



Designation: D 3840 – 99

Standard Specification for “Fiberglass” (Glass-Fiber-Reinforced Thermosetting-Resin) Pipe Fittings for Nonpressure Applications¹

This standard is issued under the fixed designation D 3840; 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 fiberglass pipe fittings intended for use in gravity flow systems for conveying sanitary sewage, storm water, and those industrial wastes for which the fittings are determined to be suitable. Elbows, tees, laterals, crosses, reducers, and adapters are included. Both glass-fiber-reinforced and thermosetting-resin pipe (RTRP) and glass-fiber-reinforced plastic mortar pipe (RPMP) are fiberglass pipes.

1.2 This specification is intended to cover only dimensions, material properties, and workmanship rather than the structural design of the fittings. The structural design of the fittings shall be as agreed upon between purchaser and supplier and should take into consideration the anticipated conditions of installation and service.

1.3 This specification covers only fittings fabricated from cut sections of pipe, or from a combination of pipe sections and contact molded (hand layup), or machine fabricated components.

1.4 The values given in parentheses are provided for information purposes only.

1.5 The following safety hazards caveat pertains only to the test method portion, Section 11, 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.*

NOTE 1—There is no similar or equivalent ISO standard.

2. Referenced Documents

2.1 ASTM Standards:

D 638 Test Method for Tensile Properties of Plastics²

D 883 Terminology Relating to Plastics²

D 1600 Terminology for Abbreviated Terms Relating to Plastics²

¹ This specification is under the jurisdiction of ASTM Committee D-20 on Plastics and is the direct responsibility of Subcommittee D 20.23 on Reinforced Plastic Piping Systems and Chemical Equipment.

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

D 1763 Specification for Epoxy Resins³

D 2290 Test Method for Apparent Tensile Strength of Ring or Tubular Plastics and Reinforced Plastics by Split Disk Method³

D 3262 Specification for “Fiberglass” (Glass-Fiber-Reinforced Thermosetting-Resin) Sewer Pipe⁴

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

D 3892 Practice for Packaging/Packing of Plastics⁵

F 412 Terminology Relating to Plastic Piping Systems⁴

F 477 Specification for Elastomeric Seals (Gaskets) for Joining Plastic Pipe⁴

3. Terminology

3.1 Definitions:

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

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *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.

3.2.2 *reinforced plastic mortar pipe*—a fiberglass pipe with aggregate.

3.2.3 *reinforced thermosetting resin pipe*—a fiberglass pipe without aggregate.

3.2.4 *qualification*—One or more tests used to prove the design of a product. Not a routine quality control test.

NOTE 2—Qualification requirements appear in 6.1, 7.2, and 12.3.

4. Materials

4.1 Laminating Resin:

4.1.1 *Type 1*—Polyester thermosetting resin, with or without fillers or thixotropic agents or both.

NOTE 3—For the purpose of this standard, polyester includes vinyl ester resins.

³ *Annual Book of ASTM Standards*, Vol 08.02.

⁴ *Annual Book of ASTM Standards*, Vol 08.04.

⁵ *Annual Book of ASTM Standards*, Vol 08.03.

*A Summary of Changes section appears at the end of this standard.

4.1.2 *Type 2*—Epoxy resin, conforming to the requirements of Specification D 1763, with or without fillers or thixotropic agents, or both.

4.2 *Reinforcement:*

4.2.1 *Grade 1*—A commercial grade of glass fibers with a polyester-compatible finish.

4.2.2 *Grade 2*—A commercial grade of glass fibers with an epoxy-compatible finish.

4.3 *Gaskets*—The elastomeric gaskets used with the fittings joined to pipe shall conform to the requirements of Specification F 477.

5. Fabrication

5.1 *Permissible Components:*

5.1.1 Fittings covered under this specification shall be fabricated from cut section of pipe that conform to the requirements of Specification D 3262, or from a combination of such pipe sections and contact molded (hand layup) or machine fabricated components.

5.1.2 Saddles, wrappers, necked flanges, and other components of metal or other dissimilar materials may be incorporated as agreed upon between purchaser and supplier, provided the materials of such components are resistant to the corrosive effects of the internal and external environments anticipated in service, or are lined or coated or both with materials that provide equivalent protection.

5.2 *Bonding and Laminate Overlay Reinforcements:*

5.2.1 Sections of the fitting shall be aligned and bonded together using polyester (Type 1) or epoxy (Type 2) resin materials with or without fiberglass reinforcement. Fiberglass reinforcement materials shall be compatible with the laminating resin; Grade 1 reinforcements shall be used with Type 1 laminating resin, and Grade 2 reinforcements shall be used with Type 2 laminating resin.

5.2.2 Laminated reinforcing overlays of bonded seams may be applied to either the outside or inside surface of the fitting, or to both inside and outside surfaces. The laminate shall be of chemically resistant construction suitable for the purpose and shall provide the additional strength necessary to meet the physical requirements shown in Table 1. Finished seam overlays shall be built up in two or more successive layers of reinforcement and shall be as crevice free as described in this paragraph and 5.2.3. The width of the first layer shall be 2 in. (50 mm) minimum. Successive layers shall increase uniformly in width to provide the specified minimum total width of overlay that shall be centered on the seam. Table 1 shows minimum widths of overlays required. The ends of each layer of reinforcement shall be overlapped a minimum of 1 in. (25 mm). Crevices between joined sections shall be filled with a filled resin paste, leaving a smooth inner surface. The interior of the seams shall also be sealed by covering with not less than

TABLE 1 Minimum Properties of Structural Laminates

Nominal Diameter, in. (mm)	Minimum Hoop Tensile Strength, lbf/in. (kN/m) of width ^A	Minimum Axial Tensile Strength, lbf/in. (kN/m) of circumference ^A	Minimum Total Width of Overlay, in. (mm) ^B
8 (203)	1600 (280)	1600 (280)	4 (100)
10 (254)	1600 (280)	1600 (280)	4 (100)
12 (305)	1600 (280)	1600 (280)	4 (100)
14 (356)	1600 (280)	1600 (280)	4 (100)
15 (381)	1600 (280)	1600 (280)	4 (100)
16 (406)	1600 (280)	1600 (280)	4 (100)
18 (457)	1600 (280)	1600 (280)	4 (100)
20 (508)	1600 (280)	1600 (280)	4 (100)
21 (533)	1600 (280)	1600 (280)	4 (100)
24 (610)	1600 (280)	1600 (280)	4 (100)
27 (686)	1600 (280)	1600 (280)	4 (100)
30 (762)	1600 (280)	1600 (280)	4 (100)
33 (838)	1700 (300)	1700 (300)	6 (150)
36 (914)	1800 (315)	1800 (315)	6 (150)
39 (991)	2000 (350)	2000 (350)	6 (150)
42 (1067)	2100 (368)	2100 (368)	6 (150)
45 (1143)	2300 (403)	2300 (403)	6 (150)
48 (1219)	2400 (420)	2400 (420)	8 (200)
51 (1295)	2600 (455)	2600 (455)	8 (200)
54 (1372)	2700 (473)	2700 (473)	8 (200)
60 (1524)	3000 (525)	3000 (525)	8 (200)
66 (1676)	3300 (578)	3300 (578)	10 (250)
72 (1829)	3600 (630)	3600 (630)	10 (250)
78 (1981)	3900 (683)	3900 (683)	10 (250)
84 (2134)	4200 (736)	4200 (736)	12 (300)
90 (2286)	4500 (788)	4500 (788)	12 (300)
96 (2438)	4800 (841)	4800 (841)	14 (350)
102 (2591)	5100 (893)	5100 (893)	16 (400)
108 (2743)	5400 (946)	5400 (946)	16 (400)
114 (2896)	5700 (998)	5700 (998)	16 (400)
120 (3048)	6000 (1051)	6000 (1051)	16 (400)
132 (3353)	6600 (1156)	6600 (1156)	18 (450)
144 (3658)	7200 (1261)	7200 (1261)	20 (500)

^A The values given are minimums only. Sound engineering practice dictates that all fittings be designed to withstand the loads and conditions anticipated in the service for which they are intended.

^B The dimensions given are minimums for "butt-and-strap" type joints.

a 0.03 in. (0.76 mm) thickness of reinforced resin-rich surface that provides corrosion resistance suitable for the intended service. Alternatively, when it is necessary to fabricate a fitting where the size and configuration do not allow adequate access to interior seams, the cut edges of sections shall be sealed prior to assembly and any reinforcing overlay protected by a resin-rich surface that provides corrosion resistance suitable for the intended service.

5.2.3 Components of dissimilar materials, such as steel to polyester or epoxy laminates, or polyester to epoxy laminates, shall be bonded with a resin compound capable of adhering to both materials. The resin compound shall contact the joining surfaces of both components with the spaces between the components filled. The excess resin compound that extrudes from the seam shall be removed, leaving a smooth fillet. Sealing laminates and reinforcing overlays shall be applied where required (see 5.1.1, 5.2.1, and 5.2.2).

6. Joints

6.1 The fitting joints shall be coupling or bell-and-spigot in accordance with the joint requirements of Specification D 3262, unless otherwise specified. Joint designs may be qualified on straight sections of pipe.

7. Physical Requirements

7.1 Properties of structural laminates, used either as seam reinforcing overlays or as contact molded or machine fabricated components, other than cut sections of pipe, shall be as shown in Table 1, when tested in accordance with 11.1.

7.2 *Shear Strength*—The minimum shear strength of seam reinforcing overlays shall be 500 psi (3.45 MPa) when tested in accordance with 11.2.

8. Dimensions and Permissible Variations

8.1 *Wall Thickness*—The wall thickness of any area of the fitting furnished under this specification shall not at any point be less than 87.5 % of the nominal wall thickness published in the manufacturers’ literature current at the time of purchase when measured in accordance with 11.3.1.

8.2 *Fitting Diameters*—Fittings shall be supplied in nominal diameters as given in Specification D 3262. The fitting diameter tolerances shall be as given in Specification D 3262, when measured in accordance with 11.3.2.

8.3 *Lengths*—The tolerance for the laying length and other significant dimensions shall be ±2 in. (±51 mm) or ±1 % of the dimension, whichever is greater. See Tables 2-6 and Figs. 1 and 2 for typical minimum laying lengths.

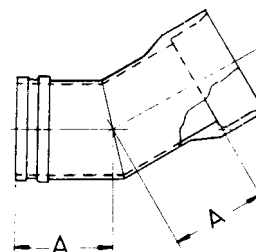
8.4 *Angular Dimensions*—Angular dimensions shall have a tolerance of ±1° when measured in accordance with 11.3.4.

9. Workmanship, Finish, and Appearance

9.1 The inside surfaces of each fitting shall blend smoothly and shall be free of bulges, dents, ridges, or other irregularities that result in a variation of more than 1/8 in. (3.2 mm) from that obtained on adjacent portions of the surface.

NOTE 4—This requirement is concerned with roughness and waviness and does not apply to diameter tolerances or thickness of internal seam reinforcement if present. See 8.2 for inside diameter tolerances, including internal reinforcement.

TABLE 2 0° to 30° Elbow^A



Pipe Size, in. (mm)	Dimension A ^B , in. (mm)
8 (203)	12 (305)
10 (254)	13 (330)
12 (305)	13 (330)
14 (356)	14 (356)
15 (381)	14 (356)
16 (406)	15 (381)
18 (457)	15 (381)
20 (508)	16 (406)
21 (533)	16 (406)
24 (610)	17 (432)
27 (686)	17 (432)
30 (762)	18 (457)
33 (838)	18 (457)
36 (914)	20 (508)
39 (991)	21 (533)
42 (1067)	22 (559)
45 (1143)	23 (584)
48 (1219)	24 (610)
54 (1372)	25 (635)
60 (1524)	26 (660)
66 (1676)	29 (737)
72 (1829)	29 (737)
78 (1981)	30 (762)
84 (2134)	34 (864)
90 (2286)	36 (914)
96 (2438)	38 (965)
102 (2591)	39 (991)
108 (2743)	41 (1041)

^A Fitting end configurations other than the typical bell and spigot shown in the figure are acceptable as agreed upon between manufacturer and purchaser. Refer to Section 6.

^B Dimensions given are typical minimum laying lengths. Laying lengths for fittings larger than 108 in. diameter shall be as agreed upon between purchaser and supplier.

9.2 Joint sealing surfaces shall be free of dents, gouges, cracks, and other surface imperfections that will affect the integrity of the joints.

9.3 The inner surface of each reinforced plastic fitting component and connecting seam shall be composed of resin with or without reinforcement, aggregate, or filler. No glass fiber-reinforcement shall penetrate the interior surface of the fitting wall.

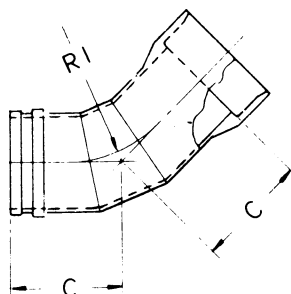
9.4 Internal and external reinforcements shall be free of voids, dry spots, cracks, and crazing. Some waviness in the internal reinforcement is permissible so long as the surface is smooth. Unless otherwise agreed upon between purchaser and supplier, all fittings shall meet the visual and repair criteria of Tables 7 and 8.

9.5 Fittings shall show good workmanship, including uniformity from item to item.

10. Sampling

10.1 *Lot*—Unless otherwise agreed upon between purchaser and supplier, one lot shall consist of 100 fittings of each type,

TABLE 3 31° to 60° Elbow^A



Pipe Size, in. (mm)	Dimension C ^B , in. (mm)	R1 (45°), in. (mm)
8 (203)	18.5 (470)	12.0 (305)
10 (254)	19.5 (495)	15.0 (381)
12 (305)	20.5 (521)	18.0 (457)
14 (356)	22.0 (559)	21.0 (533)
15 (381)	22.5 (572)	22.5 (572)
16 (406)	23.0 (584)	24.0 (610)
18 (457)	25.0 (635)	27.0 (686)
20 (508)	25.5 (648)	30.0 (762)
21 (533)	26.0 (660)	31.5 (800)
24 (610)	27.5 (699)	36.0 (914)
27 (686)	28.5 (724)	40.5 (1029)
30 (762)	31.0 (787)	45.0 (1143)
33 (838)	33.0 (838)	49.5 (1257)
36 (914)	34.5 (876)	54.0 (1372)
39 (991)	36.5 (927)	58.5 (1486)
42 (1067)	38.0 (965)	63.0 (1600)
45 (1143)	40.5 (1029)	67.5 (1715)
48 (1219)	41.5 (1054)	72.0 (1829)
54 (1372)	45.0 (1143)	81.0 (2057)
60 (1524)	48.5 (1232)	90.0 (2286)
66 (1676)	52.0 (1321)	99.0 (2515)
72 (1829)	55.5 (1410)	108.0 (2743)
78 (1981)	59.0 (1499)	117.0 (2972)
84 (2134)	62.5 (1588)	126.0 (3200)
90 (2286)	66.5 (1689)	135.0 (3429)
96 (2438)	70.0 (1778)	144.0 (3658)
102 (2591)	73.5 (1867)	153.0 (3886)
108 (2743)	77.0 (1956)	162.0 (4115)

^AFitting end configurations other than the typical bell and spigot shown in the figure are acceptable as agreed upon between the manufacturer and purchaser. Refer to Section 6.

^BDimensions given are typical minimum laying lengths. Laying lengths for fittings larger than 108 in. diameter shall be as agreed upon between purchaser and supplier.

grade, and construction of laminate overlay reinforcement, or contact molded or machine fabricated component, or both.

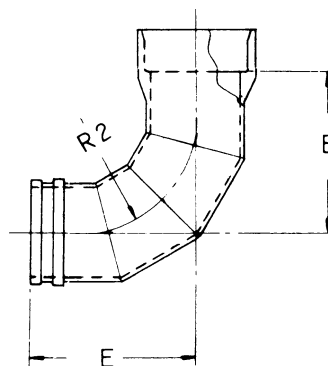
10.2 *Unit Sample*—Select one fitting from each lot. Prepare a sample or representative laminate and test specimens to determine conformance with the requirements of 7.1 for ultimate tensile strength.

11. Test Methods

11.1 *Ultimate Tensile Strength*—Determine the ultimate tensile strength of sample laminate specimens cut from seam reinforcing overlays or contact molded or machine fabricated components, or from specimens of a laminate fabricated to be consistent in every way with the construction used in the reinforcing overlay or component of the fitting. One or both of the following test methods shall be employed at the manufacturer's option:

11.1.1 *Test Method D 2290*, using Type B specimens, except that the size of the specimens may be modified and speed of

TABLE 4 61° to 90° Elbow^A



Pipe Size, in. (mm)	Dimension E ^B , in. (mm)	R2 (90°), in. (mm)
8 (203)	26.0 (660)	12.0 (305)
10 (254)	28.5 (724)	15.0 (381)
12 (305)	31.0 (787)	18.0 (457)
14 (356)	34.5 (876)	21.0 (533)
15 (381)	35.5 (902)	22.5 (572)
16 (406)	37.0 (940)	24.0 (610)
18 (457)	40.5 (1029)	27.0 (686)
20 (508)	43.0 (1092)	30.0 (762)
21 (533)	44.0 (1118)	31.5 (800)
24 (610)	46.0 (1219)	36.0 (914)
27 (686)	49.0 (1308)	40.5 (1029)
30 (762)	53.0 (1422)	45.0 (1143)
33 (838)	58.0 (1549)	49.5 (1257)
36 (914)	63.0 (1638)	54.0 (1372)
39 (991)	68.0 (1778)	58.5 (1486)
42 (1067)	71.0 (1854)	63.0 (1600)
45 (1143)	77.5 (1969)	67.5 (1715)
48 (1219)	80.0 (2070)	72.0 (1829)
54 (1372)	88.0 (2286)	81.0 (2057)
60 (1524)	95.0 (2489)	90.0 (2286)
66 (1676)	103.0 (2705)	99.0 (2515)
72 (1829)	115.0 (2921)	108.0 (2743)
78 (1981)	123.0 (3137)	117.0 (2972)
84 (2134)	131.5 (3340)	126.0 (3200)
90 (2286)	140.0 (3556)	135.0 (3429)
96 (2438)	148.5 (3772)	144.0 (3658)
102 (2591)	157.0 (3988)	153.0 (3886)
108 (2743)	165.5 (4204)	162.0 (4115)

^AFitting end configurations other than the typical bell and spigot shown in the figure are acceptable as agreed upon between the manufacturer and purchaser. Refer to Section 6.

^BDimensions given are typical minimum laying lengths. Laying lengths for fittings larger than 108 in. diameter shall be as agreed upon between purchaser and supplier.

testing and rate of crosshead motion shall not apply. Record the load to fail of each specimen and determine the specimen width as close to the break as possible. Use the measured width and failure load to calculate the tensile strength.

11.1.2 *Test Method D 638*, using flat Type I specimens, except that the specimens shall be the actual thickness of the reinforcing overlay or fabricated component and the other dimensions shall be suitable for the specimen thickness and the testing apparatus. Specimens may be machined on the edges, but shall not be machined on the surface. Tensile strength shall be the average of five specimens tested at a speed of 0.20 to 0.25 in. (5 to 6.4 mm)/min.

11.1.3 Conduct tests of anisotropic laminates to determine the ultimate tensile strength in both the hoop and axial directions. The ultimate tensile strength of isotropic laminates