



Designation: C1639 – 10a

Standard Specification for Fabrication Of Cellular Glass Pipe And Tubing Insulation¹

This standard is issued under the fixed designation C1639; 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 reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

1. Scope

1.1 This specification covers fabrication techniques for cellular glass block into billets to fabricate pipe and tubing insulation. All materials shall be in accordance with Specification C552.

1.2 The purpose of this specification is to optimize the thermal performance of installed cellular glass insulation systems. This is best achieved by limiting the number of joints, in particular through joints.

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 *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

- C168 Terminology Relating to Thermal Insulation
- C450 Practice for Fabrication of Thermal Insulating Fitting Covers for NPS Piping, and Vessel Lagging
- C552 Specification for Cellular Glass Thermal Insulation
- C585 Practice for Inner and Outer Diameters of Thermal Insulation for Nominal Sizes of Pipe and Tubing
- D312 Specification for Asphalt Used in Roofing

2.2 ASTM Adjuncts:³

- ADJC0450A ASTM Recommended Dimensional Standards for Fabrication of Thermal Insulation Fitting Covers

¹ This specification is under the jurisdiction of ASTM Committee C16 on Thermal Insulation and is the direct responsibility of Subcommittee C16.40 on Insulation Systems.

Current edition approved Sept. 1, 2010. Published September 2010. Originally approved in 2007. Last previous version approved in 2010 as C1639-10. DOI: 10.1520/C1639-10A.

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 ASTM International Headquarters. Order Adjunct No. ADJC0450A.

3. Terminology

3.1 Terminology C168 shall be considered as applying to the terms in this specification.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *billet / bun*—a single piece of insulation made up from a number of smaller blocks held together with an adhesive.

3.2.2 *lags*—pieces of insulation typically curved or tapered used for insulating pipes, tanks and other cylindrical equipment.

3.2.3 *precision cut V-grooved pipe insulation, n*—rigid insulation pieces cut into 4-sided polygons, of two parallel surfaces and two non-parallel surfaces of equal angles = $180^\circ / N$, such that when N number of these sections are assembled, they form an approximate circle and can be installed around a pipe.

3.2.3.1 *Discussion*—the adjective precision refers to the fact that when these N sections are installed onto a pipe, they fit exactly with no appreciable gaps between sections.

4. Classification

4.1 Specification C552 defines Type I and Type II materials. The same classifications shall be used in this standard.

5. Workmanship, Finish, and Appearance

5.1 The insulation shall have no visible defects that will adversely affect its performance.

6. Standard Sizes, Dimensions, and Fabrication Configurations of Cellular Glass Pipe and Tubing Insulation

6.1 Cellular glass pipe and tubing insulation shall be fabricated in lengths as agreed to by the purchaser and the supplier. Typical lengths are 23½-in. (597mm), 24 in. (610 mm), or 36 in. (914 mm).

6.2 Cellular glass pipe and tubing insulation for NPS 4 (102 mm) and smaller pipe shall be made to a minimum thickness of 1-in. (25 mm). Pipe insulation for pipes larger than 4 in. NPS (102 mm) shall be made to a minimum 1½-in. (38 mm) thickness. Sizes shall conform to Practice C585. A minimum 2 in. (51 mm) thickness should be used for pipe sizes larger than 12 in. NPS (324 mm).

6.3 Cellular glass pipe insulation must be provided in half sections for up to and including 12 in. NPS (324 mm). Half sections shall consist of hollow cylindrical sections split lengthwise in a plane that includes the cylindrical axis.

6.4 Cellular glass pipe insulation for pipe sizes 14 in. (356 mm) to 24 in. NPS (406 mm) must be fabricated in half-sections or in quarter-sections. At 26 in. NPS (660 mm) and above, segmented pipe insulation shall be furnished. Segmented pipe insulation (see Fig. 1) shall be fabricated in equal widths such that no additional field cuts are required.

6.5 For operating temperatures above ambient, precision cut V-grooved pipe insulation, as shown on Fig. 2 specifically cut to fit the required diameter or segmented fabrication is an acceptable alternative.

7. Dimensional Tolerances

7.1 Fabrication tolerances for the bore diameter and wall thickness shall be as specified in Practice C585.

7.2 Tolerance for length of pipe and tubing insulation shall be $\pm 1/4$ in. (± 3.2 mm).

7.3 The following dimensional tolerances apply only to cellular glass pipe and tubing insulation applied in half sections:

7.3.1 *Fit and Closure*—When fitted to the appropriate size pipe by banding on 9 in. (230 mm) centers, the longitudinal joints on both sides of the pipe insulation shall close to within $1/16$ in. (1.6 mm) along the entire length of the section.

7.3.2 *Concentricity*—The inner bore of the pipe insulation shall be concentric with the outer cylindrical surface. Deviation from concentricity shall not exceed $1/8$ in. (3.2 mm) or 5% of the wall thickness, whichever is greater, at all points.

7.3.3 *Half-Section Balance*—the plane formed by the slit between half sections shall include the cylindrical axis. Deviation of the split plane from the cylindrical axis over a 24-in. (610-mm) length shall not exceed $1/8$ in. (3.2 mm).

8. Fabrication Standards

8.1 Cellular glass pipe and tubing insulation shall be fabricated from the minimum number of insulation blocks. Sectional pipe insulation shall contain not more than four "through" joints per full section of insulation, excluding the half section mating plane (Fig. 3). Precision cut v-groove fabrication is an exception.

8.2 Fabrication adhesive shall be hot asphalt, Specification D312, Type II, III, or IV, for operating temperatures below 250°F (121°C). For operating temperatures above ambient, fabrication adhesive shall include but not be limited to Type II hot asphalt, elastomeric asphalt, or gypsum-based cement of the type and grade specified by the insulation manufacturer. Adhesives shall be suitable for specified design conditions.

8.2.1 Fabricating adhesive shall be applied such that there is 100% coverage of adhesive on the mating surfaces.

8.2.2 There shall be no visible voids in the adhered joint nor shall any adhered joint exceed $1/16$ in. (1.6 mm) in width.

8.3 Billet and miter construction shall conform to the following:

8.3.1 Insulation blocks or sections shall be hand rubbed if necessary to fit prior to bonding.

8.3.2 Bond joints shall be made with a full depth of approved adhesive. (See 3.2.1.)

8.4 *Bond Joints for Segmented Fabrication*—Bond joints are defined as an adhesive joint in insulation for construction purposes:

8.4.1 Are "Non-through" - start at the outside circumference and run continuously in a straight line to the opposite side terminating at the outside circumference, or;

8.4.2 Are "through" start at the outside circumference and runs continuously in a straight line to the opposite side and terminates at the inside circumference (See Fig. 3 and Fig. 4)

8.4.3 Bond joints shall be no greater than $1/16$ in. (1.6mm) thick.

8.4.4 Fabricated sections of insulation shall be a minimum of $1/2$ in. (12.7mm) thick. (See Fig. 3 and Fig. 4)

8.4.5 Bond joints on the inside and outside diameter of fabricated pieces shall be smooth and consistent with the shape of the fabricated pieces. Care shall be taken that adhesive is not recessed or extended from the dimension of the fabricated more than $1/32$ in. (0.8mm).

8.4.6 Bond joints which meet other bond joints must meet at 90° angles, must be a minimum of 1 in. (25.4mm) in length and shall not cross. (Fig. 4)

8.4.7 There shall be a maximum of two bond joints per half section or sidewall segment. (See Fig. 3 and Fig. 4).

8.4.8 For pipe insulation that is designed for pipe sizes 6 in. (152 mm) and under, there shall not be more than one fabrication joint per half section.

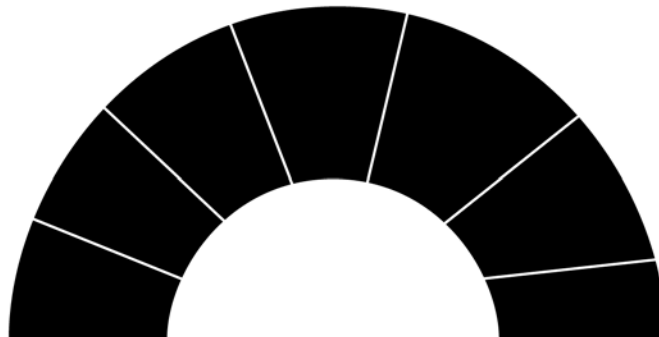


FIG. 1 Circular Cut Segmented Pipe Insulation