



Standard Practice for Rehabilitation of Existing Pipelines and Conduits by the Pulled in Place Installation of Glass Reinforced Plastic (GRP) Cured-in-Place Thermosetting Resin Pipe (CIPP)¹

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1. Scope

1.1 This practice covers the procedures for the reconstruction of pipelines and conduits (4 to 48 in. (100 to 1200 mm) diameter) by the pulled-in place installation of a resin-impregnated, flexible fabric tube into an existing conduit followed by inflation with compressed air (see Fig. 1). The resin/fabric tube is cured by flow through the fabric tube of mixed air and steam. When cured, the finished cured-in-place pipe will be continuous and tight fitting. This reconstruction process can be used in a variety of gravity flow applications such as sanitary sewers, storm sewers, process piping, electrical conduits and ventilation systems.

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

1.3 *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 and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:

- D 543 Testing Method of Resistance of Plastics to Chemical Reagents²
- D 578 Specifications for Glass Fiber Strands³
- D 638 Testing Method for Tensile Properties of Plastics²
- D 790 Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials²
- D 1600 Terminology for Abbreviated Terms Relating to Plastics²
- D 1682 Test Method for Breaking Load and Elongation of Textile Fabrics⁴
- D 3567 Practice for Determining Dimensions of Reinforced

¹ This practice is under the jurisdiction of ASTM Committee F-17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.67 on Trenchless Plastic Pipeline Technology.

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² *Annual Book of ASTM Standards*, Vol 08.01.

³ *Annual Book of ASTM Standards*, Vol 07.01.

⁴ Discontinued; see 1991 *Annual Book of ASTM Standards*, Vol 07.01.

- Thermosetting Resin Pipe (RTRP) and Fittings⁵
- D 5813 Specification for Cured-in-Place Thermosetting Resin Sewer Pipe⁵
- F 412 Terminology Relating to Plastic Piping Systems⁵
- F 1216 Practice for Rehabilitation of Existing Pipelines and Conduits by the Inversion and Curing of a Resin-Impregnated Tube⁵
- F 1417 Test Method for Installation Acceptance of Gravity Plastic Sewer Lines Using Low Pressure Air Testing⁵
- 2.2 *AWWA Standard:*
Manual on Cleaning and Lining Water Mains, M28⁶
- 2.3 *NASSCO Standard:*
Recommended Specifications for Sewer Collection System Rehabilitation⁷

3. Terminology

3.1 General:

3.1.1 Definitions are in accordance with Terminology F 412. Abbreviations are in accordance with Abbreviations D 1600, unless otherwise indicated.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *calibration hose*—an impermeable bladder installed inside the fabric tube, and inflated with air or steam to press the tube firmly against the wall of the existing pipe until the resin is cured with air and steam. The calibration hose is removed when the installation is finished.

3.2.2 *cured-in-place pipe (CIPP)*—a hollow cylinder consisting of a glass reinforced plastic (GRP) fabric tube with cured thermosetting resin. External foils are included. The CIPP is formed within an existing pipe and takes the shape of the pipe.

3.2.3 *delamination*—separation of the layers in the sandwich constructed CIPP

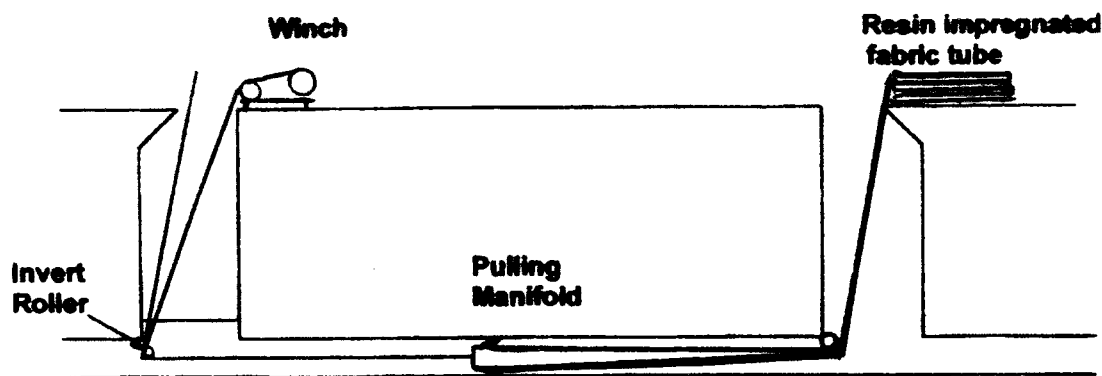
3.2.4 *dry spot*—an area of the fabric tube, where the finished CIPP is deficient or devoid of resin.

3.2.5 *E-CR glass*—an E-glass type that is resistant to normal sewer effluents as tested according to 6.4.1 and 6.4.2 of Specification D 5813.

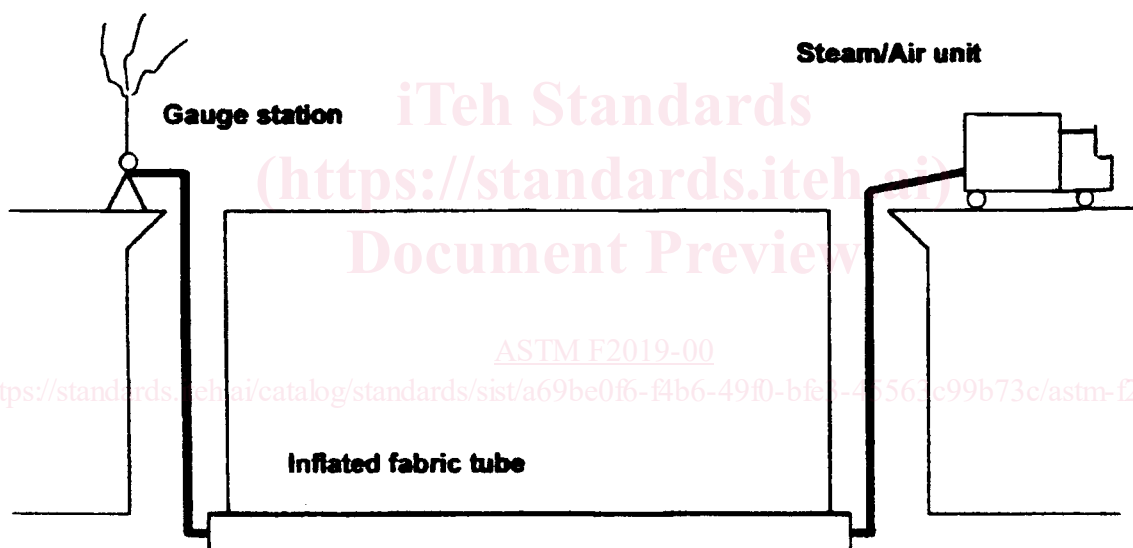
⁵ *Annual Book of ASTM Standards*, Vol 08.04.

⁶ Available from American Water Works Association 6666 West Quincy Ave., Denver CO 80235.

⁷ Available from National Association of Sewer Service Companies, 423 W. King Street, Suite 3000, Chambersburg, PA 17201



Step 1 - Pulling resin impregnated fabric tube in place



Step 2 Inflated resin impregnated fabric tube

FIG. 1 Cured-In-Place Pipe Installation Method (Air/Steam)

3.2.6 *fabric tube*—flexible sandwich fiberglass materials formed into a tubular shape which during the installation is saturated with resin and holds the resin in place as a permanent part of the installed cured-in-place pipe as further described in 5.2.1.

3.2.7 *lift*—a portion of the CIPP that is a departure from the existing conduit well forming a section of reverse curvature in the CIPP.

3.2.8 *slip-foil*—a plastic foil installed prior to the fabric tube covering the lower third of the circumference of the existing pipe to reduce friction.

4. Significance and Use

4.1 This practice is for use by designers and specifiers, regulatory agencies, owners and inspection organizations who

are involved in the rehabilitation of conduits through the use of a resin-impregnated fabric tube, pulled in place through an existing conduit and subsequently inflated and cured. As for any standard practice, modifications may be required for specific job conditions.

5. Recommended Materials and Manufacture

5.1 *General*—The fabric tube, resin and external preliners shall produce a CIPP that meets the requirements of these specifications.

5.2 *CIPP Wall Composition*—The wall shall consist of a corrosion resistant fiberglass fabric tube (Fig. 2) saturated with a thermosetting (cross-linked) resin, and if used a filler material.

5.2.1 *Fabric Tube*—The fabric tube shall consist of at least

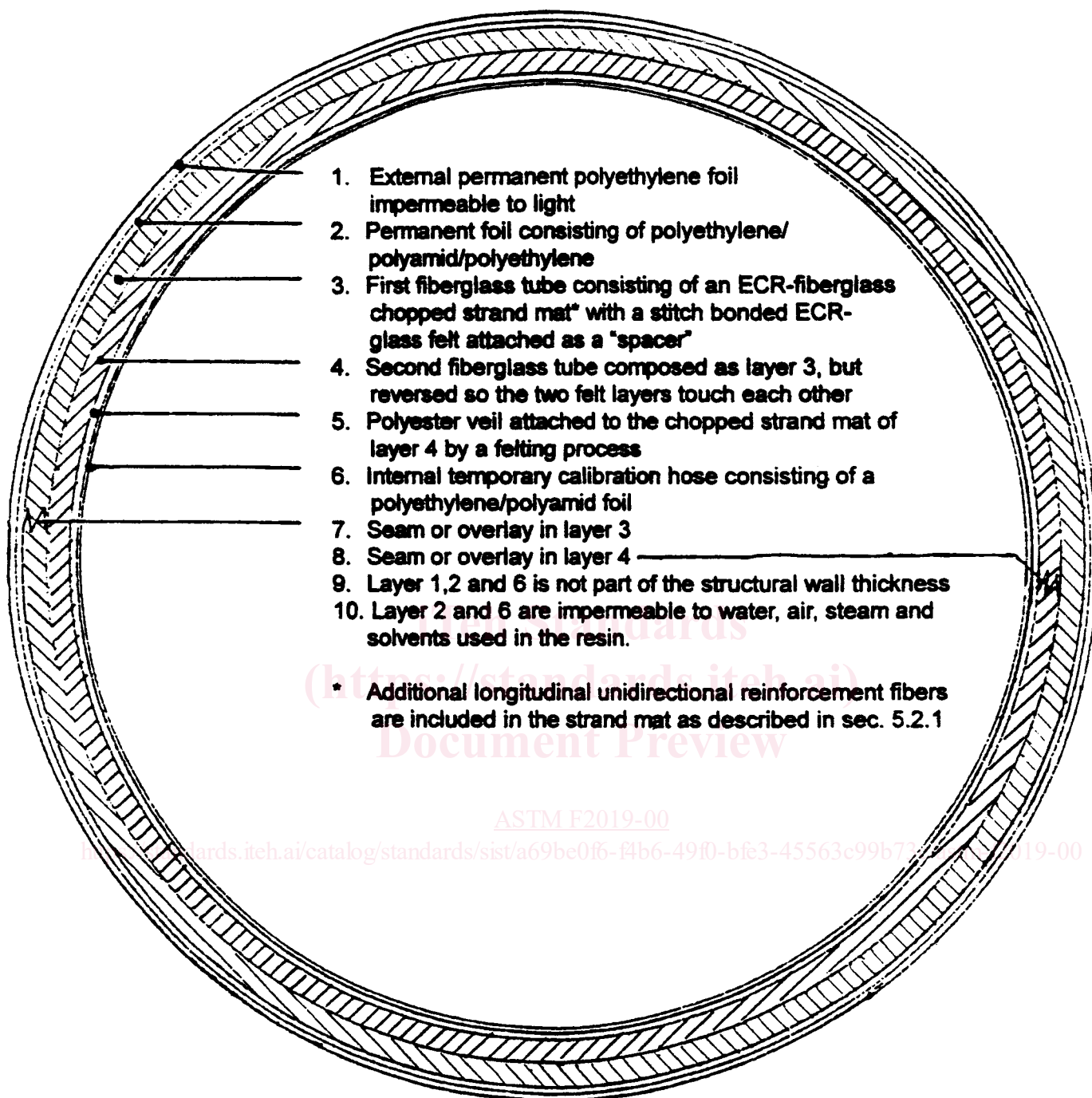


FIG. 2 Composition of Fabric Tube

two separate tubes made of corrosion resistant (E-CR) glass fibers in accordance with Specification D 578. The internal surface shall consist of a veil preferably made of polyester. The fabric tube shall further be constructed with longitudinal unidirectional glass roving of sufficient strength to negotiate a pulling force at least equal to the weight of the liner. The fabric tube shall tolerate up to 10 % circumferential changes in the existing conduit.

5.2.2 *External Foils*—The external foils (Layers 1 and 2 in Fig. 2) shall consist of one or more layers of styrene and light proof tube shaped plastic foils.

5.2.3 *Calibration hose*—The calibration hose (Layer 6 in Fig. 2) which is installed during the construction of the fabric tube, shall consist of a tube shaped plastic foil able to resist styrene and temperatures up to 260°F (126°C) while exposed to the installation pressure sufficient to keep the fabric tube tight against the pipe wall. It shall further release easily from the inside wall for removal, when the installation is finished.

5.2.4 *Resin*—The resin system shall consist of a chemically resistant isophthalic polyester or vinyl ester thermoset resin and catalyst system or an epoxy resin and hardener that is compatible to the installation process. The resin system shall