



Designation: ~~C479-04~~ Designation: C 479 – 04 (Reapproved 2008)

Standard Specification for Vitrified Clay Liner Plates¹

This standard is issued under the fixed designation C 479; 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 the criteria for the acceptance of vitrified clay liner plates used to protectively line or face pipe, culverts, abutments, structures, or appurtenances.

~~1.2 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.~~

1.2 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.

2. Referenced Documents

2.1 *ASTM Standards:*²

C 43 [Terminology of Structural Clay Products](#)

C 301 [Test Methods for Vitrified Clay Pipe](#)

3. Terminology

~~3.1 Definitions:~~

3.1 Definitions—Clay, fire clay, shale, and surface clay are defined in Terminology C 43.

4. Classification

4.1 Liner plates manufactured in accordance with this specification shall be known as curved liner plates or flat liner plates.

5. Materials and Manufacture

5.1 Liner plates shall be manufactured from fire clay, shale, surface clay, or a combination of these materials that, when formed into liner plates and fired to suitable temperatures, yield a product that is strong, durable, serviceable, free of objectionable defects, and conform to this specification.

~~6. Physical and Chemical Requirements~~ Physical and Chemical Requirements [86c5-d102babd1a89/astm-c479-042008](https://standards.iteh.ai/document/astm-c479-04/2008)

6. Physical and Chemical Requirements

6.1 *Absorption*—The absorption of liner plates shall not exceed 6 %.

6.2 *Acid Resistance:*

6.2.1 This test is used to determine the resistance of liner plates to the action of acids. The test shall be performed only when specified.

6.2.2 Liner plates shall be acceptable if the acid-soluble matter does not exceed 0.25 %.

7. Dimensions and Permissible Variations

7.1 *Tenon Ribs:*

7.1.1 Liner plates shall have either three or five longitudinal, monolithic, dovetail tenon ribs uniformly and symmetrically spaced on the back of the plate (see Note 1). When five tenon ribs are used, the outer fin of the exterior tenons shall be eliminated so that parallel jointing faces between abutting plates may be achieved.

¹ This specification is under the jurisdiction of ASTM Committee C04 on Vitrified Clay Pipe and is the direct responsibility of Subcommittee C04.20 on Methods of Test and Specifications.

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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.