



Standard Specification for Polymer Concrete Pipe¹

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1. Scope

1.1 This specification covers polymer concrete pipe, 6 in. (150 mm) through 144 in. (3 660 mm), intended for use in gravity-flow systems for conveying sanitary sewage, storm water, and industrial wastes.

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

1.2 Although this specification is suited primarily for pipe to be installed by direct burial and pipe jacking, it may be used to the extent applicable for other installations such as sliplining and rehabilitation of existing pipelines.

NOTE 2—Unlike reinforced thermosetting resin pipes, polymer concrete pipe is designed and installed using rigid pipe design theory and practices.

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

1.4 The following safety hazards caveat pertains only to the test methods portion, Section 8, of this specification. *This standard may involve hazardous materials, operations, and equipment. 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 requirements prior to use.*

2. Referenced Documents

2.1 ASTM Standards:

- A 276 Specification for Stainless Steel Bars and Shapes²
- C 33 Specification for Concrete Aggregates³
- C 117 Test Method for Materials Finer than 75 μm (No. 200) Sieve in Mineral Aggregates by Washing⁴
- C 125 Terminology Relating to Concrete and Concrete Aggregates⁴
- C 136 Test Method for Sieve Analysis of Fine and Coarse Aggregates⁴

¹ This specification 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 01.03.

³ Annual Book of ASTM Standards, Vol 04.02.

⁴ Annual Book of ASTM Standards, Vol 04.05.

- C 579 Test Method for Compressive Strength of Chemical-Resistant Mortars, Grouts, Monolithic Surfacing and Polymer Concretes⁴
- D 648 Test Method for Deflection Temperature of Plastics Under Flexural Load in the Edgewise Position⁵
- D 883 Terminology Relating to Plastics⁵
- D 1600 Terminology for Abbreviated Terms Relating to Plastics⁵
- D 2584 Test Method for Ignition Loss of Cured Reinforced Resins⁶
- D 3567 Practice for Determining Dimensions of “Fiberglass” (Glass-Fiber-Reinforced-Thermosetting-Resin) Pipe and Fittings⁷
- D 3681 Test Method for Chemical Resistance of “Fiberglass” (Glass-Fiber-Reinforced-Thermosetting-Resin) Pipe in a Deflected Condition⁷
- D 3892 Practice for Packaging/Packing of Plastics⁶
- D 4161 Specification for “Fiberglass” (Glass-Fiber-Reinforced-Thermosetting-Resin) Pipe Joints Using Flexible Elastomeric Seals⁷
- F 412 Terminology Relating to Plastic Piping Systems⁷
- F 477 Specification for Elastomeric Seals (Gaskets) for Joining Plastic Pipe⁷

3. Terminology

3.1 *Definitions*—Unless otherwise indicated, definitions are in accordance with Terminologies C 125, D 883, and F 412, and abbreviations are in accordance with Terminology D 1600.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *aggregate, n*—a granular material, such as sand, gravel, or crushed stone, in accordance with the requirements of Specification C 33 except that the requirements for gradation shall not apply.

3.2.2 *pipe jacking, n*—a system of directly installing pipes behind a shield machine by hydraulic jacking from a drive shaft, such that the pipes form a continuous string in the ground.

3.2.3 *polymer concrete, n*—a composite material that consists essentially of a thermosetting resin within which are embedded particles or fragments of aggregate.

⁵ Annual Book of ASTM Standards, Vol 08.01.

⁶ Annual Book of ASTM Standards, Vol 08.02.

⁷ Annual Book of ASTM Standards, Vol 08.04.

3.2.4 *polymer concrete pipe, n*—tubular product containing aggregate, embedded in or surrounded by cured thermosetting resin, which may also contain granular or platelet fillers, thixotropic agents, pigments, or dyes.

3.2.5 *qualification test, n*—one or more tests used to prove the design of a product and which are not routine quality control tests.

4. Classification

4.1 Polymer concrete pipe furnished under this specification is manufactured in strength classes I, II, III, IV, or V as given in Table 1. (See also Note 5.)

NOTE 3—The D-Load is the three-edge bearing strength per unit length divided by the inside diameter.

NOTE 4—Other strength categories shall be permitted by agreement between the purchaser and the manufacturer.

5. Materials and Manufacture

5.1 *Wall Composition*—The wall composition shall consist of a thermosetting resin and aggregate.

5.1.1 *Thermosetting Resin*—The resin shall have a minimum deflection temperature of 158°F (70°C) when tested at 264 psi (1.820 mPa) following Test Method D 648. The resin content shall not be less than 7 % of the weight of the sample as determined by Test Method D 2584.

5.1.2 *Aggregate*—Aggregate, and mineral fillers tested in accordance with all requirements of Test Methods C 117 and C 136, except requirements for gradation shall not apply.

5.2 *Joints*—The pipe shall have a gasket sealed joining system that shall prevent leakage of fluid in the intended service condition.

5.2.1 *Couplings*—Stainless Steel 316 Ti, in accordance with, Specification A 276, or a glass-fiber-reinforced-thermosetting-resin coupling which uses an elastomeric seal. Figs. 1 and 2 show typical couplings.

5.2.2 *Gaskets*—Elastomeric gaskets used with this pipe shall conform to the requirements of Specification F 477, except that composition of the elastomer shall be as agreed upon between the purchaser and the supplier as being resistant to the intended chemical environments.

6. Requirements

6.1 *Workmanship*—Each pipe shall be free from all defects, including indentations, cracks, foreign inclusions, and resin-starved areas that, due to 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.

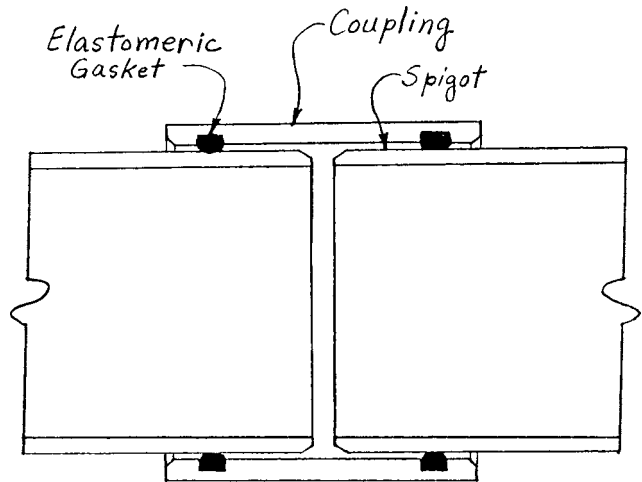


FIG. 1 Typical Coupling Joint Detail

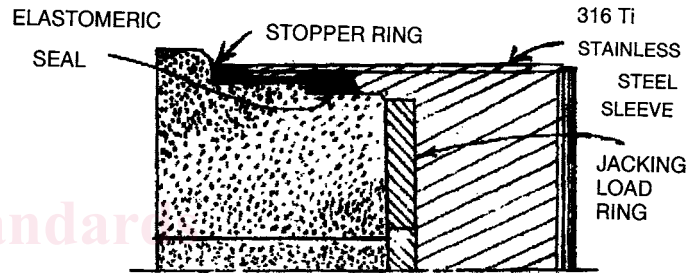


FIG. 2 Typical Jacking Pipe Joint

6.1.1 The inside surface of each pipe shall be free of bulges, dents, ridges, and other defects that result in a variation of inside diameter of more than 1/8 in. (3.2 mm) from that obtained on adjacent unaffected portions of the surface.

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

6.2 *Dimensions:*

6.2.1 *Pipe Diameter*—The pipe shall be supplied in the nominal diameters shown in Table 2 when measured in accordance with 8.1.1.

6.2.2 *Lengths*—Pipe shall be supplied in nominal lengths of 3, 4, 5, 6, 8, and 10 ft. (0.92, 1.22, 1.52, 1.83, 2.44, and 3.05 m) unless otherwise agreed to between purchaser and seller. Tolerance on length shall be ±2 in. (±50 mm). The pipe shall be measured in accordance with 8.1.2.

6.2.3 *Wall Thickness*—The average wall thickness of the pipe shall not be less than the nominal wall thickness published in the manufacturer’s literature current at the time of purchase, when measured in accordance with 8.1.3.

6.2.4 *Straightness of Pipe:*

6.2.4.1 *Direct Bury Pipe*—Pipes shall not deviate from straight by more than 0.10 in./ft (8.3mm/m) for nominal diameters through 39 inch, 0.12 in./ft (10mm/m) for nominal diameters 42 in. through 78 in. and 0.14 in./ft (11.7mm/m) for nominal diameters 84 in. through 144 in. when measured in accordance with 8.1.4.

6.2.4.2 *Jacking Pipe* —Pipes shall not deviate from straight by more than 0.04 in./ft (3.3 mm/m) for nominal diameters

TABLE 1 Strength Classes for Polymer Concrete Pipe

Strength Class	D-Load lb/ft/ft (kN/m/m)
I	1200 (57.5)
II	1500 (71.9)
III	2000 (95.8)
IV	3000 (143.8)
V	3750 (179.7)

TABLE 2 Diameters for Polymer Concrete Pipe

Nominal Diameter, in.	Inside Diameter in. (mm)	Tolerance on ID in. (mm)
6	6.00 (152.4)	± 0.25 (6.4)
8	8.00 (203.2)	± 0.25 (6.4)
10	10.00 (254.0)	± 0.25 (6.4)
12	12.00 (304.8)	± 0.25 (6.4)
14	14.00 (355.6)	± 0.25 (6.4)
15	15.00 (381.0)	± 0.25 (6.4)
16	16.00 (406.4)	± 0.25 (6.4)
18	18.00 (457.2)	± 0.25 (6.4)
20	20.00 (508.0)	± 0.25 (6.4)
21	21.00 (533.4)	± 0.25 (6.4)
24	24.00 (609.6)	± 0.25 (6.4)
27	27.00 (685.8)	± 0.27 (6.4)
30	30.00 (762.0)	± 0.30 (7.6)
33	33.00 (838.2)	± 0.33 (8.4)
36	36.00 (914.4)	± 0.36 (9.1)
39	39.00 (990.6)	± 0.39 (9.9)
42	42.00 (1066.8)	± 0.42 (10.7)
45	45.00 (1143.0)	± 0.45 (11.4)
48	48.00 (1219.2)	± 0.48 (12.2)
51	51.00 (1295.4)	± 0.51 (13.0)
54	54.00 (1371.6)	± 0.54 (13.7)
60	60.00 (1524.0)	± 0.60 (15.2)
66	66.00 (1676.4)	± 0.66 (16.8)
72	72.00 (1828.8)	± 0.72 (18.3)
78	78.00 (1981.2)	± 0.78 (19.8)
84	84.00 (2133.6)	± 0.84 (21.3)
90	90.00 (2286.0)	± 0.90 (22.9)
96	96.00 (2438.4)	± 0.96 (24.4)
102	102.00 (2590.8)	±1.00 (25.4)
108	108.00 (2743.2)	±1.00 (25.4)
114	114.00 (2895.6)	±1.00 (25.4)
120	120.00 (3048.0)	±1.00 (25.4)
132	132.00 (3352.8)	±1.00 (25.4)
144	144.00 (3657.6)	±1.00 (25.4)

NOTE—Other diameters shall be permitted by agreement between the purchaser and the manufacturer.

through 39 inch, 0.06 in./ft (5.0mm/m) for nominal diameters 42 in. through 78 in., and 0.08 in./ft (6.7mm/m) for nominal diameters 84 in. through 144 in. when measured in accordance with 8.1.4.

6.2.5 Roundness of Pipe—The outside diameter shall not vary from a true circle by more than 1.0 % when measured in accordance with 8.1.5.

6.2.6 Squareness of Pipe Ends:

6.2.6.1 Direct Bury Pipe —The ends of the pipe shall be perpendicular to the longitudinal axis within ± 0.25 in (± 6.4 mm) or ± 0.5 % of the nominal diameter, whichever is the greater, when tested when tested in accordance with 8.1.6

6.2.6.2 Jacking Pipe —The ends of the pipe shall be perpendicular to the longitudinal axis within 0.06 in (1.5mm) for nominal diameters through 39 inch, 0.12 inch (3mm) for nominal diameters 42 inch through 102 inch and 0.20 inch (5mm) for diameters 108 inch through 144 inch, when tested in accordance with 8.1.6.

6.3 Three-Edge Bearing—The pipe shall withstand, without failure, the three-edge bearing loads specified in Table 1 when tested in accordance with 8.2.

6.4 Hydrostatic Pressure—The pipe shall withstand an internal pressure of 35 psi (0.25 mPa) when tested in accordance with 8.3.

6.5 Compressive Strength—The minimum axial compressive strength shall be 10 000 psi (68.9 mPa) when tested in accordance with 8.4.

6.6 Chemical Resistance:

6.6.1 Long Term—When tested in accordance with 8.5, the extrapolated 50 year strength value shall be at least 50 % of the initial three-edge bearing strength of the test pipes.

6.6.2 Control Requirements—When tested in accordance with 8.5, pipe specimens shall be capable of sustaining without failure for 1 000 h a load equal to 60 % of the initial three-edge bearing strength of the test pipes.

6.7 Joint Tightness—The joint shall meet the requirements described in Specification D 4161, except that the internal pressure shall be 35 psi (0.25 mPa) and the minimum test time shall be 15 min.

7. Sampling

7.1 Lot—Unless otherwise agreed upon between the purchaser and supplier, one lot shall consist of a manufacturing run of no more than 100, but at least 20, lengths of pipe of each diameter and strength class produced.

7.2 Production Tests—Select one pipe at random from each lot to determine conformance of the material to the workmanship, dimensional, and physical requirements of 6.1, 6.2, 6.3 and 6.5, respectively.

7.2.1 Pipe Acceptance—If the tested specimen of a designated lot passes the test, the entire lot shall be acceptable. If the tested specimen of a designated lot fails to pass the test, then five additional specimens from that same lot shall be selected for testing. If the five additional specimens pass, the lot shall be acceptable. except the one previous failing specimen. If any of the five additional specimens fail, the entire lot shall be rejected.

7.3 Qualification Tests—Sampling for qualification tests (see 3.2.5) is not required unless otherwise agreed upon between the purchaser and the manufacturer. Qualification tests shall be conducted for changes in polymer aggregate and manufacturing process and for changes in pipe joint or gasket geometry. Qualification tests for which a certification and test report shall be furnished when requested by the purchaser include the following:

7.3.1 Hydrostatic Pressure Test—(see 6.4).

7.3.2 Chemical Resistance Test—(see 6.6).

7.3.3 Joint-Tightness Test—(see 6.7).

7.4 Control for Chemical Resistance Test—Perform sampling and testing for the control requirements of the chemical resistance test at least once annually, unless otherwise agreed upon between the purchaser and the supplier.

7.5 For individual orders, conduct only those additional tests and number of tests specifically agreed upon between the purchaser and the supplier.

8. Test Methods

8.1 Dimensions:

8.1.1 Diameters:

8.1.1.1 Inside Diameter—Take inside diameter measurements at a point approximately 6 in. (152 mm) from the end of the pipe section using a steel tape or an inside micrometer with