



Standard Practice for Determining Dimensions of “Fiberglass” (Glass-Fiber- Reinforced Thermosetting Resin) 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 practice covers the determination of outside diameter, inside diameter, total wall thickness, reinforced wall thickness, liner thickness (where applicable), and length dimensions of “fiberglass” (glass-fiber-reinforced thermosetting resin) pipe. Included are procedures for measuring tapered dimensions and taper angles for pipe intended to be joined by tapered socket fittings, and procedures for gaging internal and external threads.

1.2 This practice also includes procedures for determining dimensions for fiberglass pipe fittings.

1.3 The values stated in inch-pound units are to be regarded as the standard. The SI units given in parentheses are for information only.

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

1.4 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of whoever uses this standard to consult and establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:

D 4166 Test Method for Measurement of Thickness of Nonmagnetic Materials by Means of a Digital Magnetic Intensity Instrument²

2.2 ANSI Standard:

B 2.1 Pipe Threads (Except Dryseal)³

2.3 API Standard:

API 5B Threading, Gaging, and Thread Inspection of Casing, Tubing, and Line Pipe Threads⁴

¹ This practice is under the jurisdiction of ASTM Committee D20 on Plastics and is the direct responsibility of Subcommittee D20.23 on Reinforced Plastic Piping Systems and Chemical Equipment.

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² *Annual Book of ASTM Standards*, Vol 08.04.

³ Available from American National Standards Institute, 25 West 43rd Street, 4th Floor, New York, NY 10036.

⁴ Available from American Petroleum Institute, 1220 L St., NW, Washington, DC 20005.

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *deviation from straightness*—the maximum deviation from a straight line exhibited by a pipe specimen divided by the length of the specimen.

3.1.2 *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.

3.1.3 *laying length of fittings*—the actual increase in the length of a line afforded by the fitting when installed.

3.1.4 *liner and exterior surface layer thicknesses*—the inner and outer portions of the wall used to enhance chemical and water resistance; they may have a different composition than the reinforced wall and the thicknesses of these internal and external surfaces may be measured when their boundary limits are visually indentifiable and if they are each at least 0.005 in. (0.10 mm) in thickness.

3.1.5 *reinforced thermosetting resin pipe (RTRP)*—a fiberglass pipe without aggregate.

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

4. Significance and Use

4.1 This practice provides for determining the physical dimensions of fiberglass pipe and fittings. This practice is suitable for determination of dimensional compliance with product specifications.

5. Conditioning

5.1 Test conditions for measurements shall be in accordance with appropriate product specification(s).

6. Total Wall Thickness—Pipe and Fittings

6.1 *Apparatus*—Calipers, optical comparators described in Section 7, ultrasonic thickness meters, or other gages such as the digital magnetic intensity instrument described by Test Method D 4166, with graduations of 0.01 in. (0.025 mm) or less that produces a thickness measuring accuracy of within

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

5 %, may be used for measuring thicknesses of 0.20 in. (5.1 mm) or greater. For thicknesses less than the above, use a micrometer or other gage with graduations of 0.001 in. (0.025 mm) and an accuracy of within 5 %. Use a cylindrical tubing micrometer or spherical anvil micrometer with a radius end where the diameter of the pipe is small and a measuring error of 5 % or less would be exceeded without its use.

6.2 Procedure—Make a series of at least four readings at random selected locations, approximately equally spaced around the circumference. The location of the measurements should be taken some distance in from the pipe ends if the end thickness would be expected to be greater than other regions of the pipe.

NOTE 2—Take care to ensure that the measurements are not made at either a tapered or belled pipe end.

NOTE 3—Take care to avoid misalignment of the anvil with the longitudinal axis of the specimen when using cylindrical anvil micrometers that may bridge specimen surface curvature or indentations and give falsely high readings.

6.3 Calculation—Calculate the average total wall thickness of the four or more thicknesses taken.

6.4 Report—The report shall include the following:

- 6.4.1 Observed minimum and maximum wall thickness, and
- 6.4.2 Calculated average total wall thickness.

7. Reinforced Wall Thickness and Liner Thicknesses— Pipe and Fittings

7.1 Sampling—When performed on finished pipe or fittings, this procedure will usually destroy or damage the part. When this procedure is to be used for quality control or sampling, it is intended for use on samples taken from the excess of the fabrication, such as the ends of pipe or fittings, or both. If the procedure requires destructively testing the pipe or fittings, the requirements shall be agreed upon between the buyer and the seller.

7.2 Apparatus—An optical scale comparator with a 7 to 10X magnification and having a reticle graduated as follows:

7.2.1 For products with liner measurements less than 0.050 in. (1.27 mm): 0.001-in. (0.025-mm) divisions or not more than 10 % of liner thickness, whichever is smaller.

7.2.2 For products with liner measurements 0.050 in. (1.27 mm) or larger: 0.005-in. (0.13-mm) divisions or smaller.

7.3 Procedure:

7.3.1 Surface Preparation—At the desired cross section of the pipe or fitting, make a sawcut at right angles to the inside surface. Remove burrs and sand the cut surface smooth, using 200-grit (or finer) sandpaper. Thoroughly wash the sanded surface with clean water to remove resin and glass dust, then blot dry.

7.3.2 Reinforced Wall and Liner Thickness—Measure the cut surface of the pipe or fitting by setting a major scale division of the reticle at the apparent interface between the liner and reinforced wall. Make 6 measurements 60° apart as follows:

7.3.2.1 Read toward the outer surface of the pipe or fitting wall and observe the reinforced wall thickness.

7.3.2.2 Read toward the inner surface of the pipe or fitting wall and observe the liner thickness.

7.3.3 Surface Layer Thickness—If the product specification requires surface layer measurement, set a major scale division at the apparent interface between the coating and the reinforced wall. Make 6 measurements 60° apart by reading toward the outer surface of the pipe or fitting and observing the surface layer thickness.

7.3.4 Nonreinforced Layers, within the reinforced wall or combination reinforcement layers. If the product involves unreinforced layers or multiple reinforcement layers of different types, the amount and type of measurements shall be agreed upon between the buyer and the seller.

7.3.4.1 The thickness of these layers shall be determined by setting a major scale division of the reticle at the apparent interface and reading toward the next apparent interface. Make 6 measurements 60° apart.

7.4 Calculations—Calculate the average reinforced wall thickness and liner thickness by averaging the values obtained.

7.5 Report—The report shall include the following:

- 7.5.1 Observed minimum and maximum reinforced wall thickness,
- 7.5.2 Calculated average reinforced wall thickness,
- 7.5.3 Observed minimum and maximum liner thickness,
- 7.5.4 Calculated average liner thickness, and
- 7.5.5 Observations of exterior surface layer, nonreinforced layers, or other reinforced layer measurements within the reinforced wall when measured.

8. Average Outside Diameter Measurements

NOTE 4—The need for measurements and the location of the measurements should be evaluated since the outside surface of the pipe may not be smooth. Uneven surfaces or burrs will influence the accuracy of the outside diameter measurements.

8.1 Apparatus—A circumferential vernier wrap tape shall be used to determine the average outside diameter. The tape should be accurate to within ± 0.02 in. (± 0.4 mm) on the circumference measured.

8.2 Procedure—Individually measure and record the outside diameter end-sealing surfaces or special OD control surfaces. Make the OD measurements near each end and at three intermediate locations. Take the OD measurement by placing the circumferential wrap tape around the pipe, making sure it is at right angles to the pipe axis. Average all five readings.

8.2.1 Calculate the diameter as follows:

$$D = C_{OD} / \pi \quad (1)$$

where:

C_{OD} = average of the readings.

NOTE 5—For larger diameter piping, the weight of the piping may cause significant distortion. Take care in measurement and evaluation of the significance of this measurement. If significant product distortion due to weight occurs, the pipe may be measured when in the vertical position. Alternatively, the diameter may be measured as a reference from the mandril from which the pipe was made as follows:

$$d = (C_M / \pi + 2 \times \text{wall thickness}) \quad (2)$$

where: