



Standard Specification for Chlorinated Poly (Vinyl Chloride) (CPVC) Plastic Pipe Fittings, Schedule 80¹

This standard is issued under the fixed designation F439; 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.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope*

1.1 This specification covers chlorinated poly(vinyl chloride) (CPVC) Schedule 80 pipe fittings. Included are requirements for materials, workmanship, dimensions, and burst pressure.

NOTE 1—The threaded CPVC fittings covered by this specification were covered previously in Specification F437.

1.2 The text of this specification references notes, footnotes, and appendixes which provide explanatory material. These notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of this specification.

1.3 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.4 The following safety hazards caveat pertains only to the test method portion, Section 8, 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, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.5 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:²

D618 Practice for Conditioning Plastics for Testing

¹ This specification is under the jurisdiction of ASTM Committee F17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.10 on Fittings.

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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.

D1599 Test Method for Resistance to Short-Time Hydraulic Pressure of Plastic Pipe, Tubing, and Fittings

D1600 Terminology for Abbreviated Terms Relating to Plastics

D1784 Specification for Rigid Poly(Vinyl Chloride) (PVC) Compounds and Chlorinated Poly(Vinyl Chloride) (CPVC) Compounds

D2122 Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings

D2749 Symbols for Dimensions of Plastic Pipe Fittings

F412 Terminology Relating to Plastic Piping Systems

F437 Specification for Threaded Chlorinated Poly(Vinyl Chloride) (CPVC) Plastic Pipe Fittings, Schedule 80

F1498 Specification for Taper Pipe Threads 60° for Thermoplastic Pipe and Fittings

2.2 Federal Standard:

Fed. Std. No. 123 Marking for Shipment (Civil Agencies)³

2.3 Military Standard:

MIL-STD-129 Marking for Shipment and Storage³

2.4 NSF Standard:

Standard No. 14 for Plastic Piping Components and Related Materials⁴

Standard No. 61 for Drinking Water System Components—Health Effects⁴

3. Terminology

3.1 *Definitions*—Definitions are in accordance with Terminology F412 and abbreviations are in accordance with Terminology D1600, unless otherwise indicated. The abbreviation for chlorinated poly(vinyl chloride) is CPVC.

4. Classification

4.1 *General*—This specification covers Schedule 80 CPVC pipe fittings, intended for use with Iron Pipe Size (IPS) outside-diameter plastic pipe.

³ Available from DLA Document Services, Building 4/D, 700 Robbins Ave., Philadelphia, PA 19111-5094, http://quicksearch.dla.mil.

⁴ Available from NSF International, P.O. Box 130140, 789 N. Dixboro Rd., Ann Arbor, MI 48105, http://www.nsf.org.

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

4.1.1 Fittings covered by this specification are normally molded. In-line fittings, such as couplings, unions, bushings, caps, nipples, and so forth, shall be molded or machined from extruded stock.

4.1.2 Fittings fabricated by back welding or butt fusion are not included in this specification.

NOTE 2—This specification does not include requirements for pipe and fittings intended to be used to vent combustion gases.

5. Materials and Manufacture

5.1 This specification covers CPVC pipe fittings made from compounds meeting the requirements of Class 23447 and Class 23448 as defined in Specification D1784.

NOTE 3—Mechanical strength, heat resistance and flammability requirements are covered in Specification D1784.

5.2 *Rework Material*—The manufacturers shall use only their own clean rework fitting material, and the fittings produced shall meet all the requirements of this specification.

6. Requirements

6.1 Dimensions and Tolerances:

6.1.1 Fitting sockets, inside diameters (waterways), minimum wall thicknesses, and dimensions shall be as shown in Tables 1-6 when measured in accordance with Test Method D2122.

6.1.2 When multistep reducer bushings are cored out, the inner socket shall be reinforced from the outer wall by a minimum of three ribs extending from the top of the inner socket to the deepest extremity of the coring. The transition from D to DJ (Table 3) shall be straight, tapered as shown, or radiused. A positive taper in the same direction of the taper in the socket on the outside diameter of the bushing is optional (see XA/XB in Table 3). Any point measured along the outside diameter of the bushing (between XA and XB) shall not fall below minimum pipe OD.

6.1.3 The minimum wall thickness of fittings shall be 125 % of the minimum wall thickness of the corresponding size of Schedule 80 pipe for which they are designed to be used, except that for the socket, the wall thickness shall be at least equal to the minimum wall thickness of the corresponding size of Schedule 80 pipe.

6.1.4 The minimum inside diameter of the fittings shall be not less than the minimum specified inside diameter of the corresponding size of Schedule 80 pipe. This is calculated as follows:

$$(\text{minimum OD}) - 2 \times (\text{maximum wall}) = \text{minimum ID} \quad (1)$$

6.1.5 Minimum dimensions have zero negative tolerance. Tolerances on other dimensions are shown in Tables 1 and 3.

6.1.6 *Fitting Not Illustrated*—All fittings, whether illustrated in Tables 1-5 or not, shall maintain the dimensions conforming to 6.1 and 6.2.

6.2 *Threads*—For all fittings having taper pipe threads, threads shall conform to Specification F1498 and be gaged in accordance with 8.4.

6.3 Burst Pressure:

6.3.1 The minimum burst strength of the fittings shall be not less than that calculated for the size and wall thickness of the pipe with which it is to be used, when calculated from the following equation and using a stress of 6400 psi for 8-in. and smaller fittings, and a stress of 5100 psi for fittings larger than 8-in.:

$$S = P(D_o - t)/2t \quad (2)$$

where:

S = hoop stress, psi (MPa),
 P = internal pressure, psi (MPa),
 D_o = average outside diameter, in. (mm), and
 t = minimum wall thickness, in. (mm).

Fittings tested in accordance with 8.5 shall withstand the minimum burst pressure shown in Table 6.

6.3.2 Pressures shown are minimum burst pressures and do not imply rated working pressures. The burst pressure shall be used only as an indication of quality.

7. Workmanship, Finish, and Appearance

7.1 The fittings shall be homogeneous throughout and free of cracks, holes, foreign inclusions, or other defects. The fittings shall be as uniform as commercially practicable in color, opacity, density, and other physical properties.

8. Test Methods

8.1 *Conditioning*—Condition of test specimens at 73.4 ± 3.6 °F (23 ± 2 °C) and 50 ± 10 % relative humidity for not less than 40 h prior to test in accordance with Procedure A of Practice D618, for those tests where conditioning is required.

8.2 *Test Conditions*—Conduct tests in the standard laboratory atmosphere of 73.4 ± 3.6 °F (23 ± 2 °C) and 50 ± 10 % relative humidity, unless otherwise specified in the test methods or in this specification.

8.3 *Sampling*—A sufficient quantity of fittings as agreed upon between the seller and the purchaser shall be selected at random from each lot or shipment and tested to determine that the basic design is in conformance with this specification.

NOTE 4—For individual orders or specifications where supplemental tests are required, only those tests and numbers of tests specifically agreed upon between the purchaser and the seller need be conducted.

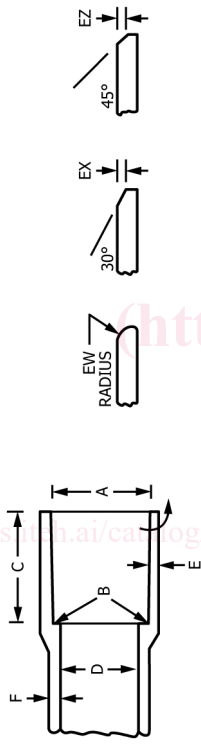
8.4 *Threads*—All taper pipe threads shall be gaged in accordance with Specification F1498.

8.5 *Burst Pressure*—Determine the minimum burst pressure in accordance with Test Method D1599, Procedure B. The time of testing each specimen shall be between 60 and 70 s.

9. Retest and Rejection

9.1 If the results of any test(s) do not meet the requirements of this specification, the test(s) shall be conducted again only by agreement between the purchaser and the seller. Under such agreement, minimum requirements shall not be lowered, changed, or modified, nor shall specification limits be changed. If upon retest, failure occurs, the quantity of product represented by the test(s) does not meet the requirements of this specification.

TABLE 1 Tapered Sockets for CPVC Pipe Fittings, Schedule 80, in. (mm)^A



Nominal Pipe Size	Socket Entrance Diameter A		Socket Bottom Diameter B		Maximum Out-of-Round	Tolerance on Nominal Diameter	Diameter	Diameter	Tolerance on Nominal Diameter	Maximum Out-of-Round	Socket Length, min C ^B	Inside Diameter, min C ^C	E	Wall Thickness, min			
	Diameter	Tolerance on Nominal Diameter	Diameter	Tolerance on Nominal Diameter										E	F	EW	EX, EZ
1/4	0.552 (14.02)	±0.004 (0.10)	0.536 (13.61)	±0.004 (0.10)	0.016 (0.41)	±0.004 (0.10)	0.536 (13.61)	0.536 (13.61)	±0.004 (0.10)	0.016 (0.41)	0.625 (15.88)	0.258 (6.55)	0.119 (3.02)	0.149 (3.78)	0.02 (0.5)	0.02 (0.5)	0.02 (0.5)
3/8	0.687 (17.45)	±0.004 (0.10)	0.671 (17.04)	±0.004 (0.10)	0.016 (0.41)	±0.004 (0.10)	0.671 (17.04)	0.671 (17.04)	±0.004 (0.10)	0.016 (0.41)	0.750 (19.05)	0.379 (9.63)	0.126 (3.20)	0.158 (4.01)	0.03 (0.8)	0.03 (0.8)	0.03 (0.8)
1/2	0.848 (21.54)	±0.004 (0.10)	0.836 (21.23)	±0.004 (0.10)	0.016 (0.41)	±0.004 (0.10)	0.836 (21.23)	0.836 (21.23)	±0.004 (0.10)	0.016 (0.41)	0.875 (22.22)	0.502 (12.75)	0.147 (3.73)	0.184 (4.67)	0.03 (0.8)	0.03 (0.8)	0.03 (0.8)
3/4	1.058 (26.87)	±0.004 (0.10)	1.046 (26.57)	±0.004 (0.10)	0.020 (0.51)	±0.004 (0.10)	1.046 (26.57)	1.046 (26.57)	±0.004 (0.10)	0.020 (0.51)	1.000 (25.40)	0.698 (17.73)	0.154 (3.91)	0.193 (4.90)	0.03 (0.8)	0.03 (0.8)	0.03 (0.8)
1	1.325 (33.66)	±0.005 (0.13)	1.310 (33.27)	±0.005 (0.13)	0.020 (0.51)	±0.005 (0.13)	1.310 (33.27)	1.310 (33.27)	±0.005 (0.13)	0.020 (0.51)	1.125 (28.58)	0.910 (23.11)	0.179 (4.55)	0.224 (5.69)	0.06 (1.5)	0.06 (1.5)	0.06 (1.5)
1 1/4	1.670 (42.42)	±0.005 (0.13)	1.655 (42.04)	±0.005 (0.13)	0.024 (0.61)	±0.005 (0.13)	1.655 (42.04)	1.655 (42.04)	±0.005 (0.13)	0.024 (0.61)	1.250 (31.75)	1.227 (31.17)	0.191 (4.85)	0.239 (6.07)	0.06 (1.5)	0.06 (1.5)	0.06 (1.5)
1 1/2	1.912 (48.56)	±0.006 (0.15)	1.894 (48.11)	±0.006 (0.15)	0.024 (0.61)	±0.006 (0.15)	1.894 (48.11)	1.894 (48.11)	±0.006 (0.15)	0.024 (0.61)	1.375 (34.93)	1.446 (36.73)	0.200 (5.08)	0.250 (6.35)	0.06 (1.5)	0.06 (1.5)	0.06 (1.5)
2	2.387 (60.63)	±0.006 (0.15)	2.369 (60.17)	±0.006 (0.15)	0.024 (0.61)	±0.006 (0.15)	2.369 (60.17)	2.369 (60.17)	±0.006 (0.15)	0.024 (0.61)	1.500 (38.10)	1.881 (47.78)	0.218 (5.54)	0.273 (6.93)	0.06 (1.5)	0.06 (1.5)	0.06 (1.5)
2 1/2	2.889 (73.38)	±0.007 (0.18)	2.868 (72.85)	±0.007 (0.18)	0.030 (0.76)	±0.007 (0.18)	2.868 (72.85)	2.868 (72.85)	±0.007 (0.18)	0.030 (0.76)	1.750 (44.45)	2.250 (57.15)	0.276 (7.01)	0.345 (8.76)	0.09 (2.3)	0.09 (2.3)	0.13 (3.3)
3	3.515 (89.28)	±0.007 (0.18)	3.491 (88.67)	±0.007 (0.18)	0.023 (0.58)	±0.007 (0.18)	3.491 (88.67)	3.491 (88.67)	±0.007 (0.18)	0.023 (0.58)	1.875 (47.63)	2.820 (71.63)	0.300 (7.62)	0.375 (9.53)	0.09 (2.3)	0.09 (2.3)	0.13 (3.3)
3 1/2	4.016 (102.01)	±0.008 (0.20)	3.992 (101.40)	±0.008 (0.20)	0.030 (0.76)	±0.008 (0.20)	3.992 (101.40)	3.992 (101.40)	±0.008 (0.20)	0.030 (0.76)	2.125 (53.98)	3.280 (83.31)	0.318 (8.06)	0.398 (10.11)	0.09 (2.3)	0.09 (2.3)	0.13 (3.3)
4	4.517 (114.73)	±0.008 (0.20)	4.490 (114.04)	±0.008 (0.20)	0.023 (0.58)	±0.008 (0.20)	4.490 (114.04)	4.490 (114.04)	±0.008 (0.20)	0.023 (0.58)	2.250 (57.15)	3.737 (94.92)	0.337 (8.56)	0.420 (10.67)	0.09 (2.3)	0.09 (2.3)	0.13 (3.3)
5	5.583 (141.81)	±0.010 (0.25)	5.553 (141.05)	±0.010 (0.25)	0.060 (1.52)	±0.010 (0.25)	5.553 (141.05)	5.553 (141.05)	±0.010 (0.25)	0.060 (1.52)	2.625 (66.68)	4.713 (119.71)	0.375 (9.53)	0.469 (11.91)	0.09 (2.3)	0.09 (2.3)	0.13 (3.3)
6	6.647 (168.83)	±0.011 (0.28)	6.614 (168.00)	±0.011 (0.28)	0.060 (1.52)	±0.011 (0.28)	6.614 (168.00)	6.614 (168.00)	±0.011 (0.28)	0.060 (1.52)	3.000 (76.20)	5.646 (143.41)	0.432 (10.97)	0.540 (13.72)	0.13 (3.3)	0.13 (3.3)	0.19 (4.8)
8	8.655 (219.84)	±0.015 (0.38)	8.610	±0.015 (0.38)	0.090 (2.29)	±0.015 (0.38)	8.610	8.610	±0.015 (0.38)	0.090 (2.29)	4.000 (101.60)	7.490 (190.25)	0.500 (12.70)	0.625 (15.88)	0.13 (3.3)	0.13 (3.3)	0.19 (4.8)
10	10.780 (273.81)	±0.015 (0.38)	10.735 (272.67)	±0.015 (0.38)	0.100 (2.54)	±0.015 (0.38)	10.735 (272.67)	10.735 (272.67)	±0.015 (0.38)	0.100 (2.54)	5.000 (127.00)	9.407 (238.94)	0.593 (15.06)	0.741 (18.82)	0.125 (3.18)	0.125 (3.18)	0.187 (4.76)
12	12.780 (324.61)	±0.015 (0.38)	12.735 (323.47)	±0.015 (0.38)	0.120 (3.05)	±0.015 (0.38)	12.735 (323.47)	12.735 (323.47)	±0.015 (0.38)	0.120 (3.05)	6.000 (152.40)	11.197 (284.40)	0.687 (17.45)	0.859 (21.82)	0.125 (3.18)	0.125 (3.18)	0.187 (4.76)

^A The sketches and designs of fittings are illustrative only.

^B Socket depth, measured from socket entrance face to socket bottom face.

^C See 6.1.4.