



Standard Specification for Folded Poly(Vinyl Chloride) (PVC) Pipe for Existing Sewer and Conduit Rehabilitation¹

This standard is issued under the fixed designation F 1504; 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 materials, dimensions, workmanship, flattening resistance, impact resistance, pipe stiffness, extrusion quality, and a form of marking for folded (vinyl chloride) (PVC) pipe for existing sewer and conduit rehabilitation.

1.2 Pipe produced to this specification is for use in non-pressure sewer and conduit rehabilitation where the folded PVC pipe is inserted into and then expanded to conform to the wall of the original conduit forming a new structural pipe-within-a-pipe.

NOTE 1—An ASTM specification for the installation of folded PVC pipe is under preparation and will be referenced in this specification when published.

1.3 This specification includes pipe made only from materials specified in Section 6. This specification does not include pipe manufactured from reprocessed, recycled, or reclaimed PVC.

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

1.5 The following precautionary statement pertains to the test method portion only, Section 11, 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:

D 618 Practice for Conditioning Plastics and Electrical Insulating Materials for Testing²

D 790 Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials²

D 1600 Terminology for Abbreviated Terms Relating to Plastics²

D 1784 Specification for Rigid Poly(Vinyl Chloride) (PVC) Compounds and Chlorinated Poly(Vinyl Chloride) (CPVC) Compounds²

D 2122 Test Method of Determining Dimensions of Thermoplastic Pipe and Fittings³

D 2152 Test Method for Degree of Fusion of Extruded Poly(Vinyl Chloride) (PVC) Pipe and Molded Fittings by Acetone Immersion³

D 2412 Test Method of Determination of External Loading Characteristics of Plastic Pipe by Parallel-Plate Loading³

D 2444 Test Method for Impact Resistance of Thermoplastic Pipe and Fittings by Means of a Tup (Falling Weight)³

F 412 Terminology Relating to Plastic Piping Systems³

F 1057 Practice for Estimating the Quality of Extruded Poly(Vinyl Chloride) (PVC) Pipe by the Heat Reversion Technique³

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 *General*—Abbreviations used in this specification are in accordance with Terminology D 1600 and definitions are in accordance with Terminology F 412 unless otherwise indicated.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *folded pipe*—pipe that has been manufactured in a folded shape for use in existing sewer and conduit rehabilitation. See Fig. 1.

3.2.2 *rounded pipe*—A rounded pipe is a sample for test purposes formed when the folded pipe has been inserted into a circular casing pipe and expanded with heat and pressure to fit tightly to the casing pipe taking a circular cross section, in accordance with Section 10. See Fig. 1.

4. Significance and Use

4.1 The requirements of this specification are intended to provide folded pipe suitable for the rehabilitation of existing

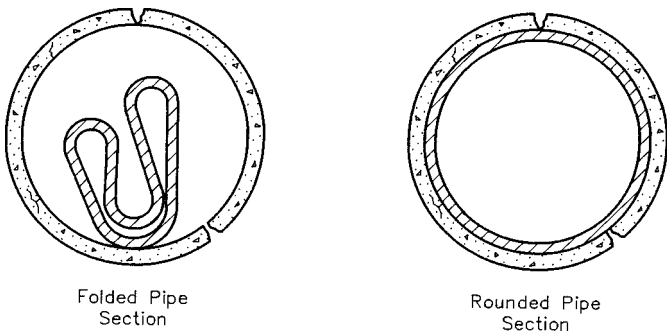
¹ This specification is under the jurisdiction of ASTM Committee F-17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.67 on Trenchless Plastic Pipeline Technology.

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² *Annual Book of ASTM Standards*, Vol 08.01.

³ *Annual Book of ASTM Standards*, Vol 08.04.

⁴ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.



NOTE—This figure is intended only for clarification of terms specific to this specification and shows a representative folded pipe shape. Other folded pipe shapes may meet the requirements of this specification.

FIG. 1 **Folded Pipe and Rounded Pipe—Clarification of Terms**

pipelines and conduits conveying sewage, process flow, and storm water, under gravity flow conditions, through the heating, insertion, and expansion of the folded pipe.

NOTE 2—Industrial waste disposal lines should be installed only with the specific approval of the cognizant code authority since chemicals not commonly found in drains and sewers and temperatures in excess of 140°F (60°C) may be encountered.

5. Application of Materials

5.1 The nominal folded PVC pipe sizes specified in Section 8 are applicable for a range of original pipe inside diameters. Table 1 lists the recommended ranges for each nominal size.

6. Materials and Manufacture

6.1 *Basic Materials*—The pipe shall be made from virgin PVC compound meeting all the requirements for cell classifications 12334-B, 12344-B, or 13223-B as defined in Specification D 1784.

6.2 *Rework Material*—Clean rework material, generated from the manufacturer’s own PVC sewer pipe production may be used by the same manufacturer provided that the rework material meets the requirements of 6.1 and that the pipe produced meets all the requirements of this specification.

7. Other Requirements

7.1 *Pipe Flattening*—There shall be no evidence of split-

TABLE 1 **Folded PVC Pipe, Recommended Size Ranges of Use**

NOTE—The minimum and maximum recommended existing pipe inside diameters shown in Table 1 are mean inside diameters along the pipe length and are not intended as absolute limits on localized dimensions. Consult the manufacturer for use of folded PVC pipe for sizes of existing pipe beyond the recommended ranges shown in Table 1.

Folded Pipe Nominal Outside Diameter, in. (mm)	Recommended Existing Pipe Inside Diameter Range, in. (mm)		Resulting DR over Diameter Range		
	min	max	DR 50	DR 41	DR 35
4 (102)	3.7 (94)	4.2 (107)	32–40
6 (152)	5.6 (142)	6.3 (160)	...	38–46	32–40
8 (203)	7.4 (188)	8.4 (213)	47–55	38–46	32–40
9 (229)	8.3 (211)	9.4 (239)	47–55	38–46	32–40
10 (254)	9.3 (236)	10.5 (267)	47–55	38–46	32–40
12 (305)	11.3 (287)	12.8 (325)	47–55	38–46	32–40
15 (381)	13.9 (353)	15.7 (399)	47–55	38–46	32–40

ting, cracking, or breaking when the rounded pipe is tested in accordance with 11.3.

7.2 *Pipe Impact Strength*—The impact strength of the rounded pipe shall not be less than the values given in Table 2 when tested in accordance with 11.4.

NOTE 3—This test is intended only for use as a quality-control test, not as a simulated service test.

7.3 *Pipe Stiffness*—Pipe stiffness values for the rounded pipe shall comply with Table 3 when tested in accordance with 11.6.

7.4 *Extrusion Quality*—The extrusion quality of the pipe shall be evaluated by both of the following test methods.

7.4.1 *Acetone Immersion*—The pipe shall not flake or disintegrate when tested in accordance with 11.6.1.

7.4.2 *Heat Reversion*—The extrusion quality shall be estimated by heat reversion method in accordance with 11.6.2.

7.5 *Flexural Properties*—Flexural modulus of elasticity values for the rounded pipe shall comply with Table 4 when tested in accordance with 11.7.

8. Dimensions, Mass, and Permissible Variations

8.1 *Rounded Pipe Diameter*—The average outside diameter of the rounded pipe shall meet the requirements given in Table 5 with a tolerance of ±1.0 % when measured in accordance with 11.2.1.

8.2 *Rounded Pipe Wall Thickness*—The minimum wall thickness of the rounded pipe, when measured in accordance with 11.2.2, shall not be less than the values specified in Table 5.

9. Workmanship, Finish, and Appearance

9.1 The rounded and folded pipes shall be homogeneous throughout and free from visible cracks, holes, foreign inclusions, or other injurious defects. The pipe shall be as uniform as commercially practical in color, opacity, density, and other physical properties.

10. Sampling

10.1 Rounded pipe sample preparation shall involve the unfolding and expansion of a folded pipe sample within a split pipe mold with an inside diameter equal to the nominal outside diameter shown in Table 2. A folded pipe sample of sufficient length (10 ft (3 m) maximum) to complete the testing requirements shall be inserted into the split pipe mold and secured at the ends. The assembly shall then be placed in an enclosed chamber for heating. Ambient pressure steam shall be applied to the chamber for at least a 15-min period at a minimum temperature of 200°F (93°C). While maintaining the minimum

TABLE 2 **Minimum Impact Strength at 73°F (23°C)**

Pipe Size, in. (mm)	Impact Strength, ft·lbf (J)
4 (102)	150 (203)
6 (152)	210 (284)
8 (203)	210 (284)
9 (229)	220 (299)
10 (254)	220 (299)
12 (305)	220 (299)
15 (381)	220 (299)