



Designation: C 877 – 02

Standard Specification for External Sealing Bands for Concrete Pipe, Manholes, and Precast Box Sections¹

This standard is issued under the fixed designation C 877; 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 external sealing bands to be used in conjunction with concrete pipe as defined in Terminology C 822 and conforming to Specifications C 14, C 76, C 412, C 478, C 506, C 507, C 655, C 985, C 1417, and C 1433.

1.1.1 Type I, Rubber and Mastic Bands.

1.1.2 Type II, Plastic Film and Mesh Reinforced Mastic Bands.

1.1.3 Type III, Chemically-Bonded Adhesive Butyl Bands.

1.2 A complete metric companion to Specification C 877 has been developed—C 877M; therefore, no metric equivalents are presented in this specification.

NOTE 1—This specification covers only the design and material of the sealing bands. Sealing bands covered by this specification are adequate, when properly installed, for external hydrostatic pressures up to 13 psi, (30 ft) without leakage. The amount of infiltration or exfiltration flow in an installed pipeline is dependent upon many factors other than the sealing bands; allowable quantities and suitable testing of the installed pipeline and system must be covered by other specifications.

2. Referenced Documents

2.1 ASTM Standards:

- A 167 Specification for Stainless and Heat-Resisting Chromium-Nickel Plate, Sheet, and Strip²
- C 14 Specification for Concrete Sewer, Storm Drain, and Culvert Pipe³
- C 76 Specification for Reinforced Concrete Culvert, Storm Drain, and Sewer Pipe³
- C 412 Specification for Concrete Drain Tile³
- C 478 Specification for Precast Reinforced Concrete Manhole Sections³
- C 506 Specification for Reinforced Concrete Arch Culvert, Storm Drain, and Sewer Pipe³
- C 507 Specification for Reinforced Concrete Elliptical Culvert, Storm Drain, and Sewer Pipe³
- C 655 Specification for Reinforced Concrete D-Load Cul-

- vert, Storm Drain, and Sewer Pipe³
- C 681 Test Method for Volatility of Oil- and Resin-Based, Knife-Grade, Channel Glazing Compounds⁴
- C 766 Test Method for Adhesion After Impact of Preformed Tape Sealants⁴
- C 822 Terminology Relating to Concrete Pipe and Related Products³
- C 985 Specification for Nonreinforced Concrete Specified Strength Culvert, Storm Drain, and Sewer Pipe³
- C 1417 Specification for Manufacture of Reinforced Concrete Sewer, Storm Drain, and Culvert Pipe for Direct Design³
- C 1433 Specification for Precast Reinforced Concrete Box Sections for Culverts, Storm Drains, and Sewers³
- D 36 Test Method for Softening Point of Bitumen (Ring and Ball Apparatus)⁵
- D 217 Test Methods for Cone Penetration of Lubricating Grease⁶
- D 395 Test Methods for Rubber Property—Compression Set⁷
- D 412 Test Methods for Vulcanized Rubber and Thermoplastic Rubbers and Thermoplastic Elastomers—Tension⁷
- D 471 Test Method for Rubber Property—Effect of Liquids⁷
- D 570 Test Method for Water Absorption of Plastics⁸
- D 573 Test Method for Rubber—Deterioration in an Air Oven⁷
- D 624 Test Method for Tear Strength of Conventional Vulcanized Rubber and Thermoplastic Elastomers⁷
- D 882 Test Method for Tensile Properties of Thin Plastic Sheetings⁸
- D 1171 Test Method for Rubber Deterioration—Surface Ozone Cracking Outdoors or Chamber (Triangular Specimens)⁷
- D 1278 Test Methods for Rubber from Natural Sources—Chemical Analysis⁷

¹ This specification is under the jurisdiction of ASTM Committee C13 on Concrete Pipe and is the direct responsibility of Subcommittee C13.08 on Rubber Gaskets.

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² Annual Book of ASTM Standards, Vol 01.03.

³ Annual Book of ASTM Standards, Vol 04.05.

⁴ Annual Book of ASTM Standards, Vol 04.07.

⁵ Annual Book of ASTM Standards, Vol 04.04.

⁶ Annual Book of ASTM Standards, Vol 05.01.

⁷ Annual Book of ASTM Standards, Vol 09.01.

⁸ Annual Book of ASTM Standards, Vol 08.01.

- D 1682 Test Methods for Breaking Load and Elongation of Textile Fabrics⁹
- D 1963 Test Method for Specific Gravity of Drying Oils, Varnishes, Resins, and Related Materials at 25/25°C¹⁰
- D 2202 Test Method for Slump of Sealants⁴
- D 2240 Test Method for Rubber Property—Durometer Hardness⁷
- D 3407 Test Methods for Joint Sealants, Hot-Poured, for Concrete and Asphalt Pavements¹¹
- D 3953 Specification for Strapping, Flat Steel and Seals¹²

3. Terminology

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

4. Basis of Acceptance

4.1 The acceptability of the sealing bands shall be determined by the results of the physical tests prescribed in this specification, if and when required, and by inspection to determine whether the sealing bands conform to this specification as to design and freedom from defects.

5. Materials and Manufacture for Sealing Bands

5.1 Type I, Rubber and Mastic Bands:

5.1.1 Sealing bands shall be composed of rubber, mastic, and protective film elements as schematically shown in Fig. 1 and with dimensions as required in the following:

5.1.1.1 *Length of Sealing Band*—For a given pipe size, the length of the sealing band as furnished shall be such that after being stretched longitudinally 8 to 12 % as part of the installation procedure, the sealing band will encircle the outside perimeter of the pipe and overlap by an amount equal to, but not less than, the width of the sealing band. Sealing bands may be furnished in the required length or multiples thereof.

5.1.1.2 *Width of Sealing Band*—The width of the sealing band shall conform to the requirements of Table 1.

5.1.2 *Rubber Element*—The rubber element shall be extruded or molded from a high-grade rubber compound and shall be cured in such a manner that any cross section will be dense, homogeneous, and free of porosity, blisters, pitting, and

TABLE 1 Required Sealing Band Width

Equivalent Circular Pipe Diameter, in.	Sealing Band Width, in.
18 to 33	7
36 to 78	9
84 to 108	11
114 to 144	13

other imperfections. The basic polymer shall be natural, synthetic, or a blend of both and shall meet the physical requirements prescribed in Section 6. The rubber element shall have ribs with a height of $\frac{3}{16}$ in., spaced $\frac{3}{4}$ to $1\frac{1}{4}$ in. apart, and have a thickness between the ribs of $\frac{1}{16}$ in. The thickness of the ribs is not prohibited from varying from $\frac{1}{8}$ in. at the base to $\frac{1}{32}$ in. at the top.

5.1.3 *Mastic Element*—The mastic element shall contain rubber, reclaimed rubber and asphaltic derivatives, clay, asbestos, and/or resin and shall meet the physical requirements prescribed in Section 6. The mastic element shall have a thickness of $\frac{1}{8}$ in. and be free of porous areas, air pockets, and contamination by foreign matter.

5.1.4 *Protective Film*—The protective film shall be water soluble, have a 1-mil (0.001 in.) thickness, and meet the physical requirements prescribed in Section 6.

NOTE 2—The function of the film is to protect the mastic surface prior to installation. It is intended to dissolve away in the presence of moisture during installation and expose the mastic for sealing.

5.2 Type II Plastic Film and Mesh Reinforced Mastic Bands:

5.2.1 Sealing bands shall be composed of a plastic film, reinforced, rubberized, asphalt, mastic coating with steel straps as schematically shown in Fig. 2, with dimensions as required in the following:

5.2.1.1 *Length of Sealing Band for a Given Pipe Size*—The length of the sealing band shall be equal to the outside perimeter of the joint plus 8 in. to provide for overlap.

5.2.1.2 *Width of Sealing Band*—The width of the sealing band shall conform to the requirements of Table 1.

5.2.2 *Plastic Film Element*—The plastic film element shall be an extended polymer which provides external reinforcement and shall meet the physical requirements prescribed in Section 6.

5.2.3 *Mesh Reinforcement Element*, The mesh reinforcement shall consist of a woven plastic mesh and shall meet the physical requirements prescribed in Section 6.

5.2.4 *Rubberized Asphalt Mastic Element*—The rubberized, asphalt, mastic element shall be a self adhering composition and shall meet the requirements prescribed in Section 6.

5.2.5 *Tie Strap Element*—The tie strap element shall be steel straps with a minimum width of $\frac{3}{8}$ in. and a minimum thickness of 0.020 in. and shall conform to Specification

⁹ Discontinued. See 1992 Annual Book of ASTM Standards, Vol 07.01.
¹⁰ Annual Book of ASTM Standards, Vol 06.03.
¹¹ Discontinued. Replaced by D 5329. See 1996 Annual Book of ASTM Standards, Vol 04.03.
¹² Annual Book of ASTM Standards, Vol 15.09.

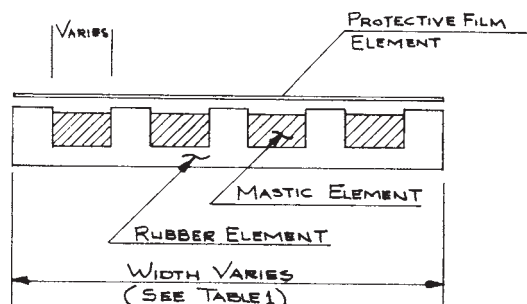


FIG. 1 Sealing Band Type I Schematic (Not to Scale)

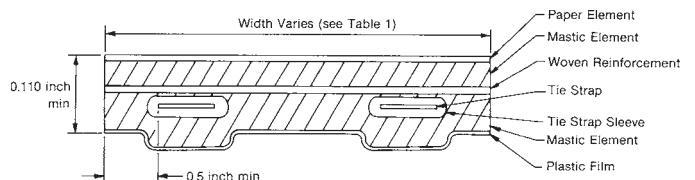


FIG. 2 Sealing Band Type II (Not to Scale)

D 3953. Steel straps shall be secured around the pipe with appropriate strapping tools as recommended by the sealing band manufacturer.

5.2.6 *Tie Strap Sleeve Element*—The tie strap sleeve element shall consist of a minimum of 1 in. wide flat sleeve inside which the steel tie straps are not prohibited from sliding freely. The sleeve shall be made from woven or non-woven polypropylene fabric with nominal weight of 3.5 oz/yd².

5.2.7 *Release Sheet Element*—The disposable release sheet element shall consist of a silicone coated paper with a minimum basis weight of 50 lb/3000 ft².

5.3 *Type III, Chemically-Bonded Adhesive Butyl Bands:*

- Type A (Plastic backing band)
- Type B (Rubber backing band)
- A semi-liquid paintable butyl rubber-based adhesive primer

5.3.1 Sealing bands shall be composed of a backing band, an applied continuous butyl adhesive coating, and an optional release element (as schematically shown in Fig. 3), with width and overlap dimensions as required by 5.3.1.1 and 5.3.1.2. Purchaser specified clamping devices or tie straps are not prohibited to be used with these sealing bands.

5.3.1.1 *Length of Sealing Band for a Given Pipe Size*—The length of the sealing bands shall be equal to the outside perimeter of the joint plus a minimum distance equal to two times the width of the material used to provide for overlap. This requirement shall allow the sealing bands to be applied without stretching the product during application.

5.3.1.2 *Width of Sealing Band*—The minimum width of the sealing band shall conform to the requirements of Table 2.

5.3.2 *Backing Band Element:*

5.3.2.1 *Type A (Plastic Backing Band)*—The plastic backing band element shall be made from high density polyethylene plastic conforming to the physical requirements prescribed in Section 6

5.3.2.2 *Type B (Rubber Backing Band)*—The rubber used in the rubber backing band element shall conform to the physical property requirements of Section 6.

5.3.3 *Butyl Rubber Adhesive Element*—The butyl rubber adhesive element, conforming to the physical requirements prescribed in Section 6, shall be a self-adhering semi-solid and shall be applied evenly and homogeneously to the backing band with a minimum thickness of:

TABLE 2 Required Sealing Band Width (Type III)

Equivalent Circular Pipe Diameter, in.	Minimum Sealing Band Width, in.
12 to 33	6
36 to 78	9
84 and larger	12

Type A (Plastic backing band)	0.03 in.
Type B (Rubber backing band)	0.03 in.

5.3.4 *Primer Element*—The primer element shall be a semi-liquid homogeneous mixture of butyl rubber and vehicle, conforming to the physical requirements prescribed in Section 6, and shall be spread in a continuous film at the intersection of the joint. The application width shall be sufficient to ensure that the entire band area will contact only primed surfaces.

5.3.5 *Optional Tie Strap Element*—The optional tie strap element shall be steel straps with a minimum width of 5/8 in. and a minimum thickness of 0.20 in. and shall conform to Specification D 3953. Steel straps shall be secured around the pipe with appropriate strapping tools as recommended by the sealing band manufacturer.

5.3.6 *Optional Clamping Devices*—Optional clamping devices shall be constructed of corrosion resistant materials meeting the physical properties and chemical composition requirements of Specification A 167.

5.3.7 *Optional Release Element*—The optional release element shall consist of coated paper or plastic that has demonstrated its suitability for this use.

6. Requirements

6.1 *Type I, Rubber and Mastic Bands:*

6.1.1 The rubber element shall have the following physical properties when tested in accordance with 8.1.1:

Tensile strength, min, psi	1200
Elongation at break, min, %	300
Shore durometer hardness:	
min	60
max	70
Compression set, max, % of deflection	25
Accelerated aging:	
Decrease in tensile strength, max, % of original	15
Decrease in elongation, max, % of original	20

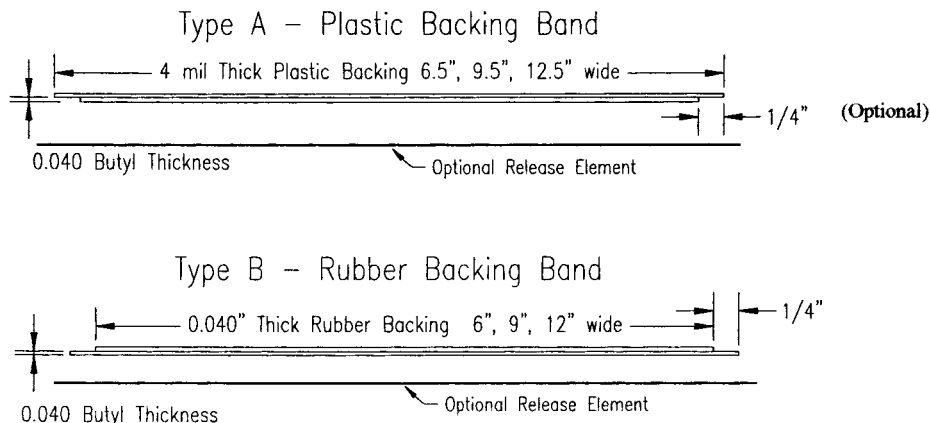


FIG. 3 Sealing Band Type III (Not to Scale)