



Standard Specification for Polyvinylidene Fluoride (PVDF) Corrosive Waste Drainage Systems¹

This standard is issued under the fixed designation F1673; 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 for ~~polyvinylidene nonpressure~~ polyvinylidene fluoride drainage systems for corrosive applications. Requirements for material, pipe and fittings are included. Polyvinylidene fluoride includes emulsion/suspension polymerization and copolymers of vinylidene fluoride/hexafluoropropylene produced by either method.

1.2 These requirements apply to Schedule 40 and 80 IPS, SDR 32.5, and SDR 21 pipe sizes. Pipe and fittings are to be joined by heat fusion or mechanical methods using the equipment supplied by the manufacturers.

1.3 This specification is not intended to provide for interchangeability between plastic pipe and fittings from different manufacturers, but it does allow for transition fittings for joining one manufacturer's product to another's product, provided the joining technique used is other than heat fusion.

1.4 This specification is not for polyvinylidene pressure systems.

1.5 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.

1.6 Notes and appendixes are not a mandatory part of this specification.

1.7 The following safety hazard caveat pertains only to the test method portion, Section 8, 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.*

2. Referenced Documents

2.1 *ASTM Standards:*²

[D543 Practices for Evaluating the Resistance of Plastics to Chemical Reagents](#)

[D570 Test Method for Water Absorption of Plastics](#)

[D618 Practice for Conditioning Plastics for Testing](#)

[D883 Terminology Relating to Plastics](#)

[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 \(Falling Weight\)](#)

[D3222 Specification for Unmodified Poly\(Vinylidene Fluoride\) \(PVDF\) Molding Extrusion and Coating Materials](#)

[D3311 Specification for Drain, Waste, and Vent \(DWV\) Plastic Fittings Patterns](#)

[D5575 Classification System for Copolymers of Vinylidene Fluoride \(VDF\) with Other Fluorinated Monomers](#)

[F412 Terminology Relating to Plastic Piping Systems](#)

[F1498 Specification for Taper Pipe Threads 60° for Thermoplastic Pipe and Fittings](#)

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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.

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

2.2 *Federal Standard:*Fed. Std. No. 123 Marking for Shipment³2.3 *Military Standard:*MIL-STD 129 Marking for Shipment and Storage³2.4 *Other Standard:*Uniform Plumbing Code⁴

3. Terminology

3.1 *Definitions:*

3.1.1 Definitions used in this specification are in accordance with the definitions given in Terminologies D883 and F412 and abbreviations are in accordance with Terminology D1600, unless otherwise indicated.

3.1.2 The plumbing terminology used in this specification is in accordance with the definitions given in the *Uniform Plumbing Code*, unless otherwise indicated.

3.1 *Definitions:*

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4. Classification

4.1 *General*—This specification covers PVDF pipe and fittings made from PVDF or VF/HFP copolymers in Schedule 40 and 80 IPS sizes and in SDR 32.5 and SDR 21-21 IPS sizes.

4.2 This specification also includes molded fittings and the larger sizes (8, 10, 12 in.) of fabricated fittings.

5. Materials and Manufacture

5.1 Polyvinylidene fluoride (PVDF) material for pipe or fittings shall conform to the requirements of Type I Grade 1, Type I Grade 2, or Type II PVDF as defined in Specification D3222 or copolymers as defined in Specification D5575.

5.2 The PVDF material may contain pigment and fillers not detrimental to the pipe and fittings, provided the pipe and fittings produced meet the requirements of this specification.

5.3 *Rework Material*—Clean rework material, generated from the manufacturer's pipe and fittings products may be used by the same manufacturer, provided that the pipe or fittings produced meet the requirements of this specification.

6. Requirements

6.1 *Dimensions and Tolerances—Pipe and Fittings:*6.1.1 *Pipe:*

6.1.1.1 Dimensions and tolerances for pipe shown in Table 1 and Table 2 shall be measured in accordance with Method D2122. The tolerance for out-of-roundness shall apply only to pipe prior to shipment.

6.1.1.2 *Toe-In*—The outside diameter, when measured in accordance with Method D2122, shall meet the requirements of Table 1 and Table 2 at any point within 1.5 pipe diameters or 11.8 in. (300 mm), whichever is less, to the cut end of the pipe length.

³ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, <http://www.dodssp.daps.mil>. DLA Document Services Building 4/D 700 Robbins Avenue Philadelphia, PA 19111-5094 <http://quicksearch.dla.mil/>

⁴ Available from International Association of Plumbing and Mechanical Officials, 5001 E. Philadelphia St., Ontario, CA 91761, <http://www.iapmo.org>.

TABLE 1 Outside Diameters and Tolerances for PVDF Pipe Schedules 40 and 80 and SDR 21, in. (mm)

Nominal Pipe Size	Average Outside Diameter	Tolerance	Out-of-Roundness (Maximum Diameter Minus Minimum Diameter)
1¼	1.660 (42.16)	±0.005 (±0.13)	0.050 (1.28)
1½	1.900 (48.26)	±0.006 (±0.15)	0.060 (1.52)
2	2.375 (60.32)	±0.006 (±0.15)	0.070 (1.78)
3	3.500 (88.90)	±0.008 (±0.20)	0.080 (2.04)
4	4.500 (114.30)	±0.009 (±0.23)	0.100 (2.54)
6	6.625 (168.28)	±0.011 (±0.28)	0.100 (2.54)
8	8.625 (219.08)	±0.015 (±0.38)	0.150 (3.80)
10	10.750 (273.05)	±0.015 (±0.38)	0.150 (3.80)
12	12.750 (323.85)	±0.015 (±0.38)	0.150 (3.80)

TABLE 2 Wall Thicknesses and Tolerances for PVDF Pipe Schedules 40 and 80 and SDR 21, in. (mm)

NOTE 1— For fittings, the wall thickness is a minimum value, except that a 10 % variation resulting from core shift is allowable. In such a case, the average of the two opposite wall thickness' shall equal or exceed the value shown in the Schedule 40 table.

Nominal Pipe Sizes	Schedule 40		Schedule 80		SDR 21		SDR 32.5	
	Minimum	Tolerance	Minimum	Tolerance	Minimum	Tolerance	Minimum	Tolerance
1¼	0.140 (3.56)	+0.020 (+0.51)	0.191 (4.85)	+0.023 (+0.58)	0.079 (2.01)	+0.020 (+0.51)	0.062 (1.57)	+0.020 (0.51)
1½	0.145 (3.68)	+0.020 (+0.51)	0.200 (5.08)	+0.024 (+0.61)	0.090 (2.28)	+0.020 (+0.51)	0.062 (1.57)	+0.020 (0.51)
2	0.154 (3.91)	+0.020 (+0.51)	0.218 (5.54)	+0.026 (+0.66)	0.113 (2.87)	+0.020 (+0.51)	0.073 (1.85)	+0.020 (0.51)
3	0.216 (5.49)	+0.026 (+0.66)	0.300 (7.62)	+0.036 (+0.91)	0.167 (4.22)	+0.020 (+0.51)	0.108 (2.74)	+0.020 (0.51)
4	0.237 (6.02)	+0.028 (+0.71)	0.337 (8.56)	+0.040 (+1.02)	0.214 (5.44)	+0.026 (+0.66)	0.138 (3.51)	+0.020 (0.51)
6	0.280 (7.11)	+0.034 (+0.86)	0.432 (10.97)	+0.052 (+1.32)	0.315 (8.00)	+0.038 (+0.97)	0.204 (5.18)	+0.0241 (0.61)
8	0.322 (8.18)	+0.039 (+0.99)	0.500 (12.70)	+0.060 (+1.52)	0.411 (10.44)	+0.049 (+1.24)	0.265 (6.73)	+0.032 (0.81)
10	0.365 (9.27)	+0.044 (+1.12)	0.593 (15.06)	+0.071 (+1.80)	0.512 (13.00)	+0.061 (+1.55)	0.331 (8.41)	+0.040 (1.02)
12	0.406 (10.31)	+0.049 (+1.24)	0.687 (17.45)	+0.082 (+2.08)	0.607 (15.42)	+0.073 (+1.85)	0.392 (9.96)	+0.047 (+1.19)

6.1.2 Fittings:

6.1.2.1 The minimum wall thickness of the body all fittings shall not be less than the corresponding Schedule 40 pipe size and shall be measured in accordance with Method **D2122**.

6.1.2.2 Spigot ends of fittings shall conform to the diameter and out-of-roundness requirements for pipe.

6.1.2.3 Socket ends of fittings shall conform to the dimensional requirements for size and tolerances as provided by the manufacturer.

6.1.2.4 The average minimum diameters of waterways of fittings, excluding adapters, shall be as specified in **Table 3**.

6.1.2.5 Taper pipe threads in any fittings shall be as specified in Specification **F1498**. The tolerance shall be 1½ large or small turns from the basic thread dimension and gaged in accordance with **8.7**.

6.1.2.6 The patterns, dimensions, and laying lengths of molded fittings, including adapters, shall meet the requirements of Specification **D3311**, or shall be of a proven design and allow a smooth transition of fluid flow from one direction to another.

6.1.2.7 Cleanouts, cleanout plugs, and caps as commonly used in the manufacturer's laboratory drainage system, shall have a thread size and depth sufficient to ensure that the minimum waterway sizes are maintained.

6.1.2.8 *Traps*—All traps shall have a minimum water seal of 2 in.

6.2 *Chemical Resistance*—Pipe and fittings material shall be evaluated in accordance with Practice **D543**, Procedures I and II, using the chemicals listed in **8.3**. The weight change shall not exceed 2 %, nor shall the apparent tensile strength change by more than 10 %. In cases where there is a change in the apparent tensile strength greater than 10 %, a further evaluation shall be made after removal from the chemical and conditioning for 72 h. If there is a minimum of 50 % recovery of tensile strength after 72 h, and that figure is within ±10 % of the original tensile strength, the specimen shall be considered acceptable.

6.3 *Water Absorption*—Pipe and fitting materials shall not change in weight more than 0.50 % when tested in accordance with **8.4**.

6.4 System Integrity:

6.4.1 Fused joints and associated pipe shall withstand a pressure of 50 psi (345 kPa) without leaking when tested in accordance with **8.5.1**.

6.4.2 Mechanical joints shall withstand a pressure of 14.5 psi (100 kPa) without leaking when tested in accordance with **8.5.2**.

NOTE 1—Mechanical joints include transition, compression, threaded, and other type mechanical joints.

6.4.3 Mechanical joints shall incorporate a positive mechanical system for axial restraint in addition to any restraint provided by friction.

6.4.4 Mechanical joints shall show no evidence of separation at the joint under Force *P* when tested in accordance with **8.6.1**, nor shall they leak or show any other damage when tested in accordance with **8.6.2**. Two fittings shall be tested and both shall pass.

TABLE 3 Average Waterway Diameter, in. (mm)

Nominal Pipe Size	Unthreaded Fittings	Under Half Thread of Male Adapters	
	Minimum	Minimum	Maximum
1¼	1.227 (31.17)	1.220 (30.99)	1.280 (32.51)
1½	1.446 (36.73)	1.458 (37.03)	1.501 (38.13)
2	1.881 (47.78)	1.915 (48.64)	1.946 (49.43)
3	2.820 (71.63)	2.849 (72.36)	2.983 (75.77)
4	3.737 (94.92)	3.806 (96.67)	3.972 (100.89)
6	5.646 (143.41)	5.851 (148.62)	6.008 (152.53)
8	7.490 (190.25)
10	9.407 (238.94)
12	11.197 (284.40)



6.5 All stainless steel parts shall be made of corrosion-resistant steel, containing not less than 16 % chromium and not less than 6 % nickel by weight.

6.6 *Sealing Rings*—Sealing rings shall be made from a material with a chemical resistance similar to PVDF.

6.7 *Flattening*—There shall be no evidence of splitting, cracking, or breaking when the pipe is tested in accordance with 8.8.1.

6.8 *Impact Resistance*—The impact resistance testing shall be in accordance with 8.9.

7. Workmanship, Finish, and Appearance

7.1 The manufacture of pipe and fittings shall be in accordance with good commercial practice, so as to produce fittings meeting the requirements of this specification. Fittings and pipe shall be homogenous throughout and free from visible cracks, holes, foreign inclusions, or injurious defects. The fittings and pipe shall be as uniform as commercially practicable in color, opacity, density, and other physical properties.

8. Test Methods

8.1 *Conditioning*—When required, condition the test specimens at $73.4 \pm 3.6^\circ\text{F}$ ($23 \pm 2^\circ\text{C}$) and $50 \pm 5\%$ relative humidity, for not less than 40 h prior to the test in accordance with Procedure A of Practice D618.

8.2 *Test Conditions*—Conduct the test in a standard laboratory atmosphere of $73.4 \pm 3.6^\circ\text{F}$ ($23 \pm 2^\circ\text{C}$) and $50 \pm 5\%$ relative humidity, unless otherwise specified in the test methods or in this specification.

8.3 *Chemical Resistance*—Determine the resistance to the following chemicals using the material quantification method in Practice D543.

Chemical	Percent in Water
Acetic acid	5 by volume
Acetone	5 by volume
Methyl alcohol	100
Ammonia hydroxide	10 by volume
Nitric acid	40 by volume
Sodium hydroxide	10 by weight
Sulfuric acid	20 by volume
Hydrochloric acid	20 by volume

8.4 *Water Absorption*—Three cleanly cut specimens measuring approximately 2 by 3 in. (50 by 75 mm) and having smooth edges shall be weighed to the nearest 0.001 g and immersed in distilled water at $73.4 \pm 1.8^\circ\text{F}$ ($23 \pm 1^\circ\text{C}$) for 24 h + ½–0 h, in accordance with Test Method D570. The specimens shall be removed, wiped dry with a clean, dry cloth, and reweighed immediately. The average percent gain in weight shall be calculated to the nearest 0.01 % on the basis of the initial mass. Weight change shall be less than 0.50 % (material qualification only).

8.5 *Joint Tests—Hydrostatic Pressure Tests:*

8.5.1 *Fused Joint Pressure Test*—Six specimens of pipe, each five times the nominal diameter or a maximum of 18 in. (450 mm) in length, shall be selected at random for each size of piping and each type of system being considered. Three suitable couplings shall also be selected at random. Three joined specimens shall be prepared by joining two pipe specimens with one coupling, using the equipment and instructions supplied by the manufacturer of the system. Fill each specimen with water at $73.4 \pm 3.6^\circ\text{F}$ ($23 \pm 2^\circ\text{C}$) and cap, taking care to exclude all air from the system. Fix one end of the specimen to a pressurizing apparatus, and support the free end if necessary. Pressurize each specimen to 50 psi (345 kPa) for a minimum of 5 min and inspect for leaks. None of the three specimens shall leak.

8.5.1.1 This is a laboratory performance test only and is not for field use.

8.5.2 *Mechanical Joint Pressure Test*—The pressure test on mechanical joints shall be carried out on test specimens prepared in a manner similar to that described in 8.5.1, except use appropriate pipe specimens where the joint is intended to join pipes of similar or dissimilar material and sizes. Pressurize the assembly to 14.5 psi (100 kPa) for a period of 24 h +15, –0.0 min and inspect for signs of leakage. Apply this test to each size and type of joint being considered.

8.5.2.1 This is a laboratory performance test only and is not for field use.

8.6 *Mechanical Joint Pullout Test:*

8.6.1 Join two sections of pipe by a coupling, with the positive mechanical axial restraint system removed or deactivated. Mount the assembly with the outer ends of the pipe sections fastened in the clamps of a tensile testing machine. Pull the two pipe sections apart at a rate of approximately

1 in./min (25 mm/min) until at least one pipe section has separated from the coupling. Record the maximum force, *F*, applied.

8.6.2 Using the setup described in 8.6.1, subject a complete joint assembled in accordance with the manufacturer’s instructions to an axial pullout force, *P*, of 25 lbf (110 N) greater than Force *F*. In no case shall this force *P* be less than 50 lbf (220 N). Apply Force *P* within 5 to 30 s and maintain for at least 60 s.

8.6.3 Remove the axial force and pressurize the complete joint assembly to 14.5-psi (100-kPa) hydrostatic pressure for a period of 1 h and inspect for leaks.