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Standard Specification for Filament-Wound "Fiberglass" (Glass-Fiber-Reinforced Thermosetting-Resin) Pipe[1]

This standard is issued under the fixed designation D2996; 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 machine-made reinforced thermosetting resin pressure pipe (RTRP) manufactured by the filament winding process up to 60 in. nominal size. Included are a classification system and requirements for materials, mechanical properties, dimensions, performance, methods of test, and marking.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are provided for information purposes only.

1.3 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.*

NOTE 1—The term "fiberglass pipe" as described in Section 3 of this specification applies to both reinforced thermosetting resin pipe (RTRP) and reinforced polymer mortar pipe (RPMP). This specification covers only reinforced thermosetting resin pipe (RTRP).

NOTE 2—There is no known ISO equivalent to this standard.

NOTE 3—This specification is applicable to RTRP where the ratio of outside diameter to wall thickness is 10:1 or more.

NOTE 4—For the purposes of this standard, polymer does not include natural polymers.

1.4 *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
D883 Terminology Relating to Plastics
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
D2105 Test Method for Longitudinal Tensile Properties of "Fiberglass" (Glass-Fiber-Reinforced Thermosetting-Resin) Pipe and Tube
D2143 Test Method for Cyclic Pressure Strength of Reinforced, Thermosetting Plastic Pipe
D2412 Test Method for Determination of External Loading Characteristics of Plastic Pipe by Parallel-Plate Loading
D2992 Practice for Obtaining Hydrostatic or Pressure Design Basis for "Fiberglass" (Glass-Fiber-Reinforced Thermosetting-Resin) Pipe and Fittings
D3567 Practice for Determining Dimensions of "Fiberglass" (Glass-Fiber-Reinforced Thermosetting Resin) Pipe and Fittings
F412 Terminology Relating to Plastic Piping Systems

3. Terminology

3.1 *Definitions:*

3.1.1 *General*—Definitions are in accordance with Terminologies D883 and F412 and abbreviations are in accordance with Terminology D1600, unless otherwise indicated. The abbreviation for reinforced thermosetting resin pipe is RTRP.

3.2 *Definitions of Terms Specific to This Standard:*

[1] This specification is under the jurisdiction of ASTM Committee D20 on Plastics and is the direct responsibility of Subcommittee D20.23 on Reinforced Thermosetting Resin Piping Systems and Chemical Equipment.

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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**

3.2.1 *coating*—a resin layer, with or without filler or reinforcement, or both, applied to the exterior surface of the pipe structural wall.

3.2.2 *fiberglass pipe*—a tubular product containing glass-fiber reinforcements embedded in or surrounded by cured thermosetting resin; the composite structure may contain aggregate, granular or platelet fillers, thixotropic agents, pigments, or dyes; thermoplastic or thermosetting liners or coatings may be included.

3.2.3 *filament winding*—a process used to manufacture tubular goods by winding continuous fibrous glass strand roving, or roving tape, saturated with liquid resin or preimpregnated with partially cured resin (subsequent heating may be required to polymerize the resin system) onto the outside of a mandrel in a predetermined pattern under controlled tension; the inside diameter (ID) of the pipe is fixed by the mandrel outside diameter and the outside diameter (OD) of the pipe is determined by the amount of material that is wound on the mandrel.

3.2.4 *liner*—the inner portion of the wall at least 0.005 in. (0.13 mm) in thickness, as determined in 8.3.2, which does not contribute to the strength in the determination of the hydrostatic design basis.

3.2.5 *reinforced polymer mortar pipe (RPMP)*—a fiberglass pipe with aggregate.

3.2.6 *reinforced thermosetting resin pipe (RTRP)*—a fiberglass pipe without aggregate.

3.2.7 *reinforced wall thickness*—the total wall thickness minus the liner or exterior coating thickness, or both.

4. Classification

4.1 *General*—Pipe meeting this specification is classified by type, grade, class, and hydrostatic design basis and by a secondary cell classification system that defines the basic mechanical properties of the pipe. These types, grades, classes, hydrostatic design basis categories, and cell classification designations are as follows:

4.1.1 *Types:—Type 1*

Filament wound.

4.1.2 *Grades:—Grade 1*

Glass fiber reinforced epoxy resin pipe.

Grade 2—Glass fiber reinforced polyester resin pipe.

Grade 7—Glass fiber reinforced furan resin pipe.

TABLE 1 Hydrostatic Design Basis Categories

Cyclic Test Method		Static Test Method	
Designation	Hoop Stress, psi (MPa)	Designation	Hoop Stress, psi (MPa)
A	2 500 (17.2)	Q	5 000 (34.5)
B	3 150 (21.7)	R	6 300 (43.4)
C	4 000 (27.6)	S	8 000 (55.2)
D	5 000 (34.5)	T	10 000 (68.9)
E	6 300 (43.4)	U	12 500 (86.2)
F	8 000 (55.2)	W	16 000 (110)
G	10 000 (68.9)	X	20 000 (138)
H	12 500 (86.2)	Y	25 000 (172)
		Z	31 500 (217)

4.1.3 *Classes:—Class A*

No liner.

Class B—Polyester resin liner (nonreinforced).

Class C—Epoxy resin liner (nonreinforced).

Class E—Polyester resin liner (reinforced).

Class F—Epoxy resin liner (reinforced).

Class H—Thermoplastic resin liner (specify).

Class I—Furan resin liner (reinforced).

4.1.4 *Hydrostatic Design Basis*—Two methods of classifying the hydrostatic design basis of the pipe are provided. Pipe meeting this specification shall be classified using either the cyclic test method or the static test method, or both, and the designations as shown in Table 1. Appendix X1 explains how these design basis categories are to be used.

4.1.4.1 For pipe subjected to axial or end loads, the effect of these loads shall be represented in the HDB testing. In the designation code, the numeral 1 shall immediately follow the HDB letter class if free-end type closures were used and the numeral 2 shall immediately follow the HDB letter class if restrained-end type closures were used to establish the HDB.

4.1.5 *Mechanical Properties*—Table 2 presents a cell classification system for identifying the mechanical properties of pipe covered by this specification.

NOTE 5—For the purposes of this classification, polyester resins shall include vinylester resins, but the purchaser should consult with the manufacturer to determine which resin is applicable for the specific conditions in which the pipe will be used.

NOTE 6—All possible combinations covered by the above classification system may not be commercially available.

TABLE 2 Physical Property Requirements

Designation Order Number	Mechanical Property	Cell Limits						
		0	1	2	3	4	5	6
1	Short-term rupture strength hoop tensile stress, min, psi	. . .	10 000	30 000	40 000	50 000	60 000	70 000
	(MPa)	. . .	(68.9)	(207)	(276)	(345)	(414)	(483)
2	Longitudinal tensile strength min, psi	. . .	8000	15 000	25 000	35 000	45 000	55 000
	(MPa)	. . .	(55.2)	(103)	(172)	(241)	(310)	(379)
3	Longitudinal tensile modulus, min, psi × 10^6	. . .	1	2	3	4	5	6
	(MPa)	. . .	(6900)	(13 000)	(20 700)	(27 600)	(34 500)	(41 400)
4	Pipe stiffness at 5 % deflection, min, psi	. . .	5	9	18	36	72	144
	(kPa)	. . .	(34)	(62)	(124)	(248)	(496)	(993)

4.1.6 *Designation Code*—The pipe designation code shall consist of the abbreviation RTRP, followed by the type and grade in Arabic numerals, the class and static or cyclic HDB level in capital letters, the type of end closure used, and four Arabic numbers identifying, respectively, the cell classification designations of the short-term rupture strength, longitudinal tensile strength, longitudinal tensile modulus, and pipe stiffness.

Example: RTRP-11FA1-1334. Such a designation would describe a filament-wound, glass-fiber reinforced, epoxy pipe having a reinforced epoxy liner; a cyclic pressure strength exceeding 2500 psi (17.2 MPa) using free-end closures; a short-term rupture strength exceeding 10 000 psi (68.9 MPa); a longitudinal tensile strength exceeding 25 000 psi (172 MPa); a longitudinal tensile modulus exceeding 3×10^6 psi (20.7×10^3MPa); and a pipe stiffness exceeding 36 psi (248 kPa).

5. Materials and Manufacture

5.1 *General*—The resins, reinforcements, colorants, fillers, and other materials, when combined as a composite structure, shall produce a pipe that shall meet the performance requirements of this specification.

6. Physical Requirements

6.1 *Workmanship*—The pipe shall be free of all defects including indentations, delaminations, bubbles, pinholes, foreign inclusions, and resin-starved areas which, due to their nature, degree, or extent, detrimentally affect the strength and serviceability of the pipe. The pipe shall be as uniform as commercially practicable in color, opacity, and other physical properties. The pipe shall be round and straight and the bore of the pipe shall be smooth and uniform. All pipe ends shall be cut at right angles to the axis of the pipe and any sharp edges removed.

6.2 *Dimensions and Tolerances:*

6.2.1 *Inside and Outside Diameter*—The inside and outside diameter and tolerances of pipe meeting these specifications shall conform to the requirements in one of the Tables 3-6, when determined in accordance with 8.3.1.

6.2.2 *Wall Thickness*—The minimum wall thickness of pipe furnished under this specification shall not at any point be less than 87.5 % of the nominal wall thickness published in the manufacturer's literature current at the time of purchase when measured in accordance with 8.3.1.

6.3 *Performance*—Pipe meeting this specification shall be categorized by a long-term static or cyclic hydrostatic design basis as shown in Table 1 when tested in accordance with 8.4 or 8.5. Additionally, the pipe shall meet the applicable cell limit requirements for short-term rupture strength, longitudinal tensile strength, longitudinal tensile modulus, and apparent stiffness factor as described in Table 2 when tested in accordance with 8.6 through 8.8.

6.3.1 Any significant changes in the original pipe categorized in 6.3, with respect to materials or manufacturing process, will require recategorizing according to 6.3. These changes include, but are not limited to: a change in reinforcement type, composition, or binder; a change in resin type, composition, or cure; or change in linear composition, thickness, or cure.

TABLE 3 Dimensions and Tolerances for Outside Diameter (OD) Series Pipe with Steel-Pipe-Equivalent (Iron Pipe Size)

Nominal Pipe Size, in.	in.	(mm)
1	1.315 + 0.060 −0.016	33.40 + 1.52 −0.41
1½	1.900 + 0.060 −0.018	48.26 + 1.52 −0.46
2	2.375 + 0.060 −0.018	60.32 + 1.52 −0.46
2½	2.875 + 0.060 −0.018	73.02 + 1.52 −0.46
3	3.500 + 0.060 −0.018	88.90 + 1.52 −0.46
4	4.500 + 0.060 −0.018	114.30 + 1.52 −0.46
6	6.625 + 0.066 −0.028	168.28 + 1.68 −0.64
8	8.625 + 0.086 −0.040	219.08 + 2.18 −1.02
10	10.750 + 0.108 −0.048	273.05 + 2.74 −1.22
12	12.750 + 0.128 −0.056	323.85 + 3.25 −1.42
14	14.000 + 0.145 −0.064	355.60 + 3.68 −1.63
16	16.000 + 0.165 −0.074	406.40 + 4.19 −1.88

[A] Outside diameters other than listed in Tables 3 to 6 shall be permitted by agreement between the manufacturer and the purchaser.

TABLE 4 Dimensions and Tolerances for Inside Diameter (ID) Series Pipe

Nominal Pipe Size, in.	in.	mm
1	1.00 ± 0.06	25.4 ± 1.52
1½	1.500 ± 0.06	38.1 ± 1.52
2	2.000 ± 0.06	50.8 ± 1.52
2½	2.500 ± 0.06	63.5 ± 1.52
3	3.000 ± 0.12	76.2 ± 3.05
4	4.000 ± 0.12	101.6 ± 3.05
6	6.000 ± 0.25	152.4 ± 6.35
8	8.000 ± 0.25	203.2 ± 6.35
10	10.000 ± 0.25	254.0 ± 6.35
12	12.000 ± 0.25	304.8 ± 6.35
14	14.000 ± 0.25	355.6 ± 6.35
15	15.000 ± 0.25	381.0 ± 6.35
16	16.000 ± 0.25	406.4 ± 6.35
18	18.000 ± 0.25	457.2 ± 6.35
20	20.000 ± 0.25	508.0 ± 6.35
24	24.000 ± 0.25	609.6 ± 6.35
30	30.000 ± 0.30	762.0 ± 7.62
36	36.000 ± 0.36	914.4 ± 9.14
42	42.000 ± 0.42	1066.8 ± 10.68
48	48.000 ± 0.48	1219.2 ± 12.19
54	54.000 ± 0.54	1371.6 ± 13.72
60	60.000 ± 0.60	1524.0 ± 15.24

NOTE 7—The purchaser should consult the manufacturer for the proper class, type, and grade of pipe to be used under the installation and operating conditions, with respect to temperature, conveyed fluid, pressure, etc., that will exist for the project in which the pipe is to be used.

7. Sampling

7.1 At least one sample of pipe, to determine conformance of the material to the short-term hoop tensile rupture requirements as shown in Table 2, shall be taken at random on a