



Standard Specification for Plastic Insert Fittings for Polyethylene (PE) Plastic Pipe¹

This standard is issued under the fixed designation D2609; 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.

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

1. Scope

1.1 This specification covers plastic insert fittings for polyethylene (PE) plastic pipe. Included are requirements for materials, workmanship, dimensions, and burst pressure.

1.2 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.

1.3 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.

1.4 The following safety hazards caveat pertains only to the test methods portion, Section 8, 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:²

- D256 Test Methods for Determining the Izod Pendulum Impact Resistance of Plastics
- D618 Practice for Conditioning Plastics for Testing
- D638 Test Method for Tensile Properties of Plastics
- D648 Test Method for Deflection Temperature of Plastics Under Flexural Load in the Edgewise Position
- D789 Test Methods for Determination of Solution Viscosities of Polyamide (PA)
- D1599 Test Method for Resistance to Short-Time Hydraulic Pressure of Plastic Pipe, Tubing, and Fittings

¹ This specification is under the jurisdiction of ASTM Committee F17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.10 on Fittings.

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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.

D1600 Terminology for Abbreviated Terms Relating to Plastics

D1784 Specification for Rigid Poly(Vinyl Chloride) (PVC) Compounds and Chlorinated Poly(Vinyl Chloride) (CPVC) Compounds

D2104 Specification for Polyethylene (PE) Plastic Pipe, Schedule 40 (Withdrawn 2010)³

D2239 Specification for Polyethylene (PE) Plastic Pipe (SIDR-PR) Based on Controlled Inside Diameter

F412 Terminology Relating to Plastic Piping Systems

F1498 Specification for Taper Pipe Threads 60° for Thermoplastic Pipe and Fittings

2.2 NSF Standards:

Standard No. 14 for Plastic Piping Components and Related Materials⁴

Standard No. 61 for Drinking Water System Components—Health Effects⁴

3. Terminology

3.1 Definitions are in accordance with Terminology F412 and abbreviations are in accordance with Terminology D1600, unless otherwise specified.

4. Classification

4.1 This specification covers one class of fittings suitable for use with PE plastic pipe that meet the requirements of applicable ASTM specifications. At present, these are Specifications D2104 and D2239.

5. Materials

5.1 *Types of Plastics*—The fittings shall be made from one of the following plastics:

5.1.1 Nylon plastics (NP) meeting the requirements of either Type I or Type II (except Grade 2A) in Test Methods D789.

5.1.2 Propylene plastic (PP) with a minimum tensile strength at yield of 24.0 MPa (3410 psi) when tested in accordance with Test Method D638 at a speed of 51 mm/min

³ The last approved version of this historical standard is referenced on www.astm.org.

⁴ Available from NSF International, P.O. Box 130140, 789 N. Dixboro Rd., Ann Arbor, MI 48113-0140, http://www.nsf.org.

(2.0 in./min), an Izod impact resistance at 23°C of at least 30 J/m (0.6 ft–lbf/in.) when tested in accordance with Method A of Test Methods D256, and a minimum deflection temperature of 64°C at 455 KPa stress when tested in accordance with Test Method D648.

5.1.3 Poly(vinyl chloride) plastics (PVC) meeting the requirements of 12454-B, 12454-C, 11443-B, or 14333-D, in Specification D1784.

5.2 Rework Material—The manufacturers shall use only their own clean rework fitting material and the fittings produced shall meet all the requirements of this specification. The types of materials specified in 5.1 shall not be mixed with one another.

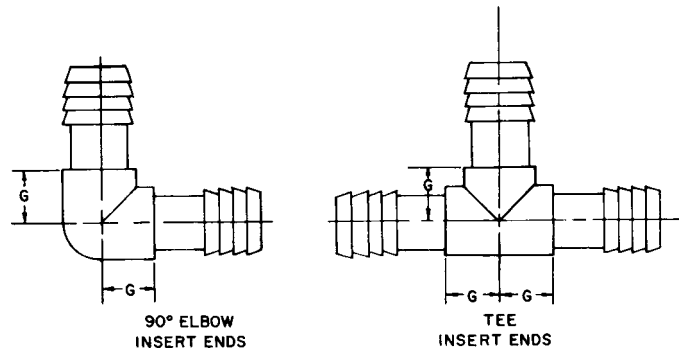
6. Requirements

6.1 Dimensions and Tolerances—The dimensions and tolerances shall be as shown in Tables 1-3 when measured in accordance with 8.4. The negative tolerance on all minimum dimensions is zero.

6.1.1 Alignment—The alignment of all openings of fittings shall be within 1/4 in./ft.

6.1.2 Fittings Not Illustrated—All fittings, whether illustrated in Tables 1-3 or not, shall have insert ends in accordance with Table 1 or threaded ends in accordance with Table 3. For insert ends, which have more than four barbs, the first four barbs, starting from the open end of the fitting connection, shall meet all requirements of Table 1. The remaining barbs shall also meet Table 1, with the exception that mold marks left as a result of the manufacturing process, such as ejector pin marks, are exempt from the “V” dimension requirement, and the minimum requirement for “Z.” D, Zmax, and F apply in all

TABLE 2 Dimensions^A of Insert Elbow and Tee, in. (mm)



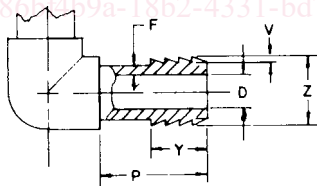
Nominal Pipe Size ^B	Laying Length Tee and Elbow, min G
1/2	0.344 (8.7)
3/4	0.453 (11.5)
1	0.625 (15.9)
1 1/4	0.781 (19.8)
1 1/2	0.875 (22.2)
2	1.125 (28.6)
2 1/2	1.625 (41.3)
3	1.875 (47.6)
4	2.438 (61.9)

^A The sketches and designs of fittings shown are illustrative only.
^B For dimensions not given in this table, see Table 1.

cases. For designs where the entire fitting end is barbed, such as “F” cannot be readily measured, “F” shall be calculated as $[(Z - 2V) - D] / 2$.

6.1.3 Threads—For all fittings having taper pipe threads, threads shall conform to Specification F1498 and be gaged in accordance with 8.6.

TABLE 1 Dimensions of Insert End,^A in. (mm)



Nominal Pipe Size	Insert Length, P min	Barbs			Depth, V min	Wall Thickness, F min	Inside Diameter of Fitting, D min
		Length, Y min	Outside Diameter, Z ^B max	Number min			
1/2	1 1/4 (31.8)	3/4 (19.0)	0.665 (16.9)	0.635 (16.1)	4	0.015 (0.4)	0.406 (10.3)
3/4	1 1/4 (31.8)	3/4 (19.0)	0.865 (22.0)	0.835 (21.2)	4	0.015 (0.4)	0.562 (14.3)
1	1 1/4 (31.8)	3/4 (19.0)	1.095 (27.8)	1.065 (27.0)	4	0.020 (0.5)	0.750 (19.0)
1 1/4	1 1/4 (31.8)	3/4 (19.0)	1.425 (36.2)	1.395 (35.4)	4	0.025 (0.6)	0.995 (25.3)
1 1/2	1 1/2 (38.1)	3/4 (19.0)	1.665 (42.3)	1.630 (41.4)	4	0.030 (0.8)	1.125 (28.6)
2	1 1/2 (38.1)	3/4 (19.0)	2.125 (54.0)	2.085 (53.0)	4	0.030 (0.8)	1.656 (42.1)
2 1/2	2 (50.8)	1 (25.4)	2.520 (64.0)	2.487 (63.2)	4	0.030 (0.8)	2.062 (52.4)
3	2 1/8 (54.0)	1 1/8 (28.6)	3.125 (79.4)	3.086 (78.4)	4	0.030 (0.8)	2.600 (66.0)
4	3 (76.2)	1 1/4 (31.8)	4.090 (103.9)	4.044 (102.7)	4	0.030 (0.8)	3.525 (89.5)

^A The sketches and designs of fittings shown are illustrative only. The dimensions specified shall govern in all cases.

^B Outside diameter maximum and minimum apply to each individual measurement, not the average of the four (see 8.4).