



Standard Specification for 2 to 60 inch [50 to 1500 mm] Annular Corrugated Profile Wall Polyethylene (PE) Pipe and Fittings for Land Drainage Applications¹

This standard is issued under the fixed designation F2648/F2648M; 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 annular corrugated profile wall polyethylene pipe and fittings with an interior liner. The inside diameters covered are 2 to 60 in. [50 to 1500 mm].

1.2 The requirements of this specification are intended to provide non-pressure (gravity flow) pipe and fittings suitable for underground use for subsurface and land drainage systems, which do not operate under surcharge pressure heads.

NOTE 1—Pipe and fittings produced in accordance with this specification are to be installed in compliance with Practice D2321 or Practice F449 based on diameter limitations within the respective standards.

NOTE 2—Subsurface and land drainage systems pertain principally to non-municipal or private facilities for water table control, storm drainage and agricultural drainage applications. The products supplied under this specification are not intended for any sanitary sewer or municipal storm sewer applications.

1.3 This specification covers pipe and fittings with an interior liner using an annular exterior corrugated profile (Fig. 1).

1.4 This specification permits the use of recycled materials for pipe in accordance with the requirements in Section 5.

1.5 *Units*—The values stated in either inch-pound units or SI units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

1.6 *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*

appropriate 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

D1600 Terminology for Abbreviated Terms Relating to Plastics

D2122 Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings

D2321 Practice for Underground Installation of Thermoplastic Pipe for Sewers and Other Gravity-Flow Applications

D2412 Test Method for Determination of External Loading Characteristics of Plastic Pipe by Parallel-Plate Loading

D2444 Test Method for Determination of the Impact Resistance of Thermoplastic Pipe and Fittings by Means of a Tup (Falling Weight)

D3350 Specification for Polyethylene Plastics Pipe and Fittings Materials

D4218 Test Method for Determination of Carbon Black Content in Polyethylene Compounds By the Muffle-Furnace Technique

D5630 Test Method for Ash Content in Plastics

D7209 Guide for Waste Reduction, Resource Recovery, and Use of Recycled Polymeric Materials and Products

D7399 Test Method for Determination of the Amount of Polypropylene (PP) in Polypropylene/LDPE Mixtures Using Infrared Spectrophotometer (FTIR)

F412 Terminology Relating to Plastic Piping Systems

F449 Practice for Subsurface Installation of Corrugated Polyethylene Pipe for Agricultural Drainage or Water Table Control

F2136 Test Method for Notched, Constant Ligament-Stress

¹ This specification is under the jurisdiction of ASTM Committee F17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.65 on Land Drainage.

Current edition approved Aug. 1, 2011. Published August 2011. Originally approved in 2007. Last previous edition approved in 2010 as F2648/F2648M-10. DOI: 10.1520/F2648_F2648M-11.

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.

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

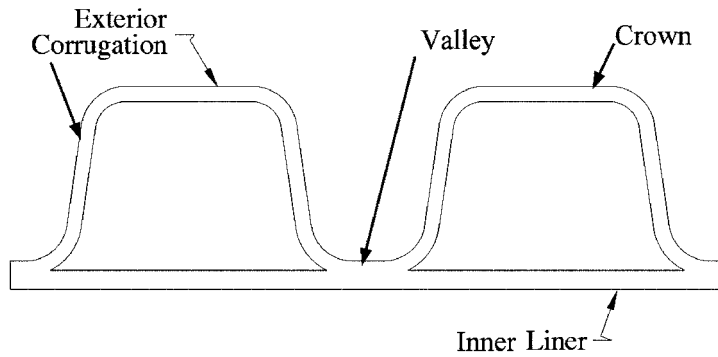


FIG. 1 Annular Corrugated Profile Wall Polyethylene Pipe with Interior Liner

TABLE 1 Pipe Stiffness and Pipe Dimensions

Pipe Inside Diameter ^A		Minimum Pipe Stiffness at 5% Deflection		Minimum Inner Liner Thickness	
inch	[mm]	lb/in/in	[kPa]	Inch	[mm]
2	[50]	50	[345]	0.020	[0.5]
3	[75]	50	[345]	0.020	[0.5]
4	[100]	50	[345]	0.020	[0.5]
6	[150]	50	[345]	0.020	[0.5]
8	[200]	50	[345]	0.024	[0.6]
10	[250]	50	[345]	0.024	[0.6]
12	[300]	50	[345]	0.035	[0.9]
15	[375]	42	[290]	0.040	[1.0]
18	[450]	40	[275]	0.051	[1.3]
21	[525]	38	[260]	0.060	[1.5]
24	[600]	34	[235]	0.060	[1.5]
27	[675]	30	[205]	0.060	[1.5]
30	[750]	28	[195]	0.060	[1.5]
36	[900]	22	[150]	0.067	[1.7]
42	[1050]	20	[140]	0.071	[1.8]
48	[1200]	18	[125]	0.071	[1.8]
54	[1350]	16	[110]	0.079	[2.0]
60	[1500]	14	[97]	0.079	[2.0]

^AInside Diameters for metric (SI) sizes are in direct Imperial equivalent dimensions

ASTM F2648/F2648M-11

<https://www.astm.org/standards/F2648> (NCLS) Test to Determine Slow-Crack-Growth Resistance of HDPE Resins or HDPE Corrugated Pipe

2.2 American Association of Highway and Transportation Officials³

(AASHTO) AASHTO LRFD Bridge Design Specifications

2.3 Federal Standards:⁴

Fed. Stds. No. 123 Marking for Shipment (Civil Agencies)

2.4 Military Standard:⁵

MIL-STD-129 Marking for Shipment and Storage

3. Terminology

3.1 Definitions are in accordance with Terminology F412 and abbreviations are in accordance with Terminology D1600, unless otherwise specified. The abbreviation for polyethylene is PE.

³ Available from American Association of State Highway and Transportation Officials (AASHTO), 444 N. Capitol St., NW, Suite 249, Washington, DC 20001, <http://www.transportation.org>.

⁴ Available from U.S. Government Printing Office Superintendent of Documents, 732 N. Capitol St., NW, Mail Stop: SDE, Washington, DC 20401, <http://www.access.gpo.gov>

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

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *buckling, v*—Any reverse curvature or deformation in the pipe wall or profile element that reduces the load-carrying capacity of the pipe. For testing evaluations in this standard, buckling is defined as the point where the pipe no longer sustains increasing or constant load with increasing deflection.

3.2.2 *inside diameter, n*—The manufacturer’s stated pipe inside diameter (Table 1).

3.2.3 *mold line, n*—A line formed on the product as a result of the mold blocks parting during manufacturing, also referred to as a parting line.

3.2.4 *profile wall, n*—A pipe wall construction that presents an interior liner in the waterway but includes ribs, corrugations, or other shapes, which can be either solid or hollow, that helps brace the pipe against diametrical deformation.

4. Ordering Information

4.1 Orders for product made to this specification should include the following information to adequately describe the desired product:

4.1.1 This ASTM designation,

4.1.2 Perforations:

4.1.2.1 With perforations,

- 4.1.2.2 Without perforations,
- 4.1.3 Diameters,
- 4.1.4 Total footage of each pipe diameter involved,
- 4.1.5 Pipe length,
- 4.1.6 Fitting type(s):
 - 4.1.6.1 Size and type of fittings, including mainline and branch diameters, and
 - 4.1.6.2 Number of fittings per diameter,
- 4.1.7 Material designation,
 - 4.1.7.1 Virgin resin, and
 - 4.1.7.2 Recycled resin.

5. Materials and Manufacture

5.1 Virgin Resin Products:

5.1.1 *Pipe and Fittings*—The pipe and fittings shall be made of PE virgin plastic compound meeting the requirements of the following cell classifications as defined and described in Specification **D3350**:

5.1.1.1 Pipe Diameter 2 through 10-inch: Cell Class 424420C or 424420E (ESCR Test Condition B),

5.1.1.2 Pipe Diameter 12 through 60-inch: Cell Class 435420C or 435420E (ESCR Test Condition B).

5.1.1.3 Environmental crack resistance shall be determined in accordance with **7.8**. When carbon black is used, the carbon black content shall be equal to or greater than 2.0% but not exceed 4.0 % when tested in accordance with Test Method **D4218**. In all cases, the density of the PE plastic without pigment shall not be less than 0.945gm/cc nor greater than 0.955 gm/cc. Compounds that have a higher cell classification in one or more properties shall be permitted provided all other product requirements are met.

5.1.2 *Rotationally Molded Fittings and Couplings*—Compounds used in the manufacture of rotationally molded fittings and couplings shall be made of virgin PE plastic compound meeting the requirements of cell classification 213320C or 213320E (ESCR Test Condition B) as defined in Specification **D3350**, except that the carbon black content shall be equal to or greater than 2.0% but not exceed 4 % when tested in accordance with Test Method **D4218**. Compounds that have a higher cell classification in one or more properties shall be permitted provided all other product requirements are met.

5.1.3 *Injection and Blow Molded Fittings and Couplings*—Compounds used in the manufacture of injection molded fittings and couplings shall be made of virgin PE plastic compound meeting the requirements of cell classification 414420C or 414420E (ESCR Test Condition B) as defined in Specification **D3350**, except that the carbon black content shall be equal to or greater than 2.0% but not exceed 4 % when tested in accordance with Test Method **D4218**. Compounds that have a higher cell classification in one or more properties shall be permitted provided all other product requirements are met.

5.1.4 *Rework Material*—Clean rework material generated from the manufacturer’s own pipe and fittings production shall be permitted to be used by the same manufacturer provided that the material meets the same or higher Specification **D3350** cell classification as the material required for the intended part and pipe or fittings to be produced under this specification.

5.2 Recycled Resin Products:

5.2.1 *Recycled Resin Pipe*—The pipe containing any post-consumer or industrial recycled materials shall be made of PE plastic compound as defined in Guide **D7209** meeting the requirements of the following cell classifications as defined and described in Specification **D3350**:

5.2.1.1 Pipe Diameter 2 through 10-inch: Cell Class 424400C or 424400E,

5.2.1.2 Pipe Diameter 12 through 60-inch: Cell Class 435400C or 435400E.

5.2.1.3 When carbon black is used, the carbon black content shall be equal to or greater than 2 % but not exceed 4 % when tested in accordance with Test Method **D4218**. Compounds that have a higher cell classification in one or more properties shall be permitted provided all other product requirements are met. For slow crack growth resistance, extruded pipe shall be evaluated using the notched constant ligament stress (NCLS) test according to the procedure described in **7.9**. The average failure time of the five test specimens shall exceed 12 h with no single test specimen’s failure time less than 9 h. Maximum level of polypropylene present by volume shall not be greater than 5 percent when tested in accordance with the procedures in **7.10**. Maximum ash content shall not be more than 2% in accordance with the procedures in **7.11**.

5.2.2 *Recycled Resin Fittings*—Fittings made from recycled resins are not permitted under this standard.

6. General Requirements

6.1 *Workmanship*—The pipe and fittings shall be homogeneous throughout and be as uniform as commercially practical in color, opacity and density. The pipe walls shall be free of cracks, holes, blisters, voids, foreign inclusions, or other defects that are visible to the naked eye and that may affect the wall integrity. There shall be no delamination or separation of the inner liner and the profile. The ends shall be cut squarely and cleanly. Holes intentionally placed in perforated pipe shall be permitted.

6.1.1 Visible defects, cracks, creases, splits, obstruction to flow in perforations, or in pipe are not permissible.

6.2 Dimensions and Tolerance:

6.2.1 *Inside Diameter*—The average measured inside diameter for pipe and fittings shall not vary more than (+/–) 1.0% from the inside diameter when measured in accordance with **7.4.1**.

NOTE 3—The outside diameters and the corrugation pitch of products manufactured to this specification are not specified; therefore, compatibility between pipe and fittings from different manufacturers or the same manufacturer shall be verified.

6.2.2 *Length*—The pipe shall be supplied in any length agreeable to both the owner and manufacturer. Length shall not be less than 99% of stated quantity when measured in accordance with **7.4.2**.

6.2.3 *Minimum Inner Liner Thickness*—The minimum inner liner thickness of the pipe shall meet the requirements given in **Table 1** when measured in accordance with **7.4.3**.

6.2.4 *Perforations*—Perforations shall be cleanly cut, placed in the valley of the corrugation rib, and uniformly spaced along the length and circumference of the pipe. Dimensions of the perforations and the minimum perforation inlet area shall be as

listed in **Table 2**. Other perforation dimensions and configurations shall be permitted where required to meet the needs of the specifier. All measurements shall be made in accordance with **7.4.4**. Pipe connected by bell and spigot joints shall not be perforated in the area of the bells and spigots.

6.3 Pipe Stiffness—Minimum pipe stiffness at 5% deflection shall meet the requirements given in **Table 2** when tested in accordance with **7.5**.

NOTE 4—The 5 % deflection criterion, which was selected for testing convenience, is not a limitation with respect to in-use deflection. The engineer is responsible for establishing the acceptable deflection limit.

6.4 Pipe Flattening—There shall be no evidence of splitting, cracking, breaking, separation of seams, separation between the exterior corrugation and inner liner, or combinations thereof, when tested in accordance with **7.6**.

6.5 Pipe Impact Strength—There shall be no evidence of splitting, cracking, breaking, separation of seams, separation of the outer and inner wall, or combinations thereof, when tested in accordance with **7.7**.

6.6 Fittings and Joining Systems:

6.6.1 Only fittings supplied or recommended by the pipe manufacturer shall be used. Fittings shall be installed in accordance with the manufacturer’s recommendations.

6.6.2 The joining system(s) shall be of a design that preserves alignment during construction and prevents separation at the joints. Bell and spigot, external snap or split couplers are examples of typical designs.

NOTE 5—The ability of a joint to resist soil infiltration (soil tightness) shall be considered. Soil tightness is a function of opening size, channel length, and backfill particle size. A backfill material containing a high percentage of Class III and Class IVA material as defined in Practice **D2321** requires consulting with the manufacturer for the specific type of joint to be used to guard against soil infiltration. Alternatively, the joint shall be wrapped with a geotextile designed to prevent migration of soils into the pipe.

7. Test Methods

7.1 Conditioning:

7.1.1 Referee Testing—When conditioning is required for referee tests, condition the specimens in accordance with Procedure A of Practice **D618** at $73.4 \pm 3.6^\circ \text{F}$ [$23 \pm 2^\circ \text{C}$] at 50 % relative humidity for not less than 24 hours prior to test. Conduct tests under the same conditions of temperature.

7.1.2 Quality Control Testing—Condition specimens prior to test at $73.4 \pm 3.6^\circ \text{F}$ [$23 \pm 2^\circ \text{C}$] for a minimum of 4 hours without regard to relative humidity or 1 h in water.

7.2 Test Conditions—Conduct tests other than those for routine quality control purposes 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 in the referenced test method or in this specification.

7.3 Sampling—The selection of the sample or samples of the pipe and fittings shall be as agreed upon between the owner and the seller. In case of no prior agreement, any samples selected by the testing laboratory shall be permitted.

7.4 Dimensions:

7.4.1 Inside Diameter—Measure the inside diameter in accordance with Test Method **D2122**.

7.4.2 Length—Measure pipe length in accordance with Test Method **D2122**. Length shall be measured at ambient temperature.

7.4.3 Minimum Inner Liner Thickness—Measure the thickness of the inner liner in accordance with Test Method **D2122**. Each specimen shall be cut perpendicular to the seam line of the pipe directly through a corrugation allowing a plain view of the inner wall 360 degrees around the circumference in order to obtain a minimum of eight measurements in accordance with Test Method **D2122**. As an alternative to Test Method **D2122**, minimum liner thickness is allowed to be determined with the use of a calibrated ultrasonic thickness gauge.

NOTE 6—Test Method **D2122** also permits the use of alternate measurement methods such as ultrasonic gauges.

7.4.4 Perforations—Measure dimensions of perforations on a straight specimen without external forces applied. Linear

TABLE 2 Perforation Dimensions

Pipe Inside Diameter		Type of Perforation			
		Circular			
		Maximum Diameter		Minimum Inlet Area	
in.	[mm]	in.	[mm]	In ² /ft	cm ² /m
2	[50]	0.187	[4.75]	1.0	[20]
3	[75]	0.187	[4.75]	1.0	[20]
4	[100]	0.187	[4.75]	1.0	[20]
6	[150]	0.187	[4.75]	1.0	[20]
8	[200]	0.256	[6.25]	1.0	[20]
10	[250]	0.315	[8.00]	1.0	[20]
12	[300]	0.375	[10]	1.5	[30]
15	[375]	0.375	[10]	1.5	[30]
18	[450]	0.375	[10]	1.5	[30]
21	[525]	0.375	[10]	2.0	[40]
24	[600]	0.375	[10]	2.0	[40]
27	[675]	0.375	[10]	2.0	[40]
30	[750]	0.375	[10]	2.0	[40]
36	[900]	0.375	[10]	2.0	[40]
42	[1050]	0.375	[10]	2.0	[40]
48	[1200]	0.375	[10]	2.0	[40]
54	[1350]	0.375	[10]	2.0	[40]
60	[1500]	0.375	[10]	2.0	[40]