Designation: F2720/F2720M – 20

An American National Standard

Standard Specification for Glass Fiber Reinforced Polyethylene (PE-GF) Spiral Wound Large Diameter Pipe[1]

This standard is issued under the fixed designation F2720/F2720M; 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.

1. Scope*

1.1 This specification covers requirements and test methods for materials, dimensions, workmanship, joining systems, and marking for large diameter, 12 in. [300 mm] and larger, inside diameter controlled glass fiber reinforced polyethylene (PE-GF) spiral wound pipe with electrofusion joints. The piping is intended for new construction and renewal of existing piping systems used for the transport of water, slurries, municipal sewage, domestic sewage, effluents, etc., in pressure systems.

NOTE 1—Pipe produced to this specification should be installed in accordance with Practice D2774 or F1668, where applicable, and with the manufacturer's recommendations.

1.2 The values stated in either inch-pound units or SI units are to be regarded separately as standard. Within the text the SI units are shown in brackets. 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.

1.3 All pipes produced under this specification are pressure-rated.

1.4 This specification includes criteria for choice of raw material and test methods for evaluation of raw material, together with performance requirements and test methods for determining conformance with the requirements.

1.5 In referee decisions, the SI units shall be used for metric-sized pipe and inch-pound units for pipe sized per ANSI (ANSI B 36.10).

1.6 *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.*

1.7 *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

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

D1505 Test Method for Density of Plastics by the Density-Gradient Technique

D1598 Test Method for Time-to-Failure of Plastic Pipe Under Constant Internal Pressure

D1600 Terminology for Abbreviated Terms Relating to Plastics

D2122 Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings

D2657 Practice for Heat Fusion Joining of Polyolefin Pipe and Fittings

D2774 Practice for Underground Installation of Thermoplastic Pressure Piping

D2837 Test Method for Obtaining Hydrostatic Design Basis for Thermoplastic Pipe Materials or Pressure Design Basis for Thermoplastic Pipe Products

D3350 Specification for Polyethylene Plastics Pipe and Fittings Materials

D3895 Test Method for Oxidative-Induction Time of Polyolefins by Differential Scanning Calorimetry

F412 Terminology Relating to Plastic Piping Systems

F1290 Practice for Electrofusion Joining Polyolefin Pipe and Fittings

F1668 Guide for Construction Procedures for Buried Plastic Pipe

[1] This specification is under the jurisdiction of ASTM Committee F17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.11 on Composite.

Current edition approved Sept. 1, 2020. Published September 2020. Originally approved in 2008. Last previous edition approved in 2009 as F2720/F2720M-09 which was withdrawn in August 2016 and reinstated in September 2020. DOI:10.1520/F2720_F2720M-20.

[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

2.2 *ANSI Standard:*
B36.10 Standard Dimensions of Steel Pipe (IPS)[3]

2.3 *ISO Standard:*
ISO 13479 Polyolefin Pipes for the Conveyance of Fluids—Determination of Resistance to Crack Propagation—Test Method for Slow Crack Growth on Notched Pipes (Notch Test)[4]

2.4 *NSF/ANSI Standards:*
Standard No. 4 for Plastic Piping Components and Related Materials[5]
Standard No. 61 for Drinking Water Systems Components—Health Effects[5]

3. Terminology

3.1 *Definitions*—Definitions are in accordance with Terminology F412 and abbreviations are in accordance with Terminology D1600, unless otherwise specified. The abbreviation for polyethylene is PE.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *glass fiber reinforced polyethylene (PE-GF)*—short glass fiber reinforced polyethylene compound.

3.2.2 *relation between standard dimension ratio, hydrostatic design stress, and pressure rating:*—

$$P = \frac{2S}{(Di/t)+1} \quad (1)$$

where:

S = hydrostatic design stress (HDS), psi [or kPa or MPa],
P = pressure rating, psi [or kPa or MPa],
Di = average inside diameter, in. [or mm],
t = minimum wall thickness, in. [or mm], and
Di/t = standard dimension ratio or standard inside diameter dimension ratio (SIDR).

3.2.3 *relationship between hydrostatic design basis [HDB] and hydrostatic design stress (HDS)*—the hydrostatic design stress, S, is determined by multiplying the hydrostatic design basis (HDB) by the design factor, n. The design factor, n, has a value less than 1.0.

3.2.3.1 *Discussion*—The hydrostatic pressure rating of pipes described in this specification is based on the use of a (service) design factor of 0.5.

4. Materials

4.1 *General*—The polyethylene, reinforcements, colorants, and other additives, when combined as a composite structure, shall produce a pipe that shall meet the performance requirements of this specification.

4.2 *Glass Fiber Reinforced Polyethylene (PE-GF) Material*—Pipe shall be made of PE-GF plastic compound meeting the requirements shown in Table 1. The PE-GF pipe, as manufactured, shall have a minimum hydrostatic design basis (HDB) of 2500 psi [17.2 MPa] for water at 73.4 °F [23 °C] determined using Test Method D2837. Pressure ratings are shown in Table 2. Ambient and elevated temperature sustained pressure testing requirements are shown in Table 5.

4.3 *Polyethylene (PE)*—The polyethylene base compound prior to the incorporation of the glass fibers shall meet the minimum property requirements of either cell class 333444 or 444454 as described in Specification D3350. The inner and external un-reinforced polyethylene layers shall be either black or colored and shall be made of the same polyethylene compound that is used to make the PE-GF compound.

4.4 *Glass Fibers*—Short glass fibers.

4.5 *Color and Ultraviolet (UV) Stabilization*—The pipe shall be black or blue or black with blue stripes. The external and internal colored polyethylene layers shall be made of un-reinforced polyethylene compounds meeting the requirements of Specification D3350 Code C or Code E. Code C polyethylene compounds shall have between 2.0 and 3.0 percent carbon black. Code E polyethylene compounds shall be colored and protected from Ultraviolet (UV) degradation with UV stabilizers.

4.6 *Rework Material*—Clean rework material generated from the manufacturer's own pipe production shall be allowed up to a maximum of 10 % by weight in the PE-GF compound. The PE-GF pipe produced shall meet all the requirements of this specification.

5. Classification and Uses

5.1 *Uses*—The requirements of this specification are intended to provide pipe suitable for underground or above ground pressure applications as well as gravity and low pressure drainage of sewer and surface water.

[3] Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, http://www.ansi.org.
[4] Available from International Organization for Standardization (ISO), 1, ch. de la Voie-Creuse, Case postale 56, CH-1211, Geneva 20, Switzerland, http://www.iso.ch.
[5] Available from NSF International, P.O. Box 130140, 789 N. Dixboro Rd., Ann Arbor, MI 48113-0140, http://www.nsf.org.

TABLE 1 Physical Properties of PE-GF Material Tested as Pipe

Property	Test Method(s)	Units	Minimum Value
Density	ASTM D792 or D1505	g/cm^3	1.04
Oxidation Induction Time at 412 °F [200 °C]	ASTMD3895	minutes	20
Tensile strength at yield (longitudinal direction)	ASTM D638	kpsi [MPa]	5.075 [35.0]
Tensile Elastic Modulus	ASTM D638	kpsi [N/mm^2]	333.5 [2300]
Flexural Elastic Modulus	ASTM D790	kpsi [MPa]	372 [2566]
Resistance to Notch Test	ISO 13479	hours	2500
Hydrostatic Design Basis for water at 73 °F [23 °C]	ASTM D2837	psi [MPa]	2500 [17.22]

TABLE 2 Standard Pressure Ratings

SIDR	11	13.5	15	17	19	21	24	27	31	35	39	44	49	55	63	70
Design Factor	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5
HDB, psi	3200	3200	3200	3200	3200	3200	3200	3200	3200	3200	3200	3200	3200	3200	3200	3200
P, psi	267	221	201	180	160	143	127	113	101	90	80	71	64	57	51	45
P, kPa	1838	1521	1389	1238	1103	983	876	781	696	621	553	493	439	391	349	311
SIDR	11	13.5	15	17	19	21	24	27	31	35	39	44	49	55	63	70
Design Factor	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5
HDB, psi	2500	2500	2500	2500	2500	2500	2500	2500	2500	2500	2500	2500	2500	2500	2500	2500
P, psi	208	172	157	140	125	111	99	88	79	70	63	56	50	44	40	35
P, kPa	1436	1188	1085	967	862	768	685	610	544	485	432	385	343	306	272	243

TABLE 3

Table 3A: Inch Based PE-GF Pipe Dimensions and Out-of —Roundness Allowance

Nominal Pipe Size in. [mm]	Inside Diameter, minimum in. [mm]	Inside diameter, maximum in. [mm]	Maximum Out-of- Roundness in. [mm]
18 [457]	17.82 [453]	18.0 [457]	0.18 [5]
24 [610]	23.76 [604]	24.0 [610]	0.24 [6]
30 [762]	29.70 [754]	30.0 [762]	0.30 [8]
36 [914]	35.64 [905]	36.0 [914]	0.36 [9]
42 [1067]	41.58 [1056]	42.0 [1067]	0.42 [11]
48 [1219]	47.52 [1207]	48.0 [1219]	0.48 [12]
54 [1372]	53.46 [1358]	54.0 [1372]	0.54 [14]
60 [1524]	59.40 [1509]	60.0 [1524]	0.60 [15]
72 [1829]	71.28 [1811]	72.0 [1829]	0.72 [18]
84 [2134]	83.16 [2112]	84.0 [2134]	0.84 [21]
96 [2438]	95.04 [2414]	96.0 [2438]	0.96 [24]
108 [2743]	106.92 [2716]	108.0 [2743]	1.08 [27]
120 [3048]	118.80 [3018]	120.0 [3048]	1.20 [30]
145 [3683]	143.55 [3646]	145.0 [3683]	1.45 [37]

Table 3B: Metric Based PE-GF Pipe Dimensions and Out-of-Roundness Allowance

Nominal Pipe Size, in. [mm]	Inside Diameter, minimum in. [mm]	Inside Diameter, maximum in. [mm]	Maximum Out-of-Roundness in. [mm]
12 [300]	11.81 [300]	12.13 [308]	0.39 [10]
16 [400]	15.75 [400]	16.06 [408]	0.55 [14]
20 [500]	19.69 [500]	20.00 [508]	0.67 [17]
24 [600]	23.62 [600]	23.98 [609]	0.83 [21]
28 [700]	27.56 [700]	27.95 [710]	0.94 [24]
32 [800]	31.50 [800]	31.97 [812]	1.10 [28]
36 [900]	35.43 [900]	35.94 [913]	1.22 [31]
40 [1000]	39.37 [1000]	39.96 [1015]	1.38 [35]
44 [1100]	43.31 [1100]	43.90 [1115]	1.50 [38]
48 [1200]	47.24 [1200]	47.95 [1218]	1.65 [42]
52 [1300]	51.18 [1300]	51.89 [1318]	1.77 [45]
56[1400]	55.12 [1400]	55.94 [1421]	1.93 [49]
64 [1600]	62.99 [1600]	63.94 [1624]	2.20 [56]
72 [1800]	70.87 [1800]	71.93 [1827]	2.48 [63]
80 [2000]	78.74 [2000]	79.92 [2030]	2.76 [70]
88 [2200]	86.61 [2200]	87.91 [2233]	3.03 [77]
96 [2400]	94.49 [2400]	95.91 [2436]	3.31 [84]
104 [2600]	102.36 [2600]	103.90 [2639]	3.58 [91]
112 [2800]	110.24 [2800]	111.89 [2842]	3.86 [98]
120 [3000]	118.11 [3000]	119.49 [3035]	4.13 [105]
128 [3200]	125.98 [3200]	127.87 [3248]	4.41 [112]
136 [3400]	133.86 [3400]	135.87 [3451]	4.69 [119]
144 [3600]	141.73 [3600]	143.86 [3654]	4.96 [126]
152 [3800]	149.61 [3800]	151.85 [3857]	5.24 [133]
160 [4000]	157.48 [4000]	159.84 [4060]	5.51 [140]

5.2 *Classifications*—This specification covers PE-GF pressure pipe products made in standard inside diameter ratios (SIDR) from 11 to 70. Standard pressure ratings for the various SIDR pipes are shown in Table 2.

6. Joining Systems

6.1 *Electrofusion Joint:*

TABLE 4

Table 4A: Inch Based PE-GF Minimum and Maximum Wall Thickness by SIDR

Nominal Pipe Size, in. [mm]	SIDR 11		SIDR 13.5		SIDR 15		SIDR 17	
	Min. Wall in. [mm]	Max. Wall in. [mm]	Min. Wall in. [mm]	Max. Wall in. [mm]	Min. Wall in. [mm]	Max. Wall in. [mm]	Min. Wall in. [mm]	Max. Wall in. [mm]
18 [457]	1.62 [41]	1.88 [48]	1.32 [34]	1.53 [39]	1.19 [30]	1.38 [35]	1.05 [27]	1.22 [31]
24 [610]	2.16 [55]	2.51 [64]	1.76 [45]	2.04 [52]	1.58 [40]	1.84 [47]	1.40 [36]	1.62 [36]
30 [762]	2.70 [69]	3.14 [80]	2.20 [56]	2.56 [65]	1.98 [50]	2.30 [58]	1.75 [44]	2.03 [52]
36 [914]	3.24 [82]	3.76 [96]	2.64 [67]	3.07 [78]	2.38 [60]	2.76 [70]	2.10 [53]	2.44 [62]
42 [1067]	3.78 [96]	4.39 [112]	3.08 [78]	3.58 [92]	2.77 [70]	3.22 [82]	2.45 [62]	2.84 [72]
48 [1219]	4.32 [110]	5.02 [127]	3.52 [89]	4.09 [104]	3.17 [80]	3.68 [93]	2.80 [71]	3.25 [82]
54 [1372]	4.86 [123]	5.65 [143]	3.96 [101]	4.60 [117]	3.56 [91]	4.14 [105]	3.14 [80]	3.65 [93]
60 [1524]	5.40 [137]	6.27 [159]	4.40 [112]	5.11 [130]	3.96 [101]	4.60 [117]	3.49 [89]	4.06 [103]
72 [1829]	6.48 [165]	7.53 [191]	5.28 [134]	6.13 [156]	4.75 [121]	5.52 [140]	4.19 [107]	4.87 [124]
84 [2134]	7.56 [192]	8.78 [223]	6.16 [156]	7.16 [182]	5.54 [141]	6.44 [164]	4.89 [124]	5.68 [144]
96 [2438]	8.64 [219]	10.04 [255]	7.04 [179]	8.18 [208]	6.34 [161]	7.36 [187]	5.59 [142]	6.49 [165]
108 [2743]	9.72 [247]	11.29 [287]	7.92 [201]	9.20 [234]	7.13 [181]	8.28 [210]	6.29 [160]	7.31 [186]
120 [3048]	10.80 [274]	12.55 [319]	8.80 [224]	10.22 [260]	7.92 [201]	9.20 [234]	6.99 [178]	8.12 [206]
145 [3683]	13.05 [331]	15.16 [385]	10.63 [270]	12.35 [314]	9.57 [243]	11.12 [282]	8.44 [214]	9.81 [249]

Table 4B: Inch Based PE-GF Minimum and Maximum Wall Thickness by SIDR

Nominal Pipe Size, in. [mm]	SIDR 19		SIDR 21		SIDR 24		SIDR 27	
	Min. Wall in. [mm]	Max. Wall in. [mm]	Min. Wall in. [mm]	Max. Wall in. [mm]	Min. Wall in. [mm]	Max. Wall in. [mm]	Min. Wall in. [mm]	Max. Wall in. [mm]
18 [457]	0.94 [24]	1.09 [28]	0.85 [22]	0.99 [25]	0.74 [19]	0.86 [22]	0.66 [17]	0.77 [19]
24 [610]	1.25 [32]	1.45 [37]	1.13 [29]	1.31 [33]	0.99 [25]	1.15 [29]	0.88 [22]	1.02 [26]
30 [762]	1.56 [40]	1.82 [46]	1.41 [36]	1.64 [42]	1.24 [31]	1.44 [37]	1.10 [28]	1.28 [32]
36 [914]	1.88 [48]	2.18 [55]	1.70 [43]	1.97 [50]	1.49 [38]	1.73 [44]	1.32 [34]	1.53 [39]
42 [1067]	2.19 [56]	2.54 [65]	1.98 [50]	2.30 [58]	1.73 [44]	2.01 [51]	1.54 [39]	1.79 [45]
48 [1219]	2.50 [64]	2.91 [74]	2.26 [57]	2.63 [67]	1.98 [50]	2.30 [58]	1.76 [45]	2.04 [52]
54 [1372]	2.81 [71]	3.27 [83]	2.55 [65]	2.96 [75]	2.23 [57]	2.59 [66]	1.98 [50]	2.30 [58]
60 [1524]	3.13 [79]	3.63 [92]	2.83 [72]	3.29 [83]	2.48 [63]	2.88 [73]	2.20 [56]	2.56 [65]
72 [1829]	3.75 [95]	4.36 [111]	3.39 [86]	3.94 [100]	2.97 [75]	3.45 [88]	2.64 [67]	3.07 [78]
84 [2134]	4.38 [111]	5.08 [129]	3.96 [101]	4.60 [117]	3.47 [88]	4.03 [102]	3.08 [78]	3.58 [91]
96 [2438]	5.00 [127]	5.81 [148]	4.53 [115]	5.26 [134]	3.96 [101]	4.60 [117]	3.52 [89]	4.09 [104]
108 [2743]	5.63 [143]	6.54 [166]	5.09 [129]	5.91 [150]	4.46 [113]	5.18 [131]	3.96 [101]	4.60 [117]
120 [3048]	6.25 [159]	7.26 [184]	5.66 [144]	6.57 [167]	4.95 [126]	5.75 [146]	4.40 [112]	5.11 [130]
145 [3683]	7.56 [192]	8.78 [223]	6.84 [174]	7.94 [202]	5.98 [152]	6.95 [176]	5.32 [135]	6.18 [157]

Table 4C: Inch Based PE-GF Minimum and Maximum Wall Thickness by SIDR

Nominal Pipe Size, in. [mm]	SIDR 31		SIDR 35		SIDR 39		SIDR 44	
	Min. Wall in. [mm]	Max. Wall in. [mm]	Min. Wall in. [mm]	Max. Wall in. [mm]	Min. Wall in. [mm]	Max. Wall in. [mm]	Min. Wall in. [mm]	Max. Wall in. [mm]
18 [457]	0.57 [15]	0.67 [17]	0.51 [13]	0.59 [15]	0.46 [12]	0.53 [13]	0.41 [10]	0.47 [12]
24 [610]	0.77 [19]	0.89 [23]	0.68 [17]	0.79 [20]	0.61 [15]	0.71 [18]	0.54 [14]	0.63 [16]
30 [762]	0.96 [24]	1.11 [28]	0.85 [22]	0.99 [25]	0.76 [19]	0.88 [22]	0.68 [17]	0.78 [20]
36 [914]	1.15 [29]	1.34 [34]	1.02 [26]	1.18 [30]	0.91 [23]	1.06 [27]	0.81 [21]	0.94 [24]
42 [1067]	1.34 [34]	1.56 [40]	1.19 [30]	1.38 [35]	1.07 [27]	1.24 [31]	0.95 [24]	1.10 [28]
48 [1219]	1.53 [39]	1.78 [45]	1.36 [34]	1.58 [40]	1.22 [31]	1.42 [36]	1.08 [27]	1.25 [32]
54 [1372]	1.72 [44]	2.00 [51]	1.53 [39]	1.77 [45]	1.37 [35]	1.59 [40]	1.22 [31]	1.41 [36]
60 [1524]	1.92 [49]	2.23 [57]	1.70 [43]	1.97 [50]	1.52 [39]	1.77 [45]	1.35 [34]	1.57 [40]
72 [1829]	2.30[58]	2.67 [68]	2.37 [60]	2.04 [52]	1.83 [46]	2.12 [54]	1.62 [41]	1.88 [48]
84 [2134]	2.68 [68]	3.12 [79]	2.38 [60]	2.76 [70]	2.13 [54]	2.48 [63]	1.89 [48]	2.20 [56]
96 [2438]	3.07 [78]	3.56 [90]	2.72 [69]	3.15 [80]	2.44 [62]	2.83 [72]	2.16 [55]	2.51 [64]
108 [2743]	3.45 [88]	4.01 [102]	3.05 [78]	3.55 [90]	2.74 [70]	3.18 [81]	2.43 [62]	2.82 [72]
120 [3048]	3.83 [97]	4.45 [113]	3.39 [86]	3.94 [100]	3.05 [77]	3.54 [90]	2.70 [69]	3.14 [80]
145 [3683]	4.63 [118]	5.38 [137]	4.10 [104]	4.76 [121]	3.68 [93]	4.28 [109]	3.26 [83]	3.79 [96]

Table 4D: Inch Based PE-GF Minimum and Maximum Wall Thickness by SIDR

Nominal Pipe Size, in. [mm]	SIDR 49		SIDR 55		SIDR 63		SIDR 70	
	Min. Wall in. [mm]	Max. Wall in. [mm]	Min. Wall in. [mm]	Max. Wall in. [mm]	Min. Wall in. [mm]	Max. Wall in. [mm]	Min. Wall in. [mm]	Max. Wall in. [mm]
18 [457]	0.36 [9]	0.42 [11]	0.32 [8]	0.38 [10]	0.28 [7]	0.33 [8]	0.25 [6]	0.30 [8]
24 [610]	0.48 [12]	0.56 [14]	0.43 [11]	0.50 [13]	0.38 [10]	0.44 [11]	0.34 [9]	0.39 [10]
30 [762]	0.61 [15]	0.70 [18]	0.54 [14]	0.63 [16]	0.47 [12]	0.55 [14]	0.42 [11]	0.49 [13]
36 [914]	0.73 [18]	0.84 [21]	0.65 [16]	0.75 [19]	0.57 [14]	0.66 [17]	0.51 [13]	0.59 [15]
42 [1067]	0.85 [22]	0.99 [25]	0.76 [19]	0.88 [22]	0.66 [17]	0.77 [19]	0.59 [15]	0.69 [18]
48 [1219]	0.97 [25]	1.13 [29]	0.86 [22]	1.00 [25]	0.75 [19]	0.88 [22]	0.68 [17]	0.79 [20]
54 [1372]	1.09 [28]	1.27 [32]	0.97 [25]	1.13 [29]	0.85 [22]	0.99 [25]	0.76 [19]	0.89 [23]
60 [1524]	1.21 [31]	1.41 [36]	1.08 [27]	1.25 [32]	0.94 [24]	1.10 [28]	0.85 [22]	0.99 [25]
72 [1829]	1.45 [37]	1.69 [43]	1.30 [33]	1.51 [38]	1.13 [29]	1.31 [33]	1.02 [26]	1.18 [30]
84 [2134]	1.70 [43]	1.97 [50]	1.51 [38]	1.76 [45]	1.32 [34]	1.53 [39]	1.19 [30]	1.38 [35]
96 [2438]	1.94 [49]	2.25 [57]	1.73 [44]	2.01 [51]	1.51 [38]	1.75 [45]	1.36 [34]	1.58 [40]
108 [2743]	2.18 [55]	2.53 [64]	1.94 [49]	2.26 [57]	1.70[43]	1.97 [50]	1.53 [39]	1.77 [45]
120 [3048]	2.42 [62]	2.82 [72]	2.16 [55]	2.51 [64]	1.89 [48]	2.19 [56]	1.70 [43]	1.97 [50]
145 [3683]	2.93 [74]	3.40 [86]	2.61 [66]	3.03 [77]	2.28 [58]	2.65 [67]	2.05 [52]	2.38 [61]

TABLE 4 *Continued*

Table 4E:Metric Based PE-GF Minimum and Maximum Wall Thickness by SIDR

Nominal Pipe Size, in. [mm]	SIDR 11		SIDR 13.5		SIDR 15		SIDR 17	
	Min wall in. [mm]	Max wall in., [mm]	Min wall in., [mm]	Max wall in., [mm]	Min wall in., [mm]	Max wall in., [mm]	Min wall in., [mm]	Max wall in., [mm]
12 [300]	1.07 [27.2]	1.26 [32]	0.88 [22.4]	0.98 [25]	0.80 [20.2]	0.88 [22.4]	0.70 [17.8]	0.78 [19.7]
16 [400]	1.43 [36.4]	1.65 [42]	1.17 [29.7]	1.30 [33]	1.06 [26.9]	1.17 [29.7]	0.94 [23.8]	1.04 [26.3]
20 [500]	1.79 [45.4]	2.09 [53]	1.46 [37.1]	1.63 [41.5]	1.32 [33.6]	1.46 [37.1]	1.17 [29.7]	1.29 [32.8]
24 [600]	2.14 [54.4]	2.48 [63]	1.75 [44.5]	1.97 [50]	1.59 [40.3]	1.75 [44.5]	1.41 [35.7]	1.55 [39.4]
28 [700]	2.50 [63.5]	2.91 [74]	2.04 [51.8]	2.28 [58]	1.85 [47.0]	2.04 [51.8]	1.64 [41.6]	1.81 [45.9]
32 [800]	2.87 [73]	3.31 [84]	2.33 [59.2]	2.60 [66]	2.11 [53.7]	2.33 [59.2]	1.87 [47.5]	2.06 [52.4]
36 [900]	3.23 [82]	3.74 [95]	2.63 [66.7]	2.95 [75]	2.38 [60.5]	2.63 [66.7]	2.11 [53.5]	2.32 [59.0]
40 [1000]	3.58 [91]	4.13 [105]	2.92 [74.1]	3.27 [83]	2.65 [67.2]	2.92 [74.1]	2.34 [59.4]	2.58 [65.5]
44 [1100]	3.94 [100]	4.57 [116]	3.22 [81.7]	3.58 [91]	2.91 [74.0]	3.22 [81.7]	2.57 [65.3]	2.84 [72.1]
48 [1200]	4.29 [109]	4.96 [126]	3.50 [88.8]	3.90 [99]	3.17 [80.6]	3.50 [88.8]	2.81 [71.3]	3.09 [78.6]
52 [1300]	4.65 [118]	5.39 [137]	3.78 [96.0]	4.25 [108]	3,42 [87.0]	3.78 [96.0]	3.04 [77.2]	3.35 [85.2]
56 [1400]	5.00 [127]	5.83 [148]	4.09 [104]	4.61 [117]	3.70 [94.0]	4.08 [103.6]	3.28 [83.2]	3.61 [91.7]
64 [1600]	5.71 [145]	6.65 [169]	4.66 [118.4]	5.24 [133]	4.23 [107.5]	4.66 [118.4]	3.74 [95.1]	4.13 [104.8]
72 [1800]	6.42 [163]	7.48 [190]	5.24 [133.1]	5.91 [150]	4.76 [120.9]	5.24 [133.1]	4.21 [107.0]	4.64 [117.9]
80 [2000]	7.17 [182]	8.31 [211]	5.82 [147.9]	6.54 [166]	5.29 [134.3]	5.82 [147.9]	4.68 [118.9]	5.15 [130.9]
88 [2200]	7.87 [200]	9.13 [232]	6.41 [162.7]	7.20 [183]	5.82 [147.8]	6.41 [162.7]	5.15 [130.8]	5.67 [144.0]
96 [2400]	8.58 [218]	9.96 [253]	6.99 [177.5]	7.87 [200]	6.35 [161.2]	6.99 [177.5]	5.61 [142.6]	6.18 [157.0]
104 [2600]	9.29 [236]	10.79 [274]	7.57 [192.3]	8.50 [216]	6.88 [174.7]	7.57 [192.3]	6.08 [154.5.]	6.70 [170.1]
112 [2800]	10.04 [255]	11.61 [295]	8.15 [207.1]	9.17 [233]	7.41 [188.1]	8.15 [207.1]	6.55 [166.4]	7.21 [183.2]
120 [3000]	10.75 [273]	12.44 [316]	8.73 [221.8]	9.84 [250]	7.93 [201.5]	8.73 [221.8]	7.02 [178.3]	7.73 [196.3]
128 [3200]	11.46 [291]	13.31 [338]	9.31 [236.6]	10.51 [267]	8.46 [215.0]	9.31 [236.8]	7.49 [190.2]	8.24 [209.4]
136 [3400]	12.20 [310]	14.09 [358]	9.90 [251.4]	11.18 [284]	8.99 [228.4]	9.90 [251.4]	7.96 [202.1]	8.76 [222.5]
144 [3600]	12.91 [328]	14.88 [378]	10.48 [266]	11.85 [301]	9.52 [241.8]	10.48 [266.1]	8.43 [214.0]	9.27 [235.5]
152 [3800]	13.54 [344]	15.67 [398]	11.06 [281]	12.48 [317]	10.05 [255.3]	11.06 [281.0]	8.89 [225.8]	9.78 [248.5]
160 [4000]	14.25 [362]	16.54 [420]	11.64 [295.7]	13.15 [334]	10.58 [268.7]	11.64 [295.7]	9.36 [237.7]	10.30 [261.6]

Table 4F:Metric Based PE-GF Minimum and Maximum Wall Thickness by SIDR

Nominal Pipe Size, in. [mm]	SIDR 19		SIDR 21		SIDR 24		SIDR 27	
	Min wall in. [mm]	Max wall in., [mm]	Min wall in., [mm]	Max wall in., [mm]	Min wall in., [mm]	Max wall in., [mm]	Min wall in., [mm]	Max wall in., [mm]
12 [300]	0.62 [15.8]	0.69 [17.5]	0.55 [14.0]	0.61 [15.5]	0.49 [12.4]	0.54 [13.8]	0.43 [11.0]	0.48 [12.2]
16 [400]	0.83 [21.1]	0.92 [23.4]	0.74 [18.7]	0.81 [20.7]	0.65 [16.5]	0.72 [18.3]	0.58 [14.7]	0.64 [16.3]
20 [500]	1.04 [26.3]	1.15 [29.1]	0.92 [23.3]	1.02 [25.8]	0.81 [20.7]	0.90 [22.9]	0.72 [18.3]	0.80 [20.3]
24 [600]	1.24 [31.6]	1.37 [34.9]	1.10 [28.0]	1.22 [30.9]	0.98 [24.8]	1.08 [27.4]	0.87 [22.0]	0.96 [24.3]
28 [700]	1.45 [36.8]	1.60 [40.6]	1.28 [32.6]	1.42 [36.0]	1.14 [29.0]	1.26 [32.0]	1.01 [25.7]	1.12 [28.4]
32 [800]	1.66 [42.1]	1.83 [46.5]	1.47 [37.3]	1.62 [41.2]	1.30 [33.1]	1.44 [36.6]	1.16 [29.4]	1.28 [32.5]
36 [900]	1.87 [47.4]	2.06 [52.3]	1.65 [42.0]	1.82 [46.3]	1.46 [37.2]	1.62 [41.1]	1.30 [33.0]	1.43 [36.4]
40 [1000]	2.07 [52.6]	2.28 [58.0]	1.83 [46.6]	2.02 [51.4]	1.63 [41.4]	1.80 [45.7]	1.44 [36.7]	1.59 [40.5]
44 [1100]	2.28 [58.0]	2.52 [64.0]	2.02 [51.2]	2.22 [56.4]	1.79 [45.4]	1.98 [50.2]	1.59 [40.4]	1.76 [44.6]
48 [1200]	2.49 [63.2]	2.74 [69.7]	2.20 [56.0]	2.43 [61.7]	1.95 [49.6]	2.15 [54.7]	1.73 [44.0]	1.91 [48.5]
52 [1300]	2.70 [68.6]	2.97 [75.4]	2.39 [60.8]	2.64 [67.0]	2.12 [57.9]	2.34 [59.4]	1.88 [47.8]	2.07 [52.6]
56 [1400]	2.90 [73.7]	3.20 [81.2]	2.57 [65.3]	2.83 [72.0]	2.28 [66.2]	2.51 [63.8]	2.02 [51.4]	2.23 [56.7]
64 [1600]	3.31 [84.2]	3.65 [92.8]	2.94 [74.6]	3.24 [82.2]	2.61 [74.4]	2.87 [73.0]	2.31 [58.7]	2.55 [64.7]
72 [1800]	3.73 [94.7]	4.11 [104.3]	3.31 [84.0]	3.64 [92.5]	2.93 [74.4]	3.23 [82.0]	2.60 [66.1]	2.87 [72.9]
80 [2000]	4.15 [105.3]	4.57 [116.0]	3.67 [93.3]	4.05 [102.8]	3.26 [82.7]	3.59 [91.1]	2.89 [73.4]	3.19 [80.9]
88 [2200]	4.56 [115.8]	5.02 [127.5]	4.04 [102.6]	4.45 [113.0]	3.58 [91.0]	3.94 [100.2]	3.18 [80.7]	3.50 [88.9]
96 [2400]	4.97 [126.3]	5.48 [139.1]	4.41 [111.9]	4.85 [123.2]	3.91 [99.3]	4.31 [109.4]	3.47 [88.1]	3.82 [97.1]
104 [2600]	5.39 [136.8]	5.93 [150.6]	4.78 [121.3]	5.26 [133.6]	4.23 [107.5]	4.66 [118.4]	3.76 [95.4]	4.14 105.1]
112 [2800]	5.80 [147.4]	6.39 [162.3]	5.14 [130.6]	5.66 [143.8]	4.56 [115.8]	5.02 [127.5]	4.04 [102.7]	4.45 [113.1]
120 [3000]	6.22 [157.9]	6.84 [173.8]	5.51 [139.9]	6.06 [154.0]	4.89 [124.1]	5.38 [136.7]	4.33 [110.1]	4.78 [121.3]
128 [3200]	6.63 [168.4]	7.30 [185.4]	5.88 [149.3]	6.47 [164.4]	5.21 [132.3]	5.74 [145.7]	4.62 [117.4]	5.09 [129.3]
136 [3400]	7.04 [178.9]	7.75 [196.9]	6.24 [158.6]	6.87 [174.6]	5.54 [140.6]	6.09 [154.8]	4.91 [124.8]	5.41 [137.4]
144 [3600]	7.46 [189.5]	8.21 [208.6]	6.61 [167.9]	7.28 [184.8]	5. 86 [148.9]	6.45 [163.9]	5.20 [132.1]	5.73 [145.5]
153 [3800]	7.87 [200.0]	8.67 [220.1]	6.98 [177.2]	7.68 [195.1]	6.19 [157.2]	6.81 [173.1]	5.49 [139.4]	6.04 [153.5]
160 [4000]	8.29 [210.5]	9.12 [231.7]	7.35 [186.6]	8.09 [205.4]	6.51 [165.4]	7.17 [182.1]	5.78 [146.8]	6.36 [161.6]

Table 4G:Metric Based PE-GF Minimum and Maximum Wall Thickness by SIDR

Nominal Pipe Size, in. [mm]	SIDR 31		SIDR 35		SIDR 39		SIDR 44	
	Min wall in. [mm]	Max wall in., [mm]	Min wall in., [mm]	Max wall in., [mm]	Min wall in., [mm]	Max wall in., [mm]	Min wall in., [mm]	Max wall in., [mm]
12 [300]	0.39 [9.8]	0.43 [10.9]	0.34 [8.7]	0.38 [9.7]	0.30 [7.7]	0.34 [8.6]	0.27 [6.9]	0.30 [7.7]
16 [400]	0.51 [13.0]	0.57 [14.4]	0.46 [11.8]	0.51 [12.9]	0.41 [10.3]	0.45 [11.5]	0.36 [9.1]	0.40 [10.2]
20 [500]	0.64 [16.3]	0.71 [18.1]	0.57 [14.5]	0.63 [16.1]	0.51 [12.9]	0.56 [14.3]	0.45 [11.4]	0.50 [12.7]
24 [600]	0.77 [19.5]	0.85 [21.6]	0.69 [17.4]	0.76 [19.3]	0.61 [15.4]	0.67 [17.1]	0.54 [13.7]	0.60 [15.2]
28 [700]	0.90 [22.8]	0.99 [25.2]	0.80 [20.3]	0.89 [22.5]	0.71 [18.0]	0.78 [19.9]	0.63 [16.0]	0.70 [17.7]
32 [800]	1.03 [26.1]	1.14 [28.9]	0.91 [23.1]	1.01 [25.6]	0.81 [20.6]	0.90 [22.8]	0.72 [18.3]	0.80 [20.3]
36 [900]	1.15 [29.3]	1.28 [32.4]	1.02 [26.0]	1.13 [28.7]	0.91 [23.1]	1.01 [25.6]	0.81 [20.6]	0.90 [22.8]
40 [1000]	1.28 [32.6]	1.42 [36.0]	1.14 [28.9]	1.26 [31.9]	1.01 [25.7]	1.12 [28.4]	0.90 [22.8]	0.99 [25.2]
44 [1100]	1.41[35.8]	1.56 [39.6]	1.25 [31.8]	1.39 [35.4]	1.11 [28.3]	1.23 [31.3]	0.99 [25.1]	1.09 [27.8]
48 [1200]	1.54 [39.1]	1.70 [43.2]	1.37 [34.7]	1.51 [38.3]	1.21 [30.8]	1.34 [34.0]	1.08 [27.4]	1.19 [30.3]
52 [1300]	1.67 [42.3]	1.84 [46.8]	1.48 [37.6]	1.64 [41.6]	1.31 [33.4]	1.45 [36.9]	1.17 [29.7]	1.29 [32.8]
56 [1400]	1.80 [45.6]	1.98 [50.3]	1.59 [40.5]	1.76 [44.7]	1.42 [36.0]	1.56 [39.7]	1.26 [32.0]	1.39 [35.3]
64 [1600]	2.05 [52.1]	2.26 [57.5]	1.82 [46.3]	2.01 [51.1]	1.62 [41.1]	1.79 [45.4]	1.44 [36.6]	1.59 [40.4]