



Standard Specification for Poly(Vinyl Chloride) (PVC) Plastic Drain, Waste, and Vent Pipe and Fittings¹

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This standard has been approved for use by agencies of the Department of Defense.

1. Scope

1.1 This specification covers requirements and test methods for materials, dimensions and tolerances, pipe stiffness, crush resistance, impact resistance, hydrostatic burst resistance, and solvent cement for poly(vinyl chloride) plastic drain, waste, and vent pipe and fittings. A form of marking is also included. Plastic which does not meet the material requirements specified in Section 5 is excluded. Installation procedures are given in the Appendix.

1.2 The values stated in inch-pound units are to be regarded as the standard. The metric equivalents of inch-pound units given in parentheses may be approximate.

1.3 The text of this specification references notes, footnotes, and appendixes which provide explanatory material. These notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of the specification.

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

2. Referenced Documents

2.1 ASTM Standards:

- D 618 Practice for Conditioning Plastics and Electrical Insulating Materials for Testing²
- D 1599 Test Method for Short-Time Hydraulic Failure Pressure of Plastic Pipe, Tubing, and Fittings³
- D 1600 Terminology for Abbreviated Terms Relating to Plastics²
- D 1784 Specification for Rigid Poly(Vinyl Chloride) (PVC) Compounds and Chlorinated Poly(Vinyl Chloride) (CPVC) Compounds²
- D 2122 Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings³

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² Annual Book of ASTM Standards, Vol 08.01.

³ Annual Book of ASTM Standards, Vol 08.04.

- D 2412 Test Method for Determination of External Loading Characteristics of Plastic Pipe by Parallel-Plate Loading³
- D 2444 Test Method for Impact Resistance of Thermoplastic Pipe and Fittings by Means of a Tup (Falling Weight)³
- D 2564 Specification for Solvent Cements for Poly(Vinyl Chloride) (PVC) Plastic Piping Systems³
- D 3311 Specification for Drain, Waste, and Vent (DWV) Plastic Fittings Patterns³
- F 402 Practice for Safe Handling of Solvent Cements and Primers Used for Joining Thermoplastic Pipe and Fittings³
- F 412 Terminology Relating to Plastic Piping Systems³
- F 1498 Specification for Taper Pipe Threads 60° for Thermoplastic Pipe and Fittings³

3. Terminology

3.1 *Definitions*—Definitions are in accordance with Terminology F 412, and abbreviations are in accordance with Terminology D 1600, unless otherwise specified.

4. Significance and Use

4.1 The requirements of this specification are intended to provide pipe and fittings suitable for the drainage and venting of sewage and certain other liquid wastes.

NOTE 1—Industrial waste disposal lines should be installed only with the specific approval of the cognizant building code authority since chemicals not commonly found in drains and sewers and temperatures in excess of 180°F (82.2°C) may be encountered.

5. Materials

5.1 *Basic Materials*—The pipe and fittings shall be made of virgin PVC compounds meeting or exceeding the requirements of Class 12454 as defined in Specification D 1784. This plastic contains stabilizers, lubricants, and pigments.

5.2 *Rework Material*—The manufacturer shall use only his own clean pipe or fitting rework material and the pipe or fittings produced shall meet all the requirements of this specification.

5.3 *Solvent Cement*—The solvent cement used to join pipe and fittings made to this specification shall meet the requirements of Specification D 2564.

6. Requirements

6.1 *General*—The pipe and fittings shall be homogeneous

throughout and free of visible cracks, holes, foreign inclusions, or other injurious defects. The pipe shall be as uniform as commercially practicable in color, opacity, density, and other physical properties.

6.2 Dimensions and Tolerances: —

6.2.1 Method All dimensions shall be determined in accordance with Test Method D 2122.

6.2.2 Dimensions:

6.2.2.1 The outside diameter and wall thicknesses of pipe shall meet the requirements of Table 2. The pipe shall be in either 10 or 20-ft (3.05 or 6.1-m) lengths, unless otherwise specified, with an allowable tolerance of +1/2, -0 in. (+13, -0 mm).

6.2.2.2 The patterns, dimensions, and laying lengths of fittings, including adaptors, shall meet the requirements of Specification D 3311 and Table 1.

6.2.2.3 The spigot dimensions of fittings shall meet the requirements of Table 2.

6.2.2.4 For all fittings having taper pipe threads, threads shall conform to Specification F 1498 and be gaged in accordance with 7.5.

6.3 Pipe Stiffness, Deflection Load and Flattening:

6.3.1 Pipe—The minimum pipe stiffness at 5 % deflection shall be in accordance with Table 3. The pipe shall deflect by 60 % of the nominal outside diameter (flattening) without cracking, rupture, or other visible evidence of failure when tested in accordance with 7.4.

6.3.1.1 Pipe Stiffness (PS)—Three specimens shall be tested. If all three meet the PS requirement, the sample meets the PS requirement. If one or two fail, additional testing shall be conducted in accordance with 6.3.1.2. If all three fail, the

sample does not meet the PS requirement.

6.3.1.2 Pipe Stiffness and Lower Confidence Limit—In the event that one or two of the specimens tested in 6.3.1 fail to meet the minimum PS requirement, the average pipe stiffness of eleven specimens shall meet or exceed the minimum requirement given in Table 3. The 99 % lower confidence limit (LCL) shall be within 15 % of the average value. The LCL shall be calculated using the Student’s “t” distribution, with N-1 degrees of freedom, where N is the number of specimens. The critical t value shall be used to at least three significant digits. Alternatively, if the LCL exceeds the minimum PS requirement in Table 3, but is not within 15 % of the average, the sample meets the requirements of the pipe stiffness testing. The eleven specimens include the three tested under 6.3.1, and an additional eight with rotation by 35°, as specified in Test Method D 2412, continuing throughout the remaining specimens.

6.3.1.3 The LCL based on testing eleven specimens is calculated as follows:

$$LCL = (\text{avg PS}) - \{2.76(\text{std. dev.})/\sqrt{(N)}\} \tag{1}$$

where:

$$(\text{avg PS}) = [\sum(PS_i)]/N \tag{2}$$

$$(\text{std. dev.}) = \left[\frac{\sum PS^2 - (\sum PS)^2 / N}{N - 1} \right]^{1/2}$$

N = 11

6.3.1.4 The 15 % requirement is calculated as follows:

TABLE 1 Dimensions and Tolerances for Fitting Sockets for PVC Plastic Drain, Waste, and Vent Pipe Fittings

Nominal Pipe Size	A Socket Entrance Diameter		B Socket Bottom Diameter		C Socket Depth, min	E Wall Thickness, min ^A	Internal Threads	
	avg ^B	T _m ^C	avg ^D	T _m ^C			Outside Diameter of Hub, M, min	Thread Length, min
	in. (mm)							
1 1/4	1.675 (42.54)	0.024 (0.61)	1.655 (42.04)	0.024 (0.61)	0.687 (17.44)	0.156 (3.96)	1.871 (47.52)	0.687 (17.44)
1 1/2	1.915 (48.64)	0.024 (0.61)	1.895 (48.13)	0.024 (0.61)	0.687 (17.44)	0.156 (3.96)	2.127 (54.03)	0.687 (17.44)
2	2.390 (60.71)	0.024 (0.61)	2.370 (60.20)	0.024 (0.61)	0.750 (19.05)	0.156 (3.96)	2.634 (66.90)	0.750 (19.05)
3	3.520 (89.41)	0.030 (0.76)	3.495 (88.77)	0.030 (0.76)	1.500 (38.10)	0.219 (5.56)	3.841 (97.56)	1.187 (30.15)
4	4.520 (114.81)	0.030 (0.76)	4.495 (114.17)	0.030 (0.76)	1.750 (44.45)	0.250 (6.35)	4.907 (124.64)	1.281 (32.54)
6	6.647 (168.83)	0.060 (1.52)	6.614 (168.00)	0.060 (1.52)	3.000 (76.20)	0.281 (7.14)	7.203 (182.96)	1.500 (38.10)
8	8.655 (219.84)	0.090 (2.29)	8.610 (218.70)	0.090 (2.29)	4.000 (101.60)	0.328 (8.33)	9.320 (236.73)	1.687 (42.85)
10	10.780 (273.82)	0.120 (3.05)	10.735 (272.67)	0.120 (3.05)	5.000 (127.00)	0.365 (9.28)	^E	^E
12	12.780 (324.62)	0.150 (3.81)	12.735 (323.47)	0.150 (3.81)	6.000 (152.40)	0.406 (10.32)	^E	^E

^A The wall thickness is a minimum value except that a ±10 % variation resulting from core shift is allowable. In such a case, the average of the two opposite wall thicknesses shall equal or exceed the value shown in the table.

^B The tolerances on this average are as follows for the corresponding pipe sizes:
 1 1/4 through 4 in. (31.75 through 101.60 mm)—+0.010 to -0.005 in. (+0.25 to -0.13 mm)
 6 in. (152.40 mm)—+0.015 and -0.010 in. (+0.38 and -0.25 mm)
 8 in. (203.20 mm)—+0.030 and -0.000 in. (+0.76 and -0.00 mm)
 10 in. (254.00 mm)—+0.025 and -0.020 in. (+0.64 and -0.51 mm)
 12 in. (304.80 mm)—+0.030 and -0.025 in. (+0.76 and -0.64 mm)

^C T_m = maximum-minimum (out-of-roundness).

^D The tolerances on this average are as follows for the corresponding pipe sizes:
 1 1/4 through 2 in. (31.75 through 50.80 mm)—±0.005 in. (±0.13 mm)
 3 and 4 in. (76.20 and 101.60 mm)—+0.005 and -0.010 in. (+0.13 and -0.25 mm)
 6 in. (152.40 mm)—±0.010 in. (±0.25 mm)
 8 in. (203.20 mm)—+0.030 and -0.000 in. (+0.76 and -0.00 mm)
 10 in. (254.00 mm)—±0.020 in. (±0.51 mm)
 12 in. (304.80 mm)—±0.020 in. (±0.51 mm)

^E Not applicable.

TABLE 2 Dimensions and Tolerances for Outside Diameters and Thicknesses of PVC Plastic Drain, Waste, and Vent Pipe

Nominal Pipe Size	Outside Diameter			Wall Thickness	
	Average	Tolerance on Average	Out-of-Roundness (maximum minus minimum) in. (mm)	Minimum	Tolerance
1 1/4	1.660 (42.16)	±0.005 (0.13)	0.024 (0.61)	0.140 (3.56)	+0.020 (0.51) -0.000
1 1/2	1.900 (48.26)	±0.006 (0.15)	0.024 (0.61)	0.145 (3.68)	+0.020 (0.51) -0.000
2	2.375 (60.33)	±0.006 (0.15)	0.024 (0.61)	0.154 (3.91)	+0.020 (0.51) -0.000
3	3.500 (88.90)	±0.008 (0.20)	0.030 (0.76)	0.216 (5.49)	+0.026 (0.66) -0.000
4	4.500 (114.30)	±0.009 (0.23)	0.100(2.54)	0.237 (6.02)	+0.028 (0.71) -0.000
6	6.625 (168.28)	±0.011 (0.28)	0.100 (2.54)	0.280 (7.11)	+0.034 (0.86) -0.000
8	8.625 (219.08)	±0.015 (0.38)	0.150 (3.81)	0.322 (8.18)	+0.039 (0.99) -0.000
10	10.750 (273.05)	±0.015 (0.38)	0.150 (3.81)	0.365 (9.27)	+0.044 (1.12) -0.000
12	12.750 (323.85)	±0.015 (0.38)	0.150 (3.81)	0.406 (10.31)	+0.049 (1.24) -0.000

TABLE 3 Pipe Stiffness Requirements for PVC DWV Pipe^A

Nominal Pipe Size, in.	Pipe Stiffness Factor, min, psi (kPa)
1 1/4	1400 (9650)
1 1/2	1010 (6960)
2	600 (4140)
3	510 (3520)
4	310 (2140)
6	150 (1030)
8	100 (690)
10	78 (530)
12	63 (430)

^A Measured at 5 % deflection.

$$(Avg - LCL)/(Avg) \times 100 \leq 15 \% \quad (3)$$

NOTE 2—This test is intended only for use as a quality control test, not for use as a simulated service test.

NOTE 3—The 5 % deflection criterion, which was arbitrarily selected for testing convenience, should not be considered as a limitation with respect to in-use deflection. The engineer is responsible for establishing the acceptable deflection.

6.3.2 *Fittings*—Individual fittings unassembled shall withstand a minimum load of 750 lbf/ft (11 kN/m) of centerline length without cracking or other visible evidence of failure when tested in accordance with 7.4.

6.4 *Minimum Hydrostatic Burst Pressure*— When tested at 73°F (23°C) in accordance with Test Method D 1599, the minimum burst pressure of pipe shall be in accordance with Table 4, and the minimum burst pressure of fittings shall be 200 psi (1.4 MPa). Test three specimens of pipe or three fittings; all shall meet the requirements.

NOTE 4—The minimum burst pressure requirements for DWV fittings are lower than for pipe because of the fittings geometry. This test is intended only for use as a quality control test and does not reflect service conditions.

6.5 *Impact Resistance*—The minimum impact resistance of pipe and fittings, when tested at the time of manufacture, shall

TABLE 4 Minimum Hydrostatic Burst Pressure at 73°F (23°C)

Nominal Pipe Size, in.	Minimum Hydrostatic Burst Pressure ^A psi (kPa) Type I
1/4	1180 (8140)
1 1/2	1060 (7310)
2	890 (6140)
3	840 (5790)
4	710 (4900)
6	560 (3680)
8	500 (3450)
10	450 (3100)
12	420 (2890)

^AThese burst pressures are calculated using a hoop stress of 6400 psi (44.1 MPa).

comply with Table 5. Test in accordance with Test Method D 2444 using Tup C and Holder A for pipe and Tup A and Holder B for fittings. Use a 12-lb (5-kg) tup for testing pipe sizes 4 in. and smaller and a 20-lb (10-kg) tup for pipe larger than 4 in. Test fittings with a 12-lb (5-kg) Tup. Test couplings cemented to short pieces of pipe and allowed to dry for 24 h.

6.5.1 Test 10 specimens. When 9 or 10 specimens pass, accept the lot. When 2 or more specimens fail, test 10 additional specimens. When 17 of 20 specimens tested pass,

TABLE 5 Impact Resistance of PVC Plastic Drain, Waste, and Vent Pipe and Fittings

Nominal Pipe Size, in.	Impact Resistance, min, ft-lbf (J) 73°F (23°C)
1 1/4	60 (81)
1 1/2	60 (81)
2	60 (81)
3	60 (81)
4	60 (81)
6	60 (81)
8	60 (81)
10	60 (81)
12	60 (81)
<i>Fittings</i> All sizes and types	15 (20)