



**Requirements for the Use of
Rework Materials in Manufacturing of
Polyethylene Gas Pipe
TN-30/2013**

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TN-30

Requirements for the use of Rework Materials in Polyethylene Gas Pipe

1.0 SCOPE AND PURPOSE

This technical note offers guidance and requirements for polyethylene gas pipe manufacturers and provides criteria for evaluation of manufacturers by purchasers of polyethylene gas pipe, with respect to the use of rework of polyethylene materials in the manufacture of ASTM D 2513 polyethylene gas pipe. These requirements address the cleanliness of rework polyethylene materials used in the manufacture of ASTM D 2513 polyethylene gas pipe to ensure that the use of rework does not compromise pipe quality. **The user should consult Title 49CFR Part 192 for the current referenced edition of ASTM D 2513.**

2.0 INTRODUCTION

The requirements in this technical note are designed to ensure the responsible use of rework materials and to ensure compliance with ASTM D 2513. In general, the requirements contained in this document reflect good rework inventory controls, good housekeeping, good manufacturing practices and good record keeping procedures. This technical note addresses only the extrusion process for pipe or tubing from polyethylene materials that are identified in ASTM D 2513, Annex A1. It does not address rework for other piping materials that are identified in ASTM D 2513.

These requirements shall be used to determine if polyethylene gas pipe is produced in facilities that have appropriate procedures for controlling the use of rework materials. A manufacturer shall be evaluated with respect to whether they comply with the rework material requirements of this technical note, ASTM D 2513, product quality, and customer expectations.

3.0 REQUIREMENTS FOR REWORK MATERIALS

In meeting ASTM D 2513 requirements, rework, sometimes called regrind, shall have specific characteristics:

3.1 Rework shall be clean

A manufacturer shall have a documented procedure governing the use of rework materials. At a minimum, there shall be written procedures and instructions for the responsible use of rework in a manufacturer's production process. Rework processes and procedures shall be designed to maintain virgin and rework material cleanliness, to avoid introducing contamination, and to remove inadvertently introduced contamination.