



Standard Specification for Chlorinated Poly (Vinyl Chloride) (CPVC) Plastic Pipe Fittings, Schedule 80¹

This standard is issued under the fixed designation F 439; 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 chlorinated poly(vinyl chloride) (CPVC) Schedule 80 pipe fittings. Included are requirements for materials, workmanship, dimensions, and burst pressure.

NOTE 1—The threaded CPVC fittings covered by this specification were covered previously in Specification F 437.

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 this specification.

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

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 method 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

D 618 Practice for Conditioning Plastics for Testing

D 1599 Test Method for Resistance to Short-Time Hydraulic Pressure of Plastic Pipe, Tubing, and Fittings

D 1600 Terminology for Abbreviated Terms Relating to Plastics

D 1784 Specification for Rigid Poly(Vinyl Chloride) (PVC) Compounds and Chlorinated Poly(Vinyl Chloride) (CPVC) Compounds

D 2122 Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings

D 2749 Symbols for Dimensions of Plastic Pipe Fittings

F 412 Terminology Relating to Plastic Piping Systems

F 437 Specification for Threaded Chlorinated Poly(Vinyl Chloride) (CPVC) Plastic Pipe Fittings, Schedule 80

F 1498 Specification for Taper Pipe Threads 60° for Thermoplastic Pipe and Fittings

2.2 Federal Standard:

Fed. Std. No. 123 Marking for Shipment (Civil Agencies)³

2.3 Military Standard:

MIL-STD-129 Marking for Shipment and Storage³

2.4 NSF Standard:

Standard No. 14 for Plastic Piping Components and Related Materials⁴

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

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. Current edition approved March-Aug. 1, 2006-2009. Published March 2006-August 2009. Originally approved in 1974. Last previous edition approved in 2005-2006 as F 439 – 05 ϵ .

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 Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS-19111-5098, <http://www.dodssp.daps.mil>.

⁴ Available from NSF International, P.O. Box 130140, Ann Arbor, MI 48113-0140.

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

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

3. Terminology

3.1 *Definitions*—Definitions are in accordance with Terminology F 412 and abbreviations are in accordance with Terminology D 1600, unless otherwise indicated. The abbreviation for chlorinated poly(vinyl chloride) is CPVC.

4. Classification

4.1 *General*—This specification covers Schedule 80 CPVC pipe fittings, intended for use with Iron Pipe Size (IPS) outside-diameter plastic pipe.

4.1.1 Fittings covered by this specification are normally molded. In-line fittings, such as couplings, unions, bushings, caps, nipples, and so forth, shall be molded or machined from extruded stock.

~~4.1.2 Fittings fabricated by back welding or butt fusion are not included in this specification.~~

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NOTE 2—This specification does not include requirements for pipe and fittings intended to be used to vent combustion gases.

5. Materials and Manufacture

5.1 This specification covers CPVC pipe fittings made from compounds meeting the requirements of Class 23447 and Class 23448 as defined in Specification D 1784.

NOTE 23—Mechanical strength, heat resistance and flammability requirements are covered in Specification D 1784.

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.

6. Requirements

6.1 *Dimensions and Tolerances:*

6.1.1 Fitting sockets, inside diameters (waterways), minimum wall thicknesses, and dimensions shall be as shown in Tables 1-6 when measured in accordance with Test Method D 2122.

6.1.2 When multistep reducer bushings are cored out, the inner socket shall be reinforced from the outer wall by a minimum of three ribs extending from the top of the inner socket to the deepest extremity of the coring. The transition from D to DJ (Table 3) shall be straight, tapered as shown, or radiused. A positive taper in the same direction of the taper in the socket on the outside diameter of the bushing is optional.

6.1.3 The minimum wall thickness of fittings shall be 125 % of the minimum wall thickness of the corresponding size of Schedule 80 pipe for which they are designed to be used, except that for the socket, the wall thickness shall be at least equal to the minimum wall thickness of the corresponding size of Schedule 80 pipe.

6.1.4 The minimum inside diameter of the fittings shall be not less than the minimum specified inside diameter of the corresponding size of Schedule 80 pipe. This is calculated as follows:

$$(\text{minimum OD}) - 2 \times (\text{maximum wall}) = \text{minimum ID} \quad (1)$$

6.1.5 Minimum dimensions have zero negative tolerance. Tolerances on other dimensions are shown in Tables 1 and 3.

6.1.6 *Fitting Not Illustrated*—All fittings, whether illustrated in Tables 1-5 or not, shall maintain the dimensions conforming to 6.1 and 6.2.

6.2 *Threads*—For all fittings having taper pipe threads, threads shall conform to Specification F 1498 and be gaged in accordance with 8.4.

6.3 *Burst Pressure:*

6.3.1 The minimum burst strength of the fittings shall be not less than that calculated for the size and wall thickness of the pipe with which it is to be used, when calculated from the following equation and using a stress of 6400 psi for 8-in. and smaller fittings, and a stress of 5100 psi for fittings larger than 8-in.:

$$S = P(D_o - t)/2t \quad (2)$$

where:

S = hoop stress, psi (MPa),

P = internal pressure, psi (MPa),

D_o = average outside diameter, in. (mm), and

t = minimum wall thickness, in. (mm).

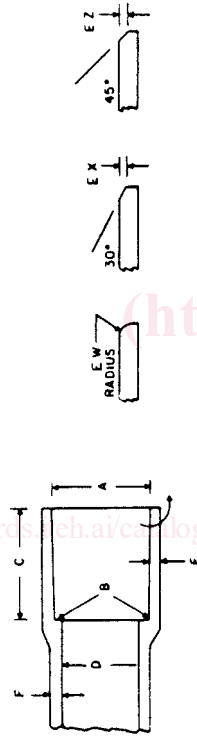
Fittings tested in accordance with 8.5 shall withstand the minimum burst pressure shown in Table 6.

6.3.2 Pressures shown are minimum burst pressures and do not imply rated working pressures. The burst pressure shall be used only as an indication of quality.

7. Workmanship, Finish and Appearance

7.1 The fittings shall be homogeneous throughout and free of cracks, holes, foreign inclusions, or other defects. The fittings shall be as uniform as commercially practicable in color, opacity, density, and other physical properties.

TABLE 1 Tapered Sockets for CPVP Pipe Fittings, Schedule 80, in. (mm)^A



Nominal Pipe Size	Socket Entrance Diameter A		Socket Bottom Diameter B		Maximum Out-of-Round	Socket Length, min C ^B	Inside Diameter, min D ^C	Wall Thickness, min				
	Diameter	Tolerance on Nominal Diameter	Diameter	Tolerance on Nominal Diameter				E	F	EW	EX, EZ	
1/4	0.552 (14.02)	±0.004 (0.10)	0.536 (13.61)	±0.004 (0.10)	0.016 (0.41)	0.625 (15.88)	0.258 (6.55)	0.119 (3.02)	0.149 (3.78)	0.02 (0.5)	0.02 (0.5)	0.02 (0.5)
3/8	0.687 (17.45)	±0.004 (0.10)	0.671 (17.04)	±0.004 (0.10)	0.016 (0.41)	0.750 (19.05)	0.379 (9.63)	0.126 (3.20)	0.160 (4.06)	0.03 (0.8)	0.03 (0.8)	0.03 (0.8)
1/2	0.848 (21.54)	±0.004 (0.10)	0.836 (21.23)	±0.004 (0.10)	0.016 (0.41)	0.875 (22.22)	0.502 (12.75)	0.147 (3.73)	0.185 (4.70)	0.03 (0.8)	0.03 (0.8)	0.03 (0.8)
3/4	1.058 (26.87)	±0.004 (0.10)	1.046 (26.57)	±0.004 (0.10)	0.020 (0.51)	1.000 (25.40)	0.698 (17.73)	0.154 (3.91)	0.195 (4.95)	0.03 (0.8)	0.03 (0.8)	0.03 (0.8)
1	1.325 (33.66)	±0.005 (0.13)	1.310 (33.27)	±0.005 (0.13)	0.020 (0.51)	1.125 (28.58)	0.911 (23.14)	0.179 (4.55)	0.225 (5.72)	0.06 (1.5)	0.06 (1.5)	0.06 (1.5)
1 1/4	1.670 (42.42)	±0.005 (0.13)	1.655 (42.04)	±0.005 (0.13)	0.024 (0.61)	1.250 (31.75)	1.227 (31.17)	0.191 (4.85)	0.240 (6.10)	0.06 (1.5)	0.06 (1.5)	0.06 (1.5)
1 1/2	1.912 (48.56)	±0.006 (0.15)	1.894 (48.11)	±0.006 (0.15)	0.024 (0.61)	1.375 (34.93)	1.446 (36.73)	0.200 (5.08)	0.250 (6.35)	0.06 (1.5)	0.06 (1.5)	0.06 (1.5)
2	2.387 (60.63)	±0.006 (0.15)	2.369 (60.17)	±0.006 (0.15)	0.024 (0.61)	1.500 (38.10)	1.881 (47.78)	0.218 (5.54)	0.275 (6.99)	0.06 (1.5)	0.06 (1.5)	0.06 (1.5)
2 1/2	2.889 (73.38)	±0.007 (0.18)	2.868 (72.85)	±0.007 (0.18)	0.030 (0.76)	1.750 (44.45)	2.250 (57.15)	0.276 (7.01)	0.345 (8.76)	0.09 (2.3)	0.09 (2.3)	0.13 (3.3)
3	3.516 (89.31)	±0.008 (0.20)	3.492 (88.70)	±0.008 (0.20)	0.030 (0.76)	1.875 (47.63)	2.820 (71.63)	0.300 (7.62)	0.375 (9.53)	0.09 (2.3)	0.09 (2.3)	0.13 (3.3)
3 1/2	4.016 (102.01)	±0.008 (0.20)	3.992 (101.40)	±0.008 (0.20)	0.030 (0.76)	2.125 (53.98)	3.280 (83.31)	0.318 (8.08)	0.400 (10.16)	0.09 (2.3)	0.09 (2.3)	0.13 (3.3)
4	4.518 (114.76)	±0.009 (0.23)	4.491 (114.07)	±0.009 (0.23)	0.030 (0.76)	2.250 (57.15)	3.737 (94.92)	0.337 (8.56)	0.420 (10.67)	0.09 (2.3)	0.09 (2.3)	0.13 (3.3)
5	5.583 (141.81)	±0.010 (0.25)	5.553 (141.05)	±0.010 (0.25)	0.060 (1.52)	2.625 (66.68)	4.703 (119.46)	0.375 (9.53)	0.470 (11.94)	0.09 (2.3)	0.09 (2.3)	0.13 (3.3)
6	6.647 (168.83)	±0.011 (0.28)	6.614 (168.00)	±0.011 (0.28)	0.060 (1.52)	3.000 (76.20)	5.646 (143.41)	0.432 (10.97)	0.540 (13.72)	0.13 (3.3)	0.13 (3.3)	0.19 (4.8)
8	8.655 (219.84)	±0.015 (0.38)	8.610 (219.29)	±0.015 (0.38)	0.090 (2.29)	4.000 (101.60)	7.610 (193.29)	0.500 (12.70)	0.625 (15.88)	0.13 (3.3)	0.13 (3.3)	0.19 (4.8)
10	10.780 (273.81)	±0.015 (0.38)	10.735 (272.67)	±0.015 (0.38)	0.100 (2.54)	5.000 (127.00)	9.407 (238.94)	0.593 (15.06)	0.741 (18.82)	0.125 (3.18)	0.125 (3.18)	0.187 (4.76)
12	12.780 (324.61)	±0.015 (0.38)	12.735 (323.47)	±0.015 (0.38)	0.120 (3.05)	6.000 (152.40)	11.197 (284.40)	0.687 (17.45)	0.859 (21.82)	0.125 (3.18)	0.125 (3.18)	0.187 (4.76)

^AThe sketches and designs of fittings are illustrative only.

^B Socket depth, measured from socket entrance face to socket bottom face.

^C See 6.1.4.