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AnAmerican National Standard

Standard Specification for 30 to 60 in. [750 to 1500 mm] Polypropylene (PP) Triple Wall Pipe and Fittings for Non-Pressure Sanitary Sewer Applications[1]

This standard is issued under the fixed designation F2764/F2764M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ε) indicates an editorial change since the last revision or reapproval.

ε[1] NOTE—Revised designation to correspond with units statement in November 2013.

1. Scope*

1.1 This specification covers requirements and test methods for triple wall polypropylene pipe and fittings. The nominal inside diameters covered are 30 to 60 in. [750 to 1600 mm].

1.2 The requirements of this specification are intended to provide pipe and fittings suitable for underground use for non-pressure sanitary sewer systems. Pipe and fittings produced in accordance with this specification shall be installed in compliance with Practice D2321.

1.3 This specification covers pipe and fittings with an essentially smooth interior wall, an essentially smooth exterior wall and an annular corrugated profile middle wall (Fig. 1).

1.4 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

1.5 The following precautionary statement applies only to Section 7 of this specification. *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 *ASTM Standards:*[2]

A666 Specification for Annealed or Cold-Worked Austenitic Stainless Steel Sheet, Strip, Plate, and Flat Bar
D256 Test Methods for Determining the Izod Pendulum Impact Resistance of Plastics
D618 Practice for Conditioning Plastics for Testing
D638 Test Method for Tensile Properties of Plastics
D790 Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials
D792 Test Methods for Density and Specific Gravity (Relative Density) of Plastics by Displacement
D1238 Test Method for Melt Flow Rates of Thermoplastics by Extrusion Plastometer
D1505 Test Method for Density of Plastics by the Density-Gradient Technique
D1600 Terminology for Abbreviated Terms Relating to Plastics
D2122 Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings
D2321 Practice for Underground Installation of Thermoplastic Pipe for Sewers and Other Gravity-Flow Applications
D2412 Test Method for Determination of External Loading Characteristics of Plastic Pipe by Parallel-Plate Loading
D2444 Test Method for Determination of the Impact Resistance of Thermoplastic Pipe and Fittings by Means of a Tup (Falling Weight)
D2990 Test Methods for Tensile, Compressive, and Flexural Creep and Creep-Rupture of Plastics
D3212 Specification for Joints for Drain and Sewer Plastic Pipes Using Flexible Elastomeric Seals
D3895 Test Method for Oxidative-Induction Time of Polyolefins by Differential Scanning Calorimetry
D4101 Specification for Polypropylene Injection and Extrusion Materials
D4218 Test Method for Determination of Carbon Black Content in Polyethylene Compounds By the Muffle-Furnace Technique

[1] This specification is under the jurisdiction of ASTM Committee F17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.62 on Sewer.

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[2] For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

***A Summary of Changes section appears at the end of this standard**

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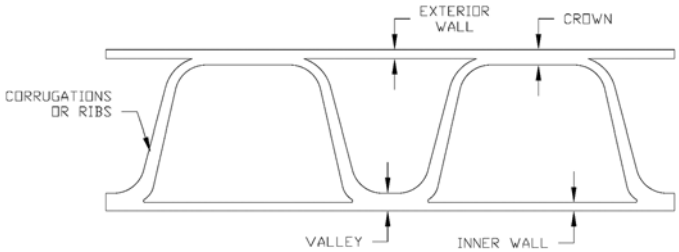

FIG. 1 Typical Triple Wall Pipe Profile

D4389 Specification for Finished Glass Fabrics Woven From Rovings
D6992 Test Method for Accelerated Tensile Creep and Creep-Rupture of Geosynthetic Materials Based on Time-Temperature Superposition Using the Stepped Isothermal Method
F412 Terminology Relating to Plastic Piping Systems
F477 Specification for Elastomeric Seals (Gaskets) for Joining Plastic Pipe
F2136 Test Method for Notched, Constant Ligament-Stress (NCLS) Test to Determine Slow-Crack-Growth Resistance of HDPE Resins or HDPE Corrugated Pipe

2.2 *AASHTO Standards:*[3]

LRFD, Section 12 AASHTO LRFD Bridge Design Specifications Section 12 – Buried Structures and Tunnel Liners

2.3 *Federal Standard:*[4]

Fed. Std. No. 123 Marking for Shipment (Civil Agencies)

2.4 *Military Standard:*[4]

MIL-STD-129 Marking for Shipment and Storage

3. Terminology

3.1 Definitions are in accordance with Terminology F412 and abbreviations are in accordance with Terminology D1600, unless otherwise specified. The abbreviation for polypropylene is PP.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *triple wall, n*—In this case, the triple pipe wall construction provides an interior wall in the waterway, an exterior wall to the soil, and includes ribs, corrugations, or other shapes, which can be either solid or hollow, that helps brace the pipe against diametrical deformation.

[3] Available from American Association of State Highway and Transportation Officials (AASHTO), 444 N. Capitol St., NW, Suite 249, Washington, DC 20001, http://www.transportation.org.

[4] Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, http://dodssp.daps.dla.mil.

4. Ordering Information

4.1 Orders for product made to this specification shall include the following information to adequately describe the desired product:

4.1.1 This ASTM designation and year of issue,
4.1.2 Diameters,
4.1.3 Total footage of each pipe diameter involved,
4.1.4 Pipe laying length,
4.1.5 *Fitting type(s):*
4.1.5.1 Size and type of fittings, including mainline and branch diameters, and
4.1.5.2 Number of fittings per diameter.

5. Materials and Manufacture

5.1 *Pipe and Fabricated Fittings*—Polypropylene Compounds – Polypropylene compounds used in the manufacture of the triple wall pipe and fittings shall have the minimum properties as shown in Table 1. Polypropylene compounds shall be comprised of the base polypropylene virgin resin and all additives, colorants, UV inhibitors and stabilizers. Conditioning sampling, preparation, and testing of molded specimens shall be accordance with the requirements in Specification D4101. For slow crack-growth resistance of the pipe corrugation, and inner and exterior walls, PP resins shall be evaluated using the notched constant ligament stress (NCLS) test according to the procedure described in 7.7.1. The average failure time of the five test specimens shall exceed 100 h with no single test specimen's failure time less than 71 h. Compounds shall be tested and validated on an annual basis or for any new formulations.

5.2 *Color and Ultraviolet Stabilization for Pipe and Fittings*—The pipe shall be colored or black. Black polypropylene compounds shall have between 2.0 and 3.0 percent carbon black when tested in accordance with the procedures in Test Method D4218. Colored polypropylene compounds shall be protected from Ultraviolet (UV) degradation with UV stabilizers.

TABLE 1 Polypropylene Compound Properties

Melt Flow Rate	D1238	g/10 min	0.25 @ 230°C	1.50 @ 230°C
Density	D792, D1505	lb/in^3 (g/cm^3)	0.0325 (0.900)	0.0343 (0.950)
Tensile Strength at Yield	D638	psi (N/mm^2)	3,500 (24)	4,500 (31)
Elongation at Yield	D638	% (%)	5 (5)	25 (25)
Flexural Modulus (1% secant)	D790B	psi (N/mm^2)	175,000 (1,200)	275,000 (1,900)
IZOD Impact Strength (730°F [230°C])	D256	ft-lb/in^2 [kJ/m^2]	23.8 (50)	No Break
Oxidative-Induction Time (392°F [200°C])	D3895	min	25	200

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5.3 *Rework Plastic*—Clean polypropylene rework plastic, generated from the manufacturer's own production of the product and having the same minimum physical properties, may be used by the manufacturer, provided that the pipe produced meets all the requirements of this specification.

5.4 *Elastomeric Seal Materials*—Elastomeric compounds and thermoplastic elastomeric compounds used in the manufacture of sealing rings or gaskets shall meet the requirements of Specification F477.

5.5 *Lubricant*—The lubricant used for assembly of gasketed joints shall have no detrimental effect of the gasket or on the pipe.

5.6 *Bell Retaining Bands*—Monolithically formed bands in or on the external wall of the bell, when used, shall provide tensile restraint to bell expansion due to gasket insertion or internal hydrostatic pressure in accordance with 6.6.4. These bands shall be made of corrosive resistant materials such as fiberglass (Specification D4389) or stainless steel (Specification A666).

NOTE 1—Compound and material properties are typically tested to validate a formulation; they are not routine quality assurance tests. Users requiring such testing for quality assurance purposes should insert these criteria in their project specifications.

6. General Requirements

6.1 Workmanship—The pipe and fittings shall be homogeneous throughout and be as uniform as commercially practical in color, opacity, and density. The pipe walls shall be free of cracks, holes, blisters, voids, foreign inclusions, or other defects that are visible to the naked eye and that may affect the wall integrity. The ends shall be cut cleanly and squarely through valleys.

6.1.1 Visible defects, cracks, creases, splits, in pipe are not permissible.

6.2 *Dimensions and Tolerance:*

6.2.1 *Nominal Size*—The nominal size for the pipe and fittings shall be the inside diameter shown in Table 2.

6.2.2 *Minimum Inside Diameter*—The minimum inside diameter shall be as shown in Table 2, when measured in accordance with section 7.3.3. In no case shall the manufacturer's stated inside diameter minus the tolerance in Table 2 be less than the required minimum inside diameter.

NOTE 2—The manufacturer's stated inside diameter is the nominal diameter plus or minus the inside diameter tolerances. The minimum inside diameter is the smallest diameter the pipe can be with these tolerances and is used for the hydraulic design of the pipe.

NOTE 3—The outside diameters and the corrugation pitch of products manufactured to this specification are not specified; therefore, compatibility between pipe and fittings made to this specification from different manufacturers should be verified.

6.2.3 *Laying Length*—The pipe shall be supplied in any laying length agreeable to both the owner and the manufacturer. Laying length shall not be less than 99 % of stated quantity when measured in accordance with 7.3.2.

6.2.4 *Minimum Wall, Crest, Valley and Liner Thickness*—— The minimum thickness of pipe sections shall meet the requirements given in Table 2 when measured in accordance with 7.3.3.

6.3 *Pipe Stiffness*—Minimum pipe stiffness at 5 % deflection shall meet the requirements given in Table 2 when tested in accordance with 7.4.

NOTE 4—The 5 % deflection criterion, which was selected for testing convenience, is not a limitation with respect to in-use deflection. The engineer is responsible for establishing the acceptable deflection limit.

6.4 *Pipe Flattening*—There shall be no evidence of splitting, cracking, breaking, separation of seams, separation of the outer and inner wall, or combinations thereof, when tested in accordance with 7.5.

6.5 *Pipe Impact Strength*—There shall be no evidence of splitting, cracking, breaking, separation of seams, separation of the outer and inner wall, or combinations thereof, when conditioned in accordance with 7.1 and tested in accordance with 7.6 and examined under normal light and the unaided eye. The minimum pipe impact strength at 73°F (23°C) shall be 140 ft-lbf (190 J).

6.6 *Fittings and Joining Systems::*

6.6.1 Only fittings and joining systems supplied or recommended by the pipe manufacturer shall be used. Fittings shall be installed in accordance with the manufacturer's recommendations and meet the same material requirements as the pipe.

NOTE 5—Fittings may be fabricated from the pipe by a variety of processes including hot plate welding, spin welding or other processes.

6.6.2 The joining system(s) shall be of a design that preserves alignment during construction and prevents separation at the joints while maintaining watertight requirements in accordance with 6.6.3.

6.6.3 Pipe and fittings shall have a watertight bell/spigot joint that complies with the laboratory tests defined and

TABLE 2 Pipe Stiffness and Pipe Dimentions

Pipe Inside Diameter		Minimum Inside Diameter		Inside Diameter Tolerances		Minimum Pipe Stiffness at 5 % Deflection		Minimum Inner Liner Thickness		Minimum Outer Liner Thickness		Minimum Valley Thickness		Minimum Crown Thickness	
in.	[mm]	in.	[mm]	in.	[mm]	lb/ in/in	[kPa]	in.	[mm]	in.	[mm]	in.	[mm]	in.	[mm]
30	[750]	29.62	[752]	+0.18/- 0.18	+4.6/-4.6	46	[317]	0.070	[1.8]	0.070	[1.8]	0.081	[2.1]	0.115	[2.9]
36	[900]	35.40	[899]	+0.21/- 0.21	+5.3/-5.3	46	[317]	0.095	[2.4]	0.095	[2.4]	0.109	[2.8]	0.165	[4.2]
42	[1050]	41.31	[1049]	+0.22/- 0.22	+5.6/-5.6	46	[317]	0.105	[2.7]	0.105	[2.7]	0.121	[3.1]	0.165	[4.2]
48	[1200]	47.31	[1201]	+0.27/- 0.27	+6.9/-6.9	46	[317]	0.105	[2.7]	0.105	[2.7]	0.126	[3.2]	0.170	[4.3]
54	[1350]	53.32	[1354]	+0.27/- 0.27	+6.9/-6.9	46	[317]	0.105	[2.7]	0.105	[2.7]	0.131	[3.3]	0.170	[4.3]
60	[1500]	59.30	[1506]	+0.31/- 0.31	+7.9/-7.9	46	[317]	0.105	[2.7]	0.105	[2.7]	0.137	[3.5]	0.210	[5.3]

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