



Designation: **F412–16a F412 – 17**

Standard Terminology Relating to Plastic Piping Systems¹

This standard is issued under the fixed designation F412; 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.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope*

1.1 This terminology is a compilation of definitions of technical terms used in the plastic piping industry. Terms that are generally understood or adequately defined in other readily available sources are not included.

1.2 When a term is used in an ASTM document for which Committee F17 is responsible it is included only when judged, after review, by Subcommittee F17.91 to be a generally usable term.

1.3 Definitions that are identical to those published by other ASTM committees or other standards organizations are identified with the committee number (for example, D20) or with the abbreviation of the name of the organization (for example, IUPAC International Union of Pure and Applied Chemistry).

1.4 A definition is a single sentence with additional information included in notes.

1.5 Definitions are followed by the committee responsible for the standard(s) (for example, [F17.26]) and standard numbers(s) in which they are used (for example, F714).

1.6 Abbreviated Terminology—

1.6.1 Abbreviated terminology is intended to provide uniform contractions of terms relating to plastic piping that have evolved through widespread common usage. The compilation in this standard has been prepared to avoid the occurrence of more than one abbreviated term for a given plastics piping term and to avoid multiple meanings for abbreviated terms.

1.6.2 The abbreviated terminology and descriptions in this standard are intended to be consistent with usage in plastics piping and the standards under F17 jurisdiction. Other ASTM Committees may assign a different word-phrase description to the same abbreviated terminology. In such cases, the abbreviated terms in this standard shall apply to usage in F17 standards, or if widespread misunderstanding could result from conflicting abbreviated terminology descriptions, the abbreviated terminology for the word-phrase shall not be used in F17 standards.

1.6.3 Acronyms and Initialisms – A word formed from the letters or parts of words of a longer word-phrase, usually from the initial letters or parts of the words. An Acronym is pronounced as a word, for example radar, for radio detection and ranging. An Initialism is pronounced as a series of letters, for example DOT for Department of Transportation.

1.6.4 The Acronym or Initialism description is the origin word-phrase for the Acronym or Initialism, not a definition.

2. Referenced Documents

2.1 *ASTM Standards:*²

C114 Test Methods for Chemical Analysis of Hydraulic Cement

D256 Test Methods for Determining the Izod Pendulum Impact Resistance of Plastics

D638 Test Method for Tensile Properties of Plastics

D648 Test Method for Deflection Temperature of Plastics Under Flexural Load in the Edgewise Position

D747 Test Method for Apparent Bending Modulus of Plastics by Means of a Cantilever Beam

D790 Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials

D882 Test Method for Tensile Properties of Thin Plastic Sheeting

D883 Terminology Relating to Plastics

¹ This terminology is under the jurisdiction of ASTM Committee F17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.91 on Editorial and Terminology.

Current edition approved Nov. 15, 2016/Jan. 1, 2017. Published January 2017/February 2017. Originally approved in 1975. Last previous edition approved in 2016 as F412 – 16. DOI: 10.1520/F0412-16A.

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

- D907 Terminology of Adhesives
- D1003 Test Method for Haze and Luminous Transmittance of Transparent Plastics
- D1079 Terminology Relating to Roofing and Waterproofing
- D1238 Test Method for Melt Flow Rates of Thermoplastics by Extrusion Plastometer
- D1488 Test Method for Amylaceous Matter in Adhesives
- D1505 Test Method for Density of Plastics by the Density-Gradient Technique
- D1527 Specification for Acrylonitrile-Butadiene-Styrene (ABS) Plastic Pipe, Schedules 40 and 80 (Withdrawn 2013)³
- D1600 Terminology for Abbreviated Terms Relating to Plastics
- D1785 Specification for Poly(Vinyl Chloride) (PVC) Plastic Pipe, Schedules 40, 80, and 120
- D2104 Specification for Polyethylene (PE) Plastic Pipe, Schedule 40 (Withdrawn 2010)³
- D2239 Specification for Polyethylene (PE) Plastic Pipe (SIDR-PR) Based on Controlled Inside Diameter
- D2241 Specification for Poly(Vinyl Chloride) (PVC) Pressure-Rated Pipe (SDR Series)
- D2282 Specification for Acrylonitrile-Butadiene-Styrene (ABS) Plastic Pipe (Withdrawn 2006)³
- D2444 Test Method for Determination of the Impact Resistance of Thermoplastic Pipe and Fittings by Means of a Tup (Falling Weight)
- D2447 Specification for Polyethylene (PE) Plastic Pipe, Schedules 40 and 80, Based on Outside Diameter (Withdrawn 2010)³
- D2513 Specification for Polyethylene (PE) Gas Pressure Pipe, Tubing, and Fittings
- D2661 Specification for Acrylonitrile-Butadiene-Styrene (ABS) Schedule 40 Plastic Drain, Waste, and Vent Pipe and Fittings
- D2666 Specification for Polybutylene (PB) Plastic Tubing (Withdrawn 2003)³
- D2680 Specification for Acrylonitrile-Butadiene-Styrene (ABS) and Poly(Vinyl Chloride) (PVC) Composite Sewer Piping
- D2683 Specification for Socket-Type Polyethylene Fittings for Outside Diameter-Controlled Polyethylene Pipe and Tubing
- D2737 Specification for Polyethylene (PE) Plastic Tubing
- D2751 Specification for Acrylonitrile-Butadiene-Styrene (ABS) Sewer Pipe and Fittings (Withdrawn 2014)³
- D2837 Test Method for Obtaining Hydrostatic Design Basis for Thermoplastic Pipe Materials or Pressure Design Basis for Thermoplastic Pipe Products
- D2846/D2846M Specification for Chlorinated Poly(Vinyl Chloride) (CPVC) Plastic Hot- and Cold-Water Distribution Systems
- D3035 Specification for Polyethylene (PE) Plastic Pipe (DR-PR) Based on Controlled Outside Diameter
- D3139 Specification for Joints for Plastic Pressure Pipes Using Flexible Elastomeric Seals
- D3261 Specification for Butt Heat Fusion Polyethylene (PE) Plastic Fittings for Polyethylene (PE) Plastic Pipe and Tubing
- D3309 Specification for Polybutylene (PB) Plastic Hot- and Cold-Water Distribution Systems
- D3350 Specification for Polyethylene Plastics Pipe and Fittings Materials
- F402 Practice for Safe Handling of Solvent Cements, Primers, and Cleaners Used for Joining Thermoplastic Pipe and Fittings
- F405 Specification for Corrugated Polyethylene (PE) Pipe and Fittings (Withdrawn 2015)³
- F441/F441M Specification for Chlorinated Poly(Vinyl Chloride) (CPVC) Plastic Pipe, Schedules 40 and 80
- F442/F442M Specification for Chlorinated Poly(Vinyl Chloride) (CPVC) Plastic Pipe (SDR-PR)³
- F449 Practice for Subsurface Installation of Corrugated Polyethylene Pipe for Agricultural Drainage or Water Table Control
- F628 Specification for Acrylonitrile-Butadiene-Styrene (ABS) Schedule 40 Plastic Drain, Waste, and Vent Pipe With a Cellular Core
- F645 Guide for Selection, Design, and Installation of Thermoplastic Water- Pressure Piping Systems
- F714 Specification for Polyethylene (PE) Plastic Pipe (DR-PR) Based on Outside Diameter
- F771 Specification for Polyethylene (PE) Thermoplastic High-Pressure Irrigation Pipeline Systems (Withdrawn 2013)³
- F876 Specification for Crosslinked Polyethylene (PEX) Tubing
- F877 Specification for Crosslinked Polyethylene (PEX) Hot- and Cold-Water Distribution Systems
- F891 Specification for Coextruded Poly(Vinyl Chloride) (PVC) Plastic Pipe With a Cellular Core
- F948 Test Method for Time-to-Failure of Plastic Piping Systems and Components Under Constant Internal Pressure With Flow
- F1025 Guide for Selection and Use of Full-Encirclement-Type Band Clamps for Reinforcement or Repair of Punctures or Holes in Polyethylene Gas Pressure Pipe
- F1281 Specification for Crosslinked Polyethylene/Aluminum/Crosslinked Polyethylene (PEX-AL-PEX) Pressure Pipe
- F1335 Specification for Pressure-Rated Composite Pipe and Fittings for Elevated Temperature Service (Withdrawn 2011)³
- F1473 Test Method for Notch Tensile Test to Measure the Resistance to Slow Crack Growth of Polyethylene Pipes and Resins
- F1488 Specification for Coextruded Composite Pipe
- F1499 Specification for Coextruded Composite Drain, Waste, and Vent Pipe (DWV)
- F1668 Guide for Construction Procedures for Buried Plastic Pipe
- F1733 Specification for Butt Heat Fusion Polyamide(PA) Plastic Fitting for Polyamide(PA) Plastic Pipe and Tubing
- F1760 Specification for Coextruded Poly(Vinyl Chloride) (PVC) Non-Pressure Plastic Pipe Having Reprocessed-Recycled Content

³ The last approved version of this historical standard is referenced on www.astm.org.

- F1924** Specification for Plastic Mechanical Fittings for Use on Outside Diameter Controlled Polyethylene Gas Distribution Pipe and Tubing
- F1948** Specification for Metallic Mechanical Fittings for Use on Outside Diameter Controlled Thermoplastic Gas Distribution Pipe and Tubing
- F1970** Specification for Special Engineered Fittings, Appurtenances or Valves for use in Poly (Vinyl Chloride) (PVC) or Chlorinated Poly (Vinyl Chloride) (CPVC) Systems
- F1973** Specification for Factory Assembled Anodeless Risers and Transition Fittings in Polyethylene (PE) and Polyamide 11 (PA11) and Polyamide 12 (PA12) Fuel Gas Distribution Systems
- F1986** Specification for Multilayer Pipe Type 2, Compression Fittings, and Compression Joints for Hot and Cold Drinking-Water Systems
- F1987** Specification for Multilayer Pipe Type 2, Compression Fittings, and Compression Joints for Hydronic Heating Systems
- F2145** Specification for Polyamide 11 (PA 11) and Polyamide 12 (PA12) Mechanical Fittings for Use on Outside Diameter Controlled Polyamide 11 and Polyamide 12 Pipe and Tubing
- F2158** Specification for Residential Central-Vacuum Tube and Fittings
- F2160** Specification for Solid Wall High Density Polyethylene (HDPE) Conduit Based on Controlled Outside Diameter (OD)
- F2176** Specification for Mechanical Couplings Used on Polyethylene Conduit, Duct and Innerduct
- F2623** Specification for Polyethylene of Raised Temperature (PE-RT) SDR 9 Tubing
- F2769** Specification for Polyethylene of Raised Temperature (PE-RT) Plastic Hot and Cold-Water Tubing and Distribution Systems
- F2788/F2788M** Specification for Metric and Inch-sized Crosslinked Polyethylene (PEX) Pipe
- F2818** Specification for Specification for Crosslinked Polyethylene (PEX) Material Gas Pressure Pipe and Tubing
- F2829/F2829M** Specification for Metric- and Inch-Sized Crosslinked Polyethylene (PEX) Pipe Systems
- F2905/F2905M** Specification for Black Crosslinked Polyethylene (PEX) Line Pipe, Fittings and Joints For Oil and Gas Producing Applications
- F2929** Specification for Crosslinked Polyethylene (PEX) Tubing of 0.070 in. Wall and Fittings for Radiant Heating Systems up to 75 psig
- F2968/F2968M** Specification for Black Crosslinked Polyethylene (PEX) Pipe, Fittings and Joints For Gas Distribution Applications
- 2.2 *ISO Standards:*⁴
- ISO 3** Preferred Numbers
- ISO 497** Preferred Numbers
- ISO 12161** Thermoplastic materials for pipes and fittings for pressure applications – Classification, designation and design coefficient
- ISO R 161** Pipes of Plastics Materials for the Transport of Fluids (Outside Diameters and Nominal Pressures) Part I, Metric Series
- ISO TR 9080** Thermoplastics Pipes for the Transport of Fluids-Methods of Extrapolation of Hydrostatic Stress Rupture Data to Determine the Long-Term Hydrostatic Strength of Thermoplastic Pipe Materials
- 2.3 *ANSI Standard:*⁴
- Z17.1** ANSI Preferred Numbers
- 2.4 *PPI Standard:*⁵
- PPI TR-4**

3. Terminology

acceptance testing—testing performed on a product to determine whether or not an individual lot of the product conforms with specified requirements. [F17]

⁴ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

⁵ Available from Plastics Pipe Institute (PPI), 105 Decker Court, Suite 825, Irving, TX 75062, <http://www.plasticpipe.org>.

DISCUSSION—

The number of requirements are usually fewer than for **qualification testing** (see definition).

acetal plastics, n—highly crystalline linear thermoplastic homopolymers or copolymers characterized by repeating oxymethylene units. [F17]

acrylonitrile-butadiene-styrene (ABS) pipe and fitting plastics—plastics containing polymers or blends of polymers, or both, in which the minimum butadiene content is 6%, the minimum acrylonitrile content is 15 %, the minimum styrene or substituted styrene content, or both, is 15 %, and the maximum content of all other monomers is not more than 5 %; plus lubricants, stabilizers, and colorants. **[F17.61] D1527, D2282 [17.62] D2680, D2751**

adhesive—a substance capable of holding materials together by surface attachment. **[F17]**

adhesive bonded joint—see **joint, adhesive bonded**.

adhesive, solvent—see **solvent cement**.

adiabatic extrusion—a method of extrusion in which, after the extrusion apparatus has been heated sufficiently by conventional means to plastify the material, the extrusion process can be continued with the sole source of heat being the conversion of the drive energy, through viscous resistance of the plastic mass in the extruder. **[D20] D883**

aging, n—

(1) the effect on materials of exposure to an environment for an interval of time.

(2) the process of exposing materials to an environment for an interval of time. **[D20] D883**

alloy, n—*in plastics*, two or more immiscible polymers united, usually by another component, to form a plastic resin having enhanced performance properties. **[D20] D883**

allowable stress—The maximum force per unit area that may be safely applied to a pipe.

DISCUSSION—

In Guide **F645**, the *allowable stress* is determined by multiplying the *hydrostatic design stress* (HDS) at 73°F by the *temperature correction factor*. **[F17.61] F645**

antioxidant, n—compounding ingredient used to retard deterioration caused by oxidation. **[F17]**

apparent density—the weight per unit volume of a material including voids inherent in the material as tested. **[F17]**

DISCUSSION—

The term bulk density is commonly used for material such as molding powder.

approving authority—the individual official, board, department, or agency established and authorized by a state, county, city, or other political subdivision, created by law to administer and enforce specified requirements.

artificial weathering—exposure to laboratory conditions, which may be cyclic, involving temperature, relative humidity, radiant energy, or any other conditions or pollutants found in the atmosphere in various geographical areas; or both. **[F17]**

DISCUSSION—

The interlaboratory exposure conditions are usually intensified beyond those encountered in actual outdoor exposure in an attempt to achieve an accelerated effect.

backfill—all material used to fill the trench from bedding to finished surface. **[F17.65] F449, F1668**

backfill, final—material used to fill the trench from initial backfill to finished surface. **[F17]**

backfill, initial—material used to fill the trench from top of bedding to a designated height over the pipe. **[F17]**

backfill, pipe zone—see **pipe zone backfill**.

backfill, unconsolidated—noncompacted material in place in trench. **[F17]**

bead-up cycle, n—part of the fusion procedure that insures complete contact between the heater surfaces and the pipe ends by applying pressure such as fusion joining pressure to force the pipe ends against the heater surfaces.

DISCUSSION—

The bead-up cycle begins at initial contact of the pipe ends against the heater and ends when an indication of melt (slight melt bead) is observed around the pipe circumference.

beam loading—the application of a load to a pipe between two points of support, usually expressed in newtons (or pounds-force) and the distance between the centers of the supports. **[F17]**

bedding, n—materials placed in the bottom of the trench on top of the foundation soil which provides stable bottom support for buried pipe including the trench bottom groove support angle or select material placed around the pipe, and envelope or filter materials where used during insulation. [F17.65] **F449, F1668**

bedding, v—placement of support materials for buried pipe. [F17]

bell-and-spigot joint—see **joint, bell-and-spigot gasket**.

bell end—the enlarged portion of a pipe that resembles the socket portion of a fitting and that is intended to be used to make a joint. [F17]

bend—a fitting either molded separately or formed from pipe for the purpose of accommodating a directional change. [F17]

DISCUSSION—

Also called *ell, elbow, or sweep*. Bends generally imply fittings of relatively shorter radii than sweeps.

beveled pipe—a pipe with an end chamfered to mate or adjust to another surface or to assist in assembly. [F17]

binder, n—in a reinforced plastic, the continuous phase which holds together the reinforcement. [D20] **D883**

DISCUSSION—

During fabrication, the binder, which may be either thermoplastic or thermoset, usually undergoes a change in state.

blinding—the placement of soil, bedding material over and on the sides of the pipe, tubing or envelope to ensure proper grade, alignment, support, and protection of pipe during backfilling and after installation. [F17.65] **F449**

blister, n—an imperfection, a rounded elevation of the surface of a plastic, with boundaries that may be more or less sharply defined, somewhat resembling in shape a blister on the human skin. [D20] **D883**

bloom, n—a visible exudation or efflorescence on the surface of a material. [D20] **D883**

blow molding—a method of fabrication in which a heated parison (hollow tube) is forced into the shape of a mold cavity by internal gas pressure. [D20] **D883**

blowing agent—a compounding ingredient used to produce gas by chemical or thermal action, or both, in manufacture of hollow or cellular articles. [D20] **D883**

brittle failure—a pipe failure mode which exhibits no visible (to the naked eye) permanent material deformation (stretching, elongation, or necking down) in the area of the break. [F17.40] **F1473**

building drain—that part of the lowest horizontal piping of a drainage system that receives the discharge from soil, waste, and other drainage pipes inside the walls of the building and conveys it to the building sewer beyond the foundation walls of the building or structure. [F17]

DISCUSSION—

The building sewer generally begins 2 to 5 ft beyond the foundation walls.

building drain (sanitary)—a building drain that conveys gray water or sewage, or both. [F17]

building drain (storm)—a building drain that conveys storm water only. [F17]

building sanitary sewer—that part of the horizontal piping of a sanitary drainage system which extends from the building sanitary drain, receives the discharge of the building sanitary drain, and conveys it to a public sewer, private sewer, individual sewage disposal system, or other point of disposal. [F17]

building storm sewer—that part of the horizontal piping of a storm drainage system which extends from the building storm drain, receives the discharge of the building storm drain, and conveys it to a public storm sewer, private storm sewer, or other point of disposal. [F17]

building supply—See **water service**.

bulk factor, n—the ratio of the volume of a given mass of molding material to its volume in the molded form. ISO/[D20] **D883**

DISCUSSION—

The bulk factor is also equal to the ratio of the density of the material to its apparent density in the unmolded form.

burst strength—the internal pressure required to cause a pipe or fitting to fail. [F17]

DISCUSSION—

This pressure will vary with the rate of buildup of the pressure and the time during which the pressure is held.

butt-fused joint—see **joint, butt-fused**.

butylene plastics—plastics based on resins made by the polymerization of butene or copolymerization of butene with one or more unsaturated compounds, the butene being in greatest amount by weight. [D20] D883

cell, n—a small cavity surrounded partially or completely by walls. [D20] D883

cell, closed—a cell totally enclosed by its walls and hence not interconnecting with other cells. (See also **cell** and **cell, open**.) ISO/[D20] D883

cell, open—a cell not totally enclosed by its walls and hence interconnecting with other cells. (See also **cell** and **cell, closed**.) [D20] D883

cellular plastic—a plastic containing numerous cells, intentionally introduced, interconnecting or not, distributed throughout the mass. [D20] D883 [17.63] F628 [17.25] F891

cellulose acetate butyrate (CAB) plastics—plastic made by compounding a cellulose acetate butyrate ester with plasticizers and other ingredients. Cellulose acetate butyrate ester is a derivative of cellulose (obtained from cotton or wool pulp, or both) made by converting some of the hydroxyl groups in cellulose to acetate and butyrate groups with chemicals. [F17]

central vacuum tubing, n—plastic tubing used for residential central vacuum systems in which outside diameter is controlled and where the wall thickness is usually small when compared to the diameter. [F17.25] F2158

chalking, n—*in plastics*, a powdery residue on the surface of a material resulting from degradation or migration of an ingredient, or both. [D20] D883

DISCUSSION—

Chalking may be a designed-in characteristic.

chamfered pipe—a pipe with a conical surface (angle) made by cutting off the edge around the outside diameter on the end of a pipe. <https://standards.iteh.ai/catalog/standards/sist/4860fbc8-5f30-4ae3-9e3f-1de972723ba9/astm-f412-17>

DISCUSSION—

To assist in assembly, of socket joining, (solvent cementing, gasketed, and socket fusion) burrs on the pipe OD are removed by chamfering. Refer to product manufacturer’s recommendations. [F17]

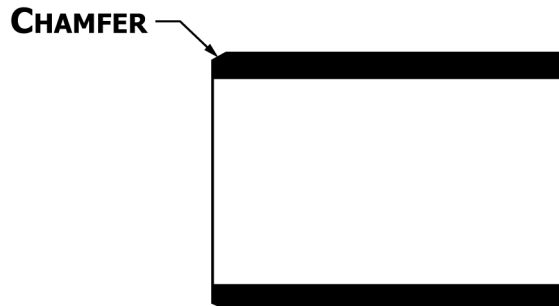


FIG. 1 Chamfered Pipe

chemical cleaner—see **cleaner, chemical**.

chemical resistance—the ability to resist chemical attack. [F17]

DISCUSSION—

The attack is dependent on the method of test and its severity is measured by determining the changes in physical properties. Time, temperature, stress, and reagent may all be factors that affect the chemical resistance of a material.

chemically formed polymeric material—a cellular material in which the cells are formed by gases generated from thermal decomposition or other chemical reaction. **[D20] D883**

chlorinated poly(vinyl chloride) plastics—plastics based on chlorinated poly(vinyl chloride) in which the chlorinated poly(vinyl chloride) is in the greatest amount by weight. **[D20] D883**

chlorofluorocarbon plastics—plastics based on polymers made with monomers composed of chlorine, fluorine, and carbon only. **ISO/ [D20] D883**

chlorofluorohydrocarbon plastics, n—plastics based on polymers made with monomers composed of chlorine, fluorine, hydrogen, and carbon only. **ISO/[D20] D883**

cleaner, chemical—an organic solvent used to remove foreign matter from the surface of plastic pipe and fittings. **[F17.20] F402**

DISCUSSION—

Cleaners have essentially no effect on the plastic surface being cleaned and may be used prior to joining with a solvent cement or adhesive.

cleaner, mechanical—an abrasive material or device used to remove foreign matter and gloss from the surface of plastic pipe and fittings. **[F17]**

DISCUSSION—

Mechanical cleaners may be used prior to joining with a solvent cement or adhesive.

closed-cell cellular plastics—cellular plastics in which almost all the cells are noninterconnecting. **[D20] D883 [F17.63] F628**

closed-cell foamed plastics—See **closed-cell cellular plastics**.

code—(1) a system of symbols, letters or numbers, used to convey a message requiring brevity; (2) a set of rules established by a legal or quasi-legal body. **[F17]**

code, classification—a code that identifies a plastic material by its properties in accordance with the pertinent ASTM specification. **[F17]**

code, manufacturer's—a code that provides manufacturing identity for a piping product. **[F17]**

code, thermoplastic pipe material designation— letters and ciphers for the designation of stress-rated thermoplastic compound, which consists of two or more characters to indicate the abbreviation as listed in Terminology D1600, for the type of thermoplastic resin—followed by four or five Arabic numerals—two or three to describe the short-term properties, in accordance with the ASTM standard being referenced, and two to designate the hydrostatic design stress when tested in water at 73°F (23°C) in units of 100 psi, with any decimal figures dropped. **[F17]**

DISCUSSION—

In some ASTM standards, the short-term properties with more than two numbers have a table provided to convert to two numbers to be used in the code.

DISCUSSION—

When the hydrostatic design stress code is less than two numbers, a zero is inserted before the number.

DISCUSSION—

For polyethylene compound, the short-term properties are described using two Arabic numerals in accordance with Specification **D3350**, specifically, the cell classification number value for density followed by the cell classification number value for slow crack growth resistance.

DISCUSSION—

For crosslinked polyethylene (PEX) materials, the short-term properties are described using two Arabic numerals in accordance with Specification **F876**, specifically, a digit for chlorine resistance performance followed by a digit for UV resistance performance.

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. [F17.63] **D2661, F628 [F17.25] F891, F1760 [F17.11] F1488**

cold flow—See **creep**.

cold molding—a special process of compression molding in which the molding is formed at room temperature and subsequently baked at elevated temperatures. [D20] **D883**

collapse, *n*—(1) inadvertent densification of cellular material during manufacture resulting from breakdown of cell structure; (2) the buckling of the inner liner of composite piping; (3) the buckling or flattening of a plastic rehabilitation liner; (4) the buckling or crushing of a plastic pipe from external forces, such as earth loads or external hydrostatic load. [F17]

compaction, soil—act of packing soil with mechanical force to increase its density. [F17]

compatible—(1) a condition wherein components of a plastic piping system or different specific plastic materials, or both, can be joined together for satisfactory joints. (2) in relation to elastomeric seal joints, a condition wherein the elastomer does not adversely affect the pertinent properties of the plastic pipe or fittings, or both, when the sealing gasket is in intimate contact with the plastic for a prolonged period. [F17]

composite pipe—pipe consisting of two or more different materials arranged with specific functional purpose to serve as pipe. [F17]

compound, *n*—a mixture of a polymer with other ingredients such as fillers, stabilizers, catalysts, processing aids, lubricants, modifiers, pigments, or curing agents. [F17.11] **F1488, F1499**

compression fitting joint—see **joint, compression fitting**.

compression gasket joint—see **joint, compression gasket**.

compression molding—the method of molding a material already in a confined cavity by applying pressure and usually heat. [D20] **D883**

conduit, (duct), *n*—a tubular raceway for carrying electric wires, cables, or other conductors. [F17.10] **F2176 [F17.26] F2160**

consolidation—reduction in volume of soil as a result of gravitational forces. [F17]

contamination—the presence of a substance not intentionally incorporated in a product. [F17]

continuous waste—a drain connecting two or more plumbing fixtures or components of plumbing fixtures to a common trap. [F17]

cool time at fusion pressure, (minimum), *n*—the minimum duration that fusion pressure is maintained while the joined pipe faces drop in temperature and solidify.

coupon, *n*—a piece or portion of a sample used to make a specimen.

crack—any narrow opening or fissure in the surface that is visible to the naked eye. [F17.65] **F405**

crater, *n*—a small, shallow surface imperfection. [D20] **D883**

crazing, *n*—apparent fine cracks at or under the surface of a plastic. [D20] **D883**

DISCUSSION—

The crazed areas are composed of polymeric material of lower density than the surrounding matrix.

creep, *n*—the time-dependent part of strain resulting from stress, that is dimensional change caused by the application of load over and above the elastic deformation and with respect to time. [D20] **D883, [17.60] F1025**

cross laminate—a laminate in which some of the layers of material are oriented approximately at right angles to the remaining layers with respect to the grain or strongest direction in tension. (See also **parallel laminate**.) [D20] **D883**

crosslinked polyethylene (PEX), *n*—a polyethylene material that has undergone a change in molecular structure through processing whereby a majority of the polymer chains are chemically linked. [F17] **F876, F1281, F2788/F2788M, F2818, F2829/F2829M, F2905/F2905M, F2929, F2968/F2968M**

crosslinking, *n*—the formation of a three dimensional polymer by means of interchain reactions resulting in changes in physical properties. [D20] **D883**

cure, v —to change the properties of a polymeric system into a more stable, usable condition by the use of heat, radiation, or reaction with chemical additives. ISO/[D20] D883

DISCUSSION—

Cure may be accomplished, for example, by removal of solvent or by crosslinking.

deadload—the static load imposed on the top of the pipe. [F17]

deburred pipe—a pipe with the sharp edge and/or cutting remnants removed from the pipe end ID or OD edges.

DISCUSSION—

Pipe cutting can result in burrs and shavings at the pipe ID and OD edges. Sharp edges and cutting remnants can interfere with flow or joining. For socket joining, (solvent cementing, gasketed and socket fusion) burrs on the pipe OD are removed by chamfering. Refer to product manufacturers recommendations. [F17]

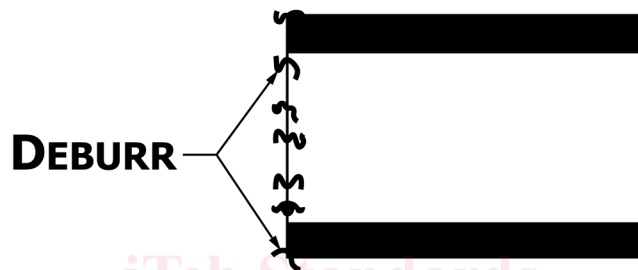


FIG. 2 Deburred Pipe

deflection temperature—the temperature at which a specimen will deflect a given distance at a given load under prescribed conditions of test. (See Test Method D648.) Formerly called heat distortion. [F17]

degradation, n —a deleterious change in chemical structure, physical properties, or appearance of a plastic. [D20] D883

density, apparent—see **apparent density**.

density of plastics—the weight per unit volume of material at 23°C expressed as D23c, g/cm^3 (kg/m^3). [F17]

DISCUSSION—

Taken from Test Method D1505.

depth, n —in the case of a beam, the dimension parallel to the direction in which the load is applied. [D20] D883

diffusion—the movement of a material such as a gas or liquid, in the body of a plastic. [F17]

DISCUSSION—

If the gas or liquid is absorbed on one side of a piece of plastic and given off on the other side, the phenomenon is called permeability. Diffusion and permeability are not due to holes or pores in the plastic.

dimension ratio (DR)—the average specified diameter of a pipe or tubing divided by the minimum specified wall thickness. The DR values shall be rounded to the nearest 0.5 unless otherwise specified. [F17.10] D2683, D3261, F1733 [17.11] D1488 [F17.26] D2737, [F17.60] D2513

DISCUSSION—

Each pipe can have two dimension ratios depending on whether the outside or inside diameter is used. In practice, the outside diameter is used if the standards requirement and manufacturing control are based on this diameter. The inside diameter is used when this measurement is the controlling one.

drag pressure (psi), n —the fusion machine's hydraulic pressure required to overcome the static and dynamic resistance to motion of the movable carriage.

dry-blend, n —dry compound prepared without fluxing or addition of solvent (also called powder blend). [D20] D883

- ductile failure**—a pipe failure mode which exhibits material deformation (stretching, elongation, or necking down) in the area of the break. [F17]
- elastomer, *n***—a macromolecular material that at room temperature returns rapidly to approximately its initial dimensions and shape after substantial deformation by a weak stress and release of the stress. [D20] **D883**
- elastomeric seal**—a material or device that uses an elastomer to effect a seal between separable piping components. [F17]
- elevated temperature testing**—tests on plastic pipe above 23°C (73°F). [F17]
- embedment**—the placement of materials completely around the pipe to provide support. [F17.62] **F1668**
- encasement, *n***—see **incasement, *n***.
- encasement, *v***—see **incasement, *v***.
- engineering plastics, *n***—those plastics and polymeric compositions for which well-defined properties are available, such that engineering rather than empirical methods can be used for design and manufacture of products requiring definite and predictable performance in structural applications over a substantial temperature range. [D20] **D883**
- envelope, drainage**—the materials completely surrounding a pipe to provide support or protection or act as a filter. [F17]
- environmental stress cracking**—the development of cracks in a material that is subjected to stress or strain in the presence of specific chemicals. [F17]
- ethylene plastics, *n***—plastics based on polymers of ethylene or copolymers of ethylene with other monomers, the ethylene being in greatest amount by mass. ISO/[D20] **D883**
- exfiltration, pipe**—the passage of fluid from a pipe section through small holes or leaks. [F17]
- expandable plastic, *n***—a plastic in a form capable of being made cellular by thermal, chemical, or mechanical means. [D20] **D883**
- expanded plastics*—See **cellular plastics**.
- extrusion, *n***—a process in which heated or unheated plastic is forced through a shaping orifice (a die) in one continuously formed shape as film, sheet, rod, or tubing. [D20] **D883**
- extrusion, adiabatic**—see **adiabatic extrusion**.
- fabricating, *n***—the manufacture of plastic products from molded parts, rods, tubes, sheeting, extrusions, or other forms by appropriate operations such as punching, cutting, drilling, and tapping including fastening plastic parts together or to other parts by mechanical devices, adhesives, heat sealing, or other means. [D20] **D883**
- failure, adhesive**—rupture of an adhesive bond, such that the plane of separation appears to be at the adhesive-adherend interface. [F17]
- failure, brittle**—see **brittle failure**
- failure, ductile**—see **ductile failure**
- failure, slit**—see **silt failure**
- filler, *n***—a relatively inert material added to a plastic to modify its strength, permanence, working properties, or other qualities or to lower costs. (See also **reinforced plastic**.) [D20] **D883**
- fish-eye, *n***—small globular mass that has not blended completely into the surrounding material. [D20] **D883**
- fitting, *n***—a piping component used to join or terminate sections of pipe or to provide changes of direction or branching in a pipe system. [F17]
- flanged joint*—see **joint, flanged**.
- flare joint*—see **joint, flare**.
- flow rate**—rate of extrusion, weight per unit of time, g/10 min (kg/s), of molten resins through a die of specified length and diameter, under prescribed conditions of temperature, load, and piston position in the barrel as the timed measurement is being made. [F17]
- fluorocarbon plastic, *n***—a plastic based on polymers made with perfluoromonomers. ISO/[D20] **D883**

DISCUSSION—

When the monomer is essentially tetrafluoroethylene, the prefix TFE is sometimes used to designate these materials. It is preferable to use the accepted

abbreviation, PFTE. TFE should not be used by itself to mean PTFE. When the resins are copolymers of tetrafluoroethylene and hexafluoropropylene, the resins may be designated with the prefix FEP. Other prefixes may be adopted to designate other fluorocarbon plastics.

fluorohydrocarbon plastics, *n*—plastics based on polymers made with monomers composed of fluorine, hydrogen, and carbon only. **ISO/[D20] D883**

fluoroplastic, *n*—a plastic based on polymers made from monomers containing one or more atoms of fluorine, or copolymers of such monomers with other monomers, the fluorine-containing monomer(s) being in the greatest amount by mass. **[D20] D883**

DISCUSSION—

For specific examples of fluoroplastic see **fluorocarbon plastic, chlorofluorocarbon plastics, fluorohydrocarbon plastics, and chlorofluorohydrocarbon plastic.**

*foamed plastics, *n**—See **cellular plastics** (the preferred terminology).

forming, *n*—a process in which the shape of plastic pieces such as sheets, rods, or tubes is changed to a desired configuration. **[D20] D883**

DISCUSSION—

The use of the term “forming” in plastics technology does not include such operations as molding, casting, or extrusion, in which shapes or pieces are made from molding materials or liquids.

frosting, *n*—a light-scattering surface resembling fine crystals. See also **chalking, haze, bloom.** **[F17]**

fungi resistance—the ability of plastic pipe to withstand fungi growth or their metabolic products, or both, under normal conditions of service or laboratory tests simulating such conditions. **[F17]**

fuse, *v*—(1) to convert plastic powder or pellets into a homogeneous mass through heat and pressure; (2) to make a plastic piping joint by heat and pressure. **[F17]**

fusion cycle, *n*—the pressure / time sequence, at a defined heater surface temperature for the fusion procedure, beginning with the bead-up cycle and ending when the cooling time is complete.

fusion machine operator, *n*—a trained person qualified to perform fusion joining of plastic pipes and/or fittings based on a fusion procedure.

fusion pressure (psi), *n*—for machines with hydraulic pressure capability, this is a calculated number determined by adding the theoretical fusion pressure (psi) and the drag pressure (psi).

DISCUSSION—

This is the gauge pressure used by the butt fusing operator on the butt fusing machine to join the pipe ends.

fusion procedure, *n*—a written document that provides detailed steps for performing fusion joining that has been qualified by testing.

gasket joint—see **joint, compression gasket** and **joint, bell-and-spigot gasket.**

gate, *n*—in an injection mold, a constriction in the flow channel between the runner and the mold cavity. **[D20] D883**

gel, *n*—(1) a semisolid system consisting of a network of solid aggregates in which liquid is held; (2) the initial jelly-like solid phase that develops during the formation of a resin from a liquid; (3) with respect to vinyl plastisols, gel is a state between liquid and solid that occurs in the initial stages of heating, or upon prolonged storage. **[D20] D883**

DISCUSSION—

All three types of gel have very low strengths and do not flow like a liquid. They are soft, flexible, and may rupture under their own weight unless supported externally.

gel point—the stage at which a liquid begins to exhibit pseudo-elastic properties. **[D20] D883**

DISCUSSION—

This stage may be conveniently observed from the inflection point on a viscosity-time plot. (See **gel** (2).)