



Designation: ~~F3123--18a~~ F3123 - 22

An American National Standard

Standard Specification for Metric Outside Diameter Polyethylene (PE) Plastic Pipe (DR- PN)¹

This standard is issued under the fixed designation F3123; 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 metric outside diameter polyethylene (PE) pipe made from polyethylene compound that qualifies for MRS, HDB and HDS ratings and for PE100 and PE4710 designations. Included are requirements for polyethylene compound, workmanship, dimensions, short-term stress and ductility, long-term stress, marking, quality assurance and verification of joining.

1.1.1 Polyethylene pipe in accordance with **Table 1** is intended to be compatible with nominal diameters in accordance with ISO 161-1, Specification ~~D3035~~**F714** and other pipe sizing conventions, nominal pressures in accordance with ISO 161-1 and wall thickness in accordance with ISO 4065.

1.1.2 Polyethylene pipe in accordance with **Table 2** is intended to be outside diameter compatible with steel pipe NPS/IPS nominal outside diameter pipe in accordance with specifications such as Specification **D3035**, Specification **F714**, or AWWA C906.

1.1.3 Polyethylene pipe in accordance with **Table 3** is intended to be outside diameter compatible with cast iron/ductile iron, DIPS/DIOD outside diameter pipe in accordance with specifications such as Specification ~~D3035~~, Specification ~~F714~~, or AWWA C906.

<https://standards.iteh.ai/catalog/standards/sist/ceffa966-5d15-494d-9e74-4cf673c66290/astm-f3123-22>

1.2 Pipes produced under this specification are intended for the pressure or non-pressure conveyance of liquid or gaseous media. Pipes produced under this specification are not intended as enclosures for electrical or communications components. See **Appendix X1**.

1.3 The values stated in SI units are to be regarded as standard. No other units of measurement are included in this standard.

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

1.5 The ANS label on this international standard certifies the development of this international standard in accordance with requirements for openness, balance, consensus and due process in accordance with *ANSI Essential Requirements: Due Process Requirements for American National Standards* and denotes in addition that this international standard is an American National Standard.

¹ This specification is under the jurisdiction of ASTM Committee **F17** on Plastic Piping Systems and is the direct responsibility of Subcommittee **F17.26** on Olefin Based Pipe.

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

TABLE 1 Diameter and Wall Thickness Dimensions and Tolerances, mm

Nominal Diameter, DN	Outside Diameter			Minimum Wall Thickness, t															
	Min. (d_n)	Tol.	OOR Tol.	PN 25		PN 20		PN 16		PN 12.5		PN 10		PN 8		PN 6		PN 5	
				DR 7.4	DR 9	DR 11	DR 13.6	DR 17	DR 21	DR 26	DR 33								
32	32	0.3	1.3	4.4	0.6	3.6	0.5	3	0.4
40	40	0.4	1.4	5.5	1.7	4.5	0.6	3.7	0.5	3.0	0.5
50	50	0.4	1.4	6.9	1.8	5.6	0.7	4.6	0.6	3.7	0.5	3.0	0.4
63	63	0.4	1.5	8.6	1	7.1	0.9	5.8	0.7	4.7	0.5	3.8	0.5	3	0.4
75	75	0.5	1.6	10.3	1.2	8.4	1	6.8	0.8	5.6	0.6	4.5	0.6	3.6	0.5
90	90	0.6	1.8	12.3	1.5	10.1	1.2	8.2	1	6.7	0.8	5.4	0.7	4.3	0.6	3.5	0.5
110	110	0.7	2.2	15.1	1.7	12.3	1.4	10	1.1	8.1	1	6.6	0.8	5.3	0.7	4.2	0.6
125	125	0.8	2.5	17.1	1.9	14	1.6	11.4	1.3	9.2	1.1	7.4	0.9	6	0.7	4.8	0.6
140	140	0.9	2.8	19.2	2.1	15.7	1.7	12.7	1.4	10.3	1.2	8.3	1	6.7	0.8	5.4	0.7
160	160	1	3.2	21.9	2.3	17.9	1.9	14.6	1.6	11.8	1.3	9.5	1.1	7.7	0.9	6.2	0.8
180	180	1.1	3.6	24.6	2.6	20.1	2.2	16.4	1.8	13.3	1.5	10.7	1.2	8.6	1	6.9	0.8
200	200	1.2	4	27.4	2.9	22.4	2.4	18.2	2	14.7	1.5	11.9	1.3	9.6	1.1	7.7	0.9
225	225	1.4	4.5	30.8	3.2	25.2	2.7	20.5	2.2	16.6	1.8	13.4	1.5	10.8	1.2	8.6	1
250	250	1.5	5	34.2	3.6	27.9	4.2	22.7	2.4	18.4	2	14.8	1.6	11.9	1.3	9.6	1.1
280	280	1.7	9.8	38.3	4	31.3	4.7	25.4	2.7	20.6	2.2	16.6	1.8	13.4	1.5	10.7	1.2
315	315	1.9	11.1	43.1	4.5	35.2	5.3	28.6	3	23.2	2.3	18.7	2	15	1.6	12.1	1.4	9.7	1.1
355	355	2.2	12.5	48.5	5	39.7	6	32.2	4.9	26.1	2.8	21.1	2.3	16.9	1.8	13.6	1.5	10.9	2.2
400	400	2.4	14	54.7	5.6	44.7	6.8	36.3	5.5	29.4	3.1	23.7	2.5	19.1	2.1	15.3	1.7	12.3	2.4
450	450	2.7	15.8	61.5	6.3	50.3	7.6	40.9	6.2	33.1	4.9	26.7	2.8	21.5	2.3	17.2	1.9	13.8	2.7
500	500	3	17.5	68.4	10.3	55.8	8.4	45.4	6.9	36.8	5.5	29.7	2.9	23.9	2.5	19.1	2.1	15.3	2.7
560	560	3.4	19.6	76.6	11.5	62.5	9.4	50.8	7.7	41.2	6.1	33.2	4.9	26.7	2.8	21.4	2.3	17.2	2.9
630	630	3.8	22.1	86.1	13	70.3	10.6	57.2	8.7	46.3	6.9	37.4	5.6	30	4.5	24.1	2.6	19.3	3.1
710	710	6.4	24.9	97.1	14.5	79.3	12	64.5	9.8	52.2	7.8	42.1	6.3	33.9	5	27.2	2.9	21.8	3.3
800	800	7.2	28	109.3	16.3	89.3	13.5	72.6	11	58.8	8.8	47.4	7.1	38.1	5.7	30.6	4.5	24.5	3.6
900	900	8.1	31.5	100.6	15	81.7	12.4	66.2	9.9	53.3	7.9	42.9	6.4	34.4	5.1	27.6	3.9
1000	1000	9	35	111.8	16.7	90.2	13.7	72.5	10.8	59.3	8.8	47.7	7.1	38.2	5.7	30.6	4.5
1200	1200	10.8	42	109.5	16.4	88.2	13.2	67.9	10.1	57.2	8.5	45.9	6.8	36.7	5.5
1400	1400	12.6	49	102.9	15.4	82.4	12.3	66.7	10	53.5	8	42.9	6.4
1600	1600	14.4	56	117.6	17.6	94.1	14.1	76.2	11.4	61.2	9.1	49	7.3
1800	1800	16.2	63	105.9	15.8	85.7	12.8	69.1	10.3	54.5	8.1
2000	2000	18	70	117.6	17.6	95.2	14.2	76.9	11.5	60.6	9
2100	2100	18.9	73.5	100	15	80.8	12.2	63.6	9.6
2250	2250	20.3	78.7	107.2	16.1	86	12.9	68.2	10.2
2300	2300	20.7	80.5	109.5	16.5	88.5	13.3	69.7	10.5
2500	2500	22.5	87.5	119	17.9	96.2	14.5	75.8	11.4

^A For minimum wall ≤ 30.0 mm, tolerance equals $0.1 \times$ minimum wall, rounded up to the nearest 0.1 mm. For minimum wall > 30.0 mm, tolerance equals $0.15 \times$ minimum wall, to nearest whole 0.1 mm, with decimal values beyond 0.1 mm dropped.

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1.6 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
- D746 Test Method for Brittleness Temperature of Plastics and Elastomers by Impact
- 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
- D1435 Practice for Outdoor Weathering of Plastics
- 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
- D1599 Test Method for Resistance to Short-Time Hydraulic Pressure of Plastic Pipe, Tubing, and Fittings
- D1600 Terminology for Abbreviated Terms Relating to Plastics
- D1603 Test Method for Carbon Black Content in Olefin Plastics
- D2122 Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings
- D2290 Test Method for Apparent Hoop Tensile Strength of Plastic or Reinforced Plastic Pipe

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.

TABLE 2 NPS/IPS Diameter and Wall Thickness Dimensions and Tolerances, mm

NPS/IPS Nominal Size ^A	Outside Diameter ^A		PN 25.5 DR 7.3 ^A		PN 20 DR 9 ^A		PN 16 DR 11 ^A		PN 12.8 DR 17 ^A		PN 10 DR 21 ^A		PN 8 DR 21 ^A		PN 6.4 DR 26 ^A		PN 5.08 DR 32.5 ^A	
	d_o	tol	t	Tol ^B	t	Tol ^B	t	Tol ^B	t	Tol ^B	t	Tol ^B	t	Tol ^B	t	Tol ^B	t	Tol ^B
1	33.3	0.3	1.3	0.6	3.8	0.5	3.1	0.5	2.5	0.4	2.0	0.3	1.7	0.3	1.3	0.3
1 1/4	42.0	0.3	1.4	0.7	4.7	0.6	3.9	0.5	3.1	0.5	2.5	0.4	2.1	0.4	1.7	0.3
1 1/2	48.1	0.3	1.4	0.8	5.4	0.7	4.4	0.6	3.6	0.5	2.9	0.4	2.4	0.4	1.9	0.3
2	60.2	0.3	1.5	1.0	6.8	0.8	5.5	0.7	4.5	0.6	3.6	0.5	2.9	0.4	2.4	0.4	2.2	0.4
3	88.7	0.4	1.8	1.4	10.0	1.1	8.1	1.0	6.6	0.8	5.3	0.7	4.3	0.6	3.4	0.5	3.3	0.5
4	114.1	0.5	2.3	1.7	12.8	1.4	10.5	1.2	8.4	1.0	6.8	0.8	5.5	0.7	4.4	0.6	4.2	0.6
6	168.0	0.6	3.4	2.4	18.8	2.0	15.4	1.7	12.4	1.4	10.0	1.1	8.1	1.0	6.5	0.8	6.2	0.8
8	218.7	0.7	4.4	2.9	24.5	2.6	20.0	2.1	16.1	1.8	13.0	1.4	10.6	1.2	8.4	1.0	8.0	0.9
10	272.7	0.8	5.5	3.6	30.5	4.6	24.9	2.6	20.1	2.2	16.2	1.8	13.2	1.5	10.5	1.2	10.0	1.1
12	323.4	0.9	6.5	4.4	36.2	5.5	29.5	4.5	23.8	2.5	19.2	2.1	15.6	1.7	12.4	1.4	11.9	1.3
14	354.0	3.2	7.1	4.8	39.6	6.0	32.3	4.9	26.0	2.7	21.0	2.2	17.1	1.9	13.6	1.5	13.0	1.4
16	404.6	3.7	8.1	5.3	45.3	6.8	36.9	5.6	29.7	4.5	24.0	2.5	19.5	2.1	15.5	1.7	14.8	1.6
18	455.1	4.1	9.2	6.2	50.9	7.7	41.5	6.3	33.5	5.1	27.0	2.8	22.0	2.3	17.5	1.9	16.7	1.8
20	505.7	4.6	10.2	10.4	56.6	8.5	46.2	7.0	37.2	5.6	30.0	4.5	24.4	2.6	19.4	2.1	18.5	2.0
22	556.3	5.0	19.5	11.5	62.2	9.4	50.8	7.7	40.9	6.2	33.0	5.0	26.8	2.8	21.4	2.3	20.4	2.2
24	606.9	5.5	21.3	12.5	67.9	10.2	55.4	8.4	44.6	6.7	36.0	5.4	29.3	4.4	23.3	2.5	22.2	2.4
26	657.4	5.9	23.1	...	73.5	11.1	60.0	9.0	48.3	7.3	39.0	5.9	31.7	4.8	25.2	2.7	24.1	2.6
28	708.0	6.4	24.8	...	79.2	11.9	64.6	9.7	52.0	7.8	42.0	6.3	34.1	5.2	27.2	4.1	25.9	2.7
30	758.6	6.9	26.6	...	84.8	12.8	69.2	10.4	55.7	8.4	45.0	6.8	36.6	5.5	29.1	4.4	27.8	4.2
32	809.1	7.3	28.4	...	90.5	13.6	73.8	11.1	59.4	9.0	48.0	7.2	39.0	5.9	31.0	4.7	29.6	4.5
34	859.7	7.8	30.1	78.4	11.8	63.2	9.5	51.0	7.7	41.4	6.3	33.0	5.0	31.5	4.8
36	910.3	8.2	31.9	83.1	12.5	66.9	10.1	54.0	8.1	43.9	6.6	34.9	5.3	33.3	5.0
42	1062.0	9.6	37.2	78.0	11.7	63.0	9.5	51.2	7.7	40.7	6.2	38.9	5.9
48	1213.7	11.0	42.5	89.1	13.4	72.0	10.8	58.5	8.8	46.5	7.0	44.4	6.7
54	1365.4	12.3	47.8	81.0	12.2	65.8	9.9	52.3	7.9	49.9	7.5
63	1593.0	14.4	55.8	76.7	11.6	61.1	9.2	58.3	8.8
65	1643.6	14.9	57.6	79.2	11.9	63.0	9.5	60.1	9.1

^A NPS/IPS Nominal Size, outside diameter, and DR consistent with Specification D3035. The outside diameter, d_o , is a minimum and the tolerance is plus only.

^B For minimum wall <30.0 mm, tolerance equals 0.1 x minimum wall, rounded up to the nearest 0.1 mm. For minimum wall >30.0 mm, tolerance equals 0.15 x minimum wall, to nearest whole 0.1 mm, with decimal values beyond 0.1 mm dropped.

TABLE 3 DIOD/DIPS Diameter and Wall Thickness Dimensions and Tolerances, mm

DIOD/ DIPS Nominal Size ^A	Outside Diameter ^A			PN 24 DR 7.7 ^A		PN 20 DR 9 ^A		PN 16 DR 11 ^A		PN 12 DR 14.3 ^A		PN 10 DR 17 ^A		PN 8 DR 21 ^A	
	min	OOR													
	d_n	min	OOR												
	tol	tol	t	tol ^B	t	tol ^B	t	tol ^B	t	tol ^B	t	tol ^B	t	tol ^B	t
3	100.1	1.0	1.9	13.7	1.5	11.2	1.3	9.2	1.1	7.4	0.9	6.0	0.7	4.9	0.6
4	121.4	1.1	2.0	16.6	1.8	13.6	1.5	11.1	1.3	9.0	1.0	7.2	0.9	5.9	0.7
6	174.5	1.6	2.4	23.9	2.5	19.6	2.1	16.0	1.7	12.9	1.4	10.4	1.2	8.5	1.0
8	228.8	2.1	2.9	31.3	4.7	25.6	2.7	20.9	2.2	16.8	1.8	13.6	1.5	11.1	1.3
10	280.7	2.6	3.3	38.4	5.8	31.4	4.8	25.6	2.7	20.7	2.2	16.7	1.8	13.6	1.5
12	333.8	3.1	6.7	45.7	6.9	37.4	5.7	30.5	4.6	24.6	2.6	19.8	2.1	16.1	1.8
14	386.9	3.5	7.8	52.9	8.0	43.3	6.5	35.3	5.3	28.5	4.3	23.0	2.4	18.7	2.0
16	440.0	4.0	8.8	60.2	9.1	49.2	7.4	40.2	6.1	32.3	4.9	26.1	2.8	21.2	2.3
18	493.1	4.5	9.9	67.4	10.2	55.2	8.3	45.0	6.8	36.2	5.5	29.3	4.4	23.8	2.5
20	546.2	5.0	11.0	61.1	9.2	49.9	7.5	40.1	6.1	32.4	4.9	26.3	2.8
24	652.4	5.9	13.1	59.5	9.0	47.9	7.2	38.7	5.9	31.5	4.8
30	809.1	7.3	16.2	59.4	9.0	48.0	7.2	39.0	5.9
36	968.4	8.8	19.4	57.5	8.7	46.7	7.1
42	1125.2	10.2	22.6	66.8	10.1	54.2	8.2
48	1284.5	11.6	45.0	61.9	9.3

^A DIOD/DIPS Nominal Size, outside diameter, and DR consistent with Specification D3035. The outside diameter, d_n , is a minimum and the tolerance is plus only.
^B For minimum wall <30.0 mm, tolerance equals 0.1 × minimum wall, rounded up to the nearest 0.1 mm. For minimum wall >30.0 mm, tolerance equals 0.15 × minimum wall, to nearest whole 0.1 mm, with decimal values beyond 0.1 mm dropped.

- [D2565 Practice for Xenon-Arc Exposure of Plastics Intended for Outdoor Applications](#)
- [D2837 Test Method for Obtaining Hydrostatic Design Basis for Thermoplastic Pipe Materials or Pressure Design Basis for Thermoplastic Pipe Products](#)
- [D3035 Specification for Polyethylene \(PE\) Plastic Pipe \(DR-PR\) Based on Controlled Outside Diameter](#)
- [D3350 Specification for Polyethylene Plastics Pipe and Fittings Materials](#)
- [D3895 Test Method for Oxidative-Induction Time of Polyolefins by Differential Scanning Calorimetry](#)
- [D4218 Test Method for Determination of Carbon Black Content in Polyethylene Compounds by the Muffle-Furnace Technique](#)
- [F412 Terminology Relating to Plastic Piping Systems](#)
- [F714 Specification for Polyethylene \(PE\) Plastic Pipe \(DR-PR\) Based on Outside Diameter](#)
- [F905 Practice for Qualification of Polyethylene Saddle-Fused Joints](#)
- [F1055 Specification for Electrofusion Type Polyethylene Fittings for Outside Diameter Controlled Polyethylene and Crosslinked Polyethylene \(PEX\) Pipe and Tubing](#)
- [F1056 Specification for Socket Fusion Tools for Use in Socket Fusion Joining Polyethylene Pipe or Tubing and Fittings](#)
- [F1290 Practice for Electrofusion Joining Polyolefin Pipe and Fittings](#)
- [F1473 Test Method for Notch Tensile Test to Measure the Resistance to Slow Crack Growth of Polyethylene Pipes and Resins](#)
- [F2620 Practice for Heat Fusion Joining of Polyethylene Pipe and Fittings](#)
- [F2928 Practice for Specimens and Testing Conditions for Testing Polyethylene \(PE\) Pipe Butt Fusions Using Tensile and Hydrostatic Test Methods](#)
- [G155 Practice for Operating Xenon Arc Lamp Apparatus for Exposure of Materials](#)
- 2.2 *ISO Documents*³
 - [ISO 161-1 Thermoplastics pipes for the conveyance of fluids—Nominal outside diameters and nominal pressures—Part 1: Metric series](#)
 - [ISO 4065 Thermoplastics pipes—Universal wall thickness table](#)
 - [ISO 4437 Plastic piping systems for the supply of gaseous fuels](#)
 - [ISO 9000 Quality management](#)
 - [ISO 9080 Plastics piping and ducting systems—Determination of the long-term hydrostatic strength of thermoplastics materials in pipe form by extrapolation](#)
 - [ISO 12162 Thermoplastics materials for pipes and fittings for pressure applications—Classification and designation—Overall service \(design\) coefficient](#)
 - [ISO 13477 Thermoplastics pipes for the conveyance of fluids—Determination of resistance to rapid crack propagation \(RCP\)—Small-scale steady-state test \(S4 test\)](#)
 - [ISO 13478 Thermoplastics pipes for the conveyance of fluids—Determination of resistance to rapid crack propagation \(RCP\)—Full-scale test \(FST\)](#)
 - [ISO 16871 Plastics piping and ducting systems—Plastics pipes and fittings—Method for exposure to direct \(natural\) weathering](#)

³ Available from International Organization for Standardization (ISO), 1, ch. de la Voie-Creuse, CP 56, CH-1211 Geneva 20, Switzerland, <http://www.iso.org>.

ISO 18553 Method for the assessment of the degree of pigment or carbon black dispersion in polyolefin pipes, fittings and compounds

2.3 NSF International Standards:⁴

NSF/ANSI Standard No. 14 for Plastic Piping Components and Related Materials

NSF/ANSI Standard No. 61 for Drinking Water System Components—Health Effects

2.4 PPI Documents:⁵

TR-3 Policies and Procedures for Developing Hydrostatic Design Basis (HDB), Pressure Design Basis (PDB), Strength Design Basis (SDB), and Minimum Required Strength (MRS) Ratings for Thermoplastic Piping Materials or Pipe

TR-4 Listing of Hydrostatic Design Bases (HDB), Strength Design Bases (SDB), Pressure Design Bases (PDB) and Minimum Required Strength (MRS) Ratings for Thermo plastic Piping Materials or Pipe

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

Handbook of Polyethylene Pipe, Second Edition

2.5 Other Documents:

ANSI Essential Requirements : Due process requirements for American National Standards⁶

AS/NZS 4130 Polyethylene (PE) Pipes for Pressure Applications⁷

Decision on Principles for the Development of International Standards , Guides and Recommendations⁸

Guidelines for Drinking-Water Quality, Third Edition Incorporating the First and Second Addenda, Volume 1: Recommendations, World Health Organization, Geneva, 2008⁹

EU Council Directive 98/83/EC of 3 November 1998 on the quality of water intended for human consumption¹⁰

AWWA C906 Polyethylene (PE) Pressure Pipe and Fittings, 4 In. Through 65 In. (100 mm Through 1,650 mm), for Waterworks¹¹

3. Terminology

3.1 Definitions—Unless otherwise specified, abbreviations, initialisms, and definitions are in accordance with Terminology F412, and Terminology D1600.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 application design coefficient, C_A , n —A coefficient or series of coefficients applied to Categorized Required strength, $CRS_{(\theta,T)}$ in accordance with 3.2.5.2, that account for application, fluid being transported, installation method and operating conditions. See 3.2.5 and A1.5.

3.2.2 application factor, f_A , n —a coefficient applied to PN in accordance with 3.2.5.1 of 1 or less that accounts for estimated long-term application effects such as chemical effects of fluid media or environment, variation of external or internal temperature or stress, and installation.

3.2.3 categorized required strength, $CRS_{(\theta,T)}$, n —a property of the material in accordance with ISO 9080 and ISO 12162 that represents a classification range in MPa of the 97.5 % lower confidence limit of the mean long-term strength at a temperature in °C other than 20 °C, θ , and at a time in years, T .

3.2.4 design stress, σ_S , n —the quotient of MRS divided by C_{min} . Design stress is at 20 °C and applicable to the conveyance of water.

3.2.5 maximum allowable operating pressure, PFA, n —the maximum operating pressure in bar determined by the designer/user that accounts for polyethylene compound properties, the media being conveyed and the conditions of conveyance.

3.2.5.1 Determination of maximum allowable operating pressure, PFA, and pressure number, PN—PN—The following equation is used in this specification to relate maximum allowable operating pressure, PFA, and pressure number, PN:

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

⁵ Available from Plastics Pipe Institute (PPI), 105 Decker Court, Suite 825, Irving, TX 75062, <http://www.plasticpipe.org>.

⁶ Available from the American National Standards Institute (ANSI) at https://share.ansi.org/shared%20documents/Standards%20Activities/American%20National%20Standards/Procedures,%20Guides,%20and%20Forms/2016_ANSI_Essential_Requirements.pdf

⁷ Available from Standards Australia at <https://www.standards.org.au> or Standards New Zealand at <https://www.standards.govt.nz>.

⁸ Available from the World Trade Organization at https://docs.wto.org/dol2fe/Pages/FE_Browse/FE_B_009.aspx

⁹ Available from WHO Press, World Health Organization, 20 Avenue Appia, 1211 Geneva 27, Switzerland (tel.: +41 22 791 3264; fax: +41 22 791 4857; e-mail: bookorders@who.int).

¹⁰ Available from Publications Office of the European Union 2, rue Mercier 2985 Luxembourg LUXEMBOURG Tel: +352 2929-1 E-mail: info@publications.europa.eu.

¹¹ Available from American Water Works Association (AWWA), 6666 W. Quincy Ave., Denver, CO 80235, <http://www.awwa.org>.

$$PFA = PN \times f_T \times f_A \quad (1)$$

where:

- PN = nominal pressure, bar,
- PFA = maximum allowable operating pressure, bar,
- f_T = temperature factor,
- f_A = application factor

3.2.5.2 *Determination of maximum allowable operating pressure, PFA, and categorized required strength, $CRS_{(\theta,T)}$* —The following equation is used in this specification to relate maximum allowable operating pressure, PFA, and categorized required strength, $CRS_{(\theta,T)}$:

$$PFA = \frac{20}{(DR - 1)} \times \frac{CRS_{\theta,T}}{C_{min}} \times (C_A \times C_A \times \dots) \quad (2)$$

where:

- $CRS_{(\theta,T)}$ = Categorized Required Strength at temperature θ and time T in accordance with 3.2.3.
- DR = dimension ratio D_o/t
- D_o = nominal outside diameter, mm,
- t = minimum wall thickness, mm,
- C_A = application design coefficient in accordance with 3.2.1 (depending on the application, the use of several, different C_A values is acceptable. See A1.5)

3.2.6 *minimum design coefficient, C_{min}* , n —a factor from ISO 12162 having a value of 1.25 that accounts for the properties of the piping material when transporting water at 20 °C.

3.2.7 *minimum required strength, MRS* , n —a property of the material in accordance with ISO 12162 that represents a classification range in MPa of the 97.5 % lower confidence limit of the mean long-term strength at 20 °C and 50 years.

3.2.8 *nominal pressure, PN* , n —a nominal design rating in bar for internal pressure water at 20 °C, but without consideration of media other than water or conditions other than sustained internal pressure and sustained temperature.

NOTE 1— PN is a nominal design rating for sustained internal pressure for water at 20 °C that provides for product comparison under specific, limited conditions. Actual allowable operating pressure (PFA) is determined by the designer/user in consideration of the media being conveyed and conditions of conveyance such as pressure and temperature stability or variation, installation and quality thereof, and desired degree of reliability. (See 3.2.5, X1.1, and X1.2 for additional information.)

3.2.9 *relation between dimension ratio, MRS and nominal pressure, n* —the following equation is used in this specification to relate pressure number (PN), dimension ratio (DR), minimum required strength (MRS), minimum design coefficient (C_{min}), and design stress (σ_S):

$$PN = \frac{20}{(DR - 1)} \times \frac{MRS}{C_{min}} = \frac{20 \times \sigma_S}{(DR - 1)} \quad (3)$$

where:

- PN = nominal pressure design rating, bar,
- MRS = minimum required strength at 20 °C, MPa,
- C_{min} = minimum design coefficient, and
- σ_S = design stress at 20 °C.
- σ_S = MRS/C_{min}

3.2.10 *temperature factor, f_T* , n —a coefficient applied to PN in accordance with 3.2.5.1 that accounts for the long term strength of the polyethylene compound at temperatures other than 20 °C.

3.2.11 *lower confidence limit of the predicted hydrostatic strength, σ_{LPL}* , n —a property of the polyethylene compound in accordance with ISO 12162 that represents a stress value in MPa for the 97.5 percent lower confidence limit of the predicted hydrostatic strength at a specified temperature in °C and time in years.

4. Pipe Classification

4.1 *General*—This specification covers 32 mm through 2500 mm metric outside diameter polyethylene pipe having wall thickness in accordance with standard dimension ratios (DR 33 through DR 7.3) and nominal pressures in bar for water at 20 °C (PN5 through PN25).

4.2 Pipe manufacturing and verification of compliance with the requirements of this standard are in accordance with a written quality assurance program that specifies policies and procedures for manufacturing, frequency of inspection, sampling and testing of materials and products, and policies and procedures for documenting compliance with the requirements of this specification.

5. Polyethylene Compound and Requirements

5.1 *Polyethylene Compound*—Polyethylene compound for the manufacture of pipe in accordance with this specification shall be designated in accordance with PPI TR-3 as PE100 and as PE4710 (“PE100/PE4710”), and shall comply with the following requirements:

5.1.1 See [Table 4](#).

5.1.2 Polyethylene compound shall contain sufficient antioxidant so that the minimum induction temperature shall not be less than 220 °C when tested for thermal stability in accordance with Specification [D3350](#).

5.1.3 The brittleness temperature shall not be warmer than –60 °C when tested in accordance with Test Method [D746](#).

5.1.4 The oxidation induction time at 200 °C shall not be less than 20 minutes when tested in accordance with Test Method [D3895](#).

5.1.5 The minimum nominal tensile strength at yield shall be 20.6 MPa, and the failure mode shall be ductile when determined in accordance with Test Method [D638](#). Testing temperature shall be 23 °C and the speed of testing shall be 50 mm/min. Specimens shall conform to the dimensions and requirements for Type IV in Test Method [D638](#) with a thickness of $\pm 91.9 \text{ mm} \pm 0.2 \text{ mm}$. Specimens shall be either die cut or machined. The minimum elongation at break shall be 400 percent.

5.1.6 The polyethylene compound melt flow rate (high load) shall be tested in accordance with Test Method [D1238](#), Condition 190/21.6.

5.1.7 The polyethylene compound density in accordance Specification [D3350](#) shall be tested in accordance with Test Method [D792](#) or Test Method [D1505](#).

5.1.8 Black polyethylene compound shall contain 2.0–2.5 percent carbon black when pipe is tested in accordance with [6.1.2](#).

5.1.9 Polyethylene compound shall be stabilized against deterioration from UV exposure for not less than 18 months for color polyethylene compounds, or for not less than 180 months for black polyethylene compounds.

NOTE 2—UV resistance is typically determined by exposure to actual outdoor (natural sunlight) weathering in accordance with Practice [D1435](#), or by

TABLE 4 PE100/PE4710 Polyethylene Compound Requirements

Requirement	Required Value or Value Range
MRS at 20 °C, per ISO 9080, ISO 12162 and PPI TR-3, ^A MPa	≥ 10
HDB at 23 °C, per Test Method D2837 and PPI TR-3, ^{A,B} MPa	≥ 11.03
HDB at 60 °C, per Test Method D2837 and PPI TR-3, ^{A,B} MPa	≥ 6.89
HDS for water at 23 °C, per Test Method D2837 and PPI TR-3, ^{A,B} MPa	≥ 6.89
Melt flow rate (high load) per Test Method D1238 , g/10 min	>4.0 to ≤ 20 ^C
Nominal natural base resin density per Specification D3350 , ^D g/cm ³	>0.947 to ≤ 0.955
Minimum average SCG Resistance (PENT) per Test Method F1473 , ^E hr	≥ 500

^A MRS, HDB and HDS determinations shall be listed in accordance with PPI TR-3.

^B HDB ratings expressed in inch-pound units are standard in Test Method [D2837](#). Per [1.3](#), SI units are standard herein; therefore, the SI values specified in [Table 4](#) are the SI equivalent values per Test Method [D2837](#). Inch-pound values for the SI equivalent values in [Table 4](#) are 73 °F = 23 °C; 140 °F = 60 °C; 1600 pound/in² = 11.03 MPa; 1000 pound/in² = 6.89 MPa.

^C Per [5.1.6](#).

^D Per 1.7 excluding carbon black. See Specification [D3350](#) for determination of carbon black content effects on density.

^E SCG resistance determined in accordance with Test Method [F1473](#) requirements for molded plaque specimens, notching per Test Method [F1473](#) Table 1, and testing at 80 °C, 2.4 MPa. Average failure time for two test specimens.