



Standard Specification for Acrylonitrile-Butadiene-Styrene (ABS) Schedule 40 Plastic Drain, Waste, and Vent Pipe With a Cellular Core¹

This standard is issued under the fixed designation F628; 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.

^{ε1} NOTE—Sections 2, 6.4.4, and the Summary of Changes were editorially corrected in March 2013.

^{ε2} NOTE—Table 2 was editorially corrected in April 2016.

1. Scope*

1.1 This specification covers coextruded acrylonitrile-butadiene-styrene (ABS) plastic drain, waste, and vent pipe made to Schedule 40 iron pipe sizes (IPS) and produced by the coextrusion process with concentric inner and outer solid ABS layers and the core consisting of closed-cell cellular ABS. Plastic which does not meet the material requirements specified in Section 5 is excluded from single layer and all coextruded layers.

1.2 Fittings suitable for use with pipe meeting the requirements of this specification are given in Annex A1. Fittings meeting the requirement of Specification D2661 are also acceptable.

1.3 Acrylonitrile-butadiene-styrene plastic which does not meet the definitions of virgin ABS plastic as given in 3.2.4 is excluded, as performance of plastic other than those defined as virgin was not determined. ABS rework plastic which meets the requirements of rework plastic as given in 5.3 is acceptable.

1.4 Reprocessed plastic or recycled plastic as defined in Terminology D883 is excluded.

1.5 Recommendations for storage, joining, and installation are provided in Appendixes X1, X2, and X3, respectively.

1.6 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.

1.7 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

¹ This specification is under the jurisdiction of ASTM Committee F17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.63 on DWV.

Current edition approved Nov. 15, 2012. Published January 2013. Originally approved in 1979. Last previous edition approved in 2008 as F628 – 08. DOI: 10.1520/F0628-12E02.

2. Referenced Documents

2.1 ASTM Standards:²

- D618 Practice for Conditioning Plastics for Testing
- D883 Terminology Relating to Plastics
- D1600 Terminology for Abbreviated Terms Relating to Plastics
- D1898 Practice for Sampling of Plastics (Withdrawn 1998)³
- D2122 Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings
- D2235 Specification for Solvent Cement for Acrylonitrile-Butadiene-Styrene (ABS) Plastic 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)
- D2661 Specification for Acrylonitrile-Butadiene-Styrene (ABS) Schedule 40 Plastic Drain, Waste, and Vent Pipe and Fittings
- D3311 Specification for Drain, Waste, and Vent (DWV) Plastic Fittings Patterns
- D3965 Classification System and Basis for Specifications for Rigid Acrylonitrile-Butadiene-Styrene (ABS) Materials for Pipe and Fittings
- D5630 Test Method for Ash Content in Plastics
- E105 Practice for Probability Sampling of Materials
- E1508 Guide for Quantitative Analysis by Energy-Dispersive Spectroscopy
- E122 Practice for Calculating Sample Size to Estimate, With Specified Precision, the Average for a Characteristic of a Lot or Process

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 The last approved version of this historical standard is referenced on www.astm.org.

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

F402 Practice for Safe Handling of Solvent Cements, Primers, and Cleaners Used for Joining Thermoplastic Pipe and Fittings

F412 Terminology Relating to Plastic Piping Systems

F1498 Specification for Taper Pipe Threads 60° for Thermoplastic Pipe and Fittings

2.2 *Federal Standard:*

Fed. Std. No. 123 Marking for Shipment (Civil Agencies)⁴

2.3 *Military Standard:*

MIL-STD-129 Marking for Shipment and Storage⁴

3. Terminology

3.1 Definitions:

3.1.1 Definitions are in accordance with Terminology **F412**, and abbreviations are in accordance with Terminology **D1600**, unless otherwise specified. The abbreviation for acrylonitrile-butadiene-styrene plastic is ABS.

3.1.2 *cellular plastic*—a plastic containing numerous cells, intentionally introduced, interconnecting or not, distributed throughout the mass.

3.1.3 *closed-cell cellular plastic*—cellular plastic in which almost all the cells are noninterconnecting.

3.1.4 *coextruded pipe*—pipe consisting of two or more concentric layers of material bonded together in processing by any combination of temperature, pressure, grafting, crosslinking, or adhesion.

3.1.5 *coextrusion*—a process whereby two or more heated or unheated plastic material streams forced through one or more shaping orifice(s) become one continuously formed piece.

3.1.6 *room temperature*—a temperature in the range from 80 to 85 ± 3.6°F (20 to 30 ± 2°C).

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *lot*—a lot shall consist of all pipe produced, of one size, from one extrusion line, during one designated 24-h period.

3.2.2 *recycled plastic*—a plastic prepared from discarded articles that have been cleaned and reground.

3.2.3 *reprocessed plastic*—a thermoplastic prepared from usually melt processed scrap or reject parts by a plastics processor, or from nonstandard or nonuniform virgin material.

3.2.4 *virgin ABS plastic*—plastic in the form of pellets, granules, powder, floc, or liquid that has not been subjected to use or processing other than that required for its initial manufacture.

4. Classification

4.1 Pipe produced in accordance with this specification is intended to provide pipe suitable for the drainage and venting of sewage and certain other non-hazardous liquid wastes.

NOTE 1—Before installing pipe for waste disposal use, the approval of the cognizant building code authority should be obtained as conditions not

commonly found in normal use may be encountered and temperatures in excess of 180°F (82°C) may be encountered.

NOTE 2—This specification does not include requirements for pipe intended to be used to vent combustion gases.

5. Materials

5.1 *Material Specification*—Virgin ABS plastic shall conform to the requirements prescribed in Specification **D3965** with a cell classification of 4-2-2-2. The color and form of the material shall be as agreed upon between the seller and the purchaser in accordance with Specification **D3965**.

5.2 The ABS plastic shall conform to the following requirements:

5.2.1 *Acrylonitrile-Butadiene-Styrene (ABS) Plastic*—Plastic shall contain a minimum of 15 % acrylonitrile, 6 % butadiene, and 15 % styrene or substituted styrene, or both, of polymers or blends of polymers.

5.2.2 ABS plastic shall contain no more than 10 % of other monomeric or polymeric components plus other necessary compounding ingredients.

5.3 *Rework Material*—The manufacturer shall use only his own clean rework pipe material conforming with these cell class requirements. Use it only in the core layer. The pipe produced shall meet all the requirements of this specification.

6. Requirements

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

6.1.1 The requirements in this section are intended only for use as quality control tests, not as simulated service tests.

6.2 Dimension and Tolerance:

6.2.1 *Outside Diameter*—The outside diameter and tolerances shall meet the requirements of **Table 1** when measured in accordance with Test Method **D2122**. The tolerances for out-of-roundness shall apply to pipe prior to shipment.

6.2.2 *Wall Thickness*—The wall thickness and tolerances shall meet the requirements of **Table 2** when measured in accordance with Test Method **D2122**.

6.2.3 *Length*—The pipe shall be in either 10 or 20-ft (3.05 or 6.1-m) lengths, unless otherwise specified. The allowable tolerance on length shall be +1/2, -0 in. (+12, -0 mm).

6.3 Performance Requirements:

6.3.1 *Pipe Stiffness*—The minimum pipe stiffness values at 5 % deflection when measured in accordance with Test Method **D2412**, shall equal or exceed the values in **Table 3**. The rate of crosshead motion shall be 0.20 to 0.25 in./min (5.1 to 6.3 mm/min). Three specimens shall be tested. If all three meet this requirement, the sample meets this requirement. If one or two fail, additional testing shall be conducted in accordance with **6.3.1.1**. If all three fail, the sample does not meet the requirement.

6.3.1.1 *Pipe Stiffness and Lower Confidence Limit*—In the event that one or two of the specimens tested in **6.3.1** fail to meet the minimum requirement, the average pipe stiffness of

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

TABLE 1 Outside Diameters and Tolerances for ABS Schedule 40 Plastic Drain, Waste, and Vent Pipe Produced by the Coextrusion Process with Concentric Inner and Outer Solid ABS-Layers and the Core Consisting of Closed-Cell Cellular ABS

Nominal Pipe Size, in.	Outside Diameter		
	Average, in. (mm)	Tolerance on Average, in. (mm)	Out-of-Roundness Maximum Diameter Minus Minimum Diameter, in. (mm) ^A
1¼	1.660 (42.16)	+0.010, -0.000 (+0.25, -0.00)	0.024 (0.60)
1½	1.900 (48.26)	+0.010, -0.000 (+0.25, -0.00)	0.024 (0.60)
2	2.375 (60.32)	+0.010, -0.000 (+0.25, -0.00)	0.024 (0.60)
3	3.500 (88.90)	+0.015, -0.000 (+0.38, -0.00)	0.030 (0.76)
4	4.500 (114.30)	+0.015, -0.000 (+0.38, -0.00)	0.100 (2.54)
6	6.625 (168.28)	+0.011, -0.011 (+0.28, -0.28)	0.100 (2.54)

^A Measured at time of manufacturing.

TABLE 2 Wall Thickness and Tolerance for ABS Schedule 40 Plastic Drain, Waste, and Vent Pipe Produced by the Coextrusion Process with Concentric Inner and Outer Solid ABS Layers and the Core Consisting of Closed-Cell Cellular ABS

Nominal Pipe Size, in.	Wall Thickness ^A	
	Minimum Total Wall, in. (mm)	Tolerance, in. (mm)
1¼	0.140 (3.56)	+0.035 (+0.89)
1½	0.145 (3.68)	+0.036 (+0.91)
2	0.154 (3.91) [†]	+0.039 (+0.99)
3	0.216 (5.49)	+0.054 (+1.37)
4	0.237 (6.02)	+0.059 (+1.50)
6	0.280 (7.11)	+0.070 (+1.78)

^A The minimum is the lowest wall thickness of the pipe at any cross section.

[†] Editorially corrected in April 2016.

TABLE 3 Pipe Stiffness of ABS Schedule 40 Plastic Drain, Waste, and Vent Pipe Produced by the Coextrusion Process with Concentric Inner and Outer Solid ABS Layers and the Core Consisting of Closed-Cell Cellular ABS

Nominal Pipe Size, in.	Minimum Pipe Stiffness at 5 % Deflection	
	psi	(MPa)
1¼	600	(4.13)
1½	535	(3.69)
2	300	(2.06)
3	280	(1.93)
4	175	(1.21)
6	75	(0.52)

eleven specimens shall meet or exceed the minimum requirement given in Table 3. The 99 % lower confidence limit (LCL) shall be within 15 % of the average value. The LCL shall be calculated using the Student’s “t” distribution, with N-1 degrees of freedom, where N is the number of specimens. The critical t value shall be used to at least three significant digits. Alternatively, if the LCL exceeds the minimum pipe stiffness requirement in Table 3, but is not within 15 % of the average, the sample meets the requirements of the Pipe Stiffness testing. The eleven specimens include the three tested under 6.3.1, and an additional eight with rotation by 35°, as specified in Test Method D2412, continuing throughout the remaining specimens.

6.3.1.2 The LCL based on testing eleven specimens is calculated as follows:

$$LCL = (\text{avg PS}) - \{2.76 (\text{std. dev.}) / \sqrt{(N)}\}$$

where:

$$(\text{avg PS}) = [\sum (\text{PS}_i)] / (11) \quad (1)$$

$$(\text{std. dev.}) = \left[\frac{\sum \text{PS}^2 - (\sum \text{PS})^2 / N}{N - 1} \right]^{1/2}$$

N = 11.

6.3.1.3 The 15 % requirement is calculated as follows:

$$(\text{avg} - \text{LCL}) / (\text{avg}) \times 100 \leq 15 \%$$

NOTE 3—For quality control testing, a single specimen may be used with the thinnest wall at the top.

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

NOTE 5—The strength and load-carrying capabilities of plastic pipe are measured and reported as pipe stiffness, which is determined in accordance with Test Method D2412. The term “crush strength” is not applicable to plastic piping because the values obtained can be significantly different, depending on the bedding, loading, or testing technique used, and the term derives from rigid pipe and refers to its ultimate strength at rupture.

6.3.2 *Pipe Flattening*—There shall be no evidence of rupture when pipe is deflected 25 % of the initial inside diameter when tested in accordance with Test Method D2412. Three specimens shall be tested; all shall meet the requirements. Failure shall be a crack or break extending entirely through the pipe wall visible to the unaided eye.

6.3.3 *Impact Strength*—The minimum impact resistance, when tested at the time of manufacture, shall comply with Table 4. Test in accordance with Test Method D2444 using Tup A and Holder B. Use 12-lb (5 kg) tup for testing pipe sizes 4 in. and smaller and a 20-lb (10-kg) tup for sizes larger than 4 in.

6.3.3.1 Test 10 specimens. When 9 or 10 specimens pass, accept the lot. When 2 or more specimens fail, test 10

TABLE 4 Impact Resistance of ABS Schedule 40 Plastic Drain, Waste, and Vent Pipe Produced by the Coextrusion Process and Concentric Inner and Outer Solid ABS Layers and the Core Consisting of Closed-Cell Cellular ABS

Nominal Pipe Size, in.	Minimum Impact Resistance, ft-lbf (J)
	At 32°F (0°C)
1¼	15 (20)
1½	20 (27)
2	30 (41)
3	40 (54)
4	40 (54)
6	40 (54)

additional specimens. When 17 of 20 specimens tested pass, accept the lot. When 4 or more of 20 specimens fail, test 20 additional specimens. When 32 of 40 specimens pass, accept the lot. When 9 or more of 40 specimens fail, the lot does not meet the requirements of this specification.

6.3.3.2 Failure of the test specimen shall be shattering or any crack or break extending entirely through the pipe wall and visible to the unaided eye.

6.3.4 *Bond*—The bond between layers shall be strong and uniform. It shall not be possible to separate any two layers with a probe or point of a knife blade so that the layers separate cleanly, or so the probe or knife blade moves freely between the layers; nor shall separation of bond occur between layers during testing performed under the requirements of this specification.

6.3.5 *Pigments or Screening Agents*—The ABS compound used in the outer layer shall contain pigments or screening agents to provide protection against UV radiation.

6.4 *Other Requirements:*

6.4.1 *Inspection*—Inspection shall be made prior to installation of all pipe. Pipe that does not meet the requirements of 6.1 shall be returned to the seller.

6.4.2 *Joining*—Coextruded ABS Schedule 40 drain, waste, and vent pipe with a cellular core are joined using molded fittings meeting the requirements of Specifications D2661 and D3311 or the requirements for fittings listed in the Annex of this specification.

6.4.3 *Solvent Cement*—In the assembly of solvent cement joints, the safety requirements of Practice F402 shall be followed using solvent cement meeting the requirements of Specification D2235.

6.4.4 *Ash Content*—Test in accordance with Test Method D5630. Maximum allowable ash content shall be 0.50 wt%. Retain the ash obtained in this test for further testing described in 6.4.5.

6.4.5 *Ash Composition*—Test ash obtained in 6.4.4 for Bromine content in accordance with Guide E1508 or other suitable analytical technique as agreed upon by the purchaser and seller. Measurement of Bromine content above detection limit shall constitute failure to meet the requirements of Specification F628.

NOTE 6—For certification testing, select a 1 ft specimen of pipe from the manufacturer's inventory or from a retail or wholesale location carrying the manufacturer's pipe products.

NOTE 7—Manufacturing of ABS cellular core pipe in Specification F628 is predicated on the use of virgin ABS materials. One potential source of non-virgin, that is, recycled materials, is the cases of electronic components such as phones and personal computers. These products typically have flame retardants within their polymer compounds, and one prolific flame retardant family consists of PBDE's, or polybrominated diphenyl ethers. The intent of 6.4.4 is to provide some demonstration that recycled materials are not used.

7. Sampling and Conditioning

7.1 *Sampling*—For the purpose of testing, the lot shall consist of all pipe produced of one size, from one extrusion line, during one designated 24-h period. The number of specimens designated for each test shall be taken from pipe selected at random from each lot in accordance with the random sampling plan of Practice D1898.

NOTE 8—Also see Practices E105 and E122.

7.2 *Number of Test for Quality Control*—When evaluating a product against this specification, the following minimum number of specimens shall be tested for each lot.

7.2.1 *Outside Diameter*—One specimen per extrusion line.

7.2.2 *Wall Thickness*—One specimen per extrusion line.

7.2.3 *Length*—One specimen per extrusion line.

7.2.4 *Pipe Stiffness*—A minimum of three specimens per extrusion line.

7.2.5 *Pipe Flattening*—A minimum of three specimens per extrusion line.

7.2.6 *Impact Strength*—A minimum of 10 specimens and a maximum of 40.

7.2.7 *Bond*—One specimen per extrusion line.

7.3 *Conditioning:*

7.3.1 For referee testing at 73°F, condition the specimens prior to the test at 73.4 ± 3.6° (23 ± 2°C) and 50 ± 5 % relative humidity in accordance with Practice D618, Procedure A.

7.3.2 For routine quality control testing at 73°F, condition the specimens at the temperature and humidity of the manufacturer's testing facility for not less than 1 h or until the specimens are at the room temperature.

7.3.3 For referee testing at 32°F, condition the specimens at 32 ± 3.6°F (0 ± 2°C) for at least 2 h, or in ice water for at least 1 h.

7.4 *Test Conditions:*

7.4.1 For referee purposes, conduct tests in the standard laboratory atmosphere of 73.4 ± 3.6 F° (23 ± 2°C) and 50 ± 5 % relative humidity.

7.4.2 For routine quality control testing, conduct tests at the temperature and humidity of the manufacturer's testing area.

7.4.3 For testing at 32°F, complete the test as soon as possible after removal from the conditioning atmosphere, but in any case within 15 s.

7.5 *Test Methods*—Only ASTM test methods specified shall be used.

8. Retest and Rejection

8.1 If the results of any test(s) do not meet the requirements of this specification, the test(s) shall be conducted again only by agreement between the purchaser and the seller. Under such agreement, minimum requirements shall not be lowered, changed, or modified, nor shall specification limits be changed. If, upon retest, failure occurs, the quantity of product represented by the test(s) does not meet the requirements of this specification.

9. Product Marking

9.1 *Quality of Marking*—The marking shall be applied to the pipe in such a manner that it remains legible (easily read) after installation and inspection.

9.2 *Content of Marking*—The pipe shall be marked in letters not less than 3/16 in. (5 mm) high, in a contrasting color, spaced at intervals of not more than 5 ft. (1.5 m), with the following information:

9.2.1 Manufacturer's name (or trademark).

9.2.2 This designation “ASTM F628”.

9.2.3 The wording “COEXTRUDED ABS CELLULAR CORE DWV”.

9.2.4 Nominal pipe size (for example: 2 in. (51 mm)).

9.2.5 Manufacturer’s code for resin manufacture, lot number, and date of manufacture.

10. Quality Assurance

10.1 When the product is marked with this designation, F628, the manufacturer affirms that the product was

manufactured, inspected, sampled, and tested in accordance with this specification and has been found to meet the requirements of this specification.

11. Keywords

11.1 ABS; cellular; DWV; fittings; pipe; plastic; thermo-plastic; Schedule 40

SUPPLEMENTARY REQUIREMENTS

GOVERNMENT/MILITARY PROCUREMENT

These requirements apply *only* to federal/military procurement, not domestic sales or transfers.

S1. *Responsibility for Inspection*—Unless otherwise specified in the contract or purchase order, the producer is responsible for the performance of all inspection and test requirements specified herein. The producer may use his own or any other suitable facilities for the performance of the inspection and test requirements specified herein, unless disapproved by the purchaser. The purchaser shall have the right to perform any of the inspections and tests set forth in this specification where such inspections are deemed necessary to ensure that material conforms to prescribed requirements.

NOTE S1.1—In U.S. Federal Government contracts, the contractor is responsible for inspection.

S2. *Packaging and Marking for U.S. Government Procurement*:

S2.1 *Packaging*—Unless otherwise specified in the contract, the material shall be packaged in accordance with the supplier’s standard practice in a manner ensuring arrival at destination in satisfactory condition and which will be acceptable to the carrier at lowest rates. Containers and packing shall comply with Uniform Freight Classification rules or National Motor Freight Classification rules.

S2.2 *Marking*—Marking for shipment shall be in accordance with Fed. Std. No. 123 for civil agencies and MIL-STD-129 for military agencies.

NOTE S2.1—The inclusion of U.S. Federal Government procurement requirements should not be construed as an indication that the U.S. Federal Government uses or endorses the products described in this specification.

<https://standards.iteh.ai/catalog/standards/sist/fe70bc35-e93c-42cd-a3f7-abf27442986e/astm-f628-12e2>

ANNEX

(Mandatory Information)

A1. ABS FITTINGS

A1.1 The pattern, dimension, and laying length of fittings shall meet the requirements of Specification **D3311** and **Table A1.1** when determined in accordance with Test Method **D2122**.

A1.2 Fittings produced by any molding process shall be made of virgin ABS plastic which shall conform to the requirements prescribed in Specification **D3965** with a cell classification of 3-2-2-2. The color and form of the material shall be as agreed upon between the seller and the purchaser in accordance with Specification **D3965**.

A1.3 *Rework Material*—The manufacturer shall use only his own clean rework pipe material conforming with these cell

class requirements. Use it only in the core layer. The pipe produced shall meet all the requirements of this specification.

A1.4 The spigot dimensions of the fittings shall meet the requirements of **Table 1** of this specification.

A1.5 For all fittings having taper pipe threads, threads shall conform to and be gaged in accordance with Specification **F1498**.

TABLE A1.1 Dimensions and Tolerances for ABS Schedule 40 Drain, Waste, and Vent Fittings

Nomi- nal Pipe Size, In.	Socket Entrance Diameter			Socket Bottom Diameter			Wall Thickness ^A			Internal Threads	
	Average ^B	Tolerance on Diameter	Out-of- Roundness (maximum minus minimum)	Average ^B	Tolerance on Diameter	Out-of- Roundness (maximum minus minimum)	Socket Depth, min	Average, min	Minimum After Core Shift	Outside Diameter of Hub M, min	Thread Length, min
1¼	1.670 (42.42)	+0.010 (0.25) -0.005 (0.13)	0.024 (0.61)	1.655 (42.04)	±0.005 (0.13)	0.024 (0.61)	0.687 (17.45)	0.156 (3.96)	0.140 (3.56)	1.871 (47.52)	0.687 (17.4)
1½	1.910 (48.51)	+0.010 (0.25) -0.005 (0.13)	0.024 (0.61)	1.895 (48.13)	±0.005 (0.13)	0.024 (0.61)	0.687 (17.45)	0.156 (3.96)	0.140 (3.56)	2.127 (54.03)	0.687 (17.4)
2	2.385 (60.58)	+0.010 (0.25) -0.005 (0.13)	0.024 (0.61)	2.370 (60.19)	±0.005 (0.13)	0.024 (0.61)	0.750 (19.05)	0.156 (3.96)	0.140 (3.56)	2.634 (66.90)	0.750 (19.0)
3	3.515 (89.28)	+0.010 (0.25) -0.005 (0.13)	0.030 (0.76)	3.495 (88.73)	+0.005 (0.13) -0.010 (0.25)	0.030 (0.76)	1.500 (38.1)	0.218 (5.54)	0.196 (4.98)	3.841 (97.56)	1.187 (30.15)
4	4.515 (114.68)	+0.010 (0.25) -0.005 (0.13)	0.030 (0.76)	4.495 (114.17)	+0.005 (0.13) -0.010 (0.25)	0.030 (0.76)	1.750 (44.45)	0.250 (6.35)	0.225 (5.72)	4.907 (124.64)	1.281 (32.54)
6	6.647 (168.83)	+0.011 (0.28) -0.011 (0.28)	0.060 (1.52)	6.614 (167.99)	±0.011 (0.28)	0.060 (1.52)	3.000 (76.20)	0.281 (7.14)	0.253 (6.43)	7.203 (182.96)	1.500 (38.10)

^A The average wall thickness is the minimum wall thickness plus the opposite wall thickness divided by 2. The average shall equal or exceed that shown in the table. The minimum wall thickness, due to core shift, shall equal or exceed the value shown in the table. The minimum wall thickness is determined by allowing a 10 % variation due to core shift.

^B The average is the maximum plus the minimum diameters divided by 2.