



Standard Specification for Rubber Gaskets for Cast Iron Soil Pipe and Fittings¹

This standard is issued under the fixed designation C564; 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 preformed rubber gaskets used to seal joints in cast iron soil pipe and fittings.

1.2 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.

1.3 The following safety hazards caveat pertains only to the test methods section 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.*

1.4 The committee with jurisdiction over this standard is not aware of another comparable standard for materials covered in this standard.

2. Referenced Documents

2.1 ASTM Standards:²

A644 [Terminology Relating to Iron Castings](#)

C1277 [Specification for Shielded Couplings Joining Hubless Cast Iron Soil Pipe and Fittings](#)

D395 [Test Methods for Rubber Property Compression Set](#)

D412 [Test Methods for Vulcanized Rubber and Thermoplastic Elastomers Tension](#)

D471 [Test Method for Rubber Property Effect of Liquids](#)

D573 [Test Method for Rubber Deterioration in an Air Oven](#)

D624 [Test Method for Tear Strength of Conventional Vulcanized Rubber and Thermoplastic Elastomers](#)

D1149 [Test Methods for Rubber Deterioration Cracking in an Ozone Controlled Environment](#)

D1415 [Test Method for Rubber Property International Hardness](#)

D2240 [Test Method for Rubber Property Durometer Hardness—Durometer Hardness](#)

D3677 [Test Methods for Rubber Identification by Infrared Spectrophotometry](#)

2.2 Other Documents

RMA [Class 3 Dimensional Tolerances, RMA Manual](#)³

CISPI 310 [Specification for couplings for use in connection with hubless cast iron soil pipe and fittings for sanitary and storm drain, waste, and vent piping applications](#)

3. Terminology

3.1 *Definitions*—For definitions of terms in this standard see Terminology A644.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *flash*—the excess material protruding from the surface of a molded article at the mold junction.

3.2.2 *virgin rubber, n*—a term that may be used interchangeably with raw rubber (raw thermoset elastomer). A rubber or thermoset elastomer that has not had any additional work, diluents incorporated, processes performed on it, or any combination thereof. A rubber that is in an unmodified state or one in which no attempt has been made to alter it in any fashion as received from the manufacturer or supplier.

3.2.3 *manufacturer, n*—the entity that molds the gaskets covered by this standard.

¹ This specification is under the jurisdiction of ASTM Committee A04 on Iron Castings and is the direct responsibility of Subcommittee A04.75 on Gaskets and Coupling for Plumbing and Sewer Piping.

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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 Rubber Manufacturer's Association, 1400 K Street NW, No. 900, Washington, DC 20005 – 2455, http://www.rma.org.

4. Materials and Manufacture

4.1 Gaskets shall be made of a properly vulcanized virgin compound containing virgin rubber as the sole elastomer with no scrap or reclaim.

~~5. Physical Requirements~~ Physical Requirements

4.2 Gaskets manufactured for use in couplings complying with Specification C1277 or CISPI 310 shall be manufactured from a properly vulcanized virgin compound in which the primary elastomer is polychloroprene (neoprene). The gaskets shall be tested in accordance with Test Methods D3677.

5. Physical Requirements

5.1 Sample gaskets selected as specified in Section 8 shall conform to the requirements for physical properties listed in Table 1 when tested in accordance with the methods specified in Section 9.

6. Dimensions and Permissible Variations

6.1 Gaskets shall conform to the dimensions specified by the manufacturer.

6.2 All cross-sectional dimensions shall have an RMA Class 3 tolerance as shown in Annex A1, and all diametral dimensions shall have a tolerance of ± 1 percent.

7. Workmanship

7.1 The surface of the gasket shall be smooth and free of pitting, cracks, blisters, air marks, and any other imperfections that will affect its behavior in service. The body of the gasket shall be free of porosity and air pockets.

7.2 Neither the flash thickness nor the flash extension shall exceed $\frac{1}{32}$ in. (0.8 mm), at any point on the sealing ring.

7.3 The offset, or failure of the mold to register accurately, shall not exceed $\frac{1}{64}$ in. (0.4 mm).

8. Sampling

8.1 For each of the tests, gaskets shall be selected at random and tests be performed by the method and frequency of the tests as specified in Section 9.

9. Test Methods

9.1 *Hardness*—The gasket material shall be tested for hardness in accordance with ASTM Test Method D2240. Test Method D1415 shall be used as the referee method. Hardness measurements shall be made on specimens prepared in accordance with 9.2. However, hardness readings for guidance purposes shall be permitted to be taken directly on the gasket, recognizing that these readings may vary slightly from those taken on the dumb-bell specimens. Tests shall be performed during the day of production not to exceed a 24-h period for each size and type gasket produced during that period.

9.2 *Elongation and Tensile Strength*—The gasket material shall be tested for elongation and tensile strength in accordance with Test Methods D412. Standard ASTM Type C dumb-bell specimens conforming to Fig. 1 (Apparatus for Tensile Set Test) of Test Methods D412 shall be cut from a section of the gasket for this test. To obtain a uniform thickness, these gasket sections shall be permitted to be buffed prior to cutting into dumb-bell specimens, so as to produce a finely ground surface without cuts or burns. Tests shall be performed during the day of production not to exceed a 24-h period for each size and type gasket produced during that period.

9.3 *Tear Strength*— The gasket material shall be tested for tear strength in accordance with Test Method D624 using Die C. Tests shall be performed during the day of production not to exceed a 24-h period for each size and type gasket produced during that period.

TABLE 1 Physical Requirements of Gaskets

Property	Requirements			ASTM Test Method
Hardness (nominal durometer ± 5) as specified by the pipe manufacturer	50	60	70	D2240
Elongation, min, %	350	300	250	D412
Tensile strength, min, psi	1500	1500	1500	D412
(MPa)	(10)	(10)	(10)	
Tear strength, min, lbf/in.	150	150	150	
(N/cm)	(268)	(268)	(268)	D624
Compression set, max, %	25	25	25	D395
Heat aging, 96 h at $158 \pm 2^\circ\text{F}$ ($70 \pm 1^\circ\text{C}$):				D573
Hardness increase, max, durometer points	10	10	10	...
Loss in tensile strength, max, %	15	15	15	...
Loss in elongation, max, %	20	20	20	...
Water absorption:				D471
Weight increase, max, %	20	20	20	...
Ozone resistance	no cracks	no cracks	no cracks	D1149
Oil immersion:				
Volume increase, max, %	80	80	80	D471