



Designation: C 505 – 99a

Standard Specification for Nonreinforced Concrete Irrigation Pipe with Rubber Gasket Joints¹

This standard is issued under the fixed designation C 505; 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 nonreinforced concrete pipe with rubber gasket joints to be used for the conveyance of irrigation water with working pressures, including hydraulic transients, as shown in Table 1.

1.2 A complete metric companion to Specification C 505 has been developed—C 505M; therefore, no SI equivalents are presented in this specification.

NOTE 1—This specification is for manufacturing and purchase only and does not include requirements for bedding, backfill, installation, or field repairs. The owner is cautioned that he must correlate field conditions with the characteristics of the pipe specified and provide inspection during installation.

2. Referenced Documents

2.1 ASTM Standards:

- C 33 Specification for Concrete Aggregates²
- C 150 Specification for Portland Cement³
- C 497 Test Methods for Concrete Pipe, Manhole Sections, or Tile⁴
- C 595 Specification for Blended Hydraulic Cements³
- C 618 Specification for Fly Ash and Raw or Calcined Natural Pozzolan for Use as a Mineral Admixture in Concrete²
- C 822 Terminology Relating to Concrete Pipe and Related Products⁴
- C 1116 Specification for Fiber-Reinforced Concrete and Shotcrete²
- D 395 Test Methods for Rubber Property—Compression Set⁵
- D 412 Test Methods for Vulcanized Rubber and Thermoplastic Rubbers and Thermoplastic Elastomers—Tension⁵
- D 471 Test Method for Rubber Property—Effect of Liquids⁵

¹ This specification is under the jurisdiction of ASTM Committee C-13 on Concrete Pipe and is the direct responsibility of Subcommittee C13.01 on Reinforced Concrete Sewer, Drain, and Irrigation Pipe.

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² Annual Book of ASTM Standards, Vol 04.02.

³ Annual Book of ASTM Standards, Vol 04.01.

⁴ Annual Book of ASTM Standards, Vol 04.05.

⁵ Annual Book of ASTM Standards, Vol 09.01.

TABLE 1 Standard Dimensions, Working Pressures, and Test Requirements

Internal Designated Diameter, in.	Wall Thickness, ^A in.	Working Pressure, ^B ft	Required Hydrostatic Test Pressure, ^C psi	Minimum Three-Edge Bearing Load, lbf/linear ft
6	3/4	30	40	1300
8	1	30	40	1350
10	1 1/4	30	40	1400
12	1 1/2	30	40	1500
15	1 7/8	30	40	1650
18	2 1/4	30	40	1800
21	2 5/8	30	40	1900
24	3	30	40	2000

^A Thinner walls may be used on pipe units not over 4 ft in length, but the thickness of such walls shall not be less than the internal diameter divided by 10.

^B With the exception of 21 and 24-in. pipe, higher pressures may be used up to a maximum of 50 ft for 6 through 12-in. diameters, and 40 ft for 15 through 18-in. diameters. In these cases the strength of the pipe shall be increased to give minimum internal hydrostatic test pressures of at least three times the design working pressure when tested as specified in 10.4.

^C For hydrostatic test requirements, refer to 10.4.

D 573 Test Method for Rubber—Deterioration in an Air Oven⁵

D 1149 Test Method for Rubber Deterioration—Surface Ozone Cracking in a Chamber⁵

D 1415 Test Method for Rubber Property—International Hardness⁵

D 2240 Test Method for Rubber Property—Durometer Hardness⁵

3. Terminology

3.1 *Definitions*—For definitions of terms relating to concrete pipe, see Terminology C 822.

4. Classification

4.1 Pipe manufactured in accordance with this specification shall be known as “Standard Nonreinforced Concrete Irrigation Pipe with Rubber Gasket Joints.”

5. Basis of Acceptance

5.1 The acceptability of the pipe, joint design, and gaskets shall be determined by the results of the tests prescribed in this specification, if and when required, and by inspection to determine whether the pipe and gaskets conform to the specification as to design and freedom from defects.

6. Materials and Manufacture

6.1 *Concrete*—The concrete shall consist of cementitious materials.

6.2 *Cementitious Materials*:

6.2.1 *Cement*—Cement shall conform to the requirements for portland cement of Specification C 150 or shall be portland blast-furnace slag cement or portland-pozzolan cement conforming to the requirements of Specification C 595, except that the pozzolan constituent in the Type IP portland-pozzolan cement shall be fly ash.

6.2.2 *Fly Ash*—Fly ash shall conform to the requirements of Specification C 618, Class F or Class C.

6.2.3 *Allowable Combinations of Cementitious Materials*—The combination of cementitious materials used in the concrete shall be one of the following:

- 6.2.3.1 Portland cement only,
- 6.2.3.2 Portland blast furnace slag cement only,
- 6.2.3.3 Portland pozzolan cement only, or
- 6.2.3.4 A combination of portland cement and fly ash.

6.3 *Aggregates*—Aggregates shall conform to Specification C 33, except that the requirements for gradation shall not apply.

6.4 *Admixtures and Blends*—Admixtures and blends may be used with the approval of the owner.

6.5 *Gaskets*:

6.5.1 *Composition*—The rubber compound used in the manufacture of the gasket shall be compounded from natural rubber, synthetic rubber, or a mixture of the two fabricated as prescribed in 6.5.2 to 6.5.6, inclusive.

6.5.2 *Fabrication*—Gaskets shall be extruded or molded and cured in such a manner that they will be dense and homogeneous at any cross section, and have uniform dimensions. They shall be free from porosity, blisters, pitting, and other defects, which may affect their serviceability.

6.5.3 *Tolerances*—Commercial tolerances A3-F3, T.032 for molded gaskets and A3-F3 for extruded gaskets in accordance with the *Rubber Handbook*⁶ shall be permitted. The tolerances in gasket and joint dimensions shall be such as not to exceed permissible deformations prescribed in Section 8.

6.5.4 *Physical Properties of Gaskets*—The rubber from which the gaskets are fabricated shall have the following physical properties:

Ultimate elongation at break, min, %	350
Ultimate elongation at break after aging, min, % of elongation before aging	80
Hardness, International Rubber Hardness Degrees or Durometer ^A	40 to 60
Compression set, max, %	25
Water absorption, %	10
Ozone resistance	no cracks in accordance with Test Method D 1149

^A Allowable variation ± 5 from manufacturer's specified hardness.

6.5.4.1 Testing shall be in accordance with Section 9.

6.5.5 *Strength of Splice*—If a splice is used in the manufacture of the gasket, the strength shall be such that the gasket shall withstand 100 % elongation over the part of the gasket that includes the splice with no visible separation of the splice.

While in the stretched position, the gasket shall be rotated in the spliced area a minimum of 180° in each direction in order to inspect for separation. Any portion of the splice shall be capable of passing a bend test without visible separation. The bend test for circular gaskets is defined as wrapping the portion of the unstretched gasket containing the splice a minimum of 180° and a maximum of 270° around a rod of a diameter equal to the cross section diameter of the gasket.

6.5.6 *Storage*—The gaskets shall be stored in a cool, clean, and shaded place, preferably at 70°F or less and in no case shall the gaskets be exposed to the direct rays of the sun for more than 72 h.

6.6 *Synthetic Fibers*—Collated fibrillated virgin polypropylene fibers may be used, at the manufacturer's option, in concrete pipe as a nonstructural manufacturing material. Only Type III synthetic fibers designed and manufactured specifically for use in concrete and conforming to the requirements of Specification C 1116 shall be accepted.

7. Design

7.1 *Design Tables*—The standard dimensions shall be as given in Table 1. Wall thicknesses furnished may be more but not less than those given in Table 1, except as affected by the tolerance specified in Section 12.

7.2 *Modified Design*—Manufacturers may submit to the owner for approval prior to manufacture, wall thicknesses other than those shown in Table 1. Such pipe shall meet all of the test and performance requirements specified by the owner in accordance with 5.1.

8. Joints

8.1 Pipe units shall be manufactured with male- and female-type joints of such design that the rubber gasket applied thereto shall be the sole element depended upon to make the joints flexible and watertight.

8.2 The slope on the conic surfaces of the gasket seat on the inside of the female portion and on the outside of the male portion shall be not more than 3.5° measured from a longitudinal trace on the inside surface of the pipe. The female or the male portions, or both, shall form a proper gasket positioning area or "seat." The joint design shall be such that, when the joint has been fully closed and is off center sufficiently to cause the outer concrete surface of the male portion and the inner concrete surface of the female portion to come into contact at some place in the joint periphery, the deformation of the gasket adjacent to that point shall not exceed 50 % of the stretched diameter for O-ring gaskets, or 75 % of the uncompressed radial thickness for all other types. At the diametrically opposite side, the gasket deformation shall be not less than 15 % of the stretched diameter for O-ring gaskets, or 25 % of the uncompressed radial thickness for all other types. O-ring gaskets are defined as solid gaskets of circular cross section. Stretched gasket diameters shall be calculated as being $\sqrt{1/(1+x)}$ times the original gasket diameter where x equals the percent of gasket stretch divided by 100.

8.3 The joint design shall provide for the deflection of each pipe unit by opening one side of the outside perimeter of the joint, wider than the fully closed position, a distance no less than 1/2 in. or 25 % of the wall thickness, whichever is less,

⁶ Available from the Rubber Manufacturers Assn., Inc., 444 Madison Ave., New York, NY 10022.