



Designation: F1697 – 09

Standard Specification for Poly(Vinyl Chloride) (PVC) Profile Strip for Machine Spiral-Wound Liner Pipe Rehabilitation of Existing Sewers and Conduit^{1,2}

This standard is issued under the fixed designation F1697; 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 covers requirements and test methods for materials, dimensions, workmanship, stiffness factor, extrusion quality, and a form of marking for extruded poly(vinyl chloride) (PVC) profile strips used for machine made field fabrication of spirally wound pipe liners in the rehabilitation of a variety of gravity applications such as sanitary sewers, storm sewers, and process piping in diameters of 6 to 180 in. and for similar sizes of non-circular pipelines such as arched or oval shapes and rectangular shapes.

1.2 Profile strip produced to this specification is for use in field fabrication of spirally wound liner pipes in nonpressure sewer and conduit rehabilitation, where the spirally wound liner pipe is expanded until it presses against the interior surface of the existing sewer or conduit, or, alternatively, where the spirally wound liner pipe is inserted as a fixed diameter into the existing sewer or conduit and the annular space between the liner pipe and the existing sewer or conduit is grouted.

1.3 This specification includes extruded profile strips made only from materials specified in 5.1.

1.4 The values stated in inch-pound units are to be regarded as standard. No other units of measurement are included in this standard.

1.5 The following precautionary caveat pertains only to the test method portion, Section 11, 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*

¹ This specification is under the jurisdiction of ASTM Committee F17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.67 on Trenchless Plastic Pipeline Technology.

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² The rehabilitation of existing pipelines and conduits by the insertion of a spiral wound liner pipe is covered by patents. (RibLoc Group Limited, Dry Creek, South Australia, Australia and Danby of North America, Inc., Cary, NC, USA). Interested parties are invited to submit information regarding the identification of acceptable alternatives to this patented item to the Committee on Standards, ASTM Headquarters, 100 Barr Harbor Drive, West Conshohocken, PA 19428-29590. Your comments will receive careful consideration at a meeting of the responsible technical committee which you may attend.

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:³

A167 Specification for Stainless and Heat-Resisting Chromium-Nickel Steel Plate, Sheet, and Strip (Withdrawn 2014)⁴

A176 Specification for Stainless and Heat-Resisting Chromium Steel Plate, Sheet, and Strip

A653/A653M Specification for Steel Sheet, Zinc-Coated (Galvanized) or Zinc-Iron Alloy-Coated (Galvannealed) by the Hot-Dip Process

A879/A879M Specification for Steel Sheet, Zinc Coated by the Electrolytic Process for Applications Requiring Designation of the Coating Mass on Each Surface

A924/A924M Specification for General Requirements for Steel Sheet, Metallic-Coated by the Hot-Dip Process

D618 Practice for Conditioning Plastics for Testing

D790 Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials

D883 Terminology Relating to Plastics

D1600 Terminology for Abbreviated Terms Relating to Plastics

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

D2122 Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings

D2152 Test Method for Adequacy of Fusion of Extruded Poly(Vinyl Chloride) (PVC) Pipe and Molded Fittings by Acetone Immersion

F412 Terminology Relating to Plastic Piping Systems

³ 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.

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

*A Summary of Changes section appears at the end of this standard

F1741 Practice for Installation of Machine Spiral Wound Poly (Vinyl Chloride) (PVC) Liner Pipe for Rehabilitation of Existing Sewers and Conduits

NOTE 1—F1741 Practice for Installation of Machine Spiral Wound Poly (Vinyl Chloride) (PVC) Liner Pipe for Rehabilitation of Existing Sewers and Conduits, is an accompanying standard to this document.

2.2 *Federal Standard:*

Federal Standard No. 123 Marking for Shipment (Civil Agencies)⁵

2.3 *Military Standard:*

MIL-STD-129 Marking for Shipment and Storage⁵

3. Terminology

3.1 *General*—Definitions are in accordance with Terminologies **D883** and **F412**. Abbreviations are in accordance with Terminology **D1600**, unless otherwise indicated.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *extruded PVC profile strips*—a product, available in various widths, consisting of a smooth inside surface and a ribbed outer surface with mechanically locked male and female edges which are self interlocking, or separate locking strips which serve the same purpose. Type A and Type B are different profiles and are installed by different installation methods. (See **Fig. 1** and **Table 1** for Type A and **Fig. 2** and **Table 2** for Type B.)

3.2.2 *non-circular pipe*—arched, oval or rectangular, or a combination thereof, shaped pipes.

3.2.3 *production run*—a continuous extrusion of a given profile type.

3.2.4 *spirally wound liner pipe*—a product field fabricated from extruded PVC profile strip into a round, or non-circular shape such as arched or oval or rectangular pipe (see **Fig. 3**).

3.2.5 *steel reinforcement*—a shaped steel strip or clip inserted into the inside of the PVC profile to provide additional reinforcement and stiffening (See **Fig. 4** and **Fig. 5**.)

4. Application of Materials

4.1 The profile strip designations specified in **Table 1** may be used for a range of existing sewer and conduit diameters.

⁵ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, <http://www.dodssp.daps.mil>

The selection of the profile designation to be used should be determined based on analysis of installation conditions.

4.2 The steel reinforcing strips shall be used to reinforce the extruded PVC profile strip where required by the design conditions, such as for pipes under high soil, surcharge or live loads throughout the design life. The steel reinforcing strips may be used to maintain the profile position during grouting.

5. Materials and Manufacture

5.1 *PVC Materials*—The extruded profile strip shall be made from PVC compound meeting all the minimum requirements for Cell Classifications 12344 or 13454 or higher, as defined in Specification **D1784**.

5.2 *Steel Materials*—The steel reinforcing strip shall be made of zinc-galvanized coated steel or stainless steel as defined in Specifications **A879/A879M**, **A167**, **A176**, **A924/A924M** or **A653/A653M**.

5.3 *Rework Material*—Clean rework material generated from the manufacturer’s own extruded PVC strip production may be used by the same manufacturer provided extruded profile strip produced meets all the requirements of this specification.

6. Other Requirements

6.1 *Stiffness Factor*—Stiffness factor values for the extruded profile strip shall comply with **Table 1** when tested in accordance with **11.3**.

6.2 *Acetone Immersion*—The profile strip shall not flake or disintegrate when tested in accordance with **11.4**.

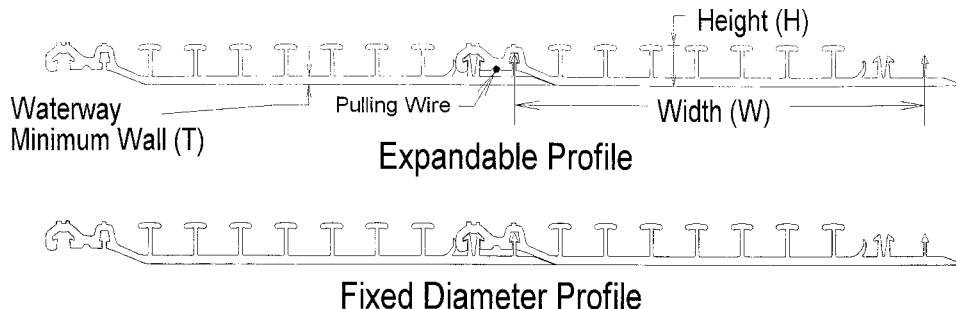
NOTE 2—This is intended only for use as a quality control test and not for use as a simulated service test.

7. Dimensions and Permissible Variation

7.1 *Width of Profile Strip*—The width of the profile strip shall meet the requirements given in **Table 1** when measured in accordance with **11.2.1**.

7.2 *Height of Profile Strip*—The height of the profile strip shall meet the requirements given in **Table 1** when measured in accordance with **11.2.2**.

7.3 *Waterway Wall Thickness*—The waterway wall thickness of the profile strip shall meet the requirements given in **Table 1** when measured in accordance with **11.2.3**.



NOTE 1—For values of width, height, and waterway minimum wall, see **Table 1**.

FIG. 1 Type A-Typical PVC Profile Strip

TABLE 1 Type A-Typical Profile Strip Dimensions and Stiffness Factors

Profile Type	Minimum Width, W		Minimum Height, H		Waterway Minimum Wall, T		Minimum Stiffness Factor, (EI) ⁴	
	in.	(mm)	in.	(mm)	in.	(mm)	in. ³ -lbf/in. ²	(MPa-mm ³)
1	2.00	(51.0)	0.216	(5.5)	0.063	(1.60)	188.0	(21.2 × 10 ³)
2	3.14	(80.0)	0.314	(8.0)	0.063	(1.60)	561	(63.4 × 10 ³)
3	4.76	(121.0)	0.511	(13.0)	0.083	(2.10)	2148	(242.7 × 10 ³)
4	4.33	(110.0)	0.480	(12.2)	0.040	(1.00)	1600.0	(180.8 × 10 ³)
5	8.00	(203.2)	0.488	(12.4)	0.060	(1.50)	1600.0	(180.8 × 10 ³)
6	12.00	(304.8)	0.488	(12.4)	0.060	(1.50)	1600.0	(180.8 × 10 ³)

⁴Stiffness factor listed is the minimum value that will be provided by the manufacturer for the given profile type.

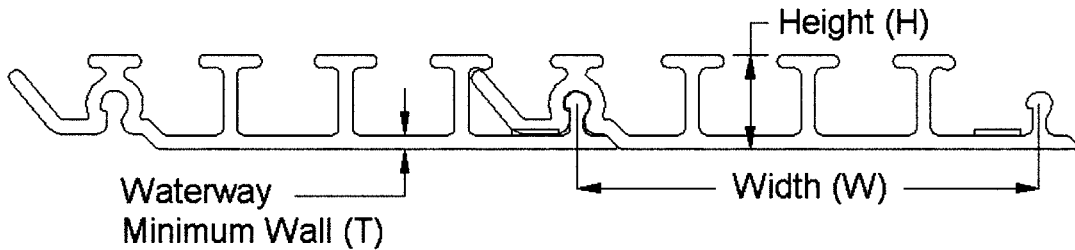


FIG. 2 Type B-Typical PVC Profile Strip

TABLE 2 Type B-Typical Profile Strip Dimensions and Stiffness Factors

Profile Type	Minimum Width, W		Minimum Height, H		Waterway Minimum Wall, T		Minimum Stiffness Factor, (EI) ⁴	
	in.	(mm)	in.	(mm)	in.	(mm)	in. ³ -lbf/in. ²	(MPa-mm ³)
1	3.19	(81.0)	0.32	(8.10)	0.06	(1.44)	362.5	40955
2	3.09	(78.3)	0.42	(10.71)	0.06	(1.62)	745.0	84127
3	2.84	(72.0)	0.58	(14.67)	0.09	(2.34)	1946.3	219900
4	2.80	(71.1)	0.76	(19.35)	0.12	(3.06)	3971.0	448656
5	2.81	(71.28)	1.12	(28.53)	0.15	(3.69)	14116.0	1594900
6	3.60	(91.44)	0.56	(14.22)	0.06	(1.44)	1513.8	171042

⁴Stiffness factor listed is the minimum value that will be provided by the manufacturer for the given profile type.

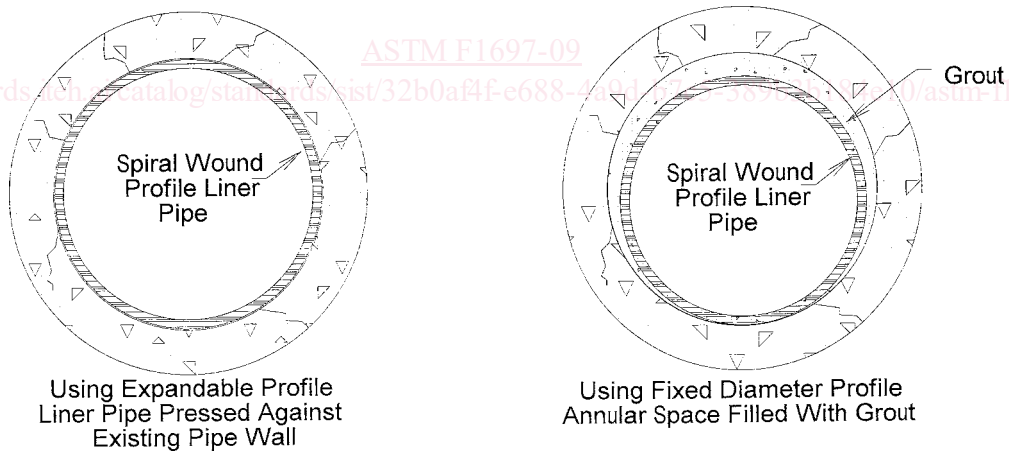


FIG. 3 Typical Spiral-Wound Liner Pipe



FIG. 4 Steel Reinforcing Strip Type A