



Standard Specification for Centrifugally Cast “Fiberglass” (Glass-Fiber-Reinforced Thermosetting-Resin) Pipe¹

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1. Scope

1.1 This specification covers machine-made glass-fiber-reinforced thermosetting-resin pressure pipe manufactured by the centrifugal casting process. Included are a classification system and requirements for materials, mechanical properties, dimensions, performance, test methods, and marking.

NOTE 1—The term “fiberglass pipe” as described in Section 3 applies to both reinforced thermosetting resin pipe (RTRP) and reinforced plastic mortar pipe (RPMP).

NOTE 2—Pipe covered by this specification has been found suitable for conveying gases, petroleum products, or corrosive fluids.

1.2 The values given in parentheses are for information only.

NOTE 3—There is no similar or equivalent ISO standard.

1.3 The following precautionary caveat pertains only to the test method 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:

- C 33 Specification for Concrete Aggregates²
- D 618 Practice for Conditioning Plastics and Electrical Insulating Materials for Testing³
- D 883 Terminology Relating to Plastics³
- D 1598 Test Method for Time-to-Failure of Plastic Pipe Under Constant Internal Pressure⁴
- D 1599 Test Method for Short-Term Hydraulic Failure Pressure of Plastic Pipe, Tubing, and Fittings⁴
- D 1600 Terminology for Abbreviated Terms Relating to Plastics³
- D 2105 Test Method for Longitudinal Tensile Properties of

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² Annual Book of ASTM Standards, Vol 04.02.

³ Annual Book of ASTM Standards, Vol 08.01.

⁴ Annual Book of ASTM Standards, Vol 08.04.

“Fiberglass” (Glass-Fiber-Reinforced Thermosetting-Resin) Pipe and Tube⁴

D 2143 Test Method for Cyclic Pressure Strength of Reinforced, Thermosetting Plastic Pipe⁴

D 2310 Classification for Machine-Made “Fiberglass” (Glass-Fiber-Reinforced Thermosetting-Resin) Pipe⁴

D 2412 Test Method for Determination of External Loading Characteristics of Plastic Pipe by Parallel-Plate Loading⁴

D 2992 Practice for Obtaining Hydrostatic Design or Pressure Design Basis for “Fiberglass” (Glass-Fiber-Reinforced Thermosetting-Resin) Pipe and Fittings⁴

D 3567 Practice for Determining Dimensions of “Fiberglass” (Glass-Fiber-Reinforced Thermosetting-Resin) Pipe and Fittings⁴

F 412 Terminology Relating to Plastic Piping Systems⁴

3. Terminology

3.1 *Definitions*—Definitions are in accordance with Terminologies D 883 and F 412 and abbreviations with Terminology D 1600, unless otherwise indicated.

3.2 *Definitions of Terms Specific to This Standard*: Descriptions of Terms Specific to This Standard:

3.2.1 *aggregate, n*—a siliceous sand conforming to the requirements of Specification C 33, except that the requirements for gradation shall not apply.

3.2.2 *centrifugal casting, n*—a manufacturing process used to produce tubular goods by applying resin and reinforcement to the inside of a mold that is rotated and heated, subsequently polymerizing the resin system. The outside diameter (OD) of the finished pipe is fixed by the inside diameter (ID) of the mold tube. The inside diameter of the pipe is determined by the amount of material introduced into the mold.

3.2.3 *fiberglass pipe, n*—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.

3.2.4 *liner, n*—the inner portion of the wall at least 0.005 in. (0.13 mm) in thickness, as determined in 7.4 which does not contribute to the strength in the determination of the hydrostatic design basis.

3.2.5 *reinforced plastic mortar pipe (RPMP), n*—a fiberglass pipe with aggregate.

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

3.2.7 *reinforced wall thickness, n*—the total wall thickness minus the liner or exterior surface resin layer thickness, or both.

4. Classification

4.1 *General*—Pipe meeting this specification is classified by type, grade, class, and hydrostatic design basis in accordance with Classification D 2310, 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 II*

Centrifugally cast pipe.

4.1.2 *Grades: —Grade 1*

Glass-fiber-reinforced epoxy-resin pipe.

Grade 2—Glass-fiber-reinforced polyester-resin pipe.

Grade 3—Glass-fiber reinforced polydicyclopentadiene-resin pipe.

Grade 8—Glass-fiber-reinforced polyester-resin mortar pipe.

Grade 9—Glass fiber reinforced epoxy resin mortar pipe.

4.1.3 *Classes:—Class A*

No liner.

Class B—Polyester-resin liner, nonreinforced.

Class C—Epoxy-resin liner, nonreinforced.

Class D—Polydicyclopentadiene-resin liner, nonreinforced.

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

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

NOTE 4—All possible combinations covered by the preceding classification system may not be commercially available.

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

4.1.6.1 *Example*—RTRP-21CA-1334. Such a designation would describe a centrifugally cast, glass-fiber-reinforced, epoxy pipe having a nonreinforced epoxy liner; a long-term cyclic pressure strength level exceeding 2500 psi (17.2 MPa); a short-term rupture strength exceeding 4000 psi (27.6 MPa); a longitudinal tensile strength exceeding 16 000 psi (110 MPa); a longitudinal tensile modulus exceeding 1.5 by 10⁶ psi (10 300 MPa); and a pipe stiffness of 72 psi (496 kPa).

NOTE 5—Although the *Form and Style for ASTM Standards* manual requires that the type classification be roman numerals, it is recognized that few companies have stencil-cutting equipment for this style of type, and it is therefore acceptable to mark the product type in arabic numbers.

5. Materials

5.1 *General*—The resins, reinforcements, colorants, fillers, and other materials, when combined as a composite structure, shall produce a pipe that shall be classified in accordance to this specification based on performance.

6. Requirements

6.1 *Workmanship*—The pipe shall be free from all defects, including indentations, delaminations, bubbles, pinholes, foreign inclusions, and resin-starved areas which, as a result of 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, density, 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 *Outside Diameter*—The outside diameter and tolerances of pipe meeting this specification shall conform to the requirements in Table 3, when determined in accordance with 7.4.

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 7.4.

6.2.3 *Liner Thickness*—Except for Class A unlined products, all other classes shall have a minimum liner thickness of 0.005 in. (5 mil), when measured in accordance with 7.4.

6.3 *Performance*—Pipe meeting this specification shall be categorized by a long-term static or cyclic hydrostatic design basis shown in Table 1, when tested in accordance with 7.5 and 7.6. Additionally, the pipe shall meet the applicable cell limit requirements for short-term rupture strength, longitudinal tensile strength, tensile modulus, and pipe stiffness described in Table 2, when tested in accordance with 7.7, 7.8, and 7.9.

7. Test Methods

7.1 *Conditioning*—Condition the test specimens at 23 ± 2°C (73.4 ± 3.6°F) and 50 ± 5 % relative humidity for not less than 48 h prior to test, in accordance with Procedure A of

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)
		X	31 500 (217)