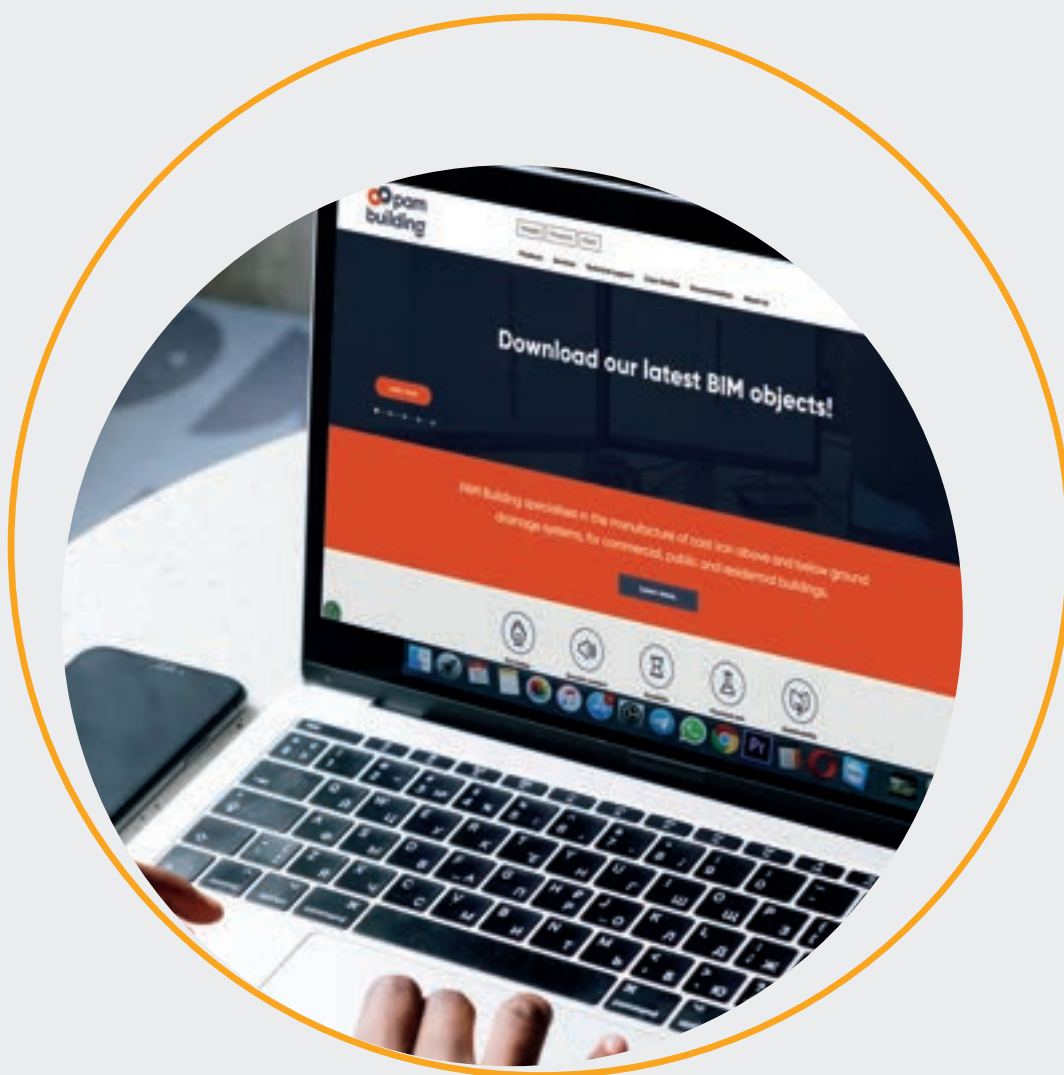
Quantity	Product code
250 ml	226788
500 ml	226788

After any cutting operation, the pipe ends must be protected by applying EXTREM 1. EXTREM 1 is a ready-to-use quick drying touch-up paint that air dries in 15 minutes. It is easily applied with a brush (included in the paint bucket),

Paints and protections / Touch-up spray paint (400 ml)

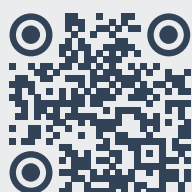


Colour	Product code
"S range" red-brown color	257025
"Plus range" grey color	257027
"Residential (Type R)" color	257028



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- Certifications
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04

The advantages of Cast Iron

Standards & certifications	106
Fire safety	110
Acoustic comfort	112
Durability, installation, & maintenance	116
Chemical & corrosion resistance	121
Environment	128



The advantages of Cast Iron

A worker wearing a white safety helmet and a dark blue safety vest with orange reflective stripes is carrying a large red pipe over their shoulder. The vest has the 'pam building' logo on it. The pipe has some text on it, including 'Made in France' and 'DN100'. The background is a blurred view of trees with yellow and green leaves, suggesting an outdoor construction or maintenance site.

CAST IRON
SYSTEMS,
AN OBVIOUS
CHOICE

Cast iron systems, an obvious choice



Certified performances

Pam Building pipe systems **comply with European standard** EN 877 and all our products are third party certified.

The quality of product ranges is guaranteed by **Quality Marks**



One of the best materials when it comes to fire safety

Cast iron, a non-combustible material, has a melting point of over 1000°C. In most cases it requires no additional fire protection.

All our systems have been tested independently: our cast iron ranges received the Euroclass ranking A1 for our standard "S" range and A2-s1, d0 for the "Plus" range.



The best acoustic solution on the market

The nature and **density of cast iron** confers acoustic properties guaranteeing comfort in use. Less protection for acoustic insulation is needed due to its acoustic properties, resulting in plasterboard savings while achieving the same performance.



Durability, ease of installation, & less maintenance

- **Cast iron has a proven 70-year lifespan** due to its outstanding mechanical properties and provides much better impact resistance
- With our networks, **maintenance operations are limited.**
- Compared to other materials, cast iron **less embedment** than other materials in buried applications where ground disturbance or extra loading is likely



Chemical & corrosion resistance

In addition to the requirements of standard EN 877, we have carried out a large panel of tests on commonly-used detergent products (floor cleaning products, laundry detergents, etc.) and special products (stain removers, drain cleaners, etc.): **we have solutions to your most demanding projects.**



Circular economy, an exceptionnal asset of cast iron

- Our cast iron is **manufactured entirely from recycled raw materials.**
- We currently have produced and verified EPDs for our S and Plus ranges
- The exceptional characteristics of our solutions allow them to contribute to HQE, BREEAM, LEED and other international environmental certifications...

Standard & Certifications



All our products comply with the European standard EN 877

The European standard EN 877 is applicable to a system (cast iron pipes and fittings, couplings and accessories for building drainage) and specifies the technical requirements for cast iron products, is the most stringent in the market.

In particular, it specifies requirements regarding:

- Reaction to fire (product range)
- Resistance to internal pressure
- Dimensional tolerances
- Tensile strength, crushing strength
- Couplings and their leak tightness
- Internal and external coatings performances.

It also defines test methods and the quality management system. Except for reaction to fire properties, EN 877 is a self-declared standard. The manufacturer is allowed to self-declare that their product complies with this standard. Only compliance with EN 877, which is validated by a third party for all criteria and periodically tested, can guarantee the performance of the systems you specify.

Quality marks

Pam Building cast iron drainage systems bear quality marks certifying the compliance with EN 877 standard by third party.

- Our system complies with all of the standard's requirements
- We are periodically audited by a third party
- This gives you the ultimate quality guarantee.

Choosing a complete and consistent range of cast iron products, whose assembly has been performance tested against regulatory requirements, provides you with peace of mind that few other materials can guarantee.

The quality of product ranges is guaranteed by quality marks:



	European standards	International standards
Cast iron pipes and fittings, their joints and accessories for the evacuation of water from buildings - (Requirements, test methods and quality assurance)	EN 877	
Elastomer seals - Material requirements	EN 681-1	ISO 4633
Requirements for a quality management system design, product development, production, installation and after-sales support		ISO 9001
Environmental management system - (Requirements with guidance for use)		ISO 14001
Energy management system		ISO 50001

Testing standards

Fire tests

Fire classification of construction products and building elements. Part 1: Classification using data from reaction to fire tests	EN 13501-1	
Fire classification of construction products and building elements. Part 2: Classification using data from fire resistance tests.	EN 13501-2	
Reaction to fire tests for building products: Building products excluding floorings exposed to thermal attack by a single burning item	EN 13823	

Measurement of noise

Laboratory measurement of noise from wastewater installations	EN 14366	
---------------------------------------------------------------	----------	--

CE Marking

The European Construction Products Regulation made CE marking mandatory on products for which the manufacturer has drawn up a declaration of performance.

The CE marking indicates that manufacturers take responsibility for the construction product's conformity with the declared performance as well as compliance with all applicable requirements laid down in the European Construction Products Regulation.

- To allow for free circulation of industrial products within the European Union and the European Economic Area
- To guarantee that these products are not dangerous to European consumers and users
- To have the same safety criteria shared throughout Europe

Fire safety was selected as the only essential requirement for the CE marking on wastewater products, which must be supported by laboratory tests conducted at recognized independent facilities. This led to a "Reaction to fire classification in the Euroclass system.

**CE marking
is not a quality
mark nor a label**

The CE marking is a self-declaration of product performance (DoP) in reference to its product standard (with the exception of reaction to fire which requires independent testing at a recognised fire testing center).

It certifies the compliance of the product with the harmonised part of the reference standards, and aims to harmonise rules for placing the product on the common european market.

Except for the reaction to fire class, the third-party certification of the performances is not guaranteed by EN 877, but by one of the following marks: Marque NF, RAL-GEG, Kitemark, Sintef, Gost, Q+, Watermark.

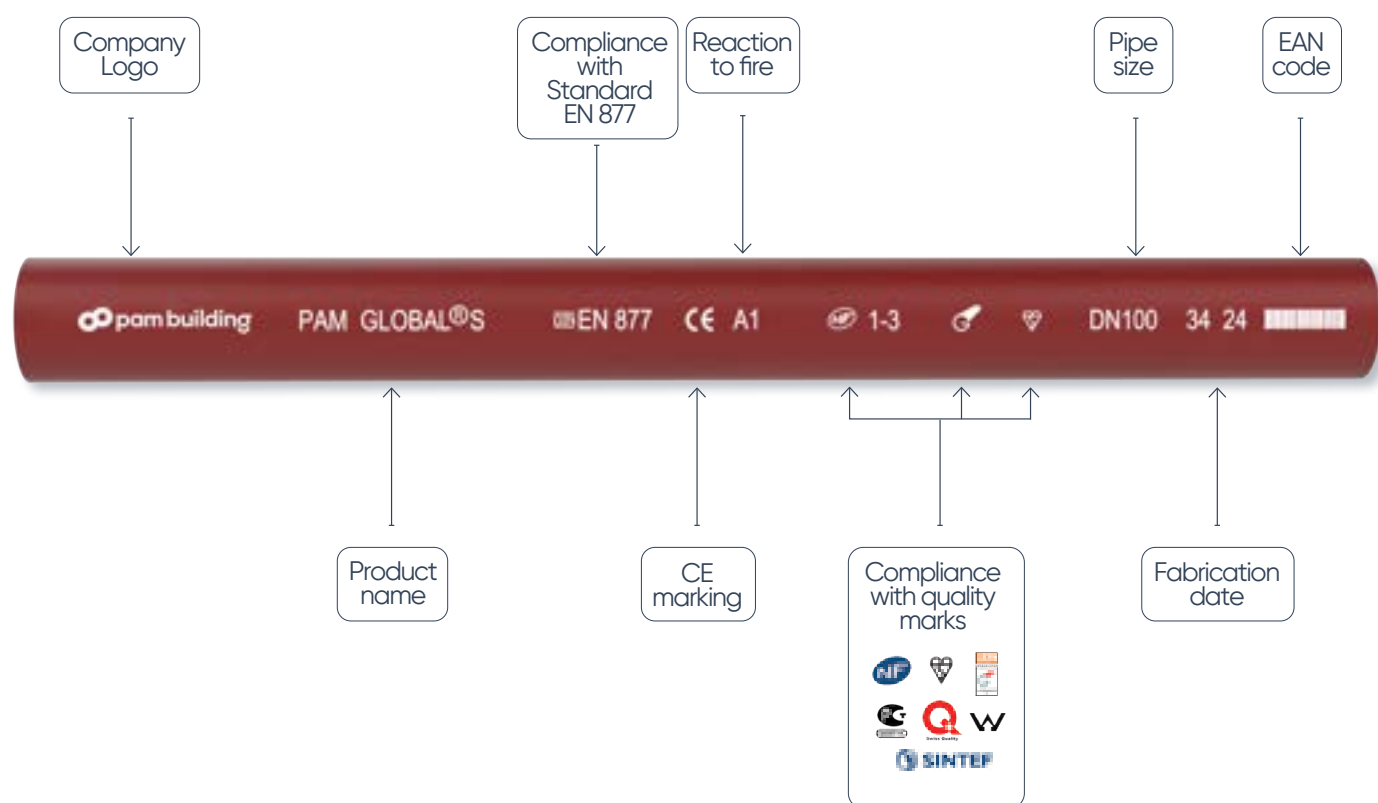
SCOPE	EN 877	
Test	CE marked product self-declared	Pam Building products third party certified
Reaction to fire	●	●
Internal pressure strength	●	●
Dimension tolerance	●	●
Mechanical resistance	●	●
Tightness	●	●
Durability (internal coating)	●	●
Durability (external coating)	●	●

● **Third-party certification not made compulsory by EN 877**

● **All our products are third party certified**



Product Marking: Pipes & Fittings



Our fittings
bear a marking
and a label
that identifies the
manufacturing site

Easy installation & reduced maintenance

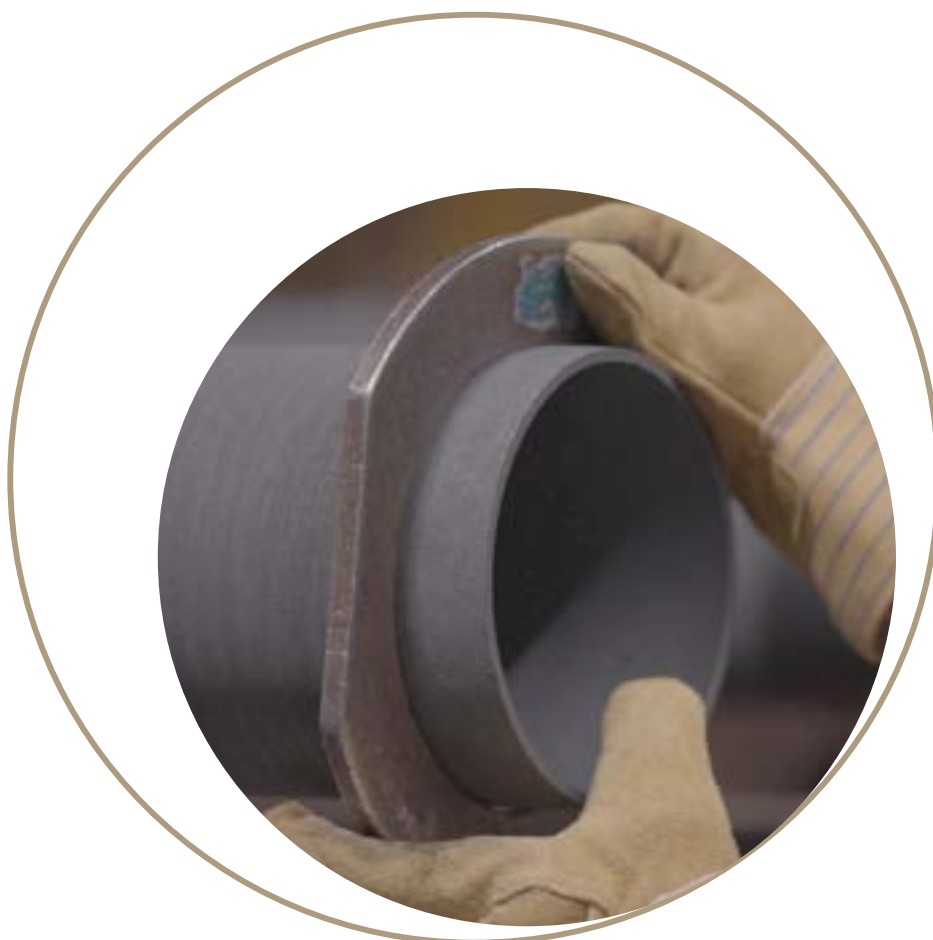
Cast iron
has a
70-year
lifespan due to its
outstanding
mechanical properties
and safety margin
in operation.

- Cast iron systems **withstand cleaning operations, even at high pressure**. They also withstand traditional unblocking chemicals and enzymes without damage: Pam Building is continuously carrying out research on its coatings to maintain such qualities.
- Cast iron in exposed sections of the drainage system, i.e. basement car parks, is **more resistant to damage** than other rainage materials. It is also less sensitive to cracks and breakage prior to installation.
- Cast iron below ground offers **greater resistance to ground movement**, and is less likely to fail in unfavorable conditions.

With our networks, maintenance operations are limited.

Cast iron drainage requires minimal maintenance during the lifetime of the building under normal conditions, making it the first choice for concealed, built-in or otherwise inaccessible systems, where repair or maintenance would cause major inconvenience to the occupants.

- Where necessary, removable mechanical couplings make repairs easier and cheaper without cutting into the stack. An extensive range of access parts provides ease of maintenance at vital points in the stack to relieve any blockages which may occur.
- In the event of destination changes in the premises or the addition of devices, the PAM systems, whose junctions are not glued or welded, can be modified without having to break or cut them, by simply removing the joints.



Explore our
tutorials
Youtube

Fire safety



Drainage systems are the arteries of a building. In case of fire, there is a risk that pipes will maintain and spread the fire in the building. Pipe penetrations through a separating element like a wall or a slab are always a source of risk for the spread of fire to the adjacent room, the floor below or the floor above. As regards a building's fire safety, the major responsibility rests with the project manager who must comply with local regulations. Accordingly, and particularly in high-risk buildings like high-rise buildings,

materials with reduced flammability should be selected as a precautionary measure. Pam Building is committed to the development of high-quality and high-safety products. Fire safety is one of the main technical performances of our products. In choosing Pam Building cast iron systems, you are guaranteeing the safety of both people and property.

There are two concepts applied to fire safety: reaction to fire and fire resistance.

Reaction to fire

EUROCLASSES		
A1	–	–
A2	s1	d0
A2	s1	d1
A2	s2	
	s3	
B	s1	d0
	s2	d1
	s3	
C	s1	d0
	s2	d1
	s3	
D	s1	d0
	s2	d1
	s3	
Classes other than E-d2 and F		

This is the instant behavior when a fire breaks out, its propensity to ignite or fuel a fire. This behavior is assessed on the basis of standardized tests and described in a Euroclass classification. The Euroclasses are based on test methods and establish reaction to fire classifications that are harmonised throughout Europe. This means they can be used to compare materials and product performances.

The Euroclass classification ranges from A1 to F, with A1 and A2 being reserved for products that are not, or are only slightly, combustible. The indices s and d respectively refer to smoke emission and the production of flaming droplets.

SMOKE production sub-classification

- s1: Low smoke production
- s2: Medium smoke production
- s3: High smoke production

FLAMING DROPLETS sub-classification

- d0: No flaming droplets
- d1: Flaming droplets that persist for less than 10 s
- d2: Flaming droplets

Cast iron remains one of the best material when it comes to fire safety



Pam Building cast iron systems are among the safest materials on the market in terms of reaction to fire, and all its drainage systems have been tested independently to the stipulated test criteria.

In tests carried out by the CSTB accredited laboratory, the Pam Building cast iron ranges (pipes, fittings and accessories, including elastomer gaskets and coatings) received the following excellent Euroclass ranking:

- **A1 for the S range: completely non combustible**
- **A2-s1,d0 for Plus range: No smoke, no flaming droplets in the event of a fire**

Scope

The CE marking for cast iron wastewater systems is based on the harmonised standard EN 877, which applies to a system including pipes, fittings, couplings and accessories, and is used to test all of the ranges' components. The classification obtained by Pam Building covers complete ranges: pipes, fittings, couplings and accessories that are components of a wastewater pipe system.

Check the reaction to fire classification of the products you specify, and ensure the tests were carried out by an accredited testing centre. This compliance is validated by complete quality marks, is periodically tested by accredited third-party laboratories and provides you with a performance guarantee for the systems you specify.



Fire resistance



Main causes of fire

Faults in electrical systems, human error, overheating, and arson. Lightning strikes or explosions play a minor role in the statistics here, but can lead to a chain reaction of fires if they do occur.

Source: www.ifs-ev.org

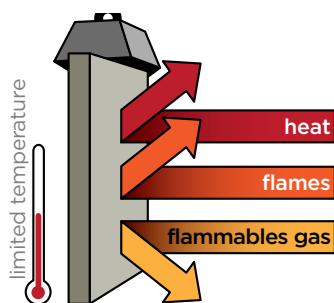
This is a construction component's ability to withstand fire for a given period of time and to retain its serviceability in the event of fire, avoiding the spread of fire. If a fire breaks out, it is essential to prevent any early collapse of the structure, and then limit the extent of the damage to ensure that occupants can be evacuated and/or belongings will be protected. Many buildings are not sufficiently protected against fire hazards. This means that fire can spread quickly, destroy the building in a short time and, more importantly, endanger the lives of the occupants. When a fire breaks out, the first objective is to slow down its spread both horizontally and vertically.

The fire resistance performance level will be influenced by a number of factors: the pipe diameter, the thickness of the floor or wall, the size of the penetration void, the material used to seal the void and even the stack configuration through the penetration.

Compartmental principle

When they exist, fire safety regulations for buildings are based on a compartmental principle. Within a building, a compartment is a fire rated space designed to stop the fire for a given period of time. The fire stopping requirement for walls (shells and slabs) is generally 2 hours or less – and exceptionally 4 hours. The requirement depends on the type of building and its level of occupancy, and can be very different from one country to the next.

Wastewater drainage systems & fire stopping requirements



Drainage systems passing through structures designed to withstand fire should not provide open breaches. For a given time, specified in the applicable regulations, they should not allow the passage of fire, smoke, heat or combustion products from one compartment another. **Cast iron, a non-combustible material, has a melting point of over 1000°C.**

In most cases it requires no additional fire protection. **Pam Building has and will continue to periodically test its cast iron drainage systems** with standard mortar penetrations and other solutions in order to understand the potential effects of fire on its integrity, resistance

and overall performance. We carried out a non-exhaustive series of tests to offer precise guidance for fire resistance. Our systems proved to meet integrity and insulation requirements **up to 240 minutes** (4 hours)*, and should therefore not collapse causing potential danger to evacuating people or firefighters.

Any questions ? Our technical team can provide guidance, help you select the right configuration for optimal performance, and provide you with a comprehensive report.

Contact our technical support team on our website: www.pambuilding.com

Comparison with other materials

For plastics, the fire stopping rule consists in "plugging the hole". This function is achieved by using fire collars recommended by the manufacturers. Plastic materials, which are highly sensitive to heat, will not withstand fire, and will not remain in place, even in the case of a contained fire. As shown by laboratory tests in Germany, if the fire collars are not activated, particularly when installed under the fire compartment, they significantly increase the risk of the fire spreading downwards in a multi-storey building.

When some types of plastic material (e.g. HDPE and polypropylene) are exposed to fire they generate molten droplets, which could potentially spread a fire down through the building. Exposed to fire, plastic material releases toxic fumes and gases, which beyond a certain amount may be fatal to the people inhaling them.

* Furnace tests carried out in 2017-2018 according to EN 1366-3 at the EFACTIS testing centre, the European leader in fire science, engineering, tests, inspection and certification.

Acoustic comfort



Noise in buildings is considered to be detrimental to health and quality of life. Efforts have been made in the last 30 years to attenuate the sounds coming from the street, worsening the perception of sounds emitted within buildings. Heat insulation policies aimed at reducing energy consumption will also heighten these perceptions. Among the priority criteria in the comparative performances of drainage materials, acoustic performance is considered to be second only to fire safety: cast iron pipe systems have intrinsic acoustic properties. Owing to the development of equipment accessories, they offer outstanding performances.

What is noise from pipe systems ?

Noise from wastewater pipe systems is classified in the regulation under "equipment noise". Noise originating from pipe systems is due to the sound energy produced by water/ air turbulence, but mostly by the mechanical effect of the water flow on the internal pipe walls. In such circumstances a pipe will radiate noise outward and transfer it to any lightweight ceilings, cupboards and similar areas wherever it makes contact. Noise is an energy that affects air pressure and is transmitted through vibration. Sound is measured in decibels (dB) using a nonlinear scale. For equipment noise, the following categories are identified and measured:



Airborne noise

Airborne noise are vibrations that are propagated. In the case of wastewater pipe systems, this noise is mainly heard in the room where the pipe is located. When a material is dense and thick, the pipe walls prevent air-borne noise transmission



Structure-borne noise

The vibration of a building's structure. It will be noticed in rooms adjacent to the pipe. When the noise produced in a pipe is not transmitted by the air, the residual noise is transmitted by structural vibrations. Whilst the mass of the cast iron limits the vibratory level, the junctions and fixings to the building will propagate noise. Objective: dampen the vibrations at the connections to the solid structure. Statutory requirements for "equipment noise" for structure-borne noise differentiate between noisy rooms and quiet rooms with sound attenuation requirements.

Quiet rooms*
> 30dB

Noisy rooms
> 35dB

*generally living rooms, resting rooms and work rooms, the noise level requirements are generally around 30 dB, in cases where noise regulations exist.

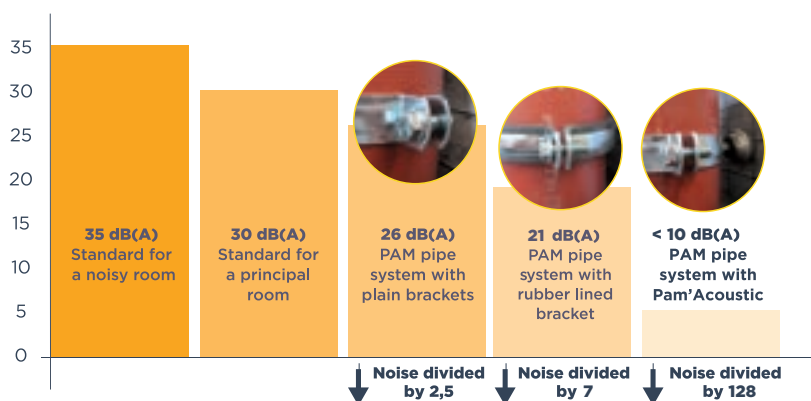
Test results

Pipe system	Test report N°	Installation acc. to EN 14366			
		Airborne noise (La,A)		Structural noise (LSC,A)	
		2.0 (l/s)	4.0 (l/s)	4.0 (l/s)	4.0 (l/s)
S range + classical bracketing with rubber and stack support in basement floor	P-BA 223/2019	47 dB (A)	50 dB (A)	21 dB (A)	26 dB (A)
S range + PAM'Acoustic without stack support in cellar	P-BA 226/2019	47 dB (A)	50 dB (A)	< 10 dB (A)	< 10 dB (A)

Complete reports are available on request. Sound levels below 10 dB(A) are not mentioned in the test report.

Structure borne noise & PAM'Acoustic

For the requirements of extreme acoustic comfort (luxury buildings, auditoriums...), PAM'Acoustic is an acoustic dampener, which, placed between the frame and the support collar of the cast iron pipe, makes it possible to achieve the exceptional structural noise level of < 10 dB (A), that is, almost silence.



Tests according to standard EN 14366 (IBP laboratory). For a flow rate of 2 liters/second, wall: 220kg/m²

The advantages of Cast Iron

Noise in real condition of use

Usually pipe systems are installed in a technical shaft that contributes to reducing the noise emitted by the effluent flowing in a pipe. Nevertheless, the noise level of pipes installed behind a shaft may not be sufficient to comply with the specifications of the owner or set by the national regulation.

Pam Building initiated several noise measurement tests with an independent laboratory in real conditions, inspired by standard EN 14366, but using a real WC flush to assess the noise level of the combination of pipe material and shaft acoustic performance (ΔL_{an}).

Below are some examples of measurements at a flow rate of 2 l/s with the S range fixed on a 15 cm thick supporting concrete wall:

Technical Shaft	S range with rubber lined steel brackets	S range with steel brackets and acoustic dampener
ΔL_{an} Performance	$LA_{S,max}$ [50–5000 Hz] (dB)	$LA_{S,max}$ [50–5000 Hz] (dB)
$19 \leq \Delta L_{an} < 24$	33	32
$24 \leq \Delta L_{an} < 29$	30	25
$29 \leq \Delta L_{an} < 34$	29	19

Comparative laboratory tests

Acoustic comfort is a differentiation criterion that indicates construction quality. The building project manager and specifier may define together specific requirements to improve the final construction.

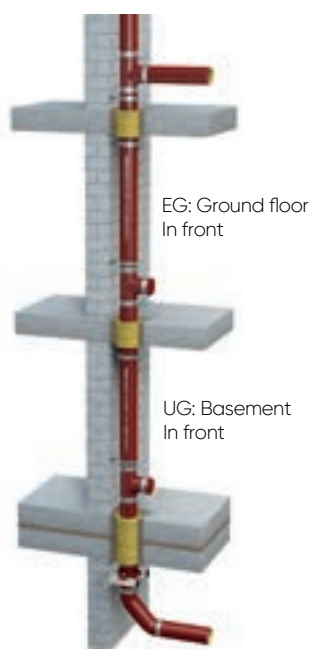
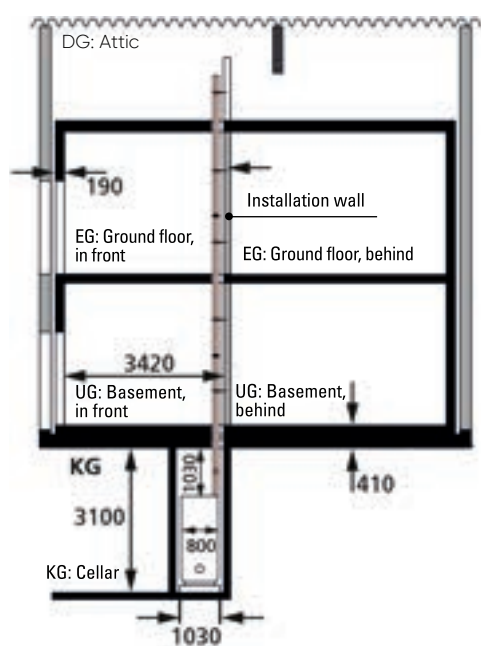
In 2019, Pam Building commissioned a series of comparative tests on airborne and structure-borne noises in installation conditions described by standard EN 14366*, at the Fraunhofer Institute for Building Physics in Stuttgart.

The measurement results for the Pam Building cast iron pipes listed in the table were determined at the Institute on an installation wall with a basis weight of 220 kg/m².

The prerequisites:

- The building conditions in the real construction situation be comparable to or more favorable than the test bench of the Institute in terms of sound technology.
- When compared with the requirements, pay attention to the simultaneous operation of plumbing installations and possible interactions among the plumbing components which may produce different results.
- As a comparison value with the requirements, the measured value should be obtained at a flow rate of 2.0 l/s, corresponding approximately to one toilet flush.
- The sound measurements were taken both on the opposite side of the installation (in the picture on the right) and in the mounting room (on the left of the picture).

*As all wastewater pipe systems manufacturers apply the standard test protocol, it allows building project managers to compare their results.



Details of the test configuration:

- **Standard bracketing:** 2 bracket collars per floor. Both mounted with a 1 Nm torque.
- **Stack support:** Stack supports are fixed to the wall/floor.
- **PAM'Acoustic:** 2 anti-vibration brackets per floor. Both mounted with a 1 Nm torque.

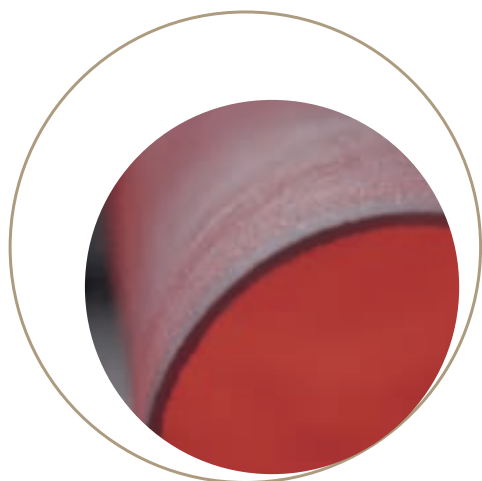
Choosing our systems guarantees the best acoustic solution on the market

- High basis weight
- Low tendency to vibrate
- Effective sound decoupling
- High insulation value
- Suitable for all pressures
- Sewage installations
- Precise installation instructions
- Compliance with project specifications or regulations



Durability

Robustness & mechanical strength



Pipe system components must withstand hazards before they reach the job site such as accidental impact before and during installation, during storage, handling and transit. In service, outdoor exposed pipes may be damaged by accidental impacts or vandalism. To avoid breakages, which can be expensive, or minor stress cracks which can have serious consequences in operation, the choice of material should be carefully considered.

Impact strength and crush resistance

Compared with other materials, **cast iron provides much better impact resistance** and is highly recommended everywhere pipes may be exposed to mechanical shock (car parks, streets, etc.). Cast iron is well known for its robustness. The quality of Pam Building products is ensured by careful control of both the metal composition and the manufacturing process. The spinning of pipes in the De Lavaud process, followed by heat treatment, gives these products outstanding mechanical properties:

- Mechanical characteristics superior to the requirements of EN 877*
- Very good resistance to crushing
- Increased impact resistance
- The pipe is more resistant to mechanical stress such as bending and compression
- For installers: installation is more comfortable and on-site handling is facilitated. Cutting pipes is easier, the slices are sharp. The set-up is therefore simpler and faster.

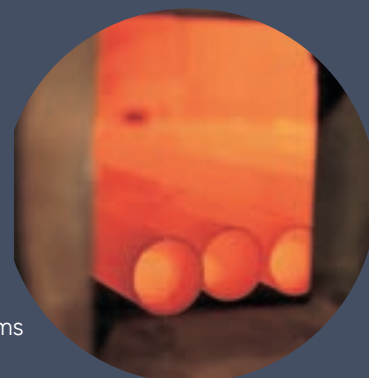
The Pipes	Pam Building process	Others	EN 877 requirements
Tensile Strength on samples in MPa (average value)	300	270	200 minimum
Ring Crush Strength in MPa (average value, DN 100 pipes)	450	360	350 minimum
Brinnell Surface Hardness in HB degree (average value)	220	245	260 maximum

These results indicate greater resistance to impacts and crushing, easier machining and cutting. This also means the products are easier to install on job sites.

*Key mechanical characteristics required by standard EN 877 are checked by three tests, carried out on pipes when coming out of the heat treatment furnace to assess tensile strength, ring crush resistance and hardness. In addition, operators have opted to perform a further test which provides a good indication of the heat treatment quality: impact test.

The De Lavaud process

In this process, a constant flow of molten metal at a perfectly controlled temperature and composition is gradually put into a steel mould rotating at high speed. The mould's external wall is cooled by circulating water and the evenly distributed molten metal cools on contact with the wall before extraction. The process is characterized by quick cooling which gives a finer solidification matrix and thus a more homogeneous metallurgical structure. The spun pipes are placed and rotated in a heat treatment furnace at 950°C and then gradually cooled again. This step is essential to the process as it transforms the cast iron's metallurgical structure. The reduction in iron carbides and the increase in ferrite content considerably improve the mechanical properties of cast iron and reduce its surface hardness. The graphite of the cast iron resulting from the Pam Building process forms clustered graphite, halfway between lamellar and ductile iron.







Stability to thermal variations

Most solids expand when heated and are liable to elongate under temperature increases.

For pipe systems made of materials that are subjected to high levels of thermal expansion, precautions must be taken at the design stage. Cast iron, which expands very little, does not require specific bracketing or expansion collars. It makes the specifiers' design work easier and avoids extra costs at the installation stage.

Thermal expansion coefficient of cast iron and other materials

The thermal expansion coefficient for cast iron – 0.01 mm/m. °C – is very low and very similar to that of steel and concrete; the building and pipe systems will move and expand together.

Thermal expansion of cast iron and other materials for a temperature rise of 50°C and 10 m			
Thermal expansion coefficient			
0.0104 mm/m°C → 5.2 mm	Cast iron		
0.07 mm/m°C → 35 mm	PVC		7 times more
0.150 mm/m°C → 75 mm	PP		14 times more
0.17 mm/m°C → 100 mm	HDPE		19 times more

For cast iron, the bracketing system is designed to only carry the weight of the pipe and its content, which makes the designers' work easier. Plastic pipes, however, expand considerably with increasing temperature. Their bracketing system must be designed and adapted accordingly, as it can significantly affect the pipework's stability and performance over time.

Thermal expansion of plastics

To allow expansion without damaging the drainage network, **plastic pipe systems require specific accessories** – expansion collars or joints, brackets allowing axial movement, in general one of the two.

If these precautions were not taken, **expansion** could be absorbed by the pipework and cause distortion.

Cast iron does not require these expensive accessories. It makes the design work easier and decreases the risk of mistakes at the installation stage. These properties of cast iron pipe systems are also valuable for engineering structures such as bridges, where significant expansions have to be carefully addressed to secure the construction project.

Cast iron pipes, thanks to their low thermal expansion coefficient, do not require specific devices to manage temperature variations, thus simplifying design and reducing installation costs.

The advantages of Cast Iron

Watertightness



Sanitary drainage systems, whether exposed or not, must remain watertight over time. Any defects can cause serious damage, leaks, dripping or slow permeation and generate costly repairs, and disruption.

Pam Building cast iron mechanical assemblies are designed to easily achieve instant watertightness and are not dependent on process control (gluing or welding, etc.).

Watertightness of cast iron systems

Cast iron is a dense and non-porous material. Our systems are watertight and impervious. Straight and rigid cast iron components are assembled using metal couplings fitted with elastomer gaskets which ensure the system is completely watertight. Assemblies benefit from a conventional approach. Put together with only simple tools, they allow installation tolerance with no risk of leaks. This ease of installation ensures the specified performance is always obtained, even in adverse conditions, unlike with plastics when either gluing or welding can be affected by installation hazards (ambient conditions such as temperature or damp), or when personnel with special skills are required.

Watertightness over time

Failure of watertightness can occur on drainage systems in operation due to breaks, misalignments, crushes or cracks. Long-lasting watertightness depends on two main factors:

- **No deterioration of pipes:** Cast iron is highly resistant to ovality. Their specified mechanical properties and stability enable cast iron systems to withstand operating stresses extremely well.
- **No deterioration of assemblies:** Elastomers are carefully selected for the long-term stability of their physico-chemical characteristics to ensure the lasting watertightness of the rubber gaskets.

Watertightness and maintenance

Blockages can sometimes occur in drainage networks, therefore the pipework materials must be resistant so that maintenance is easy. The S and Plus systems can withstand all normal maintenance processes, including high-pressure jetting, without being damaged. They have undergone a high-pressure test according to Swiss standard SN 592 012. The robustness and dimensional stability of cast iron components along with the careful selection of elastomer ensure pipe installations are high-performance and have a long service life.

” Cast iron pipes provide durable watertightness and are easy to install without special skills

Internal pressure resistance

Internal pressure in drainage networks rarely occurs and is always accidental. Thrust efforts in the overloaded sections have to be addressed to guarantee both watertightness and mechanical stability. As the robust cast iron components can withstand any pressure hazard, the couplings will be subjected to the strain. The quality of the couplings and their careful selection according to their field of use will prevent misalignment or disconnection of the pipework.

Resistance of the couplings to hydrostatic pressure



Standard pressure mechanical couplings

Wastewater drainage systems – which differ from rainwater drainage systems as regards pressure – are connected to sanitary appliances installed on each storey which may serve as outlets in case of accidental overloading (due to blockages, for example). The pressures that occur cannot therefore exceed the pressure corresponding to the height of one storey, i.e. about 0.3 bar. The couplings we describe as “standard” are perfectly suitable for this common type of application.



High-pressure mechanical couplings

In some rare cases, a wastewater drainage system may pass through a number of stories without any outlet, and there could be a risk of overloading blockage due to operation or saturation of the main sewer). The pressure resistance required to ensure these systems remain leaktight and stable in such cases depends on the height of the water column liable to occur, and in some cases calls for highpressure couplings able to withstand the resulting pressure (up to 10 bar).

Resistance to end thrust efforts

Some specific points on a pipe system may be subjected to thrust loads due to changes of direction and gradient, branches and plugs. To avoid any risk of disconnection or slippage of the pipe components, these loads must be addressed and the sections at risk must be anchored:

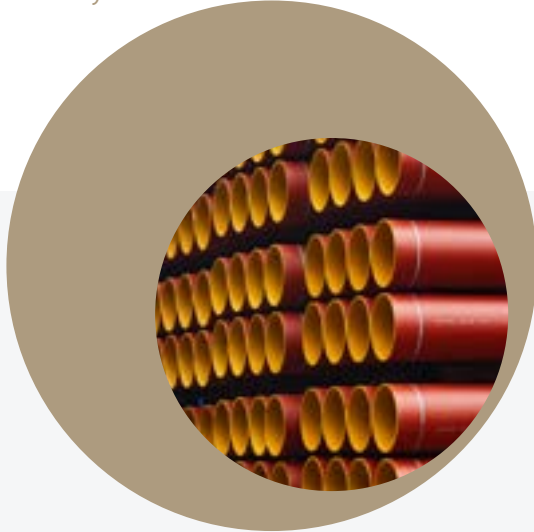
- A straight section of pipes may be held between two fixed points with ductile iron brackets for example
- Alternatively, a selfanchoring coupling or an ordinary coupling anchored with a grip collar can be used

Do you help determining
the choices for your project ?
Contact our
technical support team on:
www.pambuilding.com

The advantages of Cast Iron

Ageing behavior

” The properties of cast iron ensure the stability of the systems and long-lasting operational safety.



As components that are integrated in buildings, wastewater and rainwater drainage systems must remain in a serviceable condition over the long term despite adverse operating conditions. Ageing refers to any gradual, irreversible change in a material's structure and/or composition, liable to affect its behavior or serviceability. When a material is selected, the stability of its properties ensures operational reliability over time.

Stability of cast iron mechanical properties

The ageing of a material may be due to its own instability, environmental or chemical stresses, mechanical strains, or a combination of any of those causes. It is an established fact that cast iron offers long service, owing in particular to the stability of its mechanical properties over time.

Cast iron is not sensitive to thermal ageing

- Its mechanical strength remains stable.
- Its thermal expansion is very low compared to plastic.
- Cast iron pipe systems are not liable to creep at operating temperatures.

Cast iron does not deform under mechanical strain

- Its ring stiffness (cold measurement) around 700 kN/m is not affected by temperature and is 87 times that of PVC pipes. It is highly valued for buried pipework.
- Its longitudinal stiffness, which facilitates bracketing and protects the water stream in horizontal sections, remains intact. Its Young's modulus of elasticity is from 80 to 120 GPa vs 2 to 5 GPa for PVC.
- Cast iron's tensile strength is 8 times that of PVC: 200 MPa vs 25 (residual resistance, after 50 years according to the standards). This property is very important in case of network overloading

Resistance to climatic stresses

The properties of materials are extremely important when they are stored in or exposed to adverse conditions (extended exposure to ultraviolet light or wide-ranging temperature variations, etc.). Cast iron undergoes no structural modification under climatic stresses.

Ageing of polymers



Deterioration of mechanical properties under temperature stress

Under the effect of temperature, plastics can suffer two kinds of deterioration, including at operating temperatures:

- Creeping is an irreversible elongation under the combined action of both temperature and a significant mechanical strain. Plastic pipe systems like PVC or HDPE are particularly sensitive; in the horizontal sections, they can bend between two support brackets under their own weight.
- Modification of the elastic limit: most plastic materials will soften when exposed to a temperature increase. With a decrease in temperature, however, they crystallise. PVC, for example, becomes rigid and may crack under mechanical strain – its operating temperature range is generally between -20°C and 80°C, but depending on its nature, the range can be much narrower.

Photochemical ageing

Depending on their nature, climatic stresses (such as solar radiation, damp or heat) will cause photochemical ageing to plastic materials of varying severity. They may merely alter their surface finish, or they may also deeply modify their mechanical properties and thus adversely affect their serviceability. The same can happen as a result of a slow chemical attack by solvents or even in an aqueous medium.



Chemical & corrosion resistance

Domestic use Characterisation of common domestic applications

Building wastewater drainage systems – grey and black water – must be able to withstand the types of domestic effluents specified by standard EN 877.

In recent years, however, changes have been observed in the types of these fluids:

- Higher concentration of household detergents
- Use of more aggressive hygiene products
- Rise in operating temperatures.

The constraints on sanitary drainage systems are constantly increasing. To test chemical resistance of cast iron products, according to standard EN 877, the product samples are tested for 30 days at a temperature of 23 °C with the following liquids (pH constantly monitored):

- A solution of sulfuric acid with a pH of 2
- A solution of sodium hydroxide with a pH of 12
- A solution of wastewater with a pH of 7.

Resistance to hot water (24 h at a continuous 95°C) and thermal cycles (1,500 cycles of 5 min between 15°C and 93°C) are also tested according to standard EN 877. To provide clearer guidance on the chemical resistance of the S range in domestic applications, **Pam Building has carried out 20 further tests in addition to the requirements of standard EN 877** on commonly-used detergent products (floor cleaning products, laundry detergents, etc.) and special products (stain removers, drain cleaners, etc.).

The additional tests also aimed to assess the S and Plus range limitations.

The tests were carried out on samples, under the temperature of use recommended by the manufacturers and, where relevant, up to 70°C since hot water is normally supplied in houses at around 50–60°C. After stopping the test, the pipes and fittings were washed immediately to eliminate any stains, and the coatings were examined for blistering and rusting according to ISO 4628-2 and 3. (Accepted levels according to EN 877).

The duration of the test is considered equivalent to the extrapolation of real chemical stress undergone for 7 or 10 years (10 to 15 min of stress per day).

This test method, however, simulates severe stress since the samples lie in direct contact with the solution, the temperature is maintained and the test includes no rinsing for its duration.

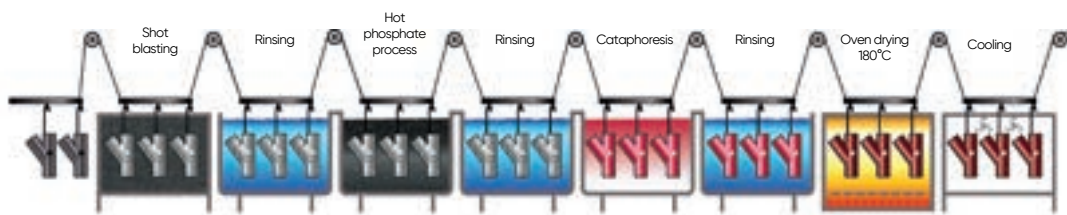
The advantages of Cast Iron

		Dillution*	pH	23°	50°	65°	70°	Test duration
SALT WATER	Same as sea water	30 g/l						28 days
DETERGENTS								
Laundry detergents	Phosphate-free detergent	2 ml/l	7.7					28 days
	Softener	2 ml/l	7.6					28 days
Dish washer detergents	Washing tablet	3 g/l	9.3					28 days
	Washing gel	3 g/l	9.8					28 days
	Washing up liquid	2 ml/l	7.65			N/A		28 days
Stain remover	"Ace Gentle" type		7.7					28 days
COMBINATION	Detergent + stain remover	2 ml/l + 3 ml/l	7.7					28 days
	Detergent + softener	2 ml/l + 3 ml/l	7.7					28 days
CLEANING PRODUCTS	Floor cleaning product	8 ml/l	8.2				N/A	28 days
	Bleach	8 ml/l	8.25			N/A		28 days
WC CLEANERS	Toilet bowl cleaner (gel)	20 ml/l	5.45					28 days
	Drain cleaner gel	0.33 ml/l	13			N/A		4 days
	Liquid descaler	80 ml/l	2.07					28 days

Cataphoresis: our industrial expertise to guarantee the best chemical resistance

Fittings and accessories are coated with an epoxy resin deposited by cataphoresis which ensures a uniform deposit and excellent covering of edges. Our industrial process is based on careful shotblasting and entails incorporating a chemical surface treatment during the coating cycle, between rinsing after shotblasting and the cataphoresis bath to enhance the coating's covering power.

At the end of the cycle, the parts are oven dried to complete the reticulation of the epoxy film. Substantial improvements in the epoxy film's adhesion to the cast iron and the corrosion resistance of the coated cast iron.



Recommended range for domestic use **S** range

According to the principle of continuity with no weak points, coatings for fittings and accessories must withstand the same stresses as pipes. There is an anti-corrosion coating process for these parts to ensure they can withstand major stresses, due to the fluids transported or the environment.

pam building

PAM GLOBAL®S

EN 877

CE A1

1-3

Intensive use

Internal stresses due to aggressive effluents



Characterisation of intense or professional uses

Aggressive effluents are characterized by their content (acids, bases, solvents, hydrocarbons, etc.), their combinations and their temperature. Above- and below-ground wastewater drainage for aggressive discharge are characterized by:

- Hot water resistance: 24 h at a continuous 95°C and thermal cycles (1,500 cycles of 5 min between 15°C and 93°C)
- Plus range external coating corrosion resistance test to neutral salt spray according to standard NF-EN ISO 9227_2017: 2500 hours
- Chemical resistance: $1 < \text{pH} < 13$

Characterisation of external stresses

Below-ground wastewater drainage systems exposed to environmental stresses. The buried section of a pipe may be laid in non-homogeneous ground or corrosive soil. When protected by galvanic effect, the pipework can be installed without requiring systematic soil studies. Buried systems are subjected to ground loadings which can cause shearing strain on couplings. For these applications, it is therefore recommended to the "all stainless steel version" of the steel couplings to avoid corrosion due to the aggressiveness of the ground.

Recommended range for intensive use

Plus range




pam building PAM GLOBAL® Plus EN 877 CE A2-s1, d0


The limitation between the S and Plus ranges is only determined by the type of fluids and the operating temperature. However, the duration of daily exposure also directly determines the appropriate range to select, hence why we called this chapter intensive or professional use. The combination of high pH products (base and alkaline products) and high temperatures systematically calls for the use of the Plus range.

With its anti-corrosion thick linings, the Plus range provides greater chemical resistance and is particularly well-suited to intensive uses.

- To transport effluents containing acids, bases or saline solutions at common operating temperatures, systematic use of the Plus range equipped with couplings with EPDM gaskets is recommended.
- For solvents, hot oil and where hydrocarbon traces may be present, the systematic use of the Plus range equipped with couplings with NBR gaskets is recommended.

The advantages of Cast Iron

	Description	Solution/medium	Dilution	Ph	Temperature of use (°C)	PLUS RANGE
 Kitchen	Highly alkaline detergent designed for use in dishwashers	Suma special L4	2 ml/l	?	60°C	OK
	Acidic rinse specially designed for use on a wide range of dishwashers	Suma CRYSTAL A8	0,1 ml/l	?	80°C	OK
	Concentrated acid cleaner for descaling small equipment	Suma calc D5	50 ml/l	?	20°C	OK
	Degreaser-disinfectant-bactericide	Suma Chlorsan D 10,4	1%	11,5	20°C	OK
 Laundries	Highly concentrated and phosphate-free detergent	Clax Revoflow PRO 0-P 35X2	4g/kg	11	60°C	OK
	Softening agent	Clax Revoflow Deosoft breeze 54x1	0,2 ml/l	3	20°C	OK
	Highly concentrated medium temperature activated oxygen bleach for fabric washing	Clax Revoflow OXI 4XP2	2 g/kg	9,9	60°C	OK
	Low-foaming disinfectant detergent for cleaning and disinfecting floors and surfaces	TASKI Sprint DS 5001	1%	9,5-11,3	20°C	OK
 Health care	Soft soap	Aniosafe (Aniosafe savon doux HF)	pure	7,9	40°C	OK
	Disinfectant	Soluscope A	0,06%	5,5	40°C	OK
	Concentrated detergent and pre-disinfectant for ENT and TEE machines	Soluscope C+ (chlorure d'ammonium)	0,50%	2,5	40°C	OK
	Disinfectant	Soluscope P (acide parasétique)	0,06%	1,5	40°C	OK
	Detergent for automatic washing machines and washing tunnels	Aniosyme Synergy WD ultra	0,50%	10	55°C	OK
	Détergent pré-désinfectant pour nettoyer les instruments médicaux	Anio (Aniosyme X3)	0,50%	7,5	20°C	OK
	Pre-disinfectant cleaner for medical and surgical instruments	Anios Clean Excel D	0,50%	7	20°C	OK
	Disinfectant for surgical equipment	Actanios HLD	pure	5	20°C	NOK
	Detergent, disinfectant for the treatment of surgical equipment	Actanios LDI	0,50%	12	55°C	OK
	Neutralising rinsing fluid with lubricating effect for dental and medical instruments	Anios RWH	0,30%	2,5	55°C	OK
	Disinfectant for hemodialysis generator circuits and water treatment circuits	Anios Oxyanalyse	3%	2,5	20°C	OK
	Acid rinsing product - Contains surfactants	Anios LB 30	0,30%	2	55°C	OK
	Concentrated rinsing detergent for the treatment of thermal wash basins	Anios LB 400	0,30%	2,5	55°C	OK
	Neutral disinfectant detergent - concentrate. Bactericide, fungicide, virucide	Degragerm Smart Dose - Taski	1%	11	20°C	OK
	Broad spectrum disinfectant detergent for non-porous surfaces - Bactericide, Virucide, Levuricide	Oxivir Excel	4%	1,5	20°C	OK
	Detergent / descaler for sanitary facilities	TASKI Sani Antikal	pure	1,5	20°C	OK
	Renovating detergent for floor maintenance in large and medium-sized stores	TASKI Jontec Combimarket	15%	13	20°C	OK
 High temperature oils		Petroleum	pure		20°	OK
		Gasoline	pure		20°	OK
		Diesel	pure		20°	OK
		Lubricants, petroleum derivatives	pure		20°	OK
		High temperature oils	pure		80°	OK

		Solution/medium	Formule	Dilution	Ph	Temperature of use (°C)	PLUS RANGE
 Laboratories Industries	Water		Salt water	30 g/l	5,5	80°	OK
			Desalinated water	pure	6,5	80°	OK
	Mineral acids	Hydrochloric acid	HCl	5%	1	20°	OK
		Sulphuric acid	H ₂ SO ₄	10%	1	20°	OK
		Phosphoric acid	H ₃ PO ₄	10%	1,3	20°	OK
		Phosphoric acid	H ₃ PO ₄	2,5	2	80°	OK
		Nitric acid	HNO ₃	10%	2	20°	OK
	Organic acids	Lactic acid	C ₃ H ₆ O ₃	10%	1,1	20°	OK
		Citric acid	C ₆ H ₈ O ₇	5%	2	80°	OK
		Vinegar		30%	2,9	20°	OK
	Bases	Soda solution(sodium hydroxide)	NaOH	0,01 mol/l	12	80°	OK
		Soda solution(sodium hydroxide)	NaOH	1 mol/l	13,5	20°	OK
		Ammonia(sodium hydroxide)	NH ₃	1 mol/l	12	80°	OK
		Potash	KOH	2 mol/l	13,5	20°	OK
		Potash	KOH	2 mol/l	13,5	80°	NOK
	Salts	Potassium chloride	KCl	3%	4,2	20°	OK
		Sodium phosphate monobasic	NaH ₂ PO ₄	3%	4,2	20°	OK
		Ammonium sulphate	(NH ₄) ₂ SO ₄	3%	6,7	20°	OK
	Solvents (except acetone)	Glykol	C ₂ H ₆ O	pure		20°	OK
		Ethanol	C ₂ H ₆ O ₂	pure		20°	OK
		Methanol	CH ₃ OH	pure		20°	OK
		Xylene	C ₈ H ₁₀	pure		20°	OK
		White spirit		pure		20°	OK

Intensive use: external stresses due to aggressive ground

Characterisation of external stresses

Below-ground wastewater drainage systems exposed to environmental stresses.

The buried section of a pipe may be laid in non-homogeneous ground or corrosive soil. When protected by galvanic effect, the pipework can be installed without requiring systematic soil studies.

Recommended range for these applications: Itinero® or Plus ranges

Buried systems are subjected to ground loadings which can cause shearing strain on couplings. For these applications, it is therefore recommended to the "all stainless steel version" of the steel couplings to avoid corrosion due to the aggressiveness of the ground.





Chemical & corrosion resistance

Intensive use: external stresses due to climate exposures

Outdoor or facade exposures

Depending on the climatic conditions, while in operation outdoor wastewater and rainwater systems can be subjected to ultraviolet radiation, saline mist, condensation, freezing-thawing cycles and pollution. The drainage systems must be fit for purpose despite exposure to adverse conditions.

Zinc coating improves the pipes' ability to withstand climatic stresses and extends their service life.

What is Zinc coating ?

The zinc metal coating is an active protection provided by the galvanic action of a zinc-iron cell. This action is two-fold:

- Formation of a stable protective layer of insoluble zinc salts
- Self-repairing of any damage.

Zinc metalisation is an excellent corrosion inhibitor and is extremely effective at extending the lifespan of products subject to backfills or climatic stresses.



Zinc
spray



Non-zinc
coated

the damage is worsened
and the corrosion
(red marks) extends
beyond the notch



Zinc
coated

a white line of zinc salt
shows that the damage
is completely plugged

Recommended range for this application
Zn range



A large pile of metal scrap, including various shapes of cast iron and steel, is shown. In the center, a circular callout with a white border contains the text 'From 99% waste recycled* to fully recyclable products'. The background is a dark, textured surface of metal debris.

**From 99%
waste
recycled*
to fully
recyclable
products**

*Recycled content: proportion, by mass, of recycled material in a product or packaging. Only pre-consumer and postconsumer materials shall be considered recycled content.

For the standard S range, recycled content is 99% with 11.5% pre-consumer & 87.5% postconsumer according to ISO 14021: 1999.

Pre-consumer material: material diverted from the waste stream during a manufacturing process. This excludes the reuse of materials such as rework, regrind, or scrap generated in a process and capable of being reclaimed within the same process that generated it.

Post-consumer material: material generated by households or commercial, industrial and institutional facilities in their role as end users of the product which can no longer be used for its intended purpose.



Environment

Pam Building, a key player in the Circular Economy



every year we recycle the
equivalent of **18.000**
cars on
average.



The preservation of natural resources is a major societal challenge, especially for the construction sector, which is a major consumer of raw materials and energy. Pam Building evacuation systems are a responsible and sustainable choice, respectful of natural resources and people.

A cast iron pipe gives our waste a second life

In order to contribute to the preservation of natural resources, Pam Building's molten iron is produced by recycling cast iron and ferrous products. Unlike plastics, it can be completely and systematically recycled at the end of its life.

Pam Building's drainage solutions can be recycled **without any deterioration of their properties.**

The product's life cycle is also first-class in terms of environmentally-friendly logistics, longlasting functionality (up to 70 years without compromising the mechanical properties), low maintenance costs and commercially beneficial recycling

Nothing is wasted: everything is recycled

Cast iron pipe systems are based on the principle of modular ranges of removable components. Their mechanical assemblies are reversible. You can change your mind today or even tomorrow. When pipe systems are disassembled or modified, these components can be reused, which cuts down on waste dumping.

Organised and numerous actors in the recycling channel

The recycling channel exists: collector network and recovery stream is existing and working!

We work with local supply for scrap (<125 km from the plant) to reduced economic and transport costs.

Following ISO 14021:1999 and LEED V4 criteria we can provide a recycled content declaration for our products.

Life Cycle Assessment

A rigorous tool for assessing the environmental impacts of our products



Understanding the environmental performances of construction products is a growing expectation for professionals in the building chain.

In Pam Building, we strongly believe that Life Cycle Assessment is the most reliable tool available to assess the green credentials of construction products and enables companies to communicate credible, fact-based information about their products to consumers. It is also a powerful tool for enhancing the environmental features of our products. LCA is a methodology based on specific standards ISO 14040 and ISO 14044:

- Multi-criteria tool: consumption of natural resources, air, ground and water emissions, waste generation, warming potential...
- Multi-step tool: "cradle to gate" or "cradle to grave".

Environmental Product Declaration

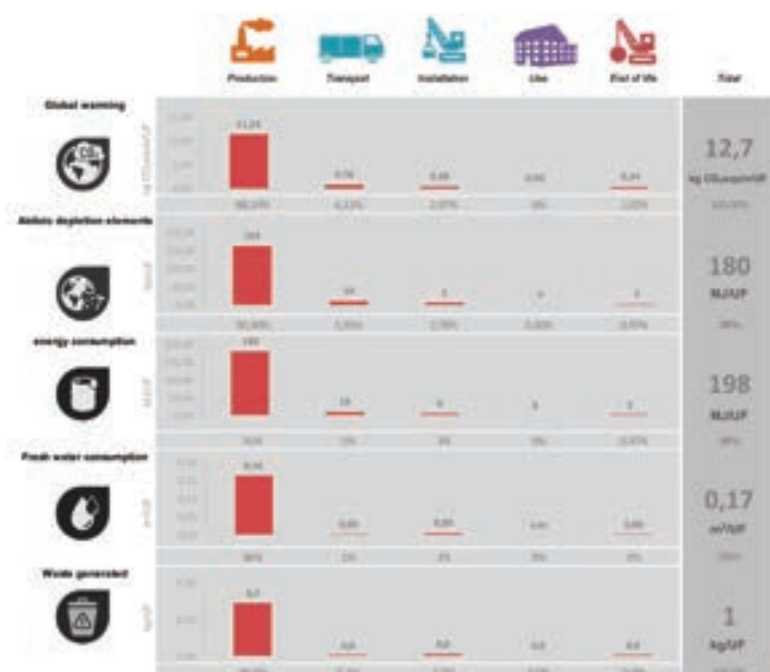
What is an Environmental Product Declaration?

The results of a LCA are presented in the form of an Environmental Product Declaration, locally administrated by program operators and based on ISO 25930 and EN 15804 standards. When an EPD has been checked by an independent third party, it is said to be verified. This process ensures the quality and reliability of the results: that is why we are committed to have verified EPDs.

We currently have produced and verified EPDs for our S and Plus ranges, both available on the Environdec platform: www.environdec.com

Overview of the EPD for our S range

This table enables a quick and synthetic overview of environmental footprint of the functional unit (1 m of SMU S cast iron pipe system for collection and drainage of waste water, sewage and rainwater in buildings), based on 70 years of lifetime. The complete EPD is available on the international Environdec platform, registration number S-P-02013.



Source: <https://www.environdec.com/Detail/?Epd=18393>



05

Design & Installation

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Resistance to pressure

Admissible pressure load EN 12056 requirements

Gravity wastewater drainage systems and ventilation systems generally operate without pressure. Although this does not exclude the possibility of pressure arising in the systems under specific operating conditions.

EN 12056-1, Section 5.4.2 Water and Gas Tightness, states that drainage installations must be sufficiently water and gas tight to withstand operating pressure. Furthermore, EN 12056-5, Section 6.3 states, with respect to securing pipe systems: Non-anchored pipes must be secured and/or supported in such a manner that they cannot be disconnected during use. The arising reaction forces must be addressed.

For the specific application of rainwater, EN 12056-3, Section 7.6.4. stipulates: Internal rainwater pipes shall be able to withstand the head of water likely to occur in the event of a blockage. The same precautions should be taken as on pipework liable to undergo accidental overloading: securing of bottom bends and joints with adequate grip collars or HP couplings.

Fluid pressure is the force the fluid exerts per surface unit, perpendicular to this surface. Pressure change applied to the surface of an enclosed fluid is transmitted evenly and undiminished in all directions. Robust cast iron components can address any pressure hazard, so the couplings will be subjected to the strain. Our couplings are tested under hydrostatic pressure: only grip collars and autogrip collars are tested under end thrust forces

Admissible pressure load Network requirements

In addition to the above standards, in a drainage network, pressure resistance requirements are dependent on:

- **The height of the water column** between the considered point of the network and the first outlet located upstream; generally speaking, we differentiate waste and toilet networks from rainwater.
- **The accidental risk of loading.** The most frequent cases are due to occasional obstruction of downstream pipeline or saturation of the public network.

Wastewater networks



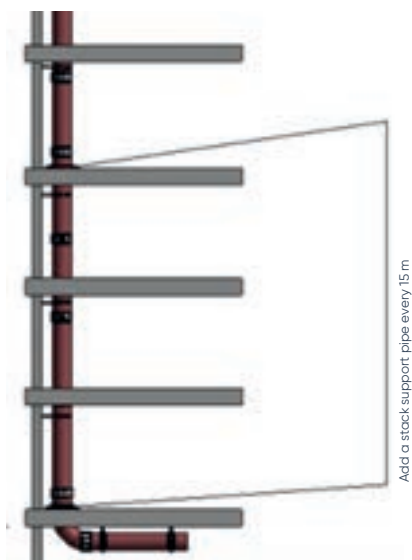
Risk of pressure build-up with a low water column

Generally, the pressures that occur in wastewater drainage systems cannot exceed the pressure corresponding to the height of one storey, i.e. about 0.3 bar, as sanitary appliances on each floor serve as outlets in case of accidental overloading. The couplings we describe as "standard" (PAM Rapid and PAM R) meet these requirements.

Risk of pressure build-up with a high water column

In very rare cases, where domestic wastewater downpipes cross several levels of a building without any outlet, and where there would be a risk of accidental loading, the installation must comply with the recommendations applicable to rainwater networks.

Rainwater networks



Legend	
	Couplings
	Grip collars
	Access pipe
	Stack support
	Bracketing

The risk of pressure build-up with a low water column is the same as wastewater networks.

Risk of pressure build-up with a high-water column

In some rare cases there could be a risk of accidental overloading. The pressure resistance required to ensure these systems remain leak tight and stable depends on the height of the water column liable to occur and could call for high-pressure couplings able to withstand the resulting pressure (up to 10 bar). Coupling solutions will be differentiated for building height between 0 to 30 m, 30 to 50 m, 50 to 100 m corresponding to different levels of pressure resistance requirements.

Straight runs of the pipework

Straight runs between two fixed points and rigid bracketing do not experience exceptional forces.

In case of accidental overloading, the couplings will only have to address hydrostatic pressure. Standard pressure couplings withstand up to 10 bar for DN50-DN125, up to 5 bar for DN150-DN200, up to 3 bar for DN250-DN300. High pressure couplings withstand up to 10 bar for DN100-DN400 and up to 6 bar for DN500 and DN600.

Stack support

On vertical straight runs, stack support pipes should be installed to address the stacks' weight. At the bottom of the stack, the first stack support pipe addresses both the pipes' weight and the end thrust effort.

For the last case, it is recommended that the support and fixings be adapted accordingly. We recommend positioning the first stack support pipe at the base of the first floor, and then every subsequent fifth floor, in the case of a standard average 2.5 m between floors, or more generally every 15m.

Resistance to pressure

Rainwater networks

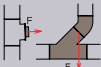

Changes of direction and specific elements (plugs, branches, bends)

End thrust forces can be exerted with changes of direction, gradient and specific components like branches and plugs, it is the result of the pressure forces exerted by a stationary fluid on the singular points of a pipe (or changes in direction):



These forces have to be addressed to avoid any risk of the pipe system disconnecting or slipping using specific couplings. It is considered that end-thrust effect must be addressed when drainage pipework may be exposed to an internal pressure higher than 0.5 bar. In such conditions, the installation must be able to stay in place to perform its functions of water tightness, and mechanical stability, preventing any dislocation at the couplings. **Grip collars and gripped HP couplings are part of the solutions to secure the network.**

The forces significantly increase with large pipe diameter as illustrated in the following table.

	DN 50	DN 75	DN 100	DN 125	DN 150	DN 200	DN 250	DN 300	DN 400	DN 500	DN 600
Expansion plugs or single long arm branches 	10.5	22.5	41.5	63.5	90.5	157	269.5	387	666.5	1029	1475
Two 45° bends 	14.5	32	59	95	127.5	225.5	382	544	941	1455.5	2087.5

It is considered that end-thrust effect must be addressed for:

1. Pipes laid under the groundwater table
2. Rainwater pipes or wastewater pipes running through several stories without outlets
3. HP>5 m
4. epams – gripped collars or gripped couplings are mandatory until positive pressure is reached.



In these areas, the forces have to be addressed to avoid any risk of the pipe system disconnecting or slipping:

- Isolating the section suspected of having thrust forces between two fixed points, like stack support pipes.
- Adapting the joints (selection of couplings solutions) between these fixed points.

To address the thrust forces, other solutions can be used, like anchoring in concrete, or using dedicated bracketing systems.

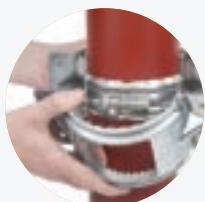
Coupling selection according to loading risks

Couplings & Grip collars performance

	PAM Rapid + GRIP collar 	GRIP HP couplings 
DN600		6 bar
DN500		
DN400		
DN300	3 bar	10 bar
DN250		
DN200	5 bar	
DN150		
DN125	10 bar	
DN100		
DN75		
DN50		

Note: under end thrust forces, where a coupling is secured with a grip collar, the maximum performance of both is limited by the weakest performance of the two products.

Focus on the PAM grip collars installation



- 1 Position the two half parts of the PAM grip collar uniformly so it encircles the pipe in parallel. The grip collars must be positioned so that the apertures fit over the coupling's fixing bolts and the teeth are directly located onto the pipe.



- 2 Insert the four screws to fix the two parts together



- 3 Tighten the screws crosswise alternately so that the two plates are put in parallel with the same spacing.



- 4 The assembly is completed when the external edges of the plates are in contact on both sides.



Explore our
tutorials
Youtube

Resistance to pressure

Coupling selection according to loading risks

Risk of pressure build-up with a high-water column

Before deciding which type of coupling to use it is important to answer the following questions:

→ Wastewater or rainwater network?

Generally, the pressures that occur in wastewater drainage systems cannot exceed the pressure corresponding to the height of one storey, i.e. about 0.3 bar, as sanitary appliances on each floor serve as outlets in case of accidental overloading.

→ Diameter of the pipes?

Thrust forces will be significantly larger for large diameter pipes and will have to be addressed with grip collars and HP couplings. Pressure resistance of couplings are specific for a given diameter. For DN 400 and larger only HP couplings are available.

→ Height of the stack?

The higher the stack is, the higher the potential pressure build-up.

→ Location of the coupling along the system?

Recommendations will change between $0\text{ m} < H \leq 30\text{ m}$, $30\text{ m} < H \leq 50\text{ m}$, and $50\text{ m} < H \leq 100\text{ m}$ as the height of the water column will correspond to different pressure levels.

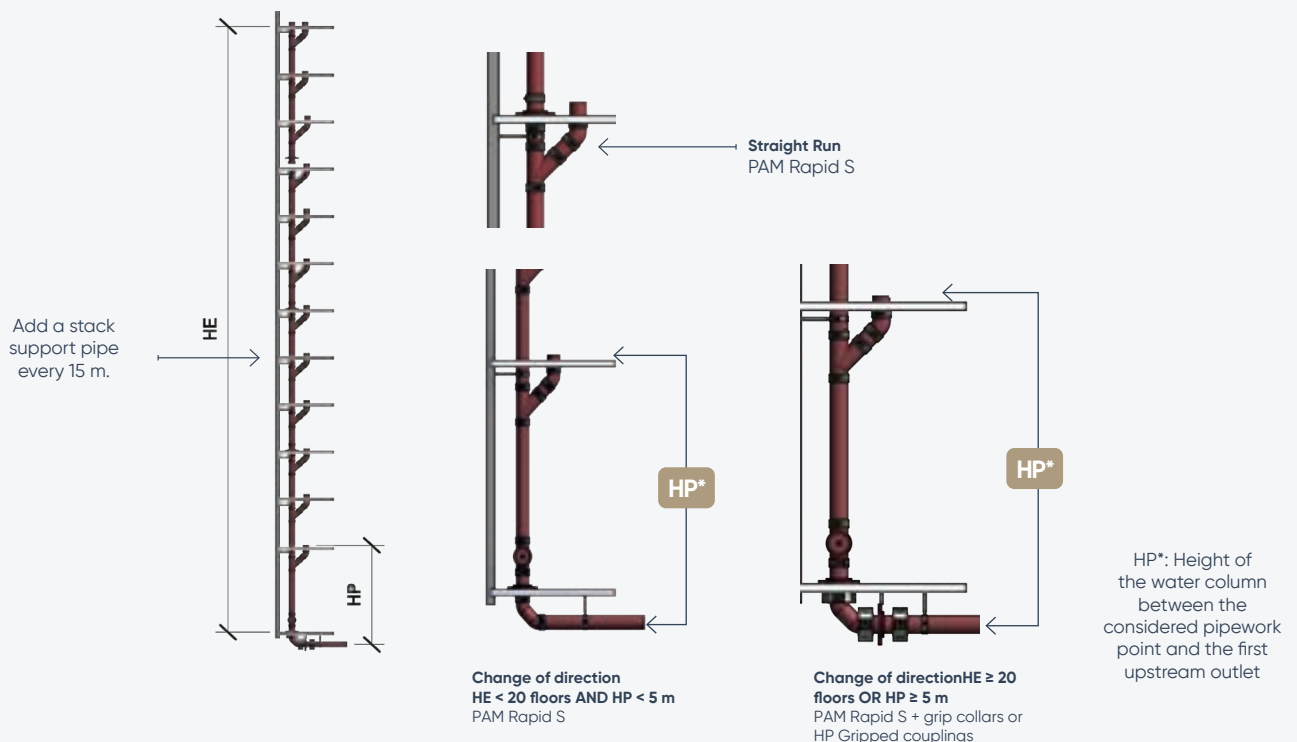
→ Straight run or change of direction?

Thrust effort will have to be addressed at change of directions.

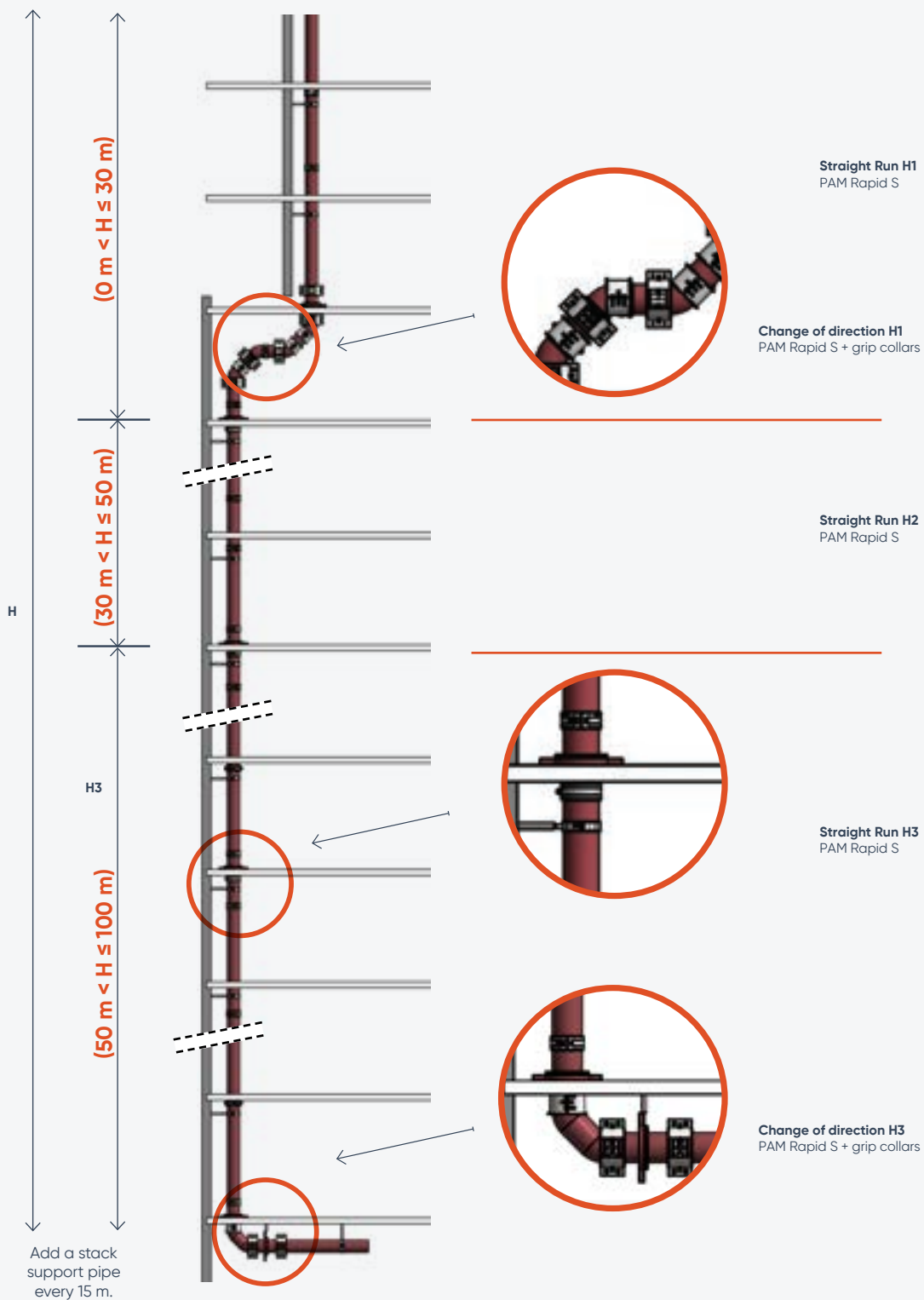
Wastewater network DN 50 to DN300

Different coupling recommendations should be followed depending on the number of floors and the HP height.

In case of several storeys without outlet, the installation must comply with the recommendations applicable to rainwater networks.

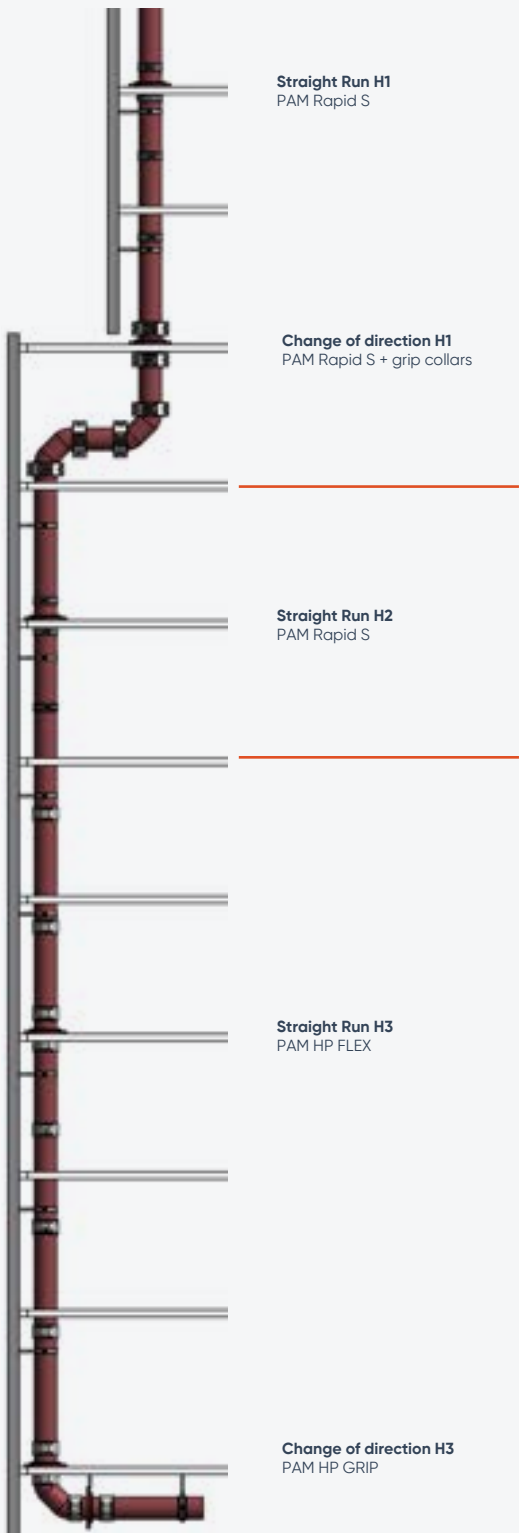


Rainwater network DN100 to DN125

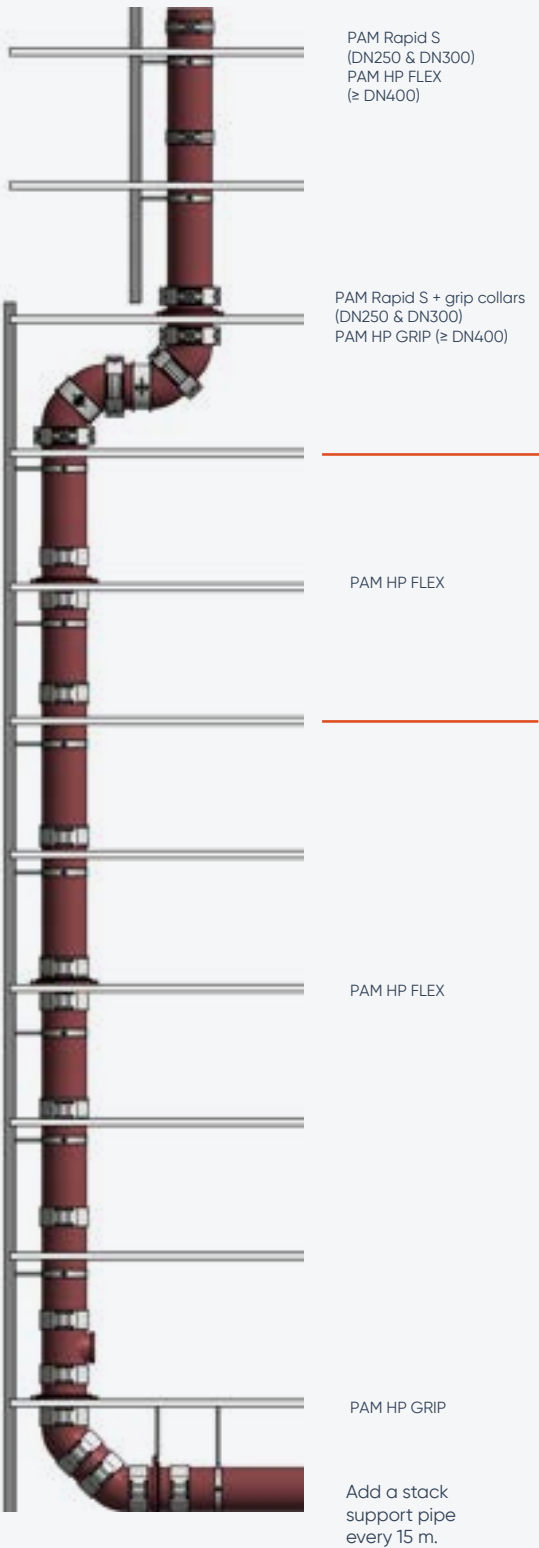


Resistance to pressure

Rainwater network DN150 to DN200



Rainwater network ≥ DN250



Ventilation

A drainage pipe is normally at neutral air pressure compared to the surrounding atmosphere. When a column of wastewater flows through a pipe, it compresses air in the pipe, creating a positive pressure that must be released or it will push back on the waste stream and downstream traps' water seals. As the column of water passes, air must flow in behind the waste stream or negative pressure (suction) results. The extent of these pressure fluctuations is determined by the waste discharge fluid volume.

The purpose of a ventilation stack is to control pressure in the pipework to prevent foul air from the wastewater system entering the building. Below are some of the main configuration principles, but combinations and variations are often required (see standard EN 12056-2). The purpose of a ventilation stack is also to avoid accumulation of dangerous gases.

Black water and grey water can be drained either in separate or in a single discharge stack. The rules for duct sizing are different depending on the option selected.



Primary ventilated system configurations:

Control of pressure is achieved by air flow in the discharge stacks. The soil stacks extend in main roof vents to above and out of the roof. Alternatively, air admittance valves may be used. They are pressure-activated, one-way mechanical vents, used in a plumbing system to eliminate the need for conventional pipe venting and roof penetrations.

A single stack is still possible but design precautions must be taken to prevent self-siphonage.

Ventilation

Secondary ventilated system configurations:

In buildings of three or more storeys, if the air pressure within the stack suddenly becomes higher than ambient, this positive transient could cause wastewater to be pushed into the fixture, breaking the trap seal.

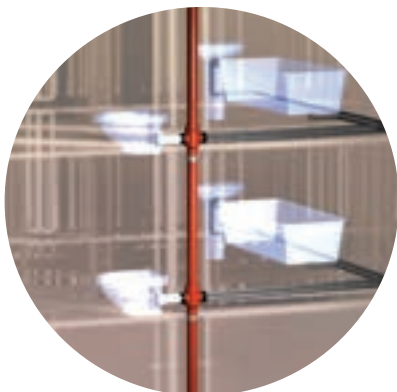
Vent stacks are put in parallel to waste stacks to allow proper venting and prevent such disorders. Air admittance valves may also be used in this configuration.

Under many building codes, a vent stack, a pipe leading to the main roof vent, is required to the draining fixtures

To allow only one vent stack and therefore one roof penetration, as permitted by local building codes, sub-vents may be tied together and exit a common vent stack.



Single stack branch



The single stack branch is a patented device made to allow wastewater drainage without secondary vent pipes.

Provided the maximum number of connected sanitary appliances is respected, the single stack branch properly drains wastewater in a single stack, without vent pipes, whilst limiting the risks of self-siphonage. This device complies with standard EN 12056. Please consult local requirements for compliance with other regulations. The branch for a single downpipe allows wastewater drainage in a combined network without secondary ventilation according to EN 12056.

Field of use:

- Multi-connection of sanitary appliances for adjacent apartments, or sanitary blocks
- Compactness when space is limited
- No secondary vent pipes are required.

Benefits: It simplifies plumbing by grouping pipework from 3 or 4 times more sources than a conventional installation. Maximum connections for each floor level: 2 toilets, 2 bathtubs and all the usual sanitary facilities for two apartments (sinks, basins, showers, etc.). The single stack branch is particularly suitable for narrow service shafts, hotel rooms, student apartments or any other building with adjacent sanitary blocks.

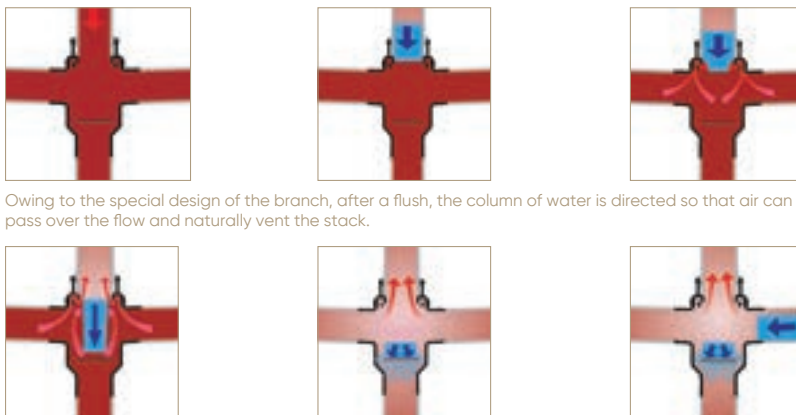
Operation features

- System under French Technical Approval
- Prevents excessive pressure variations in the stack system
- Limits negative pressure by optimal venting and prevents self-siphonage.

The single stack branch DN 100 main body is connected to the stack using standard couplings and a traditional jointing method.

Their watertightness is ensured by the rubber gaskets which equip the S and Plus ranges offered by Pam Building.

The overall plumbing works shall be executed in compliance with standard EN 12056: the appliances shall be installed with traps in compliance with the specifications of the same standard.



Owing to the special design of the branch, after a flush, the column of water is directed so that air can pass over the flow and naturally vent the stack.

Inside the branch, at the bottom of the body, a rubber deflector sprays the column of water to prevent draught or self-siphonage.

Solution



The single stack branch exists as a long tail to allow connection to the main stack under the slab and thus facilitate installation either in new or renovation works.

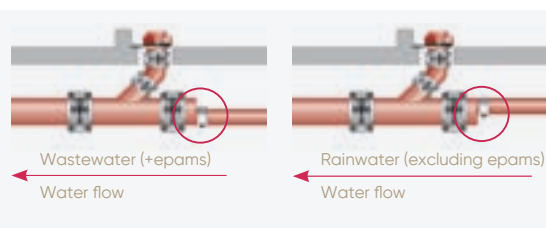
Three different products, 2 or 3 inlets:

- Corner branch two inlets 88°
- Double branch two inlets 88°
- A consecutive branch, three inlets 88°.

Rubber plugs with several pre-cut lids will allow one to three different connections.

Water flow and air circulation

According to standards EN 12056-2 and EN 12056-3



Wastewater and siphonic rainwater horizontal pipelines

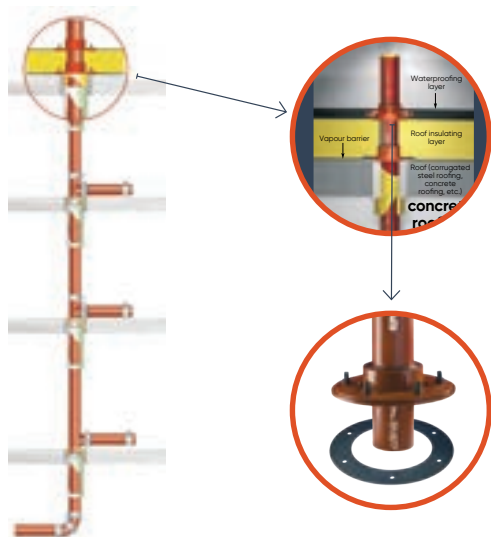
The internal diameter of pipes cannot be reduced in the direction of the water flow, except in the case of pipework operating at full bore, under negative pressure such as in the epams siphonic roof drainage system. The addition of branch connections, or changes of fall liable to increase the water flow rate, may require an increase in internal pipe diameter. This increase can be applied upstream of the new branch connection, using a tapered pipe.

Gravitary rainwater horizontal pipelines

In horizontal and near horizontal pipelines, increases in size shall be installed so that the soffit is continuous, to prevent air from being trapped.

Ventilation

Roof penetration device



To secure roof watertightness, which is of crucial importance, the number of roof penetrations should be limited. **Pam Building has designed a roof penetration device for its pipe systems that is watertight and quick to install.**

The system was developed to facilitate the installation of completely watertight roof penetration for cast iron primary ventilation pipes or vent pipes. The flanged fittings clamp both the vapour barrier and the waterproofing layer.

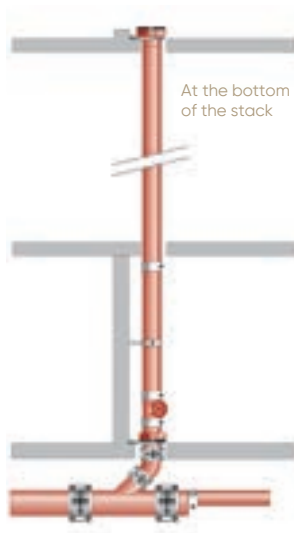
The roof penetration device is a set of two ductile iron flanged fittings. One of the flanges is fixed. The second is movable, equipped with rubber gaskets. Rubber gaskets are available in EPDM or NBR quality where hydrocarbons may be present.

The first flange fitting, installed above the roof, clamps the vapour barrier under the roof insulating layer, the second, above the insulating layer, clamps the waterproofing layer, whether it is polymer or bituminous.

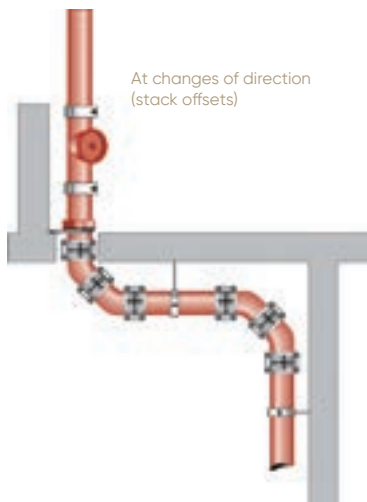
Access to the pipework

Access to the pipework must be ensured so that tests, inspections and maintenance can be performed. Access may be obtained using a short access pipe.

On downpipes

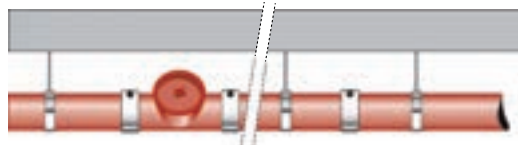


At the bottom of the stack



At changes of direction (stack offsets)

On horizontal collectors



runs, the short access pipe will be installed in a slightly sloped position with respect to the pipe crown.



The short access pipe combines reliability, ease of use and operation safety

Network supporting



Bracketing: technical

Pipe support except for the epams® system

For cast iron, the bracketing system is designed to only carry the weight of the pipe and its content, which makes the specifiers' design work easier.

Pipe weight in kg per metre

	50	75	100	125	150	200	250	300	400	500	600
Empty pipe	4.5	6	8.5	12	14.5	23.5	33.5	44	60	82	107
Full pipe	6.5	10	18	5	32.5	55	88	121.5	185	278	390

Note: The technical specifications for threaded rods and metal brackets shall be established on this basis.

Bracketing recommendations for cast iron pipe system elements

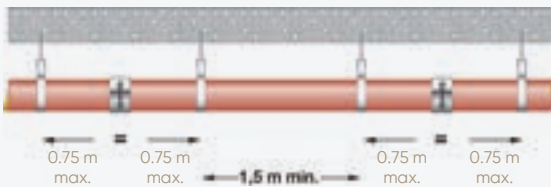
Number of brackets		
Vertical run	Pipes	1 (2)*
	Fittings**	1
Horizontal run	Pipe length ≥ 2 m	2
	Pipe length < 2 m	1
	Fittings**	1
Consult local requirements for compliance		

* For PAM GLOBAL® pipes L ≥ 2.7 m installed outdoors - ** When the shape of the fitting permits it

It is also recommended to use one bracket per length or fitting (when the shape allows it, i.e. branches, etc.)

Network supporting

Horizontal collectors



Support for horizontal pipework

The general recommendation for horizontal pipework is two load bearing brackets per pipe.

As an indication, they should be installed 0.75 m from each spigot so that, ideally, the distance between two brackets is 1.5 m. Installation shall respect a slight fall, around 1 or 2%, and 0.5% as a minimum, (0.5 cm per metre).

Vertical pipework

Bracketing installations, openings and sealings are prohibited in pre-stressed girders.



Bottom of stacks



Support for vertical pipework

For vertical waste or rainwater stacks, the brackets aim to prevent the pipework from falling over. It is recommended that one bracket be fitted for each floor level.

Ideally, the bracket should be installed on the first third of the upper spigot, and even closer to a socket joint.

At the bottom of the stacks, the forces from the pipe's weight and possible end thrust efforts will preferably be addressed through stack support pipes.

Specific bracketing for acoustic insulation

The evacuation of waste, soil and rainwater generates structure-borne and airborne sound between rooms and usually occurs as a result of a mixed flow, when the pipe is filled with water and air. In such circumstances a pipe will radiate noise outwards and transfer it to any lightweight ceilings, cupboards and similar areas wherever it makes contact.

PAM Acoustic dampener

All brackets within the Pam Building range meet the requirements of the most demanding standards. For high levels of acoustic performance, the standard steel brackets fitted with a new acoustic dampener should be used. The different assemblies have been tested to EN 14366: Laboratory measurements of noise from wastewater installations. The PAM acoustic dampener has been developed to meet the increasing demand for buildings to have a high level of acoustic performance above regulatory requirements.

Pipe installation fitted with acoustic dampener*

Structure-borne noise:

2 l/s < 10 dB(A)

4 l/s < 10 dB(A)

Sound insulation in bracketing



The Acoustic Dampener

The acoustic dampener is mounted between the wall or ceiling and the pipe bracket and dampens the noise generated in drainage pipe systems. It can be used with M8 and M10 thread rods.

- ❶ Dampener – elastomer EPDM
- ❷ M8-M10 – threaded nut; galvanized steel
- ❸ Stainless steel housing, A2
- ❹ Thread connection with 17 mm key value; galvanised steel

Assembly



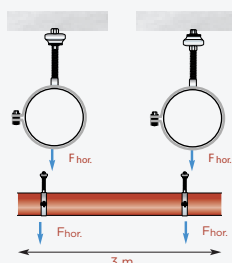
- ❶ Fasten the PAM Acoustic Dampener to the thread in the wall with an open-end wrench
- ❷ The second threaded rod connects the acoustic dampener and pipe bracket
- ❸ Fix. Finished



2 possibilities for fixing the PAM Acoustic Dampener on a Pipe Bracket:

Vertical lines

Each end of the acoustic dampener can be fixed to the bracket. For each 3 m of length minimum 1 pipe bracket must be used. For each pipe bracket 1 dampener must be used. The weight of the pipes and the resulting water pressure must be absorbed by other devices: grip collars, stack supports, etc.



Horizontal lines

Each end of the acoustic dampener can be fixed to the bracket. For each 3 m of length minimum 2 pipe brackets must be used. For each pipe bracket 1 dampener must be used. With each type of fixation, the best effect can only be achieved if the components are neither deformed nor compressed. Maximum horizontal load F per dampener: 100 daN.

Network supporting



Prohibited assembly

This mounting leads to rotation / torsion of the elastomer, which means the dampener cannot work properly and the elastomer might be cut. Therefore, this type of fixation is not allowed.



ATTENTION

This assembly causes the elastomer to twist.

Pipework stability



Stack support pipe

Pipework is subject to different forces liable to affect its stability. Stack supports are cast iron components designed to address these efforts.

On straight runs, stack support pipes should be installed to address the pipes' weight. At the bottom of the stack, the first stack support pipe addresses both the pipes' weight and the end thrust effort. For the last case, it is recommended that the support and fixings be adapted accordingly.

We recommend positioning the first stack support pipe at the base of the first floor, and then every subsequent fifth floor, in the case of a standard average 2.5 m between floors, or more generally every 15 m.

In the case of a wall or slab opening closed by mortar, thus constituting a fixed point, no stack support pipe is required.



Stack support pipe and acoustic insulation

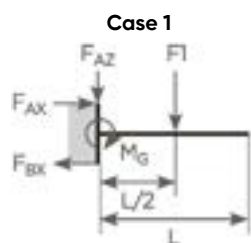
The support bracket of the stack support is covered with a rubber gasket to limit the transmission of structure-borne noise emitted by the drainage network at slab level.

During laboratory tests carried out in 2019*, a stack assembly including a stack support pipe on a console support and a rubber-lined bracket, both fixed to a wall with a surface density of 220 kg/m², showed slightly better results than the same installation made with two fixings with rubber-lined brackets. In this particular installation, the use of stack support pipes does not affect acoustic performance.

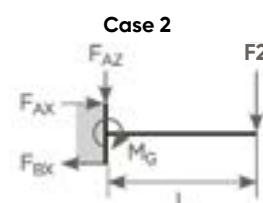
*Tests carried out according to standard EN 14366.

Pipework stability

Admissible load for stack support console

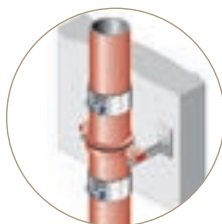


$$F_{AZ} = F1 \quad M_G = \frac{F1 \times L}{2}$$



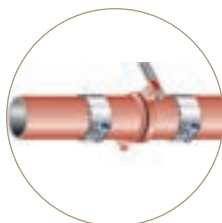
$$F_{AZ} = F2 \quad M_G = F2 \times L$$

Description	Length (mm)	Case 1 F1 (kN)	Case 2 F2 (kN)
Stack support console 262 FRK 50 Set	262	2.3	1.15
Stack support console 262 FRK 75 Set	262	2.3	1.15
Stack support console 315 FRK 100 Set	315	3.3	1.65
Stack support console 315 FRK 125 Set	315	3.3	1.65



Stack support pipe installed vertically

Either on cantilever arms or stack support consoles up to DN 125.



Stack support pipe installed horizontally

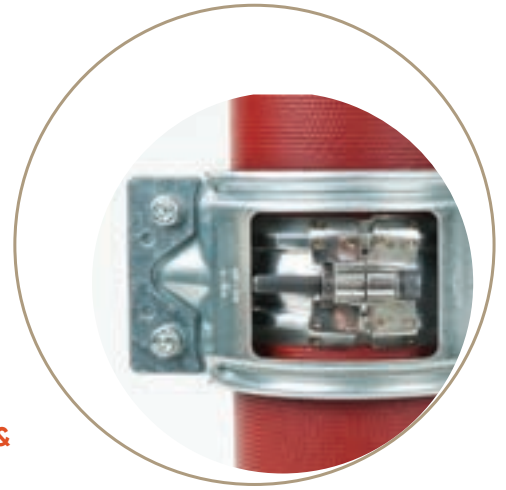
A wall bracketing system is available in mild steel, for use with stack support pipes and brackets.

Admissible load for cantilever arms

	Reference	Diameters	Length (mm)	Admissible load (F in kN)
<p>Case 1</p>	Cantilever arm 41/21/2 LG 200	50 - 75	200	1.15
	Cantilever arm 41/41/2 LG 300	100 - 125 - 150	300	3.0
	Cantilever arm 41/82/2 LG 450	200 - 250 -	450	5.0
<p>Case 2</p>	Reinforcement for cantilever arm 41/82/2 LG 450	200 - 250 - 300	450	8.0

Joining methods

Stainless steel couplings



PAM Rapid Couplings S & INOX - DN 50 to DN200

Assembly as a sleeve

Couplings are supplied pre-assembled. The PAM Rapid coupling is designed to be tightened to fully closed, or by applying the following tightening torque:

- DN 50 and DN 75: 15 Nm
- DN100: 18 Nm
- DN125 and DN150: 20 Nm.



- 1 Push the supplied assembled coupling onto the pipe spigot so that it abuts on the central register of the elastomer gasket.
- 2 Push the next pipe spigot into the other end of the coupling.
- 3 Tighten the screw to "zero gap" position, i.e. fully closed, with a ratchet spanner or electric screwdriver or apply the torque values indicated above.

DN250 to DN300

They can be assembled in two different ways, depending on whether an open strap is required.

Standard assembly:



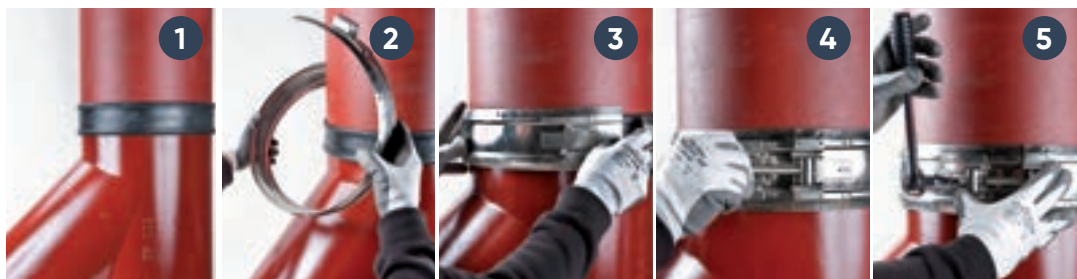
- 1 Open the stainless steel strap.
- 2 Slide the stainless steel strap loose around the first pipe component.
- 3 Push the sealing gasket onto the component spigot so it abuts on the central register of the gasket.
- 4 Push the second component into the sealing gasket, so that it abuts on the central register.
- 5 Bring the steel strap over the sealing gasket.
- 6 Tighten the bolt with a ratchet spanner or a power tool applying the following tightening torque: DN 250 and DN 300 = 25 Nm.

Stainless steel couplings

PAM Rapid S and INOX DN250 to DN300

Open strap assembly

An open strap is sometimes required to facilitate access: stack installation, etc.



Standard assembly:

- 1 Push the rubber gaskets onto the spigot ends top and bottom, ensuring the central registers are abutted against each spigot edge.
- 2 Twist the stainless steel strap to ease the wrapping around the pipe components.
- 3 Clip the bolt
- 4 Loosely assemble the coupling around the gasket.
- 5 Check the alignment of the assembly before tightening the bolt with a ratchet spanner or a power tool.



ATTENTION

Wherever couplings may be subject to end thrust forces, they must be secured with grip collars



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tutorials
Youtube



Connection to other materials

Branch connections to small diameter waste pipes

**PAM KONFIX,
the easiest solution**



Konfix

Konfix-Multi

The easiest way to connect cast iron systems to other drainage materials is to use rubber connectors or plugs. Flexible couplings and stepping rings are also available to facilitate connections where variances in diameters have to be compensated for.

Rubber transition connectors PAM KONFIX and PAM KONFIX-Multi are used to connect waste pipes made from other materials (steel or plastics) to a PAM cast iron pipe system



Insert the PAM KONFIX rubber connector loosely onto the pipe until the stop point is reached. Then secure to the pipe by tightening the hose clamp screw.



Cut the pre-cut rubber to size with a knife and remove the lid. **WARNING:** Do not cut too deep as you may damage the lip seal inside.



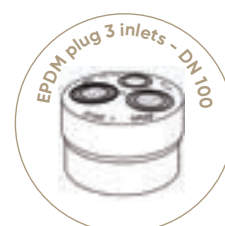
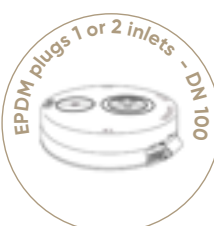
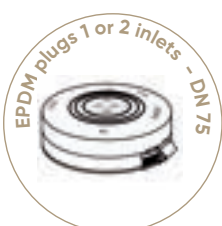
Mark the insert depth on the connecting pipe. Apply a lubricant and push in. The assembly is complete.



The connecting steel pipe illustrated here is only an example. The PAM KONFIX rubber connectors can be used to connect all waste pipe materials to the PAM cast iron systems.

EPDM plugs

The plugs can be pierced to the appropriate groove from 32 mm up to 54 mm waste connections and the center disc torn out where required.





PAM multiquick, transition connector

To connect PAM cast iron pipes with an **outside diameter of 109-112 mm** (tolerance range for PAM cast iron pipes DN 100) to other rigid materials with an **outside diameter from 72-110 mm**.

To connect PAM cast iron pipes with an **outside diameter of 109-112 mm** to waste pipes with an **outside diameter up to 115 mm** maximum. The connection is made with two hose clamps both suitable to address larger diameter tolerances.

How to assemble the PAM Multiquick connector ?

1. Push the open end of the PAM MULTIQUICK connector over the pipe end and place the hose clamp to its tightening position.
2. Then use a knife to cut open the pre-cut lid to the corresponding outside diameter of the connecting waste pipe. Then push the second hose clamp loose over the connecting rubber end.
3. Push the connecting pipe into the PAM MULTIQUICK connector and tighten the hose clamp in the right position. Ensure that the sealing zones (face ends of pipes or fittings) are clean: remove paint flakes and cement residues. The hose clamps should only be tightened manually with a screwdriver to avoid any damage to the PAM MULTIQUICK rubber connector.





**we support
you in
all your
challenges**

Cast iron to cast iron and cast iron to other materials

PAM cast iron connections to other materials may often be required in new construction projects or for renovation.

Different solutions can be used with products from our catalog (see figures below). Depending on the outside diameters, solutions exist for compensation. If you are unsure of the circumference of the material being connected, you can use a circumference tape. The range of tolerance of the different joints can help you find the required solution. The table below lists the solutions for connecting PAM cast iron to the most frequently encountered material.



PAM Rapid* +
Stepping ring (SR)



Adapting joint = AJ
Max. Pressure 0.6 bar /
Stainless steel 304



Adapting collar = AC
Max. Pressure
1.5 bar/Stainless
steel 304



Adapting collar (AC) +
Stepping ring (SR)
Max. Pressure 1.5 bar /
Stainless steel 304



A = B

*PAM Rapid can be used for type 1 installation but it may create an aesthetics default (stepping ring can exceed the width of the coupling).

DN*	Existing network material	OD** (mm)	Circumference (mm)	Admissible tolerance of couplings (mm)		Coupling type	Product code	Reference diagram
				DE	Perimeter			
50	S Range, Plus range	58	182	55-60	172-188	PAM Rapid S	210424	5
	PVC	50	157	55-60 49-52	172-188 153-163	PAM Rapid S + SR	210424 156399	1
	HDPE	50	157	55-60 49-52	72-188 153-163	PAM Rapid S + SR	210424 156399	1
75	S Range, Plus range	83	260	81-86	254-270	PAM Rapid S	210426	5
	Old cast iron	64	201	81-86 62-65 58-79	254-270 194-204 182-248	PAM Rapid S + SR	210426 156495	1
		77	241	81-86 75-79 58-79	254-270 235-248 182-248	PAM Rapid S + SR	210426 156494	1
		90	282	75-90	235-282	AC	255300	3
	PVC	75	235	81-86 75-79 58-79	254-270 235-248 182-248	PAM Rapid S + SR	210426 156494	1
		80	251	75-79	235-282	AC	255300	3
	HDPE	63	197	81-86 62-65 58-79	254-270 194-204 182-248	PAM Rapid S + SR	210426 156495	1
		75	235	81-86 75-79 58-79	254-270 235-248 182-248	PAM Rapid S + SR	210426 156494	1

*DN=Nominal Diameter **OD=External Diameter

Connection to other materials

DN*	Existing network material	OD** (mm)	Circumference (mm)	Admissible tolerance of couplings (mm)		Coupling type	Product code	Reference diagram
				DE	Perimeter			
100	S Range, Plus range	110	345	107-112	335-351	PAM Rapid S	210427	5
	Old cast iron	91	285	107-112 90-93 78-106	335-351 282-292 244-332	PAM Rapid S + SR	210427 156555	1
		104	326	100-115 78-106	314-361 244-332	AC	155002	3
		118	370	110-121	345-380	AC	TXB10NP01	3
	Ductile iron	118	370	110-121	345-380	AC	TXB10NP01	3
	Fibre cement	115	361	110-121	345-380	AC	TXB10NP01	3
	PVC	100	314	107-112 99-102 78-106	335-351 310-320 244-332	PAM Rapid S + SR	210427 156635	1
		110	345	107-112	335-351	PAM Rapid S	210427	5
	HDPE	90	282	107-112 89-92 78-106	335-351 279-288 244-332	PAM Rapid S + SR	210427 156555	1
		110	345	107-112	335-351	PAM Rapid S	210427	5
	Steel	114	358	100-115	314-361	AC	155002	3
	Sandstone	132	414	110-115 130-145	345-361 408-455	AJ	Contact us	2
	Concrete	136	427	110-115 130-145	345-361 408-455	AJ	Contact us	2
125	S Range, Plus range	135	424	133-138	417-433	PAM Rapid S	210428	5
	Old cast iron	118	370	110-125 121-136	345-387 408-427	AJ	Contact us	2
		145	455	130-150	408-471	AC	TXB12NLOG	3
	Ductile iron	144	452	130-150	408-471	AC	TXB12NLOG	3
	Fibre cement	141	442	130-150	408-471	AC	TXB12NLOG	3
	PVC and HDPE	125	392	133-138 123-127	417-433 386-398	PAM Rapid S + SR	210428 156778	1
	Steel	139	436	130-150	408-471	AC	TXB12NLOG	3
	Sandstone	159	499	121-136 144-160	379-427 452-502	AJ	Contact us	2
150	S Range, Plus range	160	502	158-164	496-514	PAM Rapid S	210429	5
	Old cast iron	145 172	455 540	130-145 155-170 150-175	408-455 486-534 471-549	AJ AC	155003 TXB15NMOJ	2 3
	Ductile iron	170	534	150-175	471-549	AC	TXB15NMOJ	3
	Fibre cement	166	521	150-175	471-549	AC	TXB15NMOJ	3
	PVC	140	439	130-145 155-170	408-455 486-534	AJ	155003	2
	PVC and HDPE	160	502	158-164	496-514	PAM Rapid S	210429	5
	Steel	168	527	150-175	471-549	AC	TXB15NMOJ	3
	Sandstone	186	584	144-160 170-193	452-502 533-606	AJ	Contact us	2
	Concrete	190	596	144-160 170-193	452-502 533-606	AJ	Contact us	2

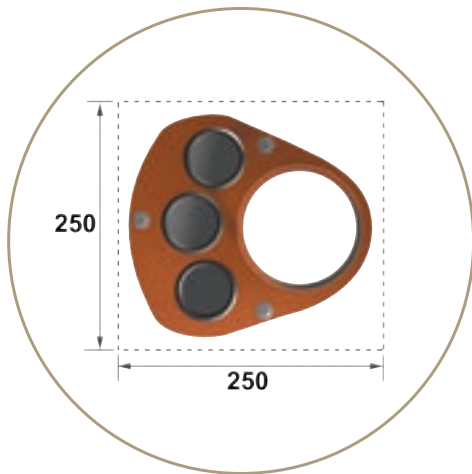
*DN=Nominal Diameter **OD=External Diameter

DN*	Existing network material	OD** (mm)	Circumference (mm)	Admissible tolerance of couplings (mm)		Coupling type	Product code	Reference diagram
				DE	Perimeter			
200	S Range, Plus range	210	659	207-213	650-668	PAM Rapid S	210430	5
	Old cast iron	172	540	170-193 210-235	534-606 659-738	AJ	155004	2
		197	618	200-225 192-201	628-706 603-631	AC + SR	TXB20NN0K	4
		218	684	200-225	628-706	AC	TXB20NL0K	3
		225	706					
	Ductile iron	222	697	200-225	628-706	AC	TXB20NL0K	3
	Fibre cement	218	684	200-225	628-706	AC	TXB20NL0K	3
	PVC and HDPE	200	628	207-213 198-202	649-668 621-634	PAM Rapid S + SR	210430 157000	1
	Steel	219	688	200-225	628-706	AC	TXB20NL0K	3
	Sandstone	242	760	204-219 238-254	640-687 747-797	AJ	Contact us	2
	Concrete	244	766	204-219 238-254	640-687 747-797	AJ	Contact us	2
250	S Range, Plus range	274	860	271-276	850-868	PAM Rapid S	228759	5
	Old cast iron	242	760	240-265 260-285	753-832 816-894	AJ	TXB25NQ0K	2
		279	876	260-285	816-894	AC	143192	2
	Ductile iron	274	860	271-276	850-868	PAM Rapid S	228759	5
	Fibre cement	274	860	271-276	850-868	PAM Rapid S	228759	5
	PVC and HDPE	250	785	271-276 248-252	850-868 778-791	PAM Rapid S + SR	228759 157085	1
	Steel	273	857	271-276	850-868	PAM Rapid S	228759	5
	Sandstone	296	929	285-310 270-290	894-973 847-910	AC + SR	TXB25NQ0L	4
300	S Range, Plus range	326	1024	323-328	1014-1031	PAM Rapid S	228771	5
	Old cast iron	312 331	980 1039	310-335	973-1051	AC	TXB30NN02	3
	Ductile iron	326	1024	323-328	1014-1031	PAM Rapid S	228771	5
	Fibre cement	329	1033	310-335	973-1051	AC	TXB30NN02	3
	PVC and HDPE	315	989	310-335	973-1051	AC	TXB30NN02	3
	Steel	324	1017	323-328	1014-1031	PAM Rapid S	228771	5
	Sandstone	350	1099	320-340 335-360	1005-1068 1051-1130	AC + SR	TXB30NQ0M	4
	Concrete	374	1174	310-335 350-375	973-1051 1099-1178	AJ	Contact us	2

*DN=Nominal Diameter **OD=External Diameter

Multiwaste

Multi-Waste Manifold Connector

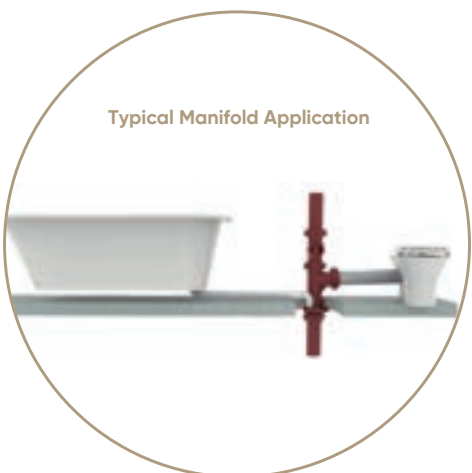
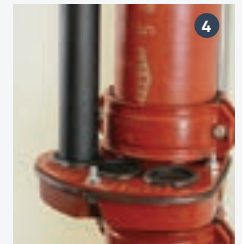
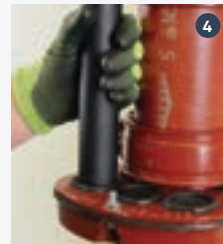
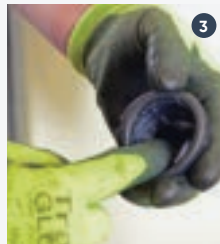
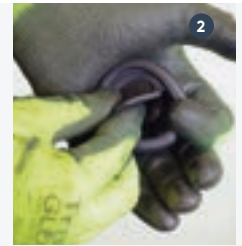
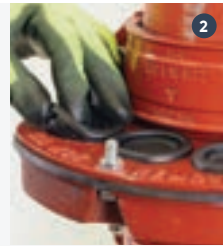
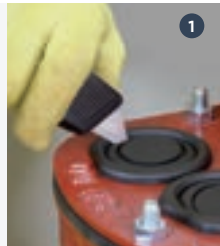


Assembly as a sleeve

The multi-waste manifold simplifies waste plumbing by grouping all associated pipework from various sources such as sinks, basins, bidets, urinals and showers to one internal point above the finished floor level. The manifold will permit the connection of three 32/38 mm copper/plastic waste inlets to any new or existing 100 mm diameter pipe stack and three 50 mm copper/plastic waste inlets to a 150 mm diameter pipe stack.

The manifold main body is connected to the stack using standard coupling. On the 100 mm manifold, to achieve a 32 mm waste connection, remove the 38 mm inner rubber ring by using the outer ring (for waste pipe maximum lengths see EN 12056-2). Pipework connecting discharge appliances to a manifold should be designed not to cause self-siphonage.

Fixing instructions



- 1 Cut the appropriate groove for 32 mm or 38 mm waste connections (100 mm manifold only), remove the grommet and tear out the centre disk where required.
- 2 Apply an appropriate silicone grease (not provided) to the outside of the grommet and re-fit into the manifold ensuring the retaining groove of the grommet is located correctly in the casing.
- 3 Lubricate the pipe ends and insert into the grommet with a rotational movement. Pipe ends may be chamfered for ease of insertion.
- 4 Any grommet not fitted with a waste pipe must also follow instruction 2 above.

Buried network



Itinero and Plus range pipe systems can be used for underground applications in contact with most soils*. Buried pipes are subject to mechanical strain due to the weight of the ground and possible wheel loading when laid under an area where traffic circulates. The mechanical performance of buried pipework is to be considered like a pipe/soil system: the interaction of the pipes with the surrounding soils depends on their stiffness or flexibility, and the type of laying condition selected. The choice of bedding and backfilling depends on the depth at which the pipes have to be laid, and the size and strength of the pipes. Standard EN 1610 "Construction and testing of drains and sewers" applies to drains normally buried in the ground and normally operating under gravity.

The hypothesis for rigid pipes retained for the calculation of admissible depth of cover is set out below.

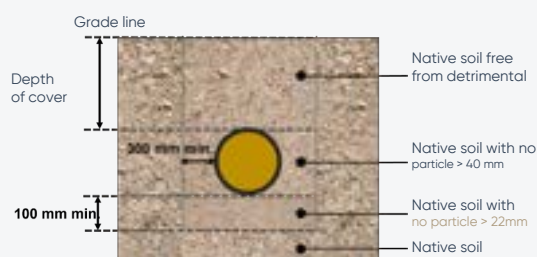
	DN 100 to DN 300
Young's modulus	110,000 N/mm ²
Poisson's ratio	0.25
Max. stress	350 N/mm ²
Strain coefficient	1.5
Buckling coefficient	2.5
Geometric defect	1.2 + DN 2,000 mm

Installation parameters are established according to:

- Soil type (see groups below)
- Quality of compaction of the embedment
- Behavior of the pipe (rigid for cast iron)
- Presence of wheel loads or not
- Particular conditions (groundwater table, etc.).

Backfilling recommendations from DN 100 to DN 300 with or without traffic loads (according to EN 1610)

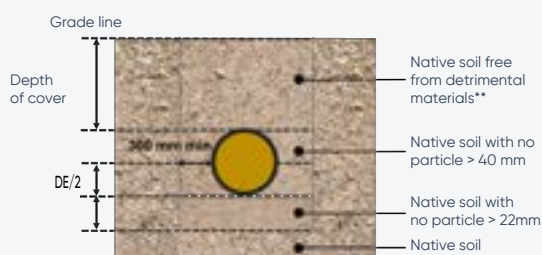
Case no.1



Two main solutions have been retained from the EN 1610 recommendations, taking into account both ease of installation and knowledge from experience of rigid pipe systems. For compaction, the most adverse hypothesis was retained.

These solutions maximise the advantage obtained from cast iron's mechanical properties: depth of cover it can withstand, possible backfilling with native soil removed, thereby limiting damage to the environment, etc.

Case no.2



*The nature of the soil in contact with the network must be homogeneous. For aggressive soils, it is recommended to use additional protection such as polyethylene couplings or other types of appropriate external coating, particularly when the nature of the soil is as follows:

- with low resistivity, less than 1,500 cm above the water table or less than 2,500 cm below ;
- with a low pH of less than 6 ;
- contaminated by organic or industrial effluents or waste.

**Detrimental materials = stones, tree roots, rubbish, organic material, clay lumps (>75 mm), snow and ice.

Buried network



Based on our experience in buried pipe systems and the French origin of our company, we have applied the French fascicule 70 calculation model (recommendations for sewage pipe systems according to the pipe material).

The table below gives values for depths of cover according to the Fascicule 70 calculation, considering rigid pipes.

Depth of cover values (m) without loads

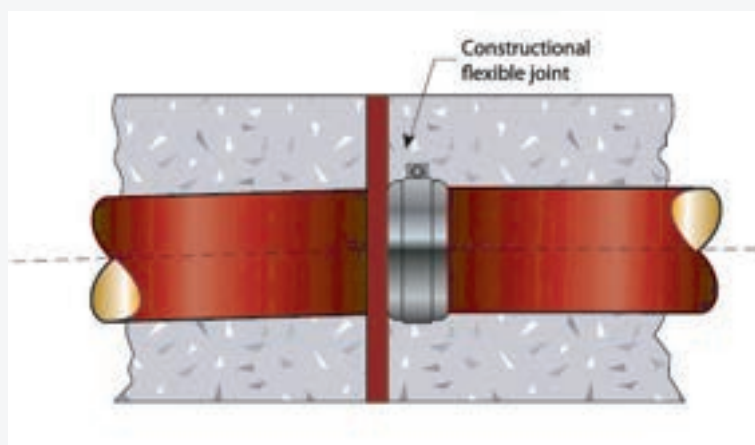
	PAM GLOBAL & ITINERO®		AGILIUM®
Min.***	0.3(1)	Min.***	0.3(1)
Max.	4.2	Max.	2.4

*** Does not take into account the frost-free arrangements.

(1) The calculation allows shallower depth of cover, but this figure includes a safety margin / ground surface proximity and related hazards.

Other precautions

- Clearance at each joint between the couplings and the granular bed to allow sufficient space, and to prevent the pipe from resting on the joints. (see EN1610 §6.5)
- Testing for pipe system leak tightness according to EN 1610 §12
- Identification of the pipework with a netting for example
- Furthermore, check that these specifications do not contravene other local or national regulations or recommendations for installation.



Installation in concrete

Where the pipe system is to be set in concrete, a minimum 2.5 cm width of concrete on every side has to be respected because during and after its curing, the concrete will be subject to shrinkage and carbonation.

To reduce the natural rigidity of the concrete and its strain, a suitable flexible joint can be installed at intervals. This could be made of a compressible material (e.g. expanded polystyrene), be placed next to a pipe joint, and conform to the full cross section of the concrete. (See Fig). Refer to local best practice.

Furthermore, the pipe system should not be in contact with the concrete's metal reinforcements. Surround should not be carried out until the pipework has been tested and inspected.



The **epams® system** is a combination of cast iron pipes, fittings and accessories, jointed with PAM Rapid couplings or couplings able to withstand a negative pressure of -900 mbar.

The system is under French Technical Approval 5.2/14-2386_V2 CSTB.



Operating mode

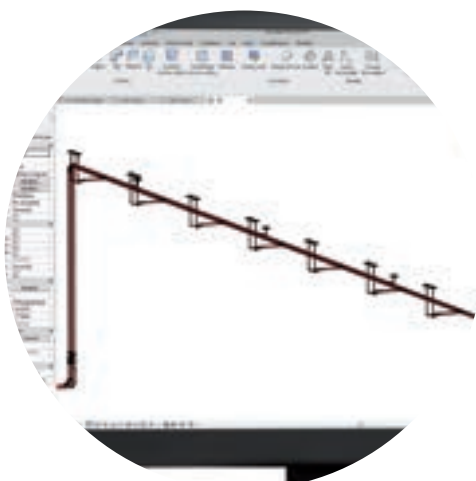


- 1 No rain
- 2 Rainfall starts at low intensity – Drainage is performed by gravity flow
- 3 Continuous flow is achieved according to the rainfall intensity and roof area drained
- 4 Rainfall intensity increases to the maximum DRI – Flow continues by gravity until the maximum value is reached
- 5 No more air entering the system – Kinetic and pressure energies enhance the absorbing capacity quickly to the maximum design flow rate
- 6 Rainfall intensity stabilises to max. value => absorbing siphonic flow rate is maintained
- 7 Rainfall intensity decreases – Flow comes back to gravity system
- 8 Rainfall intensity stabilises to low value => absorbing gravity flow rate is maintained
- 9 No more rain – the rooftop surface is emptying

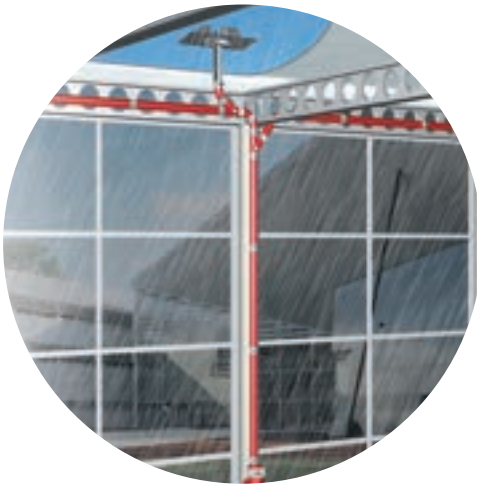
Design service

A siphonic roof drainage system is truly an «engineered system» which must be designed with careful and expert analysis. The pipework design is the key factor for performance and operational safety.

Pam Building sales staff, trained in the epams® system, first evaluate your roof drainage project. When feasibility is confirmed, a technical team designs both the technical study and network sizing using the dedicated epams® software.



Buried network

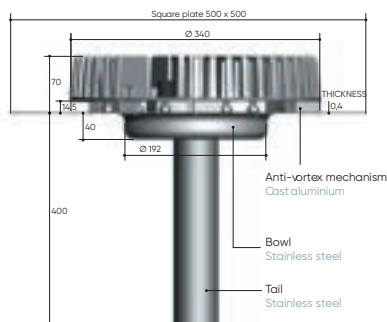


The system must always be properly balanced and the flow velocity controlled. To protect the lifespan of the epams® siphonic systems, the Pam Building design maintains that the dynamic pressure within the system should never exceed 5 bar.

Trained staff specifically in charge of your design will handle your siphonic project until the work's acceptance; each change to the plans results in the need for a new study.

Before the acceptance of the work, Pam Building or a delegated third party checks on site that the installation fully complies with the last study isometric drawings; any modification to an epams® pipework route at the installation stage requires further approval from Pam Building. This thorough management of the epams® projects – feasibility study, project follow-up and control after installation completion – ensures the epams® system's efficiency and provides the project manager with total peace of mind.

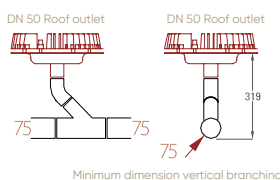
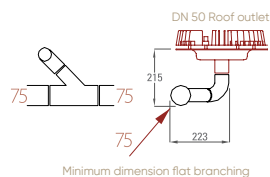
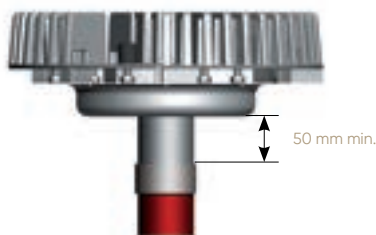
100% metal outlets



The epams® outlets are made of 3 different parts:

- The Anti-Vortex mechanism, aluminium grating. Bolted on the bowl, it is the same for all the outlets.
- An identical stainless steel bowl for all the outlets, on which different components can be assembled depending on the field of use.
- A stainless steel tail available in four DN: 50 – 75 – 100 – 125.

Installation



The epams® outlets are easy to install. The installation has to be done in accordance with best practice and the Technical Approval requirements. Pam Building epams® 100% metal outlets fully guarantee mechanical strength and durability. They fully comply with EN 1253 on each specific point: flow capacity, watertightness, solidity, mechanical strength, heat resistance and climatic stresses (resistance to UV radiation).

The grating and anti-vortex mechanism are made in one piece. This allows quick removal with no risk of mistakes at reassembly, easy intervention and maintenance.

epams® siphonic roof drainage pipework

An epams® pipework consists of one or several horizontal pipes without fall connected to a downpipe: horizontal runs and stacks are made of S range cast iron components. The joints are generally made with PAM Rapid or equivalent couplings.

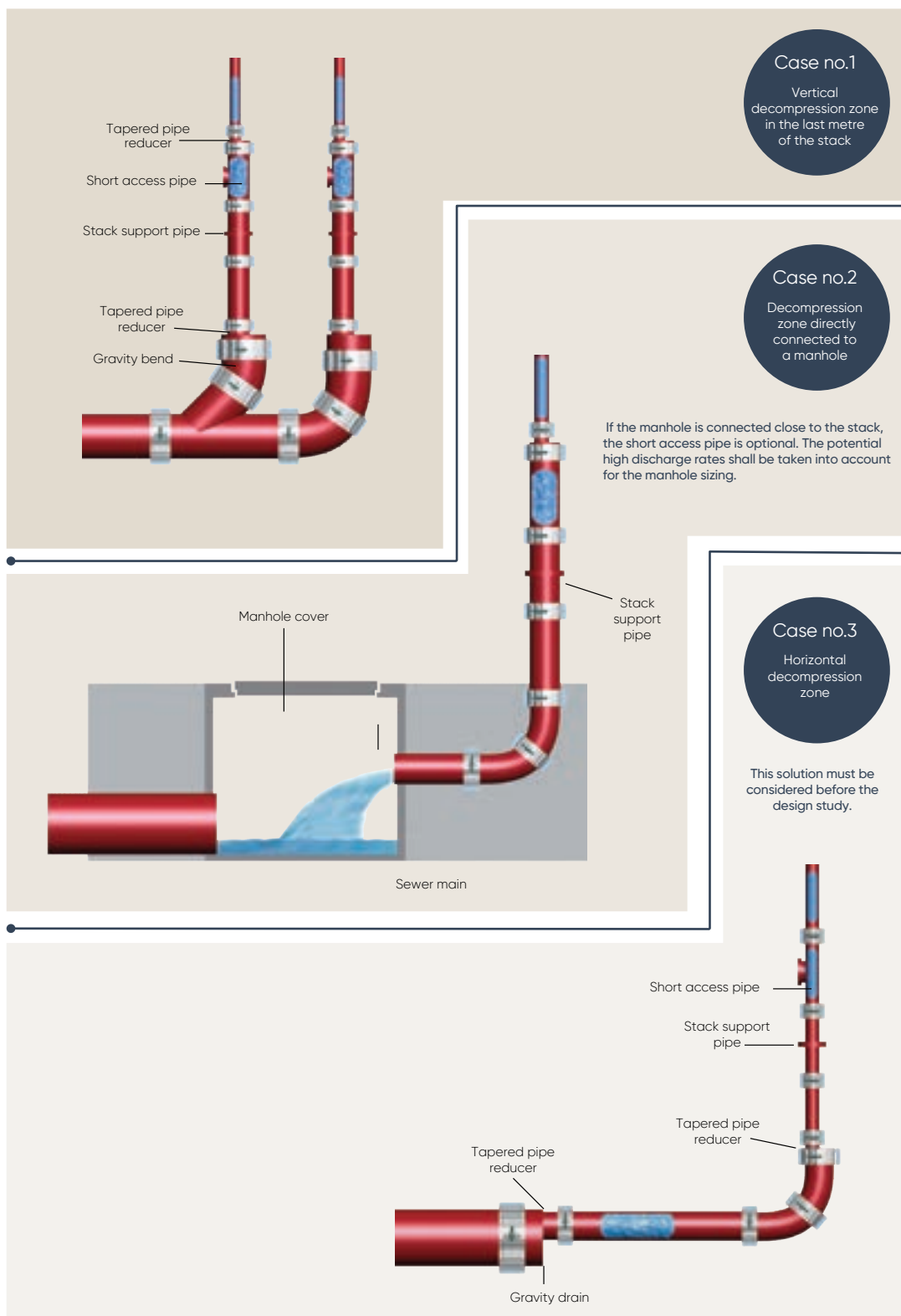
Connection of the roof outlets to the pipe system

Depending on the job site constraints, the connection can be made flat or vertical.

Decompression zone

Before connecting to the sewer main, siphonic systems have to run by gravity again.

At the end of the downpipe, the bottom pipe increases in diameter – generally two extra diameters – causing decompression and reducing the flow velocity.



Buried network



Pipe support

Stack support pipes are installed at the bottom of stacks to address forces due to changes in the stream flow systems. Every 15 metres is the general requirement.

Pipe brackets

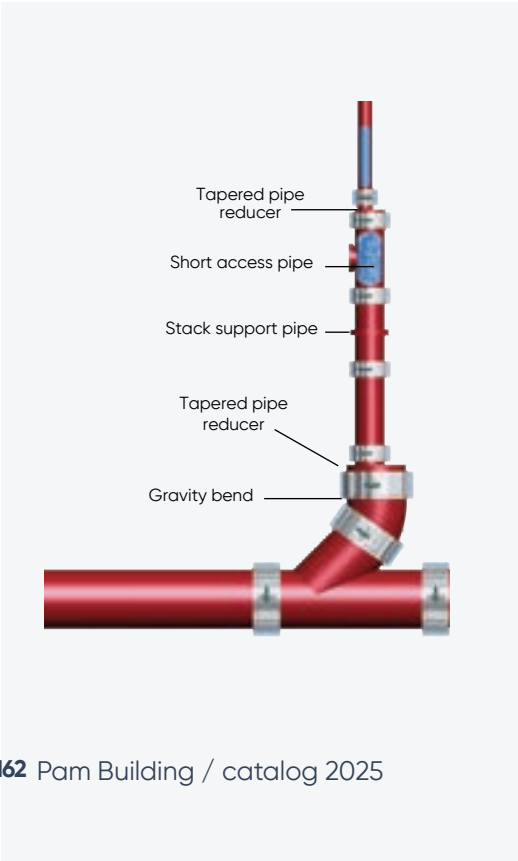
Owing to the high discharge rates, rubber-lined steel brackets are compulsory. Two brackets per pipe length shall be installed for horizontal or vertical pipework. It is also recommended to use one bracket per length or fitting (when the shape allows it, i.e. branches, etc.).

For the epams® siphonic system, only round full and rubber-lined brackets shall be used. For brackets fixed to plain threaded rods, the distance between the bearing structure (concrete slab, steel frame, etc.) and the axis of the pipe shall not exceed 500 mm. If this maximum distance cannot be respected, the rigidity of the fixings should be increased (triangulation, steel knee brace). Check local requirements for compliance.

Number of brackets		
Vertical run	Pipes	2
	Fittings*	1
Horizontal run	Pipe length > 2 m	2
	Pipe length < 2 m	1
	Fittings*	1

* When the shape of the fitting permits

Specific points of the network



Gripped couplings

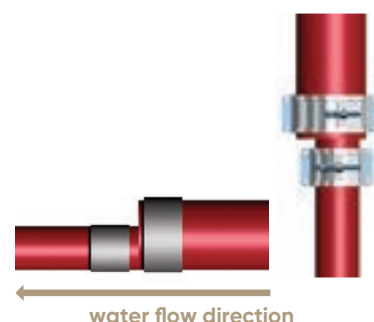
On epams® pipework, grips collars are specified on couplings where they will withstand dislocation forces.



- Horizontal pipe connected to the outlet when the expected pressure is over 0.5 bar or -0.5 bar.
- The negative pressure will be highest at the head of the stack (down to -0.9 bar); the couplings there will be systematically installed with grip collars.
- Change of direction: at changes of direction on stacks and low collectors, the couplings will be gripped. Where a change of direction will be added or removed, Pam Building will carry out a new study taking the new head loss into account.
- The decompression zone is subject to turbulences, and subsequently, every component at the bottom of the stack, before the return to the gravity flow system, will be gripped.

Reduction of flow sections

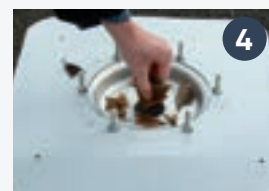
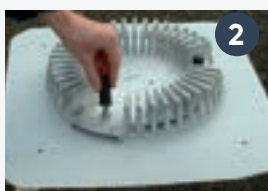
Achieving balance of potential energy and head losses on the pipework can require a reduction in the nominal diameters to increase head losses. The regulations state that reducing the nominal diameter (DN) of discharge pipes is prohibited in the direction of flow except for useful to control the pressure level. Increases and reductions of nominal diameters are made with the tapered pipe reducer. On horizontal runs, the pipe reducer will be installed so that the pipe invert is continuous.



Maintenance general features

Keeping the roof outlets clean is key to keeping an epams® siphonic system in good working order.

- The Technical Approval recommends they should be cleaned at least twice a year.
- Any element like plant matter (leaves, twigs, etc.) or debris from the surroundings can end up on rooftops, and must be regularly cleared away to prevent clogging of the pipework or epams® outlets.
- Maintenance cleaning frequency will largely depend on the building's environment.
- For buildings surrounded by trees and gardens, inspections will be done more frequently and the maintenance rate will be higher than the standard twice yearly requirement.
- For all types of roof outlets, the cleaning process must be carried out as described opposite.



- 1 Ensure the leafguard grid is in place. Clean the leafguard grid.
- 2 Remove the nut caps.
- 3 Unscrew the nuts and lift the leafguard grid to remove it.
- 4 Clean the inside of the roof outlet bowl.

General installation instructions

Installation features

Preparation

Cast iron pipe systems for drainage mainly consist of spigot pipes – generally supplied in 3 m lengths – and fittings of various shapes (bends, branches, etc.). The cast iron pipes can be cut to length. Where pipes are cut on site, ends shall be cut clean and square with burrs removed, and then re-coated with the adequate EXTREM 1 touch-up paints, or other repair products recommended by Pam Building.

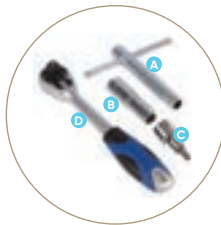
Recommended tools



Extrem 1
Touch-up paint

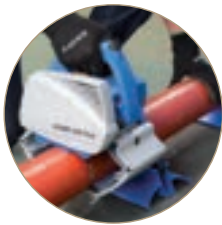


Cordless Drill



A – T-Box Spanner
B – 13 mm Deep Socket
C – Allen Key Socket
Adapter
D – Ratchet Spanner




Recommended to cut the pipe



Exact saw



Chop saw

	 Pipe cutter	 Exact saw	 Powered disc cutter
S and Plus ranges			
DN50			
DN75			
DN125			
DN150			
DN200			
DN250			
DN300			
DN400			
DN500			
DN600			

Cutting techniques

Pipes can be cut easily and quickly using either of the following methods. Cutting procedures must comply with the safety guidelines provided in the cutting tool manufacturer’s operating manual.

Coating cut ends

Pipe ends needed to be recoated with touch-up paint. We recommend protecting the cut ends with XTREM1, a new quick drying touch-up paint that air dries in 15 minutes.

Overpainting method



The acrylic paint on the pipes is a primer which can be over painted with most top coats. Finishing paint is needed where the pipework is visible, indoor or outdoor.

What types of paint can be used?

Any alkyd resin or glycerophthalic paint designed for metal care and suitable for the requirements of the local environment. The system should be gently rubbed down with suitable abrasive paper to provide a good adhesion key for the finishing coating. Where the finishing paint is to be used on zinc-coated pipes to rejuvenate them, rub them down gently to remove possible zinc salts.

Where incipient rust has already appeared on cast iron products, corrosion inhibitors can be used before painting. Some existing metal finishes, including anti-corrosive pigment, can be applied directly to rust.

The Exact saw

the ultimate and fast solution for cutting 50-150 mm cast iron

- Easy, secure and effortless cutting for use on construction sites
- Wide range of applications and dimensions
- No rework necessary – accurate cutting
- Suitable for clamping joints
- Reduction in tool costs
- Reduction in sparks – may not require hot works permit.

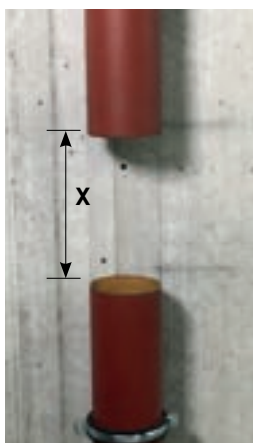


General installation instructions

Modifications to an existing installation

Typical example of a spigot system

- Measure the length of the branch, adding a further 15 mm in total to allow for the coupling's central register top and bottom.
- Make sure existing pipework is adequately supported from above.
- Mark the pipe position for cutting.
- Cut the pipe using a powered disc cutter or wheel cutter and remove sharp edges.
- Coat the cut ends with the appropriate touch-up product.
- Push the rubber gaskets onto the spigot cut ends top and bottom, ensuring the central registers are abutted against each spigot edge.
- Position the fitting in the stack within each rubber gasket abutting against the central registers.
- Loosely assemble the coupling around each gasket.
- Check alignment of assembly before tightening the bolts to the recommended level, depending on the coupling's technical recommendations.



$X = \text{fitting} + 15 \text{ mm}$



Discharge capacity

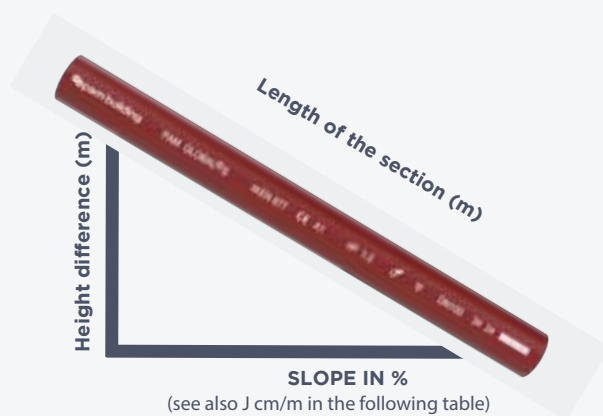
Application

For the dimensioning of rainwater and wastewater systems, the nominal sizes can be determined using the dimensioning tables in the appendix of DIN 19522. These tables only represent the discharge capacity of the smallest permissible inner diameter of the values specified.

If the pipe material is known at the latest during the execution planning, the specific discharge capacities should be determined for a differentiated calculation on the basis of the actual internal diameter of the respective drainage pipe system should be used for a differentiated calculation.

Example of wastewater pipe filling Level h/d = 1.0 WITH SLOPE 1 cm/m

DN	Drainage pipes	DIN 1986-100, A3	DIFFERENCE
100	3,0 l/s	2,5 l/s	+20%
125	5,3 l/s	3,9 l/s	+36%
150	8,5 l/s	7,7 l/s	+10%



CALCULATE THE SLOPE:

$$\text{SLOPE IN \%} = \frac{\text{HEIGHT DIFFERENCE}}{\text{LENGTH OF THE TRACK}} \cdot 100$$

Discharge capacity

Discharge capacity of PAM pipes according to EN 877 and DIN 19522

Filling level 50% ($h/di=0.5$)

	DN 75 di = 75		DN 100 di = 103		DN 125 di = 127		DN 150 di = 152		DN 200 di = 200		DN 250 di = 263		DN 300 di = 314	
J	Q	v	Q	v	Q	v	Q	v	Q	v	Q	v	Q	v
cm/m	l/s	m/s	l/s	m/s	l/s	m/s	l/s	m/s	l/s	m/s	l/s	m/s	l/s	m/s
0.5	0.9	0.4	2.1	0.5	3.7	0.6	6.0	0.7	12.5	0.8	25.8	1.0	41.3	1.1
0.6	1.0	0.4	2.3	0.6	4.1	0.6	6.6	0.7	13.7	0.9	28.3	1.0	45.3	1.2
0.7	1.1	0.5	2.5	0.6	4.4	0.7	7.1	0.8	14.8	0.9	30.6	1.1	48.9	1.3
0.8	1.1	0.5	2.7	0.6	4.7	0.7	7.6	0.8	15.8	1.0	32.7	1.2	52.3	1.4
0.9	1.2	0.6	2.9	0.7	5.0	0.8	8.1	0.9	16.8	1.1	34.7	1.3	55.5	1.4
1.0	1.3	0.6	3.0	0.7	5.3	0.8	8.5	0.9	17.7	1.1	36.6	1.3	58.5	1.5
1.1	1.4	0.6	3.2	0.8	5.5	0.9	8.9	1.0	18.6	1.2	38.4	1.4	61.4	1.6
1.2	1.4	0.6	3.3	0.8	5.8	0.9	9.4	1.0	19.4	1.2	40.1	1.5	64.2	1.7
1.3	1.5	0.7	3.4	0.8	6.0	1.0	9.7	1.1	20.2	1.3	41.8	1.5	66.8	1.7
1.4	1.5	0.7	3.6	0.9	6.3	1.0	10.1	1.1	21.0	1.3	43.4	1.6	69.3	1.8
1.5	1.6	0.7	3.7	0.9	6.5	1.0	10.5	1.2	21.7	1.4	44.9	1.7	71.8	1.9
1.6	1.6	0.7	3.8	0.9	6.7	1.1	10.8	1.2	22.4	1.4	46.4	1.7	74.1	1.9
1.7	1.7	0.8	3.9	0.9	6.9	1.1	11.1	1.2	23.1	1.5	47.8	1.8	76.4	2.0
1.8	1.7	0.8	4.1	1.0	7.1	1.1	11.5	1.3	23.8	1.5	49.2	1.8	78.7	2.0
1.9	1.8	0.8	4.2	1.0	7.3	1.2	11.8	1.3	24.5	1.6	50.6	1.9	80.8	2.1
2.0	1.8	0.8	4.3	1.0	7.5	1.2	12.1	1.3	25.1	1.6	51.6	1.9	82.9	2.1
2.5	2.0	0.9	4.8	1.2	8.4	1.3	13.5	1.5	28.1	1.8	58.0	2.1	92.8	2.4
3.0	2.2	1.0	5.3	1.3	9.2	1.5	14.8	1.6	30.8	2.0	63.6	2.3	101.7	2.6

di = internal diameter J = gradient Q = volume flow rate v = flow velocity

Discharge capacity of PAM pipes according to EN 877 and DIN 19522

Filling level 70% ($h/di=0.7$)

	DN 75 di = 75		DN 100 di = 103		DN 125 di = 127		DN 150 di = 152		DN 200 di = 200		DN 250 di = 263		DN 300 di = 314	
J	Q	v	Q	v	Q	v	Q	v	Q	v	Q	v	Q	v
cm/m	l/s	m/s	l/s	m/s	l/s	m/s	l/s	m/s	l/s	m/s	l/s	m/s	l/s	m/s
0.5	1.5	0.5	3.6	0.6	6.2	0.7	10.1	0.7	20.8	0.9	43.1	1.1	68.9	1.2
0.6	1.7	0.5	3.9	0.6	6.8	0.7	11.0	0.8	22.9	1.0	47.2	1.2	75.5	1.3
0.7	1.8	0.5	4.2	0.7	7.4	0.8	11.9	0.9	24.7	1.1	51.1	1.3	81.6	1.4
0.8	1.9	0.6	4.5	0.7	7.9	0.8	12.7	0.9	26.4	1.1	54.6	1.3	87.3	1.5
0.9	2.1	0.6	4.8	0.8	8.4	0.9	13.5	1.0	28.0	1.2	58.0	1.4	92.6	1.6
1.0	2.2	0.7	5.1	0.8	8.8	0.9	14.3	1.1	29.6	1.3	61.1	1.5	97.6	1.7
1.1	2.3	0.7	5.3	0.9	9.3	1.0	15.0	1.1	31.0	1.3	64.1	1.6	102.4	1.8
1.2	2.4	0.7	5.5	0.9	9.7	1.0	15.6	1.2	32.4	1.4	67.0	1.6	107.0	1.8
1.3	2.5	0.7	5.8	0.9	10.1	1.1	16.3	1.2	33.8	1.4	69.7	1.7	111.4	1.9
1.4	2.6	0.8	6.0	1.0	10.5	1.1	16.9	1.2	35.0	1.5	72.4	1.8	115.6	2.0
1.5	2.7	0.8	6.2	1.0	10.9	1.1	17.5	1.3	36.3	1.5	74.9	1.8	119.7	2.1
1.6	2.7	0.8	6.4	1.0	11.2	1.2	18.1	1.3	37.5	1.6	77.4	1.9	123.7	2.1
1.7	2.8	0.9	6.6	1.1	11.6	1.2	18.6	1.4	38.6	1.6	79.8	2.0	127.5	2.2
1.8	2.9	0.9	6.8	1.1	11.9	1.3	19.2	1.4	39.8	1.7	82.1	2.0	131.2	2.3
1.9	3.0	0.9	7.0	1.1	12.2	1.3	19.7	1.5	40.9	1.7	84.4	2.1	134.8	2.3
2.0	3.1	0.9	7.2	1.2	12.5	1.3	20.2	1.5	41.9	1.8	86.6	2.1	138.3	2.4
2.5	3.4	1.0	8.0	1.3	14.0	1.5	22.6	1.7	46.9	2.0	96.9	2.4	154.7	2.7
3.0	3.8	1.1	8.8	1.4	15.4	1.6	24.8	1.8	51.4	2.2	106.1	2.6	169.6	2.9

di = internal diameter J = gradient Q = volume flow rate v = flow velocity

Discharge capacity

Discharge capacity of PAM pipes according to EN 877 and DIN 19522

Filling level 100% ($h/d_i=1.0$)

	DN 75 di = 75		DN 100 di = 103		DN 125 di = 127		DN 150 di = 152		DN 200 di = 200		DN 250 di = 263		DN 300 di = 314	
J	Q	v	Q	v	Q	v	Q	v	Q	v	Q	v	Q	v
cm/m	l/s	m/s	l/s	m/s	l/s	m/s	l/s	m/s	l/s	m/s	l/s	m/s	l/s	m/s
0.5	1.8	0.4	4.2	0.5	7.4	0.6	12.0	0.7	24.9	0.8	51.6	1.0	82.6	1.1
0.6	2.0	0.4	4.7	0.6	8.2	0.6	13.2	0.7	27.4	0.9	56.6	1.0	90.5	1.2
0.7	2.1	0.5	5.0	0.6	8.8	0.7	14.2	0.8	29.6	0.9	61.2	1.1	97.8	1.3
0.8	2.3	0.5	5.4	0.6	9.4	0.7	15.2	0.8	31.6	1.0	65.4	1.2	104.6	1.4
0.9	2.4	0.6	5.7	0.7	10.0	0.8	16.2	0.9	33.6	1.1	69.4	1.3	111.0	1.4
1.0	2.6	0.6	6.0	0.7	10.6	0.8	17.1	0.9	35.4	1.1	73.2	1.3	117.1	1.5
1.1	2.7	0.6	6.3	0.8	11.1	0.9	17.9	1.0	37.1	1.2	76.8	1.4	122.8	1.6
1.2	2.8	0.6	6.6	0.8	11.6	0.9	18.7	1.0	38.8	1.2	80.3	1.5	128.3	1.7
1.3	2.9	0.7	6.9	0.8	12.1	1.0	19.5	1.1	40.4	1.3	83.6	1.5	133.6	1.7
1.4	3.1	0.7	7.2	0.9	12.5	1.0	20.2	1.1	41.9	1.3	86.7	1.6	138.7	1.8
1.5	3.2	0.7	7.4	0.9	13.0	1.0	20.9	1.2	43.4	1.4	89.8	1.7	143.6	1.9
1.6	3.3	0.7	7.7	0.9	13.4	1.1	21.6	1.2	44.9	1.4	92.8	1.7	148.3	1.9
1.7	3.4	0.8	7.9	0.9	13.8	1.1	22.3	1.2	46.3	1.5	95.6	1.8	152.9	2.0
1.8	3.5	0.8	8.1	1.0	14.2	1.1	22.9	1.3	47.6	1.5	98.4	1.8	157.3	2.0
1.9	3.6	0.8	8.3	1.0	14.6	1.2	23.6	1.3	48.9	1.6	101.1	1.9	161.7	2.1
2.0	3.7	0.8	8.6	1.0	15.0	1.2	24.2	1.3	50.2	1.6	103.8	1.9	165.9	2.1
2.5	4.1	0.9	9.6	1.2	16.8	1.3	27.1	1.5	56.2	1.8	116.1	2.1	185.6	2.4
3.0	4.5	1.0	10.5	1.3	18.4	1.5	29.7	1.6	61.6	2.0	127.2	2.3	203.3	2.6

di = internal diameter J = gradient Q = volume flow rate v = flow velocity

General terms & conditions of sale

Article 1 - GENERAL PROVISIONS

These Terms and Conditions of Sale ("T&Cs") cancel and replace those previously communicated. They apply to any order placed by a client ("Client") to Pam Building, a company organized and existing under the laws of the French Republic with a share capital of 6 812 970,75 € with its registered office at 21 avenue Camille Cavallier in Pont-à-Mousson (54700), France registered with the Register of Commerce of Nancy under number 799 283 882 ("Pam Building"), for the sale of Pam Building's goods and services ("Products").

Any order made by the Client implies its adherence to these terms and conditions of sale. The Client's purchasing conditions shall not take precedence over these terms and conditions of sale unless first agreed in writing by Pam Building. Any prior written acceptance of the latter by Pam Building may only be intended, where applicable, to supplement these conditions in the event of their silence.

Pam Building reserves the right to amend its T&Cs at any time, the applicable T&Cs being those in force on the date of the order sent by the Buyer.

Article 2 - ORDERS - ACCEPTANCE

2.1 - Each order for Products must be identified as an order and must include the necessary information for its processing, in particular sufficient accurate information on the branding, delivery and listing of the range, in order to allow Pam Building to process this order as best possible. In case of insufficient or inaccurate information, Pam Building may delay the shipping date of Products, without prejudice to any other solution.

2.2 - Orders do not become firm and final until Pam Building has issued an acknowledgement of receipt. No modification or cancellation of an order shall be taken into account after the issue of the acknowledgement of receipt of the order. Unless otherwise provided between the parties, Pam Building's silence does not constitute acceptance of an order.

Article 3 - PRICING

3.1 Products are sold under the conditions and

for the prices currently applicable on the effective delivery date or, where there is an offer, the prices indicated in relation to it, insofar as the order is received by Pam Building within the period of validity of that offer.

3.2 Where Pam Building issues an offer, prices are firm throughout the duration of the offer or for a maximum duration of two (2) months following the issue date of that offer. After this period, price increases may be applied.

3.3 Prices may be modified by Pam Building at any time with a notice period of thirty (30) days.

3.4 Unless specifically agreed, prices are expressed in euros, net, excluding VAT. If applicable according to the Products destination, these prices are billed after application of value added tax at the rate in force. Pam Building shall be entitled to recover any tax, duty or increase arising from a change to regulations or legislation, from its entry into force.

Article 4 - DELIVERY

4.1 Our delivery times are mentioned as an indication, and correspond to our best estimate. Delivery times are only firm when they are expressly classified as such in the order acknowledgement.

4.2 Non-respect of the indications relative to the delivery time does not authorise the Client to cancel their order, to delay payment beyond the agreed conditions or to withhold or offset any part of it.

4.3 No late penalty may be claimed from Pam Building if it has not been expressly agreed with regard to its principle and its terms in the order acknowledgement.

4.4 Pam Building is not responsible for breached delivery times where:

- the Client has not respected the payment conditions; or
- where information to be provided by the Client has not arrived within the required time;

4.5 The transfer of ownership of the Products to the Client is conditional upon payment of the price in full.

4.6 Risk is transferred under the conditions defined by the chosen Incoterm (Incoterms

published by Paris International Chamber of Commerce in force on the effective delivery date, the "Incoterms") or where Products are customised and covered by the carrier.

4.7 In the absence of specific conditions agreed beforehand and confirmed in the order acknowledgement by Pam Building, the Products are sold Free Carrier (FCA - Incoterms® 2020) from Pam Building's shipping site.

4.8 For any exit from the European Union territory made by the Client or the forwarding agent designated by the Client, as proof of exit, the Export Control System ("ECS") of exit must be sent to Pam Building. In the event that the ECS cannot be provided, the Client or its forwarding agent may send to PAM BUILDING, the Bill of lading for shipment by sea or the Airway Bill for shipment by air or the CMR Way Bill with receiver's signature and stamp or the Delivery note with receiver's signature and stamp.

Article 5 - INSPECTION

5.1 Products are inspected in the factory according to Pam Building's quality control procedures and the standards in force.

5.2 In cases where a special inspection has been agreed, by the Client or an organisation representing it, the inspectors in charge are advised of the dates and times in which inspections must normally take place.

Article 6 - TRANSPORT

6.1 Where the Client organises transport itself, it assumes the restrictions of adapting vehicles to Products and the obligation to make an appointment 48 hours in advance. Otherwise, the delivery cannot be loaded.

6.2 The Client is responsible for unloading operations carried out under its control. In this regard, the Client must ensure respect for safety conditions on site and provide suitable means to allow unloading in the best possible safety conditions. In particular, in case of a delivery by truck crane, the Client shall assist the driver by separating pipes and packages on the ground. The Client must establish a

General Terms & Conditions of Sale

safety protocol with the carrier prior to unloading.

6.3 In case of lost, damaged or missing Products observed upon delivery, the Client shall take recourse against the carrier, stating its reservations on the transporter's delivery form. It will confirm these reservations with the carrier, by registered letter with acknowledgement of receipt, addressing its claim with supporting documentation within 3 business days following receipt of the Products.

Article 7 – PAYMENT CONDITIONS

7.1 Unless otherwise indicated, payments are made at the address stated on the invoice, within forty-five (45) days from end of the month following the invoice issue date, independently from the date of receipt of the Products by the Client.

7.2 Drafts accepted must be returned within 10 days following their issuance. This deadline also applies to means of payment issued by the Client.

7.3 Any payment made after the payment date stated on the invoice shall allow the billing of (i) late penalties at a rate equal to the interest rate applied by the European Central Bank to its refinancing operation plus 10 percentage points and (ii) a fixed charge for recovery costs, of a sum of €40; Pam Building reserves the right to seek additional compensation, upon justification, in the event that its recovery costs exceed this amount.

7.4 In case of non-payment of an outstanding invoice, all of the invoices in arrears shall become immediately payable. In addition, Pam Building reserves the right to suspend orders in progress, without prejudice to damages and interest.

7.5 No claim by the Client may invoke the modification, delay or suspension of payments due, or authorise it to offset or deduct payments against those owed to Pam Building. Any offsetting or deduction not agreed beforehand shall constitute a payment incident justifying the application of the above measures.

7.6 In the event of a significant change to the Client's legal or financial situation, affecting Pam Building's assessment of its solvency, or in case of an excessive outstanding amount, Pam Building reserves the right even after partial execution of an order to either demand guarantees or cancel the outstanding orders.

Article 8 – GUARANTEE FOR PRODUCTS

8.1 Without prejudice to the measures to be taken with regard to the carrier, claims in relation to the non-conformity of delivered Products with those listed on the order acknowledgement must be submitted in writing within 3 days from receipt of the Products. After this time, no claims shall be accepted.

8.2 Pam Building guarantees the Client against hidden defects that may affect the sold Products. If the Client detects a manufacturing fault in the Product, in its opinion constituting a hidden defect, it must send a claim to Pam Building immediately.

8.3 The implementation of the guarantee for conformity and hidden defect is conditional upon these faults being jointly observed and acknowledged as effectively attributable to Pam Building. The Client will provide all justifications as to the reality of the faults found. It shall facilitate Pam Building in observing these faults and remedying them. The Client shall abstain from interfering with the Products.

8.4 An observation of the fault will then be conducted, within 1 month –with everything as is, except in case of force majeure – in a report in the presence of Pam Building's representatives.

8.5 If the existence of a fault is jointly found and recognised by Pam Building as being effectively attributable to it, Pam Building shall assume the repair of the Product or supply a replacement of the Product previously delivered, and the corresponding shipping costs.

8.6 The Client is obliged under its exclusive responsibility to respect the indications given by Pam Building as well as the industry standards for the compliant handling and use of the Products as well as all technical instructions.

8.7 The guarantee given is excluded in case of:

- apparent defect, or that which a professional would discover;
- defect and/or deteriorations caused by natural wear or by an external accident;
- modification of the Product not provided for or specified by Pam Building;
- defect and/or deteriorations caused by a compatibility fault against Products not provided by Pam Building;
- non-respect by the Client of the indications concerning handling, fitting, use and maintenance of Products as well as industry standards;
- force majeure or similar event.

8.8 The guarantee given by Pam Building is for 12 months from delivery. Interventions conducted in relation to the guarantee shall not result in extending this period.

ARTICLE 9 – LIABILITY

9.1 Pam Building warrants that its Products comply with their specifications at the date at which they are placed at Client's disposal. Specifications, performances and technical characteristics stated in catalogs, technical brochures and any other commercial documentation and packaging are subject to revision at any time without any prior notice to the Client. Characteristics and colours of Pam Building's Products have an indicative value due to their nature of manufacturing.

9.2 Client recognizes that he is aware of the technical characteristics of the Products as well as their conditions of use and application, defined in particular by the rules of the art and the current technical documentations. For the avoidance of doubt, the Client shall conduct prior and sufficient tests to verify that the Products meet its requirements.

9.3 Pam Building's liability is limited to the supply of the Products complying with Pam Building's specifications to the exclusion of any consequence of an improper, careless or inadequate use which remains under the exclusive responsibility and liability of the Client.

9.4 Pam Building's liability is limited to the replacement or reimbursement of the Products proved to be defective, without indemnification or compensation relating to transport or labour costs to be due to the Client. No responsibility or liability shall be accepted for any statement, representation, warranty or otherwise made by any of Pam Building representative, agent or distributors.

Article 10 – INDUSTRIAL PROPERTY

The plans, models, studies, results of trials, catalogs, notices and all commercial and technical documents disseminated on any support whatsoever, by Pam Building are the exclusive property of Pam Building. As a result, the Client is prohibited from making any copy whatsoever without Pam Building's prior agreement.

Article 11 – MANUFACTURE – RECOMMENDATION

11.1 The weights and dimensions of Products indicated on Pam Building's documents are theoretical in value. Pam Building reserves the right to make any modification to the information given in its documentation.

11.2 The documents regarding the handling, storage, fitting, use and maintenance of Products are provided by Pam Building free of charge, at the Client's request. The Client remains solely responsible for compliance with the health and safety conditions of these various operations and the implementation of the Products according to industry standards. Pam Building reserves the right to modify the data given in its documentation at any time. It is the Client's responsibility to verify their validity with Pam Building.

Article 12 - PACKAGING

12.1 The Products' packaging is designed so as to satisfy the requirements of transportation.

12.2 Packaging and dunnage not billed for by Pam Building will be recovered upon delivery.

Article 13 - CONFORMITY OF EXPORTING CONTROLS

The Client undertakes to respect all applicable laws, particularly those concerning export controls. If, at any time, a new law or regulation enters into force rendering the execution of Pam Building's obligations impossible or illegal, Pam Building shall be entitled to cancel the order and terminate the contractual relationship, without any liability with regard to the Client.

Article 14 - PERSONAL INFORMATION

14.1 Pam Building, as a controller, carries out a computerised processing of its clients personal information to place orders and make deliveries.

14.2 Personal information collected in this context (Client's company name, first and last name of Pam Building's contact at the Client's, email

address, business telephone or fax number) is strictly necessary for the T&Cs execution and enable Pam Building to manage the order, delivery, invoicing and collection.

14.3 Personal information is kept for the entire duration of the commercial relationship and within the limits of the applicable laws.

14.4 Pam Building's customer service, commercial, invoicing and collection departments, as well as its subcontractors responsible for delivery and sending invoices, receive this data.

14.5 In accordance with applicable regulations regarding personal information protection, the Client has a right to access, to correct, to erase and to object to the use of his or her personal information, which the Client may exercise, by sending an email to: privacycontact.sgPAMbatiment.fr@saint-gobain.com, or by writing to: Pam Building – Privacy Correspondent – 21 avenue Camille Cavallier, 54700 Pont-à-Mousson, France.

14.6 For more information about the way Pam Building processes personal information, the Client may consult the web page «Your data and your rights» on Pam Building's websites: www.pambuilding.fr (France website) and www.pambuilding.com (Export website).

14.7 If the Client considers, after having contacted Pam Building, that his/her rights are not respected or that the processing of his/her personal information by Pam Building does not comply with the applicable rules, the Client shall be entitled to file a claim with the French personal data protection supervisory authority (CNIL).

Article 15 - CONFIDENTIALITY

The Client undertakes not to disclose to a third party, in whole or in part, any document, data, or information exchanged, in any form and of

any nature whatsoever relating to the order and/or the Products without the prior written consent of Pam Building. This commitment shall apply for the entire duration of the order and for five (5) years from the last delivery of Products under said order.

Article 16 - FORCE MAJEURE

16.1 Pam Building is not responsible for cases of force majeure. Force majeure is understood to mean any cause independent of the will of Pam Building, which would render the performance of its contractual obligations impossible, and affect the manufacture, shipping and delivery of Products. Cases of force majeure are considered to include disruptions to production and/or delivery resulting from a war (declared or not), strike, lock-out, accident, fire, flooding, natural disaster, epidemics, pandemics, interruption or delay in delivery, shortage of materials and/or raw materials, embargoes, and settlements, of any nature whatsoever.

16.2 In the event of force majeure, Pam Building shall have a reasonable extra period of time in which to execute its obligations.

Article 17 - APPLICABLE LAW - ALLOCATION OF JURISDICTION

In the event of a dispute as to the formation, performance or interpretation of the sales contract, the Nancy courts shall be solely competent even in case of multiple defendants, guarantee claims or proceedings in chambers. These T&Cs shall be subject to French law to the exclusion of its conflict-of-law rules.



Pam Building

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Technical enquiries:

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