



Standard Practice for Installation of Poly(Vinyl Chloride)(PVC) Profile Strip Liner and Cementitious Grout for Rehabilitation of Existing Man- Entry Sewers and Conduits¹

This standard is issued under the fixed designation F 1698; 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 practice describes the procedures for the rehabilitation of sewer lines and conduits by the installation of a field-fabricated PVC liner. After installation of the liner, cementitious grout is injected into the annular space between the liner and the existing sewer or conduit. The rehabilitation of the host structure by this installation practice results in a rigid composite structure (PVC/grout/existing pipe). This rehabilitation process may be used in a variety of gravity applications, such as sanitary sewers, storm sewers and process piping of man-entry sizes (36 to 144 in. in vertical dimension). The profile strips used for field fabrication of PVC liners are supplied in coils for spiral winding of the liner or in custom-cut flat panels for circumferential lining of all or any portion of the circumference of the host conduit (see Figs. 1 and 2).

1.2 The values in parentheses are provided for information purposes only.

1.3 *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.* Particular attention is drawn to those safety regulations and requirements involving entering into and working in confined spaces.

2. Referenced Documents

2.1 ASTM Standards:

- C 39 Test Method for Compressive Strength of Cylindrical Concrete Specimens²
- C 969 Practice for Infiltration and Exfiltration Acceptance Testing of Installed Precast Concrete Pipe Sewer Lines³
- D 790 Test Method for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials⁴
- D 883 Terminology Relating to Plastics⁴

¹ This practice is under the jurisdiction of ASTM Committee F-17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.67 on Trenchless Plastic Pipeline Technology.

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² *Annual Book of ASTM Standards*, Vol 04.02.

³ *Annual Book of ASTM Standards*, Vol 04.05.

⁴ *Annual Book of ASTM Standards*, Vol 08.01.

D 1600 Terminology for Abbreviated Terms Relating to Plastics⁴

D 1784 Specification for Rigid Poly(Vinyl Chloride) (PVC) Compounds and Chlorinated Poly(Vinyl Chloride) (CPVC) Compounds⁴

F 412 Terminology Relating to Plastic Piping Systems⁵

2.2 NASSCO Standard:

Specification Guidelines for Sewer Collection System Maintenance and Rehabilitation⁶

3. Terminology

3.1 *General*—Definitions are in accordance with Terminologies D 883 and F 412. Abbreviations are in accordance with Terminology D 1600, unless otherwise indicated.

3.2 Descriptions of Terms Specific to This Standard:

3.2.1 *extruded PVC joiner strip*—a companion product to the profile former strip of such configuration as to provide the locking mechanism at the edges of the former strips; the joiner strip contains within it a coextruded flexible PVC seal which forms a compression seal when mated with the edges of the former strips.

3.2.2 *extruded PVC profile former strip*—a product, available in various sizes, consisting of a smooth inner surface and a ribbed outer surface (profile) with edge configurations to allow mechanical locking of adjacent strips.

3.2.3 *PVC liner*—a product field fabricated from extruded PVC profile strip into a shape substantially conforming to the shape of the existing pipe or conduit, for example, circular, oval, ovoid, and so forth (see Fig. 1).

3.2.4 *production run*—a continuous extrusion of a given profile type.

4. Significance and Use

4.1 This practice is for use by designers and specifiers, regulatory agencies, owners, and inspection organizations involved in the rehabilitation of non-pressure sewers and conduits. As for any practice, modifications may be required for specific job conditions.

⁵ *Annual Book of ASTM Standards*, Vol 08.04.

⁶ Available from NASSCO National Assoc. of Sewer Service Companies (NASSCO), 140 Circle Dr., Suite 103, Maitland, FL 32751.

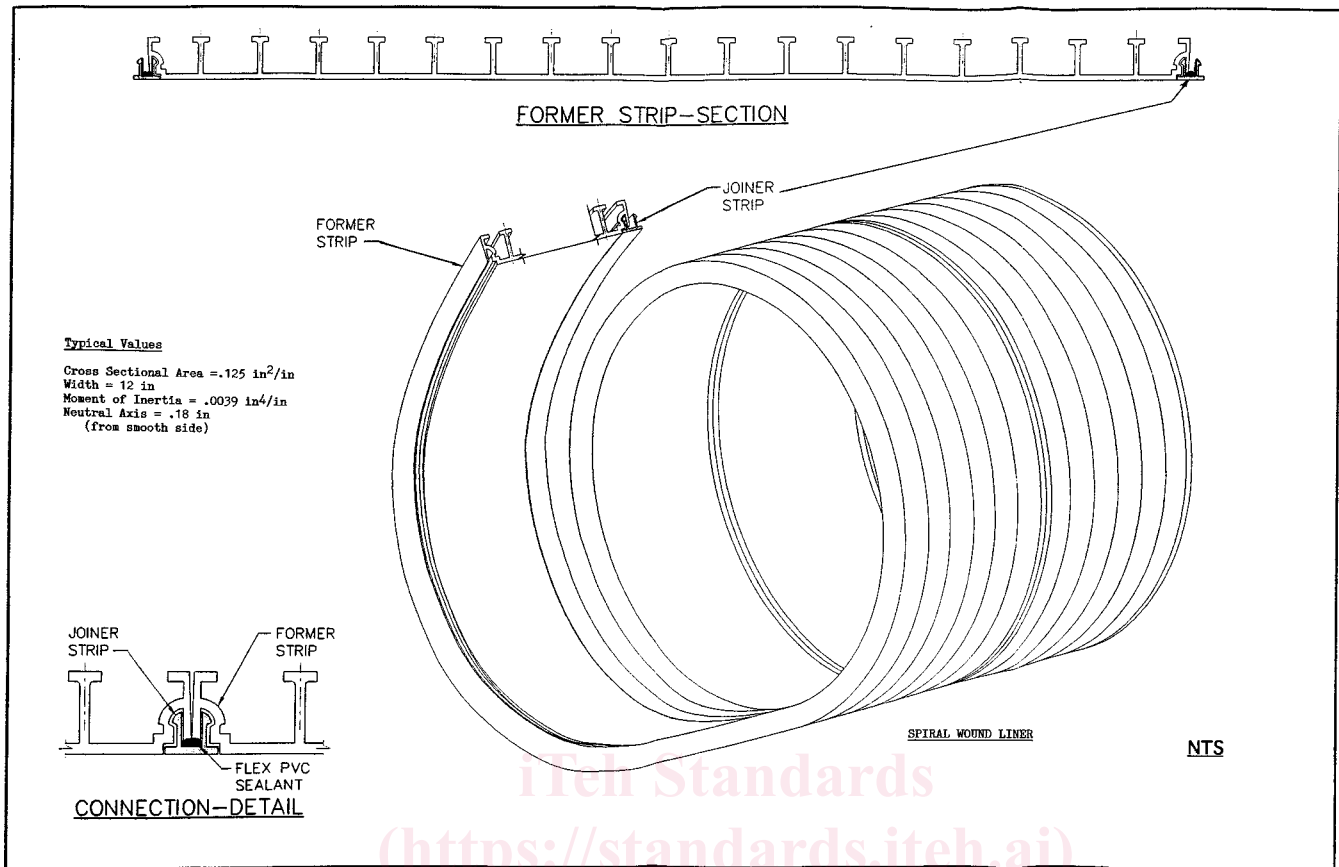


FIG. 1 Example of Profile PVC Strip

5. Materials

5.1 The extruded PVC profile strip (former and joiner) used for the field fabrication of PVC liner should be made from PVC compound meeting all requirements for Cell Classification 12344-C or higher, as defined in Specification D 1784. The coextruded flexible PVC seal in the joiner strip should be made from extrusion grade PVC with Shore A durometer of between 60 and 80 (when measured in accordance with Test Method D 2240).

NOTE 1—An ASTM specification for PVC profile strip materials is under preparation and will be referenced in this practice when approved.

5.2 The profile strip should be coiled in a continuous length as long as practical, or cut in custom length panels for storage and shipping to the job site. Handling and storage should be in accordance with the manufacturer's published recommendations.

5.3 The adhesive or sealant, or both, used should be compatible with the PVC compound and the liner process, so as not to effect the properties of the finished liner. (A 1-component, moisture-cured, polyurethane-base product is suggested.)

6. Installation Recommendations

6.1 Cleaning and Inspection:

6.1.1 Prior to entering access areas such as manholes, and performing inspection or cleaning operations, an evaluation of the atmosphere to determine the presence of toxic or flammable

vapors or lack of oxygen shall be undertaken in accordance with local, state, or federal safety and confined space entry regulations.

6.1.2 *Cleaning of Pipeline*—Internal debris should be removed from the existing pipeline. Gravity pipes should be cleaned with hydraulically powered equipment, high-velocity jet cleaners, or a combination of these methods and manually directed high-pressure (2500-psi minimum) water blasting to ensure that the exposed pipe wall is free of contamination of foreign materials and corrosion products and the surface is hard, competent original pipe material.

6.1.3 *Inspection of Pipeline*—Inspection of pipeline should be performed by experienced personnel trained in locating breaks, obstacles, and service connections, either by direct visual observation or by closed-circuit television. The interior of the pipeline should be carefully inspected to determine the location of any conditions that may prevent or adversely impact proper installation of the profile liner, such as protruding service taps, collapsed or crushed pipe, significant line sags, and deflected joints. These conditions should be noted, and as appropriate, corrected prior to installation.

6.1.4 *Line Obstructions*—The existing pipeline should be clear of obstructions that will prevent the proper placement of the PVC liner. If inspection reveals an obstruction that cannot be removed by conventional equipment, then a point repair excavation should be made to uncover and remove or repair the obstruction.