



Standard Specification for Crosslinked Polyethylene (PEX) Pipe¹

This standard is issued under the fixed designation F2788; 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 crosslinked polyethylene (PEX) pipe that is outside diameter controlled, made in nominal pipe dimension ratios, and pressure rated for water at three temperatures (see [Appendix X1](#)). Included are requirements and test methods for material, workmanship, dimensions, burst pressure, hydrostatic sustained pressure, excessive temperature pressure, excessive temperature-pressure, environmental stress cracking, stabilizer functionality, bent-pipe hydrostatic pressure, oxidative stability in potable chlorinated water, and degree of crosslinking. Requirements for pipe markings are also given.

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 Except for dimensions, 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. For dimensions, the values stated in SI units are to be regarded as standard. The values given in parentheses for nominal sizes are mathematical conversions to inch-pound units that are provided for information only and are not considered standard.

NOTE 1—Metric sized (SI units) pipe should only be joined with corresponding metric sized fittings. Inch sized fittings should not be used for metric sized pipe.

1.4 *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 appro-*

priate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. Referenced Documents

2.1 ASTM Standards:²

- D618 Practice for Conditioning Plastics for Testing
- D792 Test Methods for Density and Specific Gravity (Relative Density) of Plastics by Displacement
- D1505 Test Method for Density of Plastics by the Density-Gradient Technique
- D1598 Test Method for Time-to-Failure of Plastic Pipe Under Constant Internal Pressure
- D1599 Test Method for Resistance to Short-Time Hydraulic Pressure of Plastic Pipe, Tubing, and Fittings
- D1600 Terminology for Abbreviated Terms Relating to Plastics
- D1898 Practice for Sampling of Plastics³
- D2122 Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings
- D2765 Test Methods for Determination of Gel Content and Swell Ratio of Crosslinked Ethylene Plastics
- D2837 Test Method for Obtaining Hydrostatic Design Basis for Thermoplastic Pipe Materials or Pressure Design Basis for Thermoplastic Pipe Products
- D3895 Test Method for Oxidative-Induction Time of Polyolefins by Differential Scanning Calorimetry
- F412 Terminology Relating to Plastic Piping Systems
- F2023 Test Method for Evaluating the Oxidative Resistance of Crosslinked Polyethylene (PEX) Tubing and Systems to Hot Chlorinated Water

¹ This test method is under the jurisdiction of ASTM Committee F17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.26 on Olefin Based Pipe.

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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.

2.2 ANSI Standard:⁴

B36.10 Standards Dimensions of Steel Pipe (IPS)

2.3 Federal Standard:⁵

FED-STD-123 Marking for Shipment (Civil Agencies)

2.4 Military Standard:⁵

MIL-STD-129 Marking for Shipment and Storage

2.5 NSF Standard:⁶

NSF/ANSI 14 for Plastic Piping Components and Related Materials

2.6 ISO Standards:⁷

ISO 1167 Thermoplastics pipes, fittings and assemblies for the conveyance of fluids — Determination of the resistance to internal pressure — Part 1: General method

ISO 4427 Plastic piping systems - Polyethylene (PE) pipes and fittings for water supply

ISO 13760 Plastics pipes for the conveyance of fluids under pressure — Miner's rule ~ Calculation method for cumulative damage

ISO R 161-1690 Pipes of Plastic Materials for the Transport of Fluids (Outside Diameters and Nominal Pressures) Part 1, Metric Series

2.7 PPI Standards:⁸

PPI TR-3 Policies and Procedures for Developing Hydrostatic Design Basis (HDB), Pressure Design Basis (PDB), Strength Design Basis (SDB), and Minimum Required Strength (MRS) Ratings for Thermoplastic Piping Materials or Pipe

PPI TR-4 PPI Listing of Hydrostatic Design Basis (HDB), Strength Design Basis (SDB), Pressure Design Basis (PDB) and Minimum Required Strength (MRS) Ratings for Thermoplastic Piping Materials or Pipe

hydrostatic design basis (HDB) times the design factor (DF) for water. For this standard, the design factor is equal to 0.50.

$$\begin{aligned} HDS &= HDB \times DF \\ &= HDB \times 0.50 \text{ (for this standard)} \end{aligned} \quad (1)$$

3.5 *hydrostatic design basis (HDB)*—one of a series of established stress values (specified in Test Method **D2837**) for a plastic compound obtained by categorizing the long-term hydrostatic strength determined in accordance with Test Method **D2837**.

3.5.1 *Discussion*—A listing of HDB and HDS values are contained in PPI publication **PPI TR-4**

3.6 *pressure rating (PR)*—the estimated maximum water pressure the pipe is capable of withstanding continuously with a high degree of certainty that failure of the pipe will not occur.

3.7 *relation between dimensions, hydrostatic design stress, and pressure rating*—the following expression, commonly known as the ISO equation⁹ is used in this specification to relate dimensions, hydrostatic design stress, and pressure rating:

$$2S/P = (D_o/t) - 1 \text{ or} \quad (2)$$

$$2S/P = R - I$$

S = hydrostatic design stress, psi (or MPa),

P = pressure rating, psi (or MPa),

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

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

R = standard dimension ratio (SDR) or dimension ratio (DR)

3.8 *standard dimension ratio (SDR)/dimension ratio (DR)*—the ratio of outside diameter to wall thickness. For PEX-pipe, it is calculated by dividing the average outside diameter of the pipe by the minimum wall thickness. If the calculated dimension ratio is a Preferred Number Series R 10 modified by +1 (7, 9, 11 etc.), then it is called an SDR (standard dimension ratio); for all other numbers, it is called a DR.

3.9 *standard pipe material designation code*—The pipe material designation code shall consist of the abbreviation for the type of plastic (PEX) followed by four Arabic digits that describe short-term properties in accordance with applicable ASTM standards and as shown in **Table 1**.

3.9.1 *Discussion*—The first digit is for chlorine resistance tested in accordance with Test Method **F2023**.

(1) A digit “0” indicates that the PEX pipe either has not been tested for chlorine resistance or that the PEX pipe does not meet the minimum requirement for chlorine resistance.

(2) A digit “1” indicates the PEX pipe has been tested and meets the F XXXX requirement for minimum chlorine resistance at the end use condition of 25% at 140°F (60°C) and 75% at 73°F (23°C).

(3) A digit “2” is reserved for future application.

(4) A digit “3” indicates that the PEX pipe has been tested and meets the F XXXX requirement for minimum chlorine resistance at end use condition of 50% at 140°F and 50% at 73°F.

3. Terminology

3.1 *Definitions*—Definitions are in accordance with Terminology **F412**, and abbreviations are in accordance with Terminology **D1600**, unless otherwise specified. The abbreviation for crosslinked polyethylene is PEX. Plastic pipe denotes a particular diameter schedule of plastic pipe in which outside diameter of the pipe conforms with **ISO 4427**.

3.2 *Definitions of Terms Specific to This Standard:*

3.3 *crosslinked polyethylene plastics*—plastics prepared by crosslinking (curing) polyethylene compounds.

3.4 *hydrostatic design stress (HDS)*—the estimated maximum tensile stress the material is capable of withstanding continuously with a high degree of certainty that failure of the pipe will not occur. This stress is circumferential when internal hydrostatic water pressure is applied. The HDS is equal to the

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

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

⁶ Available from NSF International, P.O. Box 130140, 789 N. Dixboro Rd., Ann Arbor, MI 48113-0140, <http://www.nsf.org>.

⁷ Available from International Organization for Standardization (ISO), 1, ch. de la Voie-Creuse, Case postale 56, CH-1211, Geneva 20, Switzerland, <http://www.iso.ch>.

⁸ Available from Plastics Pipe Institute (PPI), 105 Decker Court, Suite 825, Irving, TX 75062, <http://www.plasticpipe.org>.

⁹ ISO R161-1690.

TABLE 1 Material Designation Code Cells

Property	Standard	0	1	2	3	4	5	6	7	8	9
Chlorine Resistance	F2023	Not tested or rated	75 % at 73°F and 25 % at 140°F	Reserved	50 % at 73°F and 50 % at 140°F	Reserved	100 % at 140°F
Reserved HDS for water at 73°F	630	...	800	...

(5) A digit “4” is reserved for future application.

(6) A digit “5” indicates that the PEX pipe has been tested and meets the requirement for minimum chlorine resistance at end use conditions of 100% of the time at 140°F

3.9.2 *Discussion*—The second digit is a “0”. This digit is reserved for a currently unspecified PEX pipe property.

3.9.3 *Discussion*—The last two digits are the hydrostatic design stress for water at 73°F (23°C) in units of 100 psi with any decimal figures dropped. Where the hydrostatic design stress code contains less than two figures, a zero is used before the number. Thus, a complete material designation code for PEX pipe shall consist of the three letters “PEX” and four digits.

4. Pipe Classification

4.1 *General*—This specification covers one PEX pipe material having pressure ratings for water at three temperatures. The pressure ratings decrease as the temperature is increased.

4.2 *Standard Dimension Ratio (SDR)*—This specification covers PEX pipe in various standard dimension ratios and dimension ratios for nominal diameters 16 mm (½ in) and larger. The pressure ratings are uniform for all nominal pipe sizes with the same DR or SDR.

5. Materials

5.1 *General*—Crosslinked polyethylene pipe, meeting the requirements of this specification, are primarily defined by

means of three criteria, namely, (1) nominal density, (2) degree of crosslinking, and (3) long-term strength tests. There is a strong correlation between nominal density and results of short-term strength tests.

NOTE 2—PEX pipe intended for use in the transport of potable water should be evaluated and certified as safe for this purpose by a testing agency acceptable to the local health authority. The evaluation should be in accordance with requirements for chemical extraction, taste, and odor that are no less restrictive than those included in **NSF/ANSI 14**. The seal or mark of the laboratory making the evaluation should be included on the pipe.

5.2 *Basic Materials*—PEX pipe shall be made from polyethylene compounds which have been crosslinked by peroxides, Azo compounds, or silane compounds in extrusion, or by electron beam after extrusion, or by other means such that the pipe meets the performance requirements of Section 6. For the use temperatures that the pipe will be marked for, the materials, procedure for mixing, and the process for crosslinking shall result in a product with long term hydrostatic stress ratings equal better than those shown in **Table 2**, when determined in accordance with procedures no less restrictive than those of **PPI TR-3⁹**. See **Appendix X1** for additional information on PPI hydrostatic stress ratings.

NOTE 3—Pipe produced by crosslinking by peroxides, Azo compounds, or silane compounds in extrusion, or by electron beam after extrusion have met the requirements of Section 6. There are several other processes for producing crosslinked polyethylene pipe. However, each process must be established as meeting the requirements of this specification.

TABLE 2 Material Designation Code Cells

DR/SDR	Rated Temperature		Hydrostatic Design Stress		Pressure Rating for Water	
	°F	°C	psi	MPa	Psig	MPa
DR 6	73.4	23	630	4.34	210	1.45
	180	82.2	400	2.76	160	1.10
	200	93.3	315	2.17	125	0.86
DR 7.4	73.4	23	630	4.34	200	1.60
	180	82.2	400	2.76	125	0.86
	200	93.3	315	2.17	100	0.69
SDR 9	73.4	23	630	4.34	160	1.10
	180	82.2	400	2.76	100	0.69
	200	93.3	315	2.17	80	0.55
SDR 11	73.4	23	630	4.34	125	0.86
	180	82.2	400	2.76	80	0.55
	200	93.3	315	2.17	60	0.41
DR 13.6	73.4	23	630	4.34	100	0.69
	180	82.2	400	2.76	60	0.41
	200	93.3	315	2.17	50	0.35
DR 16.2	73.4	23	630	4.34	41	0.28
	180	82.2	400	2.76	26	0.18
	200	93.3	315	2.17	21	0.14
SDR 17	73.4	23	630	4.34	80	0.55
	180	82.2	400	2.76	50	0.35
	200	93.3	315	2.17	40	0.28

5.3 *Pipe Material Designation*—The pipe meeting the requirements of this specification shall be designated PEX.

6. Requirements

6.1 *Workmanship*—The pipe shall be homogeneous throughout and free of visible cracks, holes, foreign inclusions, or other defects. The pipe shall be as uniform as commercially practicable in color, opacity, density, and other physical properties.

6.2 *Out-of Roundness*—The maximum out-of roundness requirements, shown in Table 3 for pipe, apply to the average, measured diameter after rounding with a rounding tool recommended by the manufacturer.

6.3 Dimensions and Tolerances:

6.3.1 *Outside Diameters*—The outside diameters and tolerances shall be as shown in Table 3, when measured in accordance with 7.4 and 7.4.1.

6.3.2 *Wall Thickness*—The wall thickness and tolerances shall be as shown in Table 4, when measured in accordance with 7.4 and 7.4.2.

NOTE 4—Pipe diameters less than 25 mm (1 in.) diameter have minimum wall thicknesses based on both hydrostatic and mechanical strength.

6.4 *Density*—When determined in accordance with 7.5, the crosslinked polyethylene pipe material shall have a minimum density of 0.926 Mg/m³.

6.5 *Hydrostatic Sustained Pressure Strength*—The pipe shall not fail, balloon, burst, or weep as defined in Test Method D1598, at the test pressures shown in Table 5 when tested in accordance with 7.6. The test pressure is based on the formula:

$$P \text{ (test pressure)} = 2 \text{ (fiber stress)} / [(average \text{ OD/minimum wall}) - 1]$$

. For most of the pipe sizes, average OD/minimum wall is the DR or SDR. For the smaller pipe sizes, the calculated value is slightly lower than the DR or SDR value, and this will result in a slightly higher test pressure, as seen in Table 5. The fiber stress values are provided in Table 5 for the three temperatures.

6.6 *Hydrostatic Burst Pressure*—The minimum burst pressure for PEX plastic pipe shall be as shown in Table 6, when determined in accordance with 7.7. The minimum burst pressure is based on the formula:

$$P \text{ (burst pressure)} = 2 \text{ (fiber stress)} / [(average \text{ OD/minimum wall}) - 1]$$

For most of the pipe sizes, average OD/minimum wall is the DR or SDR. For the smaller pipe sizes, the calculated value is slightly lower than the DR or SDR value, and this will result in a slightly higher burst pressure, as seen in Table 1. The fiber stress values are provided in Table 1 for the three temperatures.

6.7 *Environmental Stress Cracking*—There shall be no loss of pressure in the pipe, when tested in accordance with 7.8.

6.8 *Degree of Crosslinking*—When tested in accordance with 7.9, the degree of crosslinking for PEX pipe material shall be within the range from 65 to 89 % inclusive. Depending on the process used, the following minimum percentage crosslinking values shall be achieved: 70 % by peroxides, 65 % by Azo compounds, 65 % by electron beam, or 65 % by silane compounds.

NOTE 5—Techniques as found in Test Methods D2765.

6.9 *Stabilizer Functionality*—Stabilizer Functionality shall be tested in accordance with 7.10.

NOTE 6—For example PEX pipe marked with the material designation code PEX 1006 is a PEX pipe meeting the chlorine resistance requirement for 25% of the time at 140°F and 75% of the time at 73°F and having an HDS for water at 73°F of 630psi (HDB of 1250 psi) as follows:

ASTM F2788-09

<https://standards.iteh.ai/catalog/standards/astm-f2788-09> **TABLE 3 Outside Diameters and Tolerances for PEX Pipe** [lb1 fd4d2/astm-f2788-09](https://standards.iteh.ai/catalog/standards/astm-f2788-09)

Nominal Pipe Size		Average Outside Diameter	Tolerances for Average Diameter	Out-of-Roundness ^A
mm	in.	mm	mm	mm
16	(1/2)	16.15	±0.15	1.2
20	(3/4)	20.15	±0.15	1.2
25	(1)	25.15	±0.15	1.2
32	(1 1/4)	32.15	±0.15	1.3
40	(1 1/2)	40.20	±0.20	1.4
50	(2)	50.20	±0.20	1.4
63	(2 1/2)	63.20	±0.20	1.5
75	(3)	75.25	±0.25	1.6
90	(3 1/2)	90.30	±0.30	1.8
110	(4)	110.35	±0.35	2.2
125	(5)	125.40	±0.40	2.5
140	(5 1/2)	140.45	±0.45	2.8
160	(6)	160.50	±0.50	3.2
180	(7)	180.55	±0.55	3.6
200	(8)	200.60	±0.60	4.0
225	(9)	225.70	±0.70	4.5
250	(10)	250.75	±0.75	5.0
280	(11)	280.85	±0.85	9.8
315	(12)	315.95	±0.95	11.1
355	(14)	356.10	±1.10	12.5
400	(16)	410.20	±1.20	14.0
450	(18)	451.35	±1.35	15.6
500	(20)	501.50	±1.50	17.5
560	(22)	561.70	±1.70	19.6
630	(25)	631.90	±1.90	22.1

^A The Out-of-Roundness specification applies only to pipe prior to coiling.

TABLE 4 Wall Thickness and Tolerances for PEX Plastic Pipe (mm)

Nominal Size	Pipe DR/SDR													
	DR 6		DR 7.4		SDR 9		SDR 11		DR 13.6		DR 16.2		SDR 17	
	Wall Thickness (t), mm													
mm (in)	min	max	min	max	min	max	min	max	min	max	min	max	min	max
16 (1/2)	3.0	3.4	2.3	2.7	2.0	2.3
20 (3/4)	3.4	3.9	3.0	3.4	2.3	2.7	2.0	2.3
25 (1)	5.4	4.8	3.5	4.0	3.0	3.4	2.3	2.7	2.0	2.3
32 (1-1/4)	5.4	6.1	4.4	5.0	3.6	4.1	3.0	3.4	2.4	2.8	2.0	2.4	2.0	2.3
40 (1-1/2)	6.7	7.5	5.5	6.2	4.5	5.1	3.7	4.2	3.0	3.5	2.5	2.9	2.4	2.8
50(2)	8.3	9.3	6.9	7.7	5.6	6.3	4.6	5.2	3.7	4.2	3.1	3.6	3.0	3.4
63 (2-1/2)	10.5	11.7	8.6	9.6	7.1	8.0	5.8	6.5	4.7	5.3	3.9	4.4	3.8	4.3
75 (3)	12.5	13.9	10.3	11.5	8.4	9.4	6.8	7.6	5.6	6.3	4.6	5.2	4.5	5.1
90 (3-1/2)	15.0	16.7	12.3	13.7	10.1	11.3	8.2	9.2	6.7	7.5	5.6	6.3	5.4	6.1
110 (4)	18.3	20.3	15.1	16.8	12.3	13.7	10.0	12.7	8.1	9.1	7.7	8.6	6.6	7.4
125 (5)	20.8	23.0	17.1	19.0	14.0	15.6	11.4	12.7	9.2	10.3	7.7	8.6	7.4	8.3
140 (5-1/2)	23.3	25.8	19.2	21.3	15.7	17.4	12.7	14.1	10.3	11.5	8.7	9.7	8.3	9.3
160 (6)	26.6	29.4	21.9	24.2	17.9	19.8	14.6	16.2	11.8	13.1	9.9	11.0	9.5	10.6
180 (7)	29.9	33.0	24.6	27.2	20.1	22.3	16.4	18.2	13.3	14.8	11.1	12.4	10.7	11.9
200 (8)	33.2	36.7	27.4	30.3	22.4	24.8	18.2	20.2	14.7	16.3	12.4	13.8	11.9	13.2
225 (9)	37.4	41.3	30.8	34.0	25.2	27.9	20.5	22.7	16.6	18.4	13.9	15.4	13.4	14.9
250 (10)	41.5	45.8	34.2	37.8	27.9	30.8	22.7	25.1	18.4	20.4	15.5	17.1	14.8	16.4
280 (11)	46.5	51.3	38.3	42.3	31.3	34.6	25.4	28.1	20.6	22.8	17.3	19.2	16.6	18.4
315 (12)	52.3	57.7	43.1	47.6	35.2	38.9	28.6	31.6	23.2	25.7	19.5	21.6	18.7	20.7
355 (14)	59.0	65.0	48.5	53.5	39.7	43.8	32.2	35.6	26.1	28.9	21.9	24.2	21.1	23.4
400 (16)	54.7	60.3	44.7	49.3	36.3	40.1	29.4	32.5	24.7	27.3	26.2	23.7
450 (18)	61.5	67.8	50.3	55.5	40.9	45.1	33.1	36.6	27.8	30.7	26.7	29.5
500 (20)	55.8	61.5	45.4	50.1	36.8	40.6	30.9	34.1	29.7	32.8
560 (22)	62.5	68.9	50.8	56.0	41.2	45.5	34.6	38.2	33.2	36.7
630 (25)	70.3	77.5	57.2	63.1	46.3	51.1	38.9	42.9	37.4	41.3

TABLE 5 Minimum Hydrostatic Sustained Pressure Requirements for PEX SDR 9 Pipe (For other DRs or SDRs use fiber stress values below to determine the pressure) P (pressure) = 2 (fiber stress)/ [(average OD/ minimum wall)-1]

Nominal Size		Pressure Required for Test, psi ^A (MPa)					
mm	in.	73.4°F (23°C)	180°F (82.2°C)	200°F (93.3°C)			
18	(1/2)	370 (2.55)	220 (1.52)	185 (1.28)			
20	(3/4)	340 (2.34)	200 (1.38)	170 (1.17)			
25	(1)	350 (2.41)	210 (1.45)	175 (1.21)			
32	(1 1/4)	330 (2.28)	195 (1.34)	165 (1.14)			
40 and larger	(1 1/2 and larger)	325 (2.24)	190 (1.31)	165 (1.14)			

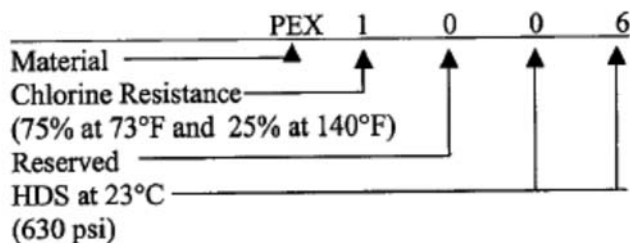
^A The fiber stresses used to derive these test pressures are:
at 73.4°F (23.0°C) 1300 psi (8.96 MPa).
at 180°F (82.2°C) 770 psi (5.31 MPa).
at 200°F (93.3°C) 650 psi (4.48 MPa).

TABLE 6 Burst Pressure Requirements for Water at Different Temperatures for PEX SDR 9 Plastic Pipe

Nominal Size		Minimum Burst Pressures at Different Temperatures, psi ^A (MPa)					
mm	in.	73.4°F (23°C)	180°F (82.2°C)	200°F (93.3°C)			
16	(1/2)	540 (3.72)	240 (1.65)	205 (1.41)			
20	(3/4)	500 (3.45)	220 (1.52)	190 (1.31)			
25	(1)	510 (3.52)	230 (1.59)	195 (1.34)			
32	(1 1/4)	480 (3.31)	215 (1.48)	185 (1.28)			
40 and larger	(1 1/2 and larger)	475 (3.27)	210 (1.45)	180 (1.24)			

^A The fiber stresses used to derive these test pressures are:
at 73.4°F (23.0°C) 1900 psi (13.10 MPa).
at 180°F (82.2°C) 850 psi (5.86 MPa).
at 200°F (93.3°C) 720 psi (4.96 MPa).

6.10 *Oxidative Stability in Potable Chlorinated Water Applications*—PEX pipe intended for use in the transport of potable water shall have a minimum extrapolated time-to-time failure of 50 years when tested and evaluated in accordance with 7.11.



6.11 *Bent Pipe Hydrostatic Sustained Pressure Strength* :

6.11.1 *General*—PEX pipe, up to and including 25 mm (1 in.) nominal diameter, shall meet 6.11.2 and 6.11.3.

NOTE 7—PEX pipe, larger than 25 mm (1 in.) nominal diameter, is typically installed as main distribution lines and is installed in straight runs. Fittings are used when a change in direction of 90° or greater and a bend radius of 6 times the outside diameter is needed. The test procedures in 6.11.2 and 6.11.3 are intended to evaluate PEX pipe installed in tight bend applications in accordance with the procedures in X3.2.4 and X3.2.5. This application applies to pipe up to and including 1 in nominal diameter only.

6.11.2 Hot-bent pipe, with a radius of 2.5 times the outside diameter and consisting of a continuous bend length inducing not less than 90° angle, shall meet the minimum hydrostatic sustained pressure strength requirements for 180°F as shown in Table 5 when tested in accordance with 7.6. The bend length and bend angle is kept throughout the testing period by rigid supports immediately outside the bend.

6.11.3 Cold-bent pipe, with a radius of 6 times the outside diameter and consisting of a continuous bend length inducing not less than 90° angle, shall meet the minimum hydrostatic sustained pressure strength requirements for 180°F as shown in Table 5 when tested in accordance with 7.6. The bend length and bend angle is kept throughout the testing period by rigid secures immediately outside the bend.

6.12 *Excessive Temperature—Pressure Capacity*:

6.12.1 *General*—In the event of a water heating system malfunction, PEX pipe shall have adequate strength to accommodate short-term conditions, 48 h of 210°F (99°C). 150 psi (1034 kPa) until repairs can be made.

6.12.2 *Excessive Temperature Hydrostatic Sustained Pressure*—Pipe shall not fail as defined in Test Method D1598 in less than 30 days (720 h) when tested in accordance with 7.12.

7. Test Methods

7.1 *Conditioning*—Condition the specimens at $73.4 \pm 3.6^\circ\text{F}$ ($23 \pm 2^\circ\text{C}$) and $50 \pm 5\%$ relative humidity for not less than 40 h prior to test in accordance with Procedure A of Practice D618, for those tests where conditioning is required. In cases of disagreement, the tolerances shall be $\pm 1.8^\circ\text{F}$ ($\pm 1^\circ\text{C}$) and $\pm 2\%$ relative humidity.

7.2 *Test Conditions*—Conduct the test in the standard laboratory atmosphere of $73.4 \pm 3.6^\circ\text{F}$ ($23 \pm 2^\circ\text{C}$) and $50 \pm 5\%$

relative humidity, unless otherwise specified in the test methods or in this specification. In cases of disagreement, the tolerances shall be $\pm 1.8^\circ\text{F}$ ($\pm 1^\circ\text{C}$) and $\pm 2\%$ relative humidity.

7.3 *Sampling*—A sufficient quantity of pipe, as agreed upon by the purchaser and the seller, shall be selected and tested to determine conformance with this specification (see Practice D1898). In the case of no prior agreement, random samples selected by the testing laboratory shall be deemed adequate.

7.3.1 *Test Specimens*—Not less than 50 % of the test specimens required for any pressure test shall have at least a part of the marking in their central sections. The central section is that portion of pipe that is at least one pipe diameter away from an end closure.

7.4 *Dimensions and Tolerances*—Use any length of pipe to determine the dimensions. Measure in accordance with Test Method D2122.

7.4.1 *Outside Diameter*—Measure the outside diameter of the pipe in accordance with Test Method D2122. The referee method of measurement is to be by circumferential wrap tape. The tolerance for out-of-roundness shall apply only to pipe prior to shipment. Averaging micrometer or vernier caliper measurements, four (4) maximum and minimum diameter measurements at any cross section, may be used for quality control checks if desired.

7.4.2 *Wall Thickness*—Make micrometer measurements of the wall thickness in accordance with Test Method D2122 to determine the maximum and minimum values. Measure the wall thickness at both ends of the pipe to the nearest 0.001 in. (0.025 mm).

7.5 *Density*—Determine the density of the pipe compound in accordance with Test Method D1505, or Test Methods D792, using three specimens.

7.6 *Hydrostatic Sustained Pressure Test*— Select the test specimens at random. Test individually with water at the three controlled temperatures and under the pressures given in Table 5, 18 specimens of pipe, each specimen at least ten times the nominal diameter in length, but not less than 10 in. (25.4 cm) or more than 3 ft (91.4 cm) between end closures and containing the permanent marking on the pipe. Test six specimens at each temperature. Condition the specimens for at least 2 h to within $\pm 3.6^\circ\text{F}$ ($\pm 2^\circ\text{C}$) of the specified test temperatures. Maintain the specimens at the pressures indicated for the appropriate temperatures for a period of 1000 h. Hold the pressure as closely as possible, but within ± 10 psi (± 0.070 MPa). Maintain the test temperatures within $\pm 3.6^\circ\text{F}$ ($\pm 2^\circ\text{C}$) of the specified temperature. Test in accordance with Test Method D1598 except maintain the pressure at the values given in Table 5 for 1000 h. Failure of two of the six specimens tested at either temperature constitutes failure in the test. Failure of one of six specimens tested at either temperature is cause for retest of six additional specimens at that temperature. Failure of one of six specimens tested at either temperature in retest constitutes failure in the test. Failure of the pipe shall be defined in accordance with Test Method D1598, namely:

7.6.1 *Failure*—Any continuous loss of pressure resulting from the transmission of the test liquid through the body of the specimen under test.