



Standard Specification for Acrylonitrile-Butadiene-Styrene (ABS) Plastic Pipe (SDR- PR)¹

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This standard has been approved for use by agencies of the Department of Defense.

1. Scope

1.1 This specification covers acrylonitrile-butadienestyrene (ABS) pipe produced by single extrusion or simultaneous multiple coextrusion, in standard thermoplastic pipe dimension ratios and pressure rated for water (see Appendix). Included are criteria for classifying ABS plastic pipe materials and ABS plastic pipe, a system of nomenclature for ABS plastic pipe, and requirements and test methods for materials, workmanship, dimensions, sustained pressure, burst pressure, and extrusion quality. Methods of marking are also given.

1.2 The products covered by this specification are intended for use with the distribution of pressurized liquids only, which are chemically compatible with the piping materials. Due to inherent hazards associated with testing components and systems with compressed air or other compressed gases some manufacturers do not allow pneumatic testing of their products. Consult with specific product/component manufacturers for their specific testing procedures prior to pneumatic testing.

NOTE 1—Pressurized (compressed) air or other compressed gases contain large amounts of stored energy which present serious safety hazards should a system fail for any reason.

1.3 The text of this specification references notes, footnotes, and appendixes which provide explanatory material. These notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of the specification.

1.4 The values stated in inch-pound units are to be regarded as the standard. 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 7, 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.*

2. Referenced Documents

2.1 ASTM Standards:

- D 618 Practice for Conditioning Plastics for Testing²
- D 1598 Test Method for Time-to-Failure of Plastic Pipe Under Constant Internal Pressure³
- D 1599 Test Method for Short-Time Hydraulic Failure Pressure of Plastic Pipe, Tubing, and Fittings³
- D 1600 Terminology for Abbreviated Terms Relating to Plastics²
- D 2122 Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings³
- D 2837 Test Method for Obtaining Hydrostatic Design Basis for Thermoplastic Pipe Materials³
- D 3965 Specification for Rigid Acrylonitrile-Butadiene-Styrene (ABS) Compounds for Pipe and Fittings⁴
- F 412 Terminology Relating to Plastic Piping Systems³

2.2 Federal Standard:

- Fed. Std. No. 123 Marking for Shipment (Civil Agencies)⁵

2.3 Military Standard:

- MIL-STD-129 Marking for Shipment and Storage⁶

2.4 NSF Standard:

- Standard No. 14 for Plastic Piping Components and Related Materials⁵

3. Terminology

3.1 General—Definitions are in accordance with Terminology F 412. Abbreviations are in accordance with Terminology D 1600, unless otherwise indicated. The abbreviation for acrylonitrile-butadiene-styrene plastic is ABS.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *acrylonitrile-butadiene-styrene (ABS) pipe and fitting plastics*—plastics containing polymers or blends of polymers, or both, in which the minimum butadiene content is 6 %, the minimum acrylonitrile content is 15 %, the minimum styrene or substituted styrene content, or both, is 15 %, and the

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² Annual Book of ASTM Standards, Vol 08.01.

³ Annual Book of ASTM Standards, Vol 08.04.

⁴ Annual Book of ASTM Standards, Vol 08.02.

⁵ Available from the National Sanitation Foundation, P.O. Box 1468, Ann Arbor, MI 48106.

⁶ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

maximum content of all other monomers is not more than 5 %, and lubricants, stabilizers, and colorants.

3.2.2 *hydrostatic design stress*—the estimated maximum tensile stress the material is capable of withstanding continuously with a high degree of certainty that failure of the pipe will not occur. This stress is circumferential when internal hydrostatic water pressure is applied.

3.2.3 *pressure rating (PR)*—the estimated maximum water pressure the pipe is capable of withstanding continuously with a high degree of certainty that failure of the pipe will not occur.

3.2.4 *relation between standard dimension ratio, hydrostatic design stress, and pressure rating*—the following expression is used in this specification to relate standard dimension ratio, hydrostatic design stress, and pressure rating:

$$2S/P = R - 1 \text{ or } 2 S/P = (D_o/t) - 1$$

where:

- S = hydrostatic design stress, psi (or MPa),
- P = pressure rating, psi (or MPa),
- D_o = average outside diameter, in. (or mm),
- t = minimum wall thickness, in. (or mm), and
- R = standard thermoplastic pipe dimension ratio (D_o/t for ABS pipe), also known as SDR.

3.2.5 *standard thermoplastic pipe dimension ratio (SDR)*—the ratio of pipe diameter to wall thickness. For ABS pipe it is calculated by dividing the average outside diameter of the pipe in millimetres or in inches by the minimum wall thickness in millimetres or in inches. If the wall thickness calculated by this formula is less than 0.060 in. (1.52 mm), it shall be arbitrarily increased to 0.060 in. (1.52 mm). SDR values shall be rounded to the nearest 0.5.

3.2.6 *standard thermoplastic pipe materials designation code*—the pipe materials designation code shall consist of the abbreviation ABS for the type of plastic, followed by the ASTM type and grade (see Table X1.2), and the hydrostatic design stress in units of 100 psi with any decimal figures dropped. When the design stress code contains less than two figures, a cipher is used before the number. Thus a complete material code consists of three letters and four figures for ABS plastic pipe materials (see 4.3).

4. Materials

4.1 *General*—Acrylonitrile-butadiene-styrene plastics used to make pipe meeting the requirements of this specification are categorized by means of two criteria namely (1) short-term strength tests and (2) long-term strength tests.

4.2 *Basic Materials*—This specification covers ABS pipe made from three ABS plastics as defined in Specification D 3965, in which the requirements are based on short-term tests. These are ABS Classes 42222, 20643, and 30444.

4.3 *Hydrostatic Design Stress*—This specification covers ABS pipe made from ABS plastics as defined by four hydrostatic design stresses developed on the basis of long-term tests (Appendix X1.2).

4.4 *Compound*—The ABS plastic extrusion compound shall meet the requirements of ABS Classes 42222, 20643, or 30444 as described in Specification D 3965. For pipe produced by simultaneous multiple coextrusion, all layers shall be of the same formulation.

4.5 *Rework Material*—The manufacturers shall use only their own clean rework pipe material and the pipe produced shall meet all the requirements of this specification.

5. Pipe Classification

5.1 *General*—This specification covers ABS pipe produced by single extrusion or simultaneous multiple coextrusion from three ABS plastic pipe materials in four standard dimension ratios and six water pressure ratings for nonthreaded pipe. Pipe produced by simultaneous multiple coextrusion shall be classified as “CoeX.”

5.2 *Standard Thermoplastic Pipe Dimension Ratios (SDR)*—This specification covers ABS pipe in four standard dimension ratios, namely, 13.5, 17, 21, and 26. These are referred to as SDR13.5, SDR17, SDR21, and SDR26, respectively. The pressure rating is uniform for all nominal pipe sizes for a given ABS pipe material and SDR (see Table X1.1, Appendix).

6. Requirements

6.1 *Workmanship*—The pipe shall be homogeneous throughout and free of visible cracks, holes, foreign inclusions, or other defects. The pipe shall be as uniform as commercially practicable in color, opacity, density, and other physical properties.

6.2 Dimensions and Tolerances:

6.2.1 *Outside Diameters*—The outside diameters and tolerances shall be as shown in Table 1 when measured in accordance with 7.4 and 7.4.1.

6.2.2 *Wall Thickness*—The wall thicknesses and tolerances shall be as shown in Table 2 when measured in accordance with 7.4 and 7.4.2.

6.2.3 *Thickness of Outer Layer*—For pipe produced by simultaneous multiple extrusion, that is, pipe containing two or more concentric layers, the outer layer shall be at least 0.020 in. (0.50 mm) thick.

TABLE 1 Outside Diameters and Tolerances for ABS Plastic Pipe, in.

Nominal Pipe Size	Outside Diameter	Average	Tolerances	
			For Max and Min (Out-of-Roundness)	
			SDR26 SDR21	SDR17 SDR13.5
1/8	0.405	±0.004	±0.015	±0.008
1/4	0.540	±0.004	±0.015	±0.008
3/8	0.675	±0.004	±0.015	±0.008
1/2	0.840	±0.004	±0.015	±0.008
3/4	1.050	±0.004	±0.015	±0.010
1	1.315	±0.005	±0.015	±0.010
1 1/4	1.660	±0.005	±0.015	±0.012
1 1/2	1.900	±0.006	±0.030	±0.012
2	2.375	±0.006	±0.030	±0.012
2 1/2	2.875	±0.007	±0.030	±0.015
3	3.500	±0.008	±0.030	±0.015
3 1/2	4.000	±0.008	±0.030	±0.015
4	4.500	±0.009	±0.050	±0.015
5	5.563	±0.010	±0.050	±0.030
6	6.625	±0.011	±0.050	±0.035
8	8.625	±0.015	±0.075	±0.045
10	10.750	±0.015	±0.075	±0.050
12	12.750	±0.015	±0.075	±0.060



TABLE 2 Wall Thicknesses and Tolerances for ABS Plastic Pipe

Nominal Pipe Size, in.	Wall Thickness ^A , in.							
	SDR26		SDR21		SDR17		SDR13.5	
	Min	Tolerance	Min	Tolerance	Min	Tolerance	Min	Tolerance
1/8	0.060	+0.020
1/4	0.060	+0.020
3/8	0.060	+0.020
1/2	0.060	+0.020	0.062	+0.020
3/4	0.060	+0.020	0.062	+0.020	0.078	+0.020
1	0.060	+0.020	0.063	+0.020	0.077	+0.020	0.097	+0.020
1 1/4	0.064	+0.020	0.079	+0.020	0.098	+0.020	0.123	+0.020
1 1/2	0.073	+0.020	0.090	+0.020	0.112	+0.020	0.141	+0.020
2	0.091	+0.020	0.113	+0.020	0.140	+0.020	0.176	+0.021
2 1/2	0.110	+0.020	0.137	+0.020	0.169	+0.020	0.231	+0.026
3	0.135	+0.020	0.167	+0.020	0.206	+0.025	0.259	+0.031
3 1/2	0.154	+0.020	0.190	+0.023	0.235	+0.028	0.296	+0.036
4	0.173	+0.021	0.214	+0.026	0.265	+0.032	0.333	+0.040
5	0.214	+0.027	0.265	+0.032	0.327	+0.039	0.412	+0.049
6	0.255	+0.031	0.316	+0.038	0.390	+0.047	0.491	+0.059
8	0.332	+0.040	0.410	+0.049
10	0.413	+0.050	0.511	+0.061
12	0.490	+0.059	0.606	+0.073

^A The minimum is the lowest wall thickness of the pipe at any cross section. The maximum permitted wall thickness, at any cross section, is the minimum wall thickness plus the stated tolerance. All tolerances are on the plus side of the minimum requirement.

6.2.4 *Wall Thickness Range*—The wall thickness range shall be within 12 % when measured in accordance with 7.4 and 7.4.3.

6.3 *Bond*—For pipe produced by simultaneous multiple coextrusion, the bond between the layers shall be strong and uniform, it shall not be possible to separate any two layers with a probe or point of a knife blade so that the layers separate cleanly at any point, nor shall separation of bond occur, between layers, during testing performed under the requirements of this specification.

6.4 *Sustained Pressure*—The pipe shall not fail, balloon, burst, or weep as defined in Test Method D 1598 at the test pressures given in Table 3 when tested in accordance with 7.5.

6.5 *Burst Pressure*—The minimum burst pressures for ABS plastic pipe shall be as given in Table 4, when determined in accordance with 7.6.

7. Test Methods

7.1 *Conditioning*—Condition the test specimens at 73 ± 3.6°F (23 ± 2°C) and 50 ± 5 % relative humidity for not less

TABLE 3 Sustained Pressure Test Conditions for Water at 73°F (23°C) for ABS Plastic Pipe

Standard Dimension Ratio	Pressure ^A Required for Test					
	ABS1316		ABS2112		ABS1208, ABS1210	
	psi	MPa	psi	MPa	psi	MPa
13.5	510	3.52	430	2.96	340	2.34
17	400	2.76	340	2.34	270	1.86
21	320	2.21	270	1.86	220	1.52
26	260	1.79	220	1.52	170	1.17

^A The fiber stresses used to derive these test pressures are as follows:

ABS1316	3200 psi (22.1 MPa)
ABS2112	2700 psi (18.6 MPa)
ABS1208, ABS1210	2140 psi (14.8 MPa)

Some minor adjustments have been made to keep the test pressures uniform to simplify testing.

TABLE 4 Burst Pressure Requirements for Water at 73°F (23°C) for ABS Plastic Pipe

Standard Dimension Ratio	Min Burst Pressure ^A							
	ABS2112		ABS1316		ABS1210		ABS1208	
	psi	MPa	psi	MPa	psi	MPa	psi	MPa
13.5	1050	7.24	960	6.62	830	5.72	530	3.65
17	830	5.72	750	5.17	660	4.55	420	2.90
21	660	4.55	600	4.14	530	3.65	330	2.28
26	530	3.65	480	3.31	420	2.90	260	1.79

^A The fiber stresses used to derive these test pressures are as follows:

ABS2112	6600 psi (45.5 MPa)
ABS1316	6000 psi (41.4 MPa)
ABS1210	5240 psi (36.2 MPa)
ABS1208	3300 psi (22.8 MPa)

Some minor adjustments have been made to keep the test pressures uniform to simplify testing.

than 40 h prior to test in accordance with Procedure A of Practice D 618 for those tests where conditioning is required.

7.2 *Test Conditions*—Conduct the tests in the Standard Laboratory Atmosphere of 23 ± 2°C and 50 ± 5 % relative humidity, unless otherwise specified in the test methods or in this specification.

7.3 *Sampling*—The selection of the sample or samples of pipe shall be as agreed upon by the purchaser and the seller. In case of no prior agreement, any sample selected by the testing laboratory shall be deemed adequate.

7.3.1 *Test Specimens*—Not less than 50 % of the test specimens required for any pressure test shall have at least a part of the marking in their central sections. The central section is that portion of pipe which is at least one pipe diameter away from an end closure.

7.4 *Dimensions and Tolerances*—Use any length of pipe to determine the dimensions. Measure in accordance with Test Method D 2122.

7.4.1 *Outside Diameter*—Measure the outside diameter of the pipe in accordance with Test Method D 2122. The average