



Designation: F 2389 – 04

Standard Specification for Pressure-rated Polypropylene (PP) Piping Systems¹

This standard is issued under the fixed designation F 2389; 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 establishes requirements for polypropylene (PP) piping system components made to metric sizes and IPS schedule 80 sizes, and pressure rated for water service and distribution supply (see Appendix X1). Included are criteria for materials, workmanship, dimensions and tolerances, product tests, and marking for polypropylene (PP) piping system components such as pipe, fittings, valves, and manifolds.

1.2 The components governed by this specification shall be permitted for use in water service lines, hot-and-cold water distribution, hydronic heating, and irrigation systems.

1.3 The pipe and fittings produced under this specification shall be permitted to be used to transport industrial process fluids, effluents, slurries, municipal sewage, etc. The user shall consult the manufacturer to determine whether the material being transported is compatible with the polypropylene piping system and will not affect the service life beyond limits acceptable to the user.

1.4 *Units*—The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.5 *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:²

- D 792 Test Method for Density and Specific Gravity (Relative Density) of Plastics by Displacement
- D 1505 Test Method for Density of Plastics by the Density-Gradient Technique
- D 1598 Test Method for Time-to-Failure of Plastic Pipe Under Constant Internal Pressure

- D 1600 Terminology for Abbreviated Terms Related to Plastics
- D 2122 Test Method for Determining Dimensions of Thermoplastics Pipe and Fittings
- D 2749 Symbols for Dimensions of Plastic Pipe Fittings
- D 3895 Test Method for Oxidative-Induction Time of Polyolefins by Differential Scanning Calorimetry
- D 4101 Specification for Polypropylene Injection and Extrusion Materials
- F 412 Terminology Relating to Plastic Piping Systems

2.2 International Organization for Standardization (ISO) Standards:

- ISO 3127 Thermoplastic Pipes—Determination of Resistance to External Blows—Round the Clock Method³
- ISO 4065 Thermoplastics Pipes—Universal Wall Thickness Table³
- ISO 9080 Plastics Piping and Ducting Systems—Determination of the Long-Term Hydrostatic Strength of Thermoplastics Materials in Pipe Form by Extrapolation³
- ISO 15874-2:2002 Plastics Piping Systems for Hot and Cold Water Installations—Polypropylene (PP)—Part 2: Pipes³
- ISO 15874-3:2002 Plastics Piping Systems for Hot and Cold Water Installations—Polypropylene (PP)—Part 3: Fittings³
- ISO/TS 15874-7 Plastics Piping Systems for Hot and Cold Water Installations—Polypropylene (PP)—Part 7: Guidance for the Assessment of Conformity³

2.3 NSF International Standards:

- NSF/ANSI 14 Plastics Piping System Components and Related Materials⁴
- NSF/ANSI 61 Drinking Water System Components—Health Effects⁴

2.4 European Norm:

- prEN 10226-1 Pipe Threads Where Pressure Tight Joints are Made on the Threads—Part 1: Designation, Dimensions and Tolerances⁵

2.5 American Society of Mechanical Engineers (ASME)

Standard:

¹ This specification is under the jurisdiction of ASTM Committee F17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.61 on Water. Current edition approved June 1, 2004. Published July 2004.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Available from the International Organization for Standardization (ISO) 1, rue de Varembe, Case postale 56 CH-1211 Geneva 20, Switzerland.

⁴ Available from the Deutsches Institut für Normung, Burggrafenstrasse 6, 10787 Berlin, Germany.

⁵ Available from NSF International, 789 Dixboro Road, Ann Arbor, MI, 48105.

B1.20.1 Pipe Threads, General Purpose, Inch⁶

2.6 *Plastic Pipe Institute (PPI) Technical Report:*

TR-4 PPI Listing of Hydrostatic Design Basis (HDB), Strength Design Basis (SDB), Pressure Design Basis (PDB) and Minimum Required Strength (MRS) Ratings for Thermoplastic Piping Materials⁷

3. Terminology

3.1 Definitions:

3.1.1 Definitions are in accordance with Terminology F 412 and abbreviations are in accordance with Terminology D 1600, unless otherwise specified.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *polypropylene random copolymer (PP-R), n*—a propylene plastic containing not more than 50 % of another olefinic monomer (or monomers), having no functional group other than the olefinic group, copolymerized with the propylene.

3.2.1.1 *Discussion*—This term is also used for finished compound which comprises the PP-R resin and additives such as colorants, UV inhibitors, and stabilizers. Polypropylene random copolymers containing more than one additional monomer are often referred to as “terpolymers.”

3.2.2 *plastic-to-metal transition fittings, n*—a fitting designed to provide a means of connection between the PP piping system and metal piping systems such as steel pipe and copper tubing. The fittings include a means of taking into account the differences in thermal expansion of the materials and maintaining a pressure-tight seal over the intended use temperature range.

4. Classification

4.1 *General*—This specification covers PP piping systems made from PP materials (PP-R) in various dimension ratios and pressure ratings.

4.2 *Thermoplastic Pipe Series and Schedule*—This specification covers PP pipe made in schedule 80 IPS sizes and metric sizes in accordance with ISO 4065.

5. Materials and Manufacture

5.1 The pipe and fittings shall be polypropylene material of type PP-R. Clean rework material, of the same PP-R resin generated from the manufacturer’s own pipe or fitting production, shall be permitted to be used provided the pipe or fittings produced meet all requirements of this specification.

5.2 For pipe compound, the melt flow rate (MFR) shall not exceed 10.8 grain/10 min (0.7 g/10 min), when tested in accordance with D 1238 using conditions of 4.76 lbm (2.16 kg) at 446°F (230°C).

5.3 The density of the unreinforced, natural color PP material shall not exceed 56.9 lbm/ft³ (912 kg/m³), when tested in accordance with Test Method D 1505 or Test Method D 792.

5.4 *Minimum Required Strength (MRS)*—The PP material used in the pipe and fittings shall have an MRS value of 1450

psi (10.0 MPa) based on testing in accordance with ISO 9080 and classification of the lower confidence limit (σ_{LCL}) at 50 years in accordance with ISO 12162.

5.5 *Categorized Required Strength ($CRS_{0,t}$)*—The PP material used in the pipe and fittings shall have a $CRS_{0,t}$ value of 280 psi (1.93 MPa) based on testing in accordance with ISO 9080 and classification of the lower confidence limit (σ_{LCL}) at 180°F (82°C) and 50 years.

5.6 *Minimum Pressure Rating*—The minimum pressure rating of the pipe shall be 160 psi (1.1 MPa) at 73°F (23°C) and 100 psi (0.69 MPa) at 180°F (82°C) for hot-and-cold distribution and 160 psi (1.1 MPa) at 73°F (23°C) for cold water service.

5.7 *Threads*—Fittings shall be permitted to be threaded by use of metal inserts molded into the fitting.

5.7.1 Metal threads shall be constructed of brass or stainless steel inserts molded into the fitting.

5.7.2 Threads shall not be molded or fabricated directly into the polypropylene plastic.

5.8 The piping compound shall be permitted to include colorants, antioxidants, reinforcing materials and additives necessary for the finished product. The modified material and finished product shall meet all requirements of this specification.

NOTE 1—The Plastics Pipe Institute (PPI) publishes listings of minimum required strength (MRS) and categorized required strength ($CRS_{0,t}$) ratings for thermoplastic piping materials in Technical Report No. 4 (TR-4). ISO/TS 15874-7 provides guidance on evaluating the effect of additives on long-term strength of the pipe and fittings material.

6. Workmanship, Finish and Appearance

6.1 The pipe and fittings shall be free of visible cracks, holes, foreign inclusions, blisters and other known injurious defects. The pipe and fittings shall be uniform in color, opacity, density and other physical properties.

7. Dimensions and Tolerances

7.1 *Pipe Dimensions*—Pipe dimensions shall meet the requirements in 7.1.1 and 7.1.2.

7.1.1 *Outside Diameters*—The outside diameters and tolerances shall be as shown in Table 1 (IPS Sch. 80), or Tables 2 and 3 (metric series), when measured in accordance with Test Method D 2122. For diameters not shown in these tables, the tolerance shall be the same percentage of outside diameter as those for the closest listed diameter.

7.1.2 *Wall Thicknesses*—The wall thicknesses and tolerances shall be as shown in Table 1, or Tables 2 and 3, when measured in accordance with Test Method D 2122. For wall thicknesses (DR’s) not shown in these tables, the minimum wall thickness shall be as calculated using the DR and outside diameter, and the tolerance on the wall thickness shall be the same percentage of the calculated minimum wall thickness as for the closest listed minimum wall thickness.

7.1.3 *Threaded Pipe*—Pipe covered by this specification shall not be threaded.

7.2 *Fittings Dimensions*—Fittings dimensions shall meet the requirements in 7.2.1 through 7.2.4.

7.2.1 *Threads*—Taper threads for joining fittings shall comply with the requirements of ASME B1.20.1 for NPT metal

⁶ European Committee for Standardization, 36, rue de Stassart, B-1050 Brussels.

⁷ Available from the Plastics Pipe Institute, 1825 Connecticut Ave. N.W., Suite 630, Washington, DC 20009.

TABLE 1 IPS Schedule 80 OD and Wall Thickness

Nominal Pipe Size	Average Outside Diameter, OD, in.		Tolerance on OD, in.		Out-of-roundness (max–min)		Minimum Wall Thickness, in.		Tolerance on Wall Thickness, in.	
½	0.840	(21.34)	±0.004	(±0.10)	0.015	(0.38)	0.147	(3.73)	+0.020	(+0.51)
¾	1.050	(26.67)	±0.004	(±0.10)	0.020	(0.51)	0.154	(3.91)	+0.020	(+0.51)
1	1.315	(33.40)	±0.005	(±0.13)	0.025	(0.64)	0.179	(4.55)	+0.021	(+0.53)
1-½	1.900	(48.26)	±0.006	(±0.15)	0.030	(0.76)	0.200	(5.08)	+0.024	(+0.61)
2	2.375	(60.33)	±0.006	(±0.15)	0.035	(0.89)	0.218	(5.54)	+0.026	(+0.66)
3	3.500	(88.90)	±0.008	(±0.20)	0.040	(1.02)	0.300	(7.62)	+0.036	(+0.91)
4	4.500	(114.30)	±0.009	(±0.23)	0.050	(1.27)	0.337	(8.56)	+0.040	(+1.02)
6	6.625	(168.28)	±0.011	(±0.28)	0.050	(1.27)	0.432	(10.97)	+0.052	(+1.32)

TABLE 2 Metric Sizes OD

Nominal Size	Outside Diameter, OD					
	Minimum Average OD, in.		Maximum Average OD, in.		Maximum Out-of-roundness, in.	
16	0.630	(16.0)	0.642	(16.3)	0.016	(0.4)
20	0.787	(20.0)	0.799	(20.3)	0.016	(0.4)
25	0.984	(25.0)	0.996	(25.3)	0.016	(0.4)
32	1.260	(32.0)	1.272	(32.3)	0.020	(0.5)
40	1.575	(40.0)	1.591	(40.4)	0.020	(0.5)
50	1.969	(50.0)	1.988	(50.5)	0.024	(0.6)
63	2.480	(63.0)	2.504	(63.6)	0.024	(0.6)
75	2.953	(75.0)	2.980	(75.7)	0.039	(1.0)
90	3.543	(90.0)	3.579	(90.9)	0.039	(1.0)
110	4.331	(110.0)	4.370	(111.0)	0.039	(1.0)
125	4.921	(125.0)	4.969	(126.2)	0.039	(1.0)

TABLE 3 Metric Sizes Wall Thickness

Nominal Size	Minimum Wall Thickness											
	DR = 11			DR = 7.3			DR = 6			DR = 5		
	Min Wall, in.	Tolerance, in.		Min Wall, in.	Tolerance, in.		Min Wall, in.	Tolerance, in.		Min Wall, in.	Tolerance, in.	
16	0.071	(1.8)	+0.020 (+0.50)	0.087	(2.2)	+0.020 (+0.50)	0.106	(2.7)	+0.020 (+0.50)	0.130	(3.3)	+0.020 (+0.50)
20	0.075	(1.9)	+0.009 (+0.23)	0.110	(2.8)	+0.013 (+0.34)	0.134	(3.4)	+0.016 (+0.41)	0.161	(4.1)	+0.019 (+0.49)
25	0.091	(2.3)	+0.011 (+0.28)	0.138	(3.5)	+0.017 (+0.42)	0.165	(4.2)	+0.020 (+0.50)	0.201	(5.1)	+0.024 (+0.61)
32	0.114	(2.9)	+0.014 (+0.35)	0.173	(4.4)	+0.021 (+0.53)	0.213	(5.4)	+0.026 (+0.65)	0.256	(6.5)	+0.031 (+0.78)
40	0.146	(3.7)	+0.017 (+0.44)	0.217	(5.5)	+0.026 (+0.66)	0.264	(6.7)	+0.032 (+0.80)	0.319	(8.1)	+0.038 (+0.97)
50	0.181	(4.6)	+0.022 (+0.55)	0.272	(6.9)	+0.033 (+0.83)	0.327	(8.3)	+0.039 (+1.00)	0.398	(10.1)	+0.048 (+1.21)
63	0.228	(5.8)	+0.027 (+0.70)	0.339	(8.6)	+0.041 (+1.03)	0.413	(10.5)	+0.050 (+1.26)	0.500	(12.7)	+0.060 (+1.52)
75	0.268	(6.8)	+0.032 (+0.82)	0.406	(10.3)	+0.049 (+1.24)	0.492	(12.5)	+0.059 (+1.50)	0.594	(15.1)	+0.071 (+1.81)
90	0.323	(8.2)	+0.039 (+0.98)	0.484	(12.3)	+0.058 (+1.48)	0.591	(15.0)	+0.071 (+1.80)	0.713	(18.1)	+0.086 (+2.17)
110	0.394	(10.0)	+0.047 (+1.20)	0.594	(15.1)	+0.071 (+1.81)	0.720	(18.3)	+0.086 (+2.20)	0.870	(22.1)	+0.104 (+2.65)
125	0.449	(11.4)	+0.054 (+1.37)	0.673	(17.1)	+0.081 (+2.05)	0.819	(20.8)	+0.098 (+2.50)	0.988	(25.1)	+0.119 (+3.01)

TABLE 4 IPS Sch 80 Socket-weld Fittings

Nominal Size	Socket Entrance, A					Socket Bottom, B						
	Average, in.	Tolerance on Average, in.		Maximum Out-of-roundness, in.		Average, in.	Tolerance on Average, in.		Maximum Out-of-roundness, in.			
½	0.840	(21.34)	±0.010	(±0.25)	0.012	(0.30)	0.794	(20.17)	±0.005	(±0.13)	0.012	(0.30)
¾	1.050	(26.67)	±0.010	(±0.25)	0.012	(0.30)	1.000	(25.40)	±0.007	(±0.18)	0.012	(0.30)
1	1.311	(33.30)	±0.010	(±0.25)	0.016	(0.41)	1.258	(31.95)	±0.007	(±0.18)	0.012	(0.30)
1-½	1.898	(48.21)	±0.012	(±0.30)	0.016	(0.41)	1.830	(46.48)	±0.007	(±0.18)	0.015	(0.38)
2	2.383	(60.53)	±0.012	(±0.30)	0.016	(0.41)	2.308	(58.62)	±0.007	(±0.18)	0.015	(0.38)
3	3.513	(89.23)	±0.012	(±0.30)	0.040	(1.02)	3.427	(87.05)	±0.010	(±0.25)	0.020	(0.51)
4	4.522	(114.86)	±0.015	(±0.38)	0.040	(1.02)	4.417	(112.19)	±0.010	(±0.25)	0.020	(0.51)
6	6.656	(169.06)	±0.032	(±0.81)	0.050	(1.27)	6.512	(165.40)	±0.012	(±0.30)	0.040	(1.02)

thread inserts or prEN 10226-1 for metric threads. Threads used by the manufacturer to join component parts of a fitting together shall meet the manufacturer's specifications.

7.2.2 Laying Lengths—Laying lengths shall be in accordance with the manufacturer's specifications.

TABLE 5 IPS Sch 80 Socket-weld Fittings

Nominal Size	Socket depth, C				Wall Thickness			
	Min, in.		Max, in.		Socket, E, Min, in.		Body, F, Min, in.	
1/2	0.835	(21.21)	0.865	(21.97)	0.147	(3.73)	0.185	(4.70)
3/4	0.960	(24.38)	0.990	(25.15)	0.154	(3.91)	0.195	(4.95)
1	1.085	(27.56)	1.115	(28.32)	0.179	(4.55)	0.225	(5.72)
1-1/2	1.335	(33.91)	1.365	(34.67)	0.200	(5.08)	0.250	(6.35)
2	1.460	(37.08)	1.490	(37.85)	0.218	(5.54)	0.275	(6.99)
3	1.830	(46.48)	1.860	(47.24)	0.300	(7.62)	0.375	(9.53)
4	2.205	(56.01)	2.235	(56.77)	0.337	(8.56)	0.420	(10.67)
6	2.955	(75.06)	2.985	(75.82)	0.432	#####	0.540	(13.72)

TABLE 6 Metric Series Socket-weld Fittings

Nominal Size	Socket Entrance, A				Socket Bottom, B							
	Minimum Average Diameter, in.		Maximum Average Diameter, in.		Maximum Out-of-roundness, in.		Minimum Average Diameter, in.		Maximum Average Diameter, in.		Maximum Out-of-roundness, in.	
16	0.598	(15.20)	0.610	(15.50)	0.016	(0.40)	0.594	(15.10)	0.606	(15.40)	0.016	(0.40)
20	0.756	(19.20)	0.768	(19.50)	0.016	(0.40)	0.748	(19.00)	0.760	(19.30)	0.016	(0.40)
25	0.953	(24.20)	0.965	(24.50)	0.016	(0.40)	0.941	(23.90)	0.957	(24.30)	0.016	(0.40)
32	1.224	(31.10)	1.240	(31.50)	0.020	(0.50)	1.217	(30.90)	1.232	(31.30)	0.020	(0.50)
40	1.535	(39.00)	1.551	(39.40)	0.020	(0.50)	1.528	(38.80)	1.543	(39.20)	0.020	(0.50)
50	1.925	(48.90)	1.945	(49.40)	0.024	(0.60)	1.917	(48.70)	1.937	(49.20)	0.024	(0.60)
63	2.437	(61.90)	2.461	(62.50)	0.024	(0.60)	2.425	(61.60)	2.445	(62.10)	0.024	(0.60)
75	2.925	(74.30)	2.949	(74.90)	0.039	(1.00)	2.878	(73.10)	2.902	(73.70)	0.039	(1.00)
90	3.516	(89.30)	3.539	(89.90)	0.039	(1.00)	3.461	(87.90)	3.484	(88.50)	0.039	(1.00)
110	4.307	(109.40)	4.331	(110.00)	0.039	(1.00)	4.240	(107.70)	4.264	(108.30)	0.039	(1.00)
125	4.898	(124.40)	4.921	(125.00)	0.039	(1.00)	4.827	(122.60)	4.850	(123.20)	0.039	(1.00)

TABLE 7 Metric Series Socket-weld Fittings

Nominal Size	Socket Depth, C				Wall Thickness			
	Min, in.		Max, in.		Socket, E, Min, in.		Body, F, Min, in.	
16	0.524	(13.30)	0.622	(15.80)	0.121	(3.06)	0.161	(4.08)
20	0.571	(14.50)	0.669	(17.00)	0.145	(3.69)	0.194	(4.92)
25	0.630	(16.00)	0.728	(18.50)	0.167	(4.25)	0.223	(5.67)
32	0.713	(18.10)	0.811	(20.60)	0.212	(5.38)	0.282	(7.17)
40	0.807	(20.50)	0.906	(23.00)	0.256	(6.50)	0.341	(8.67)
50	0.925	(23.50)	1.024	(26.00)	0.335	(8.50)	0.446	(11.33)
63	1.079	(27.40)	1.177	(29.90)	0.413	(10.50)	0.551	(14.00)
75	1.220	(31.00)	1.319	(33.50)	0.492	(12.50)	0.656	(16.67)
90	1.398	(35.50)	1.496	(38.00)	0.591	(15.00)	0.787	(20.00)
110	1.634	(41.50)	1.732	(44.00)	0.723	(18.38)	0.965	(24.50)
125	1.575	(40.00)	1.850	(47.00)	0.822	(20.88)	1.096	(27.83)

7.2.3 Socket-fused Fittings—Dimensions for socket-fused fittings shall be in accordance with Tables 4 and 5 (IPS Sch 80) or Tables 6 and 7 (metric series).

7.2.4 Electrofusion Fittings—Dimensions for electrofusion fittings shall be in accordance with manufacturer’s specifications.

8. Requirements

8.1 Longitudinal Reversion—When tested in accordance with ISO 15874-2, at the conditions given in Table 8, the mean relative change in pipe length shall not exceed 2 %.

8.2 Melt Flow Rate (MFR) of Pipe and Fittings—When tested in accordance with D 1238, the MFR of specimens taken from the finished pipe or fittings shall be within 30 % of the MFR of the compound used to produce the pipe or fitting. Two specimens shall be tested, and both shall pass.

8.3 Impact Strength—When tested in accordance with ISO 3127, 9 of 10 specimens shall pass at the impact level specified in Table 9 at a test temperature of 32 ± 2°F (0 ± 1°C).

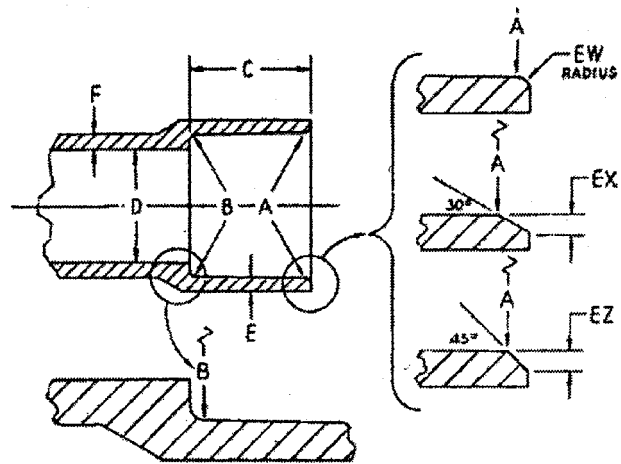


FIG. 1 Socket Dimension Symbols per D 2749