



Standard Specification for Coextruded Composite Drain, Waste, and Vent Pipe (DWV)¹

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1. Scope

1.1 This specification covers coextruded composite drain, waste, and vent pipe (DWV). The pipe is produced in Schedule 40 IPS sizes by a coextrusion die system, in which the concentric layers are formed and combined before exiting the die.

1.1.1 Coextruded composite drain, waste, and vent pipe, DWV, by definition, is permitted to be produced with two or more layers. The outer layer shall be ABS. The middle layer is permitted to be thermally foamed PVC or solid PVC or a blend of rework material, as specified in the rework material section. The inner layer is permitted to be solid PVC or ABS, or a blend of rework material as specified in the rework material section.

1.1.2 The function of this specification is to provide standardization of product, technical data, and serve as a purchasing guide.

1.2 DWV is permitted to be produced utilizing a two layer or three layer coextrusion die.

1.3 Materials that do not meet the requirements of the material section are excluded.

1.4 Pipe produced to this specification is permitted to be joined using molded fittings meeting the requirements of Specification D2661 or Specification F628. The fitting patterns must comply with Specification D3311.

1.5 Pipe produced to this specification is permitted to be perforated in accordance with any specified standard or by agreement between the purchaser and the supplier.

1.6 Pipe produced to this specification is permitted to be belled for joining by solvent cementing or belled for joining by an elastomeric seal (gasket), in accordance with any specified standard or by agreement between the purchaser and the supplier.

1.7 Recommendations for storage, joining, and installation are provided in Appendix X1, Appendix X2, and Appendix X3, respectively.

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

1.9 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 this specification.

1.10 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.

1.11 *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.*

NOTE 1—Specifications related to this specification are as follows: Specifications D2661, D2665, F628, and F891.

2. Referenced Documents

2.1 The following standards contain provisions that, though referenced in this specification, constitute provisions of this specification. All standards are subject to revision and parties using this specification, shall reference the most recent edition of the standards listed as follows:

2.2 *ASTM Standards*:²

D618 Practice for Conditioning Plastics for Testing⁸

D696 Test Method for Coefficient of Linear Thermal Expansion of Plastics Between -30°C and 30°C with a Vitreous Silica Dilatometer

D883 Terminology Relating to Plastics

D1600 Terminology for Abbreviated Terms Relating to Plastics

D1898 Practice for Sampling of Plastics³

D1972 Practice for Generic Marking of Plastic Products

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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.

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

- D2122** Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings
- D2235** Specification for Solvent Cement for Acrylonitrile-Butadiene-Styrene (ABS) Plastic Pipe and Fittings
- D2321** Practice for Underground Installation of Thermoplastic Pipe for Sewers and Other Gravity-Flow Applications
- D2412** Test Method for Determination of External Loading Characteristics of Plastic Pipe by Parallel-Plate Loading
- D2444** Test Method for Determination of the Impact Resistance of Thermoplastic Pipe and Fittings by Means of a Tup (Falling Weight)
- D2661** Specification for Acrylonitrile-Butadiene-Styrene (ABS) Schedule 40 Plastic Drain, Waste, and Vent Pipe and Fittings
- D2665** Specification for Poly(Vinyl Chloride) (PVC) Plastic Drain, Waste, and Vent Pipe and Fittings
- D3311** Specification for Drain, Waste, and Vent (DWV) Plastic Fittings Patterns
- D3965** Specification for Rigid Acrylonitrile-Butadiene-Styrene (ABS) Materials for Pipe and Fittings
- D4000** Classification System for Specifying Plastic Materials
- D4396** Specification for Rigid Poly(Vinyl Chloride) (PVC) and Chlorinated Poly(Vinyl Chloride) (CPVC) Compounds for Plastic Pipe and Fittings Used in Nonpressure Applications
- D5033** Guide for Development of ASTM Standards Relating to Recycling and Use of Recycled Plastics⁴
- E105** Practice for Probability Sampling Of Materials
- E122** Practice for Calculating Sample Size to Estimate, With Specified Precision, the Average for a Characteristic of a Lot or Process
- F402** Practice for Safe Handling of Solvent Cements, Primers, and Cleaners Used for Joining Thermoplastic Pipe and Fittings
- F412** Terminology Relating to Plastic Piping Systems
- F628** Specification for Acrylonitrile-Butadiene-Styrene (ABS) Schedule 40 Plastic Drain, Waste, and Vent Pipe With a Cellular Core
- F891** Specification for Coextruded Poly(Vinyl Chloride) (PVC) Plastic Pipe With a Cellular Core
- 2.3 Federal Standard:**
- Fed. Std. No. 123** Marking for Shipments (Civil Agencies)⁵
- 2.4 Military Standard:**
- MIL-STD-129** Marking for Shipment and Storage⁵
- 2.5 ANSI Standard:**
- ANSI Z 34.1** American National Standard for Certification-Third-Party Program⁶
- ANSI Z 34.2** American National Standard for Certification-Self-Certification by Producer or Supplier⁶
- 2.6 Uniform Classification Committee Standards:**

Uniform Freight Classification ⁷

2.7 National Motor Freight Traffic Association Standard: National Motor Freight Classification ⁸

3. Terminology

3.1 Definitions—Definitions are in accordance with Terminology **D883** and **F412**. Abbreviations are in accordance with Terminology **D1600**. Plastic materials are classified in accordance with Classification **D4000**. Generic marking is in accordance with Practice **D1972**.

3.1.1 *coextruded pipe*—pipe consisting of two or more concentric layers of material bonded together in processing by any combination of temperature, pressure, grafting, crosslinking, or adhesion.

3.1.2 *compound*—a mixture of a polymer with other ingredients such as inert fillers, stabilizers, catalysts, processing aids, lubricants, impact modifiers, pigments, or curing agents.

3.1.3 *out-of-roundness*—the allowed difference between the maximum measured diameter and the minimum measured diameter (stated as an absolute deviation).

3.1.4 *thermally foamed plastic*—a cellular plastic produced by applying heat to effect gaseous decomposition or volatilize of a constituent. (1985)

3.1.5 *virgin plastic, (adj)*—materials in the form of pellets, granules, powder, floc, or liquid that has not been subjected to use or processing other than that required for its initial manufacture. (1985)

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *ABS/PVC*—an acronym for a blend of acrylonitrile-butadiene-styrene and poly vinyl chloride.

3.2.2 *lot*—a lot shall consist of all pipe produced, of one size, from one extrusion line, during one designated 24-h period.

3.2.3 *rework material*—a blend of the different materials generated from coextruded composite drain, waste, and vent pipe (DWV).

4. Classification

4.1 Coextruded composite drain, waste, and vent pipe, DWV, produced in compliance this specification will provide pipe suitable for the drainage and venting of sewage and certain other liquid wastes.

NOTE 2—Before installing coextruded composite pipe in an industrial waste disposal system, the approval of the cognizant building code authority should be obtained as conditions not commonly found in normal use may be encountered and temperatures in excess of 180°F (82°C) may be encountered.

5. Ordering Information

5.1 Orders for coextruded composite drain, waste, and vent pipe, DWV, produced in compliance with this specification should include the following:

5.1.1 This ASTM designation number, and the year of issue,

⁴ Withdrawn. The last approved version of this historical standard is referenced on www.astm.org.

⁵ Available from Naval Publications and Forms Center, 5801 Tabor Ave., Philadelphia, PA 19120.

⁶ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

⁷ Available from the Uniform Classification Committee, Suite 1106, 222 South Riverside Plaza, Chicago, IL 60606.

⁸ Available from the National Motor Freight Traffic Association, Inc. National Motor Freight Classification, American Trucking Association, Inc. Traffic Dept., 1616 P St., NW, Washington, DC 20036.

- 5.1.2 Pipe size,
- 5.1.3 Footage required of each size, and
- 5.1.4 Materials.

6. Materials and Manufacture

6.1 *Basic Compound*—Virgin compound for use in the outer layer of coextruded composite drain, waste, and vent pipe, DWV, shall contain pigments or screening agents to provide protection against UV radiation.

6.2 *ABS Compound Specification*—The ABS compound shall be virgin ABS compound conforming to the requirements of Specification **D3965** and shall meet all of the requirements for Cell Class 4-2-2-2.

6.2.1 The color and form of the material shall be by agreement between the purchaser and the supplier, in accordance with Specification **D3965**.

6.3 *PVC Compound Specification*—The PVC compound shall be virgin PVC compound conforming to the requirements of Specification **D4396** and shall meet all of the requirements for Cell Class 1-1-4-3-2.

6.3.1 The color and form of the material shall be by agreement between the purchaser and the supplier in accordance with Specification **D4396**.

6.3.2 Individual cell class values are permitted to be greater than those listed.

6.4 *Rework Material*—A blend of clean rework materials generated from the manufacturers own pipe production is permitted to be used by the same manufacturer, provided the pipe produced meets all of the requirements of this specification. Rework material is excluded from standard definitions of recycled materials in accordance with Guide **D5033**.

6.4.1 Rework material generated from composite pipe shall not be used in the outer layer.

6.4.2 Thermally foamed layer shall not be used in the inner or outer layer.

7. Requirements

7.1 *General*—The inside and outside surfaces of pipe produced in accordance with this specification shall be free of chalking, sticky, or tacky material. The surfaces shall be free of excessive bloom. Bloom or chalking may develop in pipe exposed to direct rays of the sun (ultraviolet radiant energy) for extended periods and consequently, these requirements do not apply to pipe after extended exposure to direct rays of the sun. The inside and outside surfaces of pipe shall be free of foreign inclusion or other defects that are visible to the naked eye, and may affect the wall integrity.

7.1.1 The requirements in this section are intended only for use as quality control tests, not as simulated service tests.

7.2 Dimensions and Tolerances:

7.2.1 *Outside Diameter*—The outside diameter and tolerances shall meet the requirements of **Table 1** when measured in accordance with Method **D2122**. The tolerances for out-of-roundness shall apply to the pipe at the time of manufacture.

7.2.2 *Wall Thickness*—The wall thickness and tolerances shall meet the requirements of **Table 2** when measured in accordance with Method **D2122**.

TABLE 1 Outside Diameter and Tolerance

Nominal Pipe Sizes, in.	Average	Tolerance on Average Outside Diameter		Out-of-Roundness Maximum Diameter Minus Minimum Diameter ^A
		Outside Diameter, in. (mm)		
1¼	1.660 (42.16)	+0.010, -0.000	(+0.25, -0.00)	0.024 (0.60)
1½	1.900 (48.26)	+0.010, -0.000	(+0.25, -0.00)	0.024 (0.60)
2	2.375 (60.32)	+0.010, -0.000	(+0.25, -0.00)	0.024 (0.60)
3	3.500 (88.90)	+0.015, -0.000	(+0.38, -0.00)	0.060 (1.52)
4	4.500 (114.30)	+0.015, -0.000	(+0.38, -0.00)	0.100 (2.54)
6	6.625 (168.28)	+0.016, -0.006	(+0.41, -0.15)	0.100 (2.54)
8	8.625 (219.07)	+0.022, -0.008	(+0.56, -0.20)	0.150 (3.81)

^A Measured at time of manufacturing.

TABLE 2 Wall Thickness and Tolerance

Nominal Pipe Sizes, in.	Wall Thickness, in. (mm)	
	Minimum Wall ^A	Tolerance
1¼	0.140 (3.56)	+0.020 (+0.50)
1½	0.145 (3.68)	+0.020 (+0.50)
2	0.154 (3.91)	+0.020 (+0.50)
3	0.216 (5.42)	+0.026 (+0.66)
4	0.237 (6.02)	+0.028 (+0.71)
6	0.280 (7.11)	+0.034 (+0.86)
8	0.322 (8.18)	+0.034 (+0.86)

^A The minimum is the lowest wall thickness of the pipe at any cross section.

7.2.3 *Length*—The pipe shall be in either 10 or 20-ft (3.05 or 6.1-m) lengths, unless otherwise specified. The allowable tolerance on the length shall be +½, -0 in.

7.3 *Pipe Stiffness*—The minimum pipe stiffness at 5 % deflection when measured in accordance with Test Method **D2412** shall equal or exceed the value in **Table 3**. The rate of crosshead motion shall be 0.20 to 0.25 in./min (5.1 to 6.3 mm/min). Three specimens shall be tested. If all three meet this requirement, the sample meets this requirement. If one or two fail, additional testing shall be conducted in accordance with **7.3.1**. If all three fail, the sample does not meet the requirement.

7.3.1 *Pipe Stiffness and Lower Confidence Limit*—In the event that one or two of the specimens tested in **7.3** fail to meet the minimum requirement, the average pipe stiffness of eleven specimens shall meet or exceed the minimum requirement given in **Table 3**. The 99 % lower confidence limit (LCL) shall be within 15 % of the average value. The LCL shall be calculated using the Student's "t" distribution, with $N-1$ degrees of freedom, where N is the number of specimens (11). The critical t value shall be used to at least three significant

TABLE 3 Pipe Stiffness

Nominal Pipe Sizes, in.	Minimum Pipe Stiffness at 5 % Deflection	
	psi	(MPa)
1¼	600	(4.13)
1½	535	(3.69)
2	300	(2.06)
3	280	(1.93)
4	175	(1.21)
6	75	(0.52)
8	75	(0.52)

digits. Alternatively, if the LCL exceeds the minimum PS requirement in **Table 3**, but is not within 15 % of the average, the sample meets the requirements of the Pipe Stiffness testing. The eleven specimens include the three tested under **7.3**, and an additional eight with rotation by 35°, as specified in **D2412**, continuing throughout the remaining specimens.

The LCL based on testing eleven specimens is calculated as follows (Note: $N = 11$):

$$\text{LCL} = (\text{Average PS}) - \{2.76 (\text{Standard Deviation})/\sqrt{(N)}\} \quad (1)$$

where:

$$(\text{Average PS}) = [\Sigma(\text{PS}_i)]/(11) \quad (2)$$

$$(\text{Standard Deviation}) = \left[\frac{\Sigma \text{PS}^2 - (\Sigma \text{PS})^2/N}{N - 1} \right]^{1/2} \quad (3)$$

The 15 % requirement is calculated as:

$$(\text{Average} - \text{LCL})/(\text{Average}) \times 100 \% \leq 15 \% \quad (4)$$

NOTE 3—This test is conducted at the time of manufacture.

NOTE 4—The 5 % deflection criterion is arbitrarily selected for testing convenience. It should not be considered as a limitation with respect to in-use deflection. The engineer is responsible for establishing the deflection limit.

NOTE 5—The strength and load-carrying capabilities of composite DWV pipe is measured and reported as pipe stiffness, that is determined in accordance with Test Method **D2412**. The term “crushing strength” is not applicable to thermoplastic piping.

7.4 Pipe Flattening—There shall be no evidence of rupture or cracking when deflected 25 % of the initial inside diameter when tested by Test Method **D2412**. Test three specimens. When all pass, accept the lot. When one fails, the lot does not meet the requirements of this specification. Failure shall be a crack or break extending entirely through the pipe wall visible to the unaided eye. Refer to **9.1** (see **Note 3**).

7.5 Impact Resistance—The minimum impact resistance, when tested at the time of manufacture, shall comply with the requirements of **Table 4**. Test in accordance with Test Method **D2444** using Tup B and Holder B. Use a 20-lb (9.1 kg) tup for all sizes.

7.5.1 Test 10 specimens. When 9 or 10 specimens pass accept the lot. When 2 or more specimens fail, test 10 additional specimens. When 17 of 20 specimens tested pass, accept the lot. When 4 or more of 20 specimens fail, test 20 additional specimens. When 32 of 40 specimens pass, accept the lot. When 9 or more of 40 specimens fail, the lot does not meet the requirements of this specification.

7.5.2 Failure of the test specimen shall be shattering or any crack or break extending entirely through the pipe wall and visible to the unaided eye.

TABLE 4 Impact Resistance

Nominal Pipe Sizes, in.	Minimum Impact Resistance, ft lb3 lbf (J)	
	At 32°F (0°C)	
1¼	15 (20)	
1½	20 (27)	
2	30 (41)	
3	40 (54)	
4	40 (54)	
6	40 (54)	
8	40 (54)	

7.6 Bond—The bond between 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, or the probe or knife blade moves freely between the layers; nor shall separation of bond occur between layers during testing performed under the requirements of this specification. Refer to **9.1** (see **Note 3**).

7.7 Inspection—Inspection shall be made prior to installation of all pipe. Pipe that does not meet the requirements of Section 8 shall be returned to the seller.

7.8 Solvent Cement—In the assembly of solvent cement joints, the solvent cement shall be compatible with the material in the outer layer, as marked on the pipe, and shall meet the requirements of Specification **D2235**.

7.8.1 The safety requirements of Practice **F402** shall be followed.

7.9 Qualification Test:

7.9.1 Joint Tightness—Join two pieces of pipe together using molded fittings and solvent cement. Use solvent cement meeting the requirements of **7.8**. Cure the solvent cement joints 24 h at room temperature, before testing. Joints shall not leak when tested at an internal water pressure of 25 psi (170 kPa), for 1 h using water at 73°F (23°C). Refer to **9.1**.

NOTE 6—The qualification test is designed to qualify the thickness of the outer layer, to ensure that the thickness of the outer layer is sufficient to withstand the effect of the solvent cement, and thus ensure a good leak-free joint.

8. Sampling and Conditioning for Quality Control Testing

8.1 Sampling—The lot shall consist of all pipe produced of one size from one extrusion line during one designated 24-h period. Take the number of specimens for each test from pipe selected at random from each lot under the random sampling plan of Practice **D1898**.

NOTE 7—Also see Practices **E105** and **E122**.

8.2 Conditioning:

8.2.1 For referee testing at 73° F, condition the specimens prior to the test at 73.4 ± 3.6°F (23 ± 2°C) and 50 ± 5 % relative humidity in accordance with Practice **D618**, Procedure A.

8.2.2 For routine quality control testing at 73°F, condition the specimens at the temperature and humidity of the manufacturer's testing facility for not less than 1 h or until the specimens are at room temperature.

8.2.3 For referee testing at 32°F, condition the specimens at 32 ± 3.6°F (0 ± 2°) for at least 16 h in air.

8.2.4 For quality control testing at 32°F, condition the specimens at 32 ± 3.6°F (0 ± 2°C) for at least 12 h, or in ice water for at least 1 h.

8.3 Test Conditions:

8.3.1 For referee purposes, conduct test in the standard laboratory atmosphere of 73.4 ± 3.6°F (23 ± 2°C) and 50 ± 5 % relative humidity.

8.3.2 For routine quality control testing, conduct tests at the temperature and humidity of the manufacturer's testing area.