



# Standard Specification for Poly(Vinyl Chloride) (PVC) Plastic Pipe Fittings, Schedule 40<sup>1</sup>

This standard is issued under the fixed designation D2466; 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 ( $\epsilon$ ) 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 specification covers poly(vinyl chloride) (PVC) Schedule 40 pipe fittings. Included are requirements for materials, workmanship, dimensions, and burst pressure.

NOTE 1—Socket-type CPVC plastic pipe fittings, Schedule 40, which were formerly included in this standard, are now covered by Specification F438.

1.2 The products covered by this specification are intended for use with the distribution of pressurized liquids only, which are chemically compatible with the piping materials. Due to inherent hazards associated with testing components and systems with compressed air or other compressed gases, some manufacturers do not allow pneumatic testing of their products. Consult with specific product/component manufacturers for their specific testing procedures prior to pneumatic testing.

NOTE 2—Pressurized (compressed) air or other compressed gases contain large amounts of stored energy which present serious safety hazards should a system fail for any reason.

1.3 Fitting such as unions, flanges, special plastic-to-metal transitions and appurtenances intended for use with PVC piping are covered under specification F1970.

1.4 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.

1.5 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 The following safety hazards caveat pertains only to the test method portion, Section 7, 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.*

1.7 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

## 2. Referenced Documents

2.1 ASTM Standards:<sup>2</sup>

D618 Practice for Conditioning Plastics for Testing

D1599 Test Method for Resistance to Short-Time Hydraulic Pressure of Plastic Pipe, Tubing, and Fittings

D1600 Terminology for Abbreviated Terms Relating to Plastics

D1784 Specification for Rigid Poly(Vinyl Chloride) (PVC) Compounds and Chlorinated Poly(Vinyl Chloride) (CPVC) Compounds

D2122 Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings

D2749 Symbols for Dimensions of Plastic Pipe Fittings

F412 Terminology Relating to Plastic Piping Systems

F438 Specification for Socket-Type Chlorinated Poly(Vinyl Chloride) (CPVC) Plastic Pipe Fittings, Schedule 40

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

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee F17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.10 on Fittings. Current edition approved March 1, 2015; Aug. 1, 2017. Published July 2015; August 2017. Originally approved in 1965. Last previous edition approved in 2013 as D2466—13; D2466 – 15. DOI: 10.1520/D2466-15; 10.1520/D2466-17.

<sup>2</sup> 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

**F1970** Specification for Special Engineered Fittings, Appurtenances or Valves for use in Poly (Vinyl Chloride) (PVC) or Chlorinated Poly (Vinyl Chloride) (CPVC) Systems

2.2 *NSF Standards:*

**Standard No. 14** for Plastic Piping Components and Related Materials<sup>3</sup>

**Standard No. 61** for Drinking Water Systems Components—Health Effects<sup>3</sup>

### 3. Terminology

3.1 *General*—Definitions are in accordance with Terminology **F412**, and abbreviations are in accordance with Terminology **D1600**, unless otherwise indicated. The abbreviation for poly(vinyl chloride) plastic is PVC.

### 4. Classification

4.1 *General*—This specification covers Schedule 40 PVC pipe fittings, made from four PVC plastic compounds and intended for use with Iron Pipe Size (IPS) outside-diameter plastic pipe.

4.1.1 Fittings covered by this specification are normally molded. In-line fittings, such as couplings, bushings, caps, nipples, etc., shall be molded or machined from extruded stock.

4.1.2 Fittings fabricated by welding are not included in this specification.

### 5. Materials

5.1 This specification covers PVC pipe fittings made from five PVC plastics as classified in Specification **D1784**. These are PVC 12454, 12454, 13354, 11443, and 14333.

5.2 *Compound*—The PVC plastic compound shall meet the requirements of PVC 12454, 12454, 11443, or 14333, as described in Specification **D1784**.

NOTE 3—Mechanical strength, heat resistance, flammability, and chemical resistance requirements are covered in Specification **D1784**.

5.3 *Rework Material*—The manufacturers shall use only their own clean rework fitting material and the fittings produced shall meet all the requirements of this specification.

### 6. Requirements

6.1 *Dimensions and Tolerances:*

6.1.1 Fitting sockets inside diameters (waterways), minimum wall thicknesses, and dimensions shall be as shown in **Table 1**, **Table 2**, and **Table 3** when measured in accordance with Test Method **D2122**.

6.1.2 When multistep reducer bushings are cored out, the inner socket shall be reinforced from the outer wall by a minimum of three ribs extending from the top of the inner socket to the deepest extremity of the coring. The transition from D to DJ (**Table 3**) shall be straight, tapered as shown, or radiused. A positive taper in the same direction of the taper in the socket on the outside diameter of the bushing is optional (See XA/XB in **Table 3**). Any point measured along the outside diameter of the bushing (between points XA and XB) shall not fall below minimum pipe OD.

6.1.3 The minimum wall thickness of fittings shall be 125 % of the minimum wall thickness of the corresponding size of Schedule 40 pipe for which they are designed to be used, except that for the socket, the wall thickness shall be at least equal to the minimum wall thickness of the corresponding size of Schedule 40 pipe. For any threaded fitting the minimum wall thickness of the threaded portion shall be at least equal to the thickness of material under the thread root of threaded Schedule 80 pipe of the same size.

6.1.4 The minimum inside diameter of the fittings shall be not less than the minimum specified inside diameter of the corresponding size of Schedule 40 pipe. Any fitting having a male thread shall have an internal diameter not larger than Schedule 80 pipe of the same size.

6.1.5 Minimum dimensions have zero negative tolerance. Tolerances on other dimensions are shown in **Table 1** and **Table 3**.

6.2 *Threads*—For all fittings having taper pipe threads, threads shall conform to Specification **F1498** and be gaged in accordance with **8.4**.

6.3 *Burst Pressure:*

6.3.1 The minimum burst strength of the fittings shall be not less than that calculated for the size and wall thickness of the pipe with which it is to be used, when calculated from the following equation:

$$S = P(D_o - t)/2t \quad (1)$$

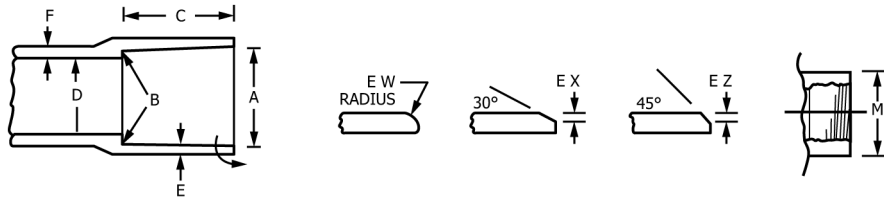
where:

$S$  = hoop stress, psi (or MPa),

$P$  = internal pressure, psi (or MPa),

<sup>3</sup> Available from NSF International, P.O. Box 130140, 789 N. Dixboro Rd., Ann Arbor, MI 48113-0140, <http://www.nsf.org>.

TABLE 1 Tapered Sockets for PVC Pipe Fittings, Schedule 40, in.<sup>A</sup>



Nominal Pipe Size	A Socket Entrance Diameter			B Socket Bottom Diameter			C <sup>B</sup> Socket Length, min	D <sup>C</sup> Inside Diameter, min	Wall Thickness, min		Min Outside Diameter of Hub, M	Entrance, min	
	Diameter	Tolerance on Diameter	Max Out-of-Round	Diameter	Tolerance on Diameter	Max Out-of-Round			E	F		EW	EX, EZ
1/8	0.417	±0.004	0.016 (0.41)	0.401	±0.004	0.016 (0.41)	0.500	0.225	0.068	0.085	0.526	1/64	1/64
1/4	0.552	±0.004	0.016 (0.41)	0.536	±0.004	0.016 (0.41)	0.500	0.320	0.088	0.110	0.672	1/64	1/64
3/8	0.687	±0.004	0.016 (0.41)	0.671	±0.004	0.016 (0.41)	0.594	0.449	0.091	0.114	0.821	1/32	1/32
1/2	0.848	±0.004	0.016 (0.41)	0.836	±0.004	0.016 (0.41)	0.688	0.578	0.109	0.136	0.998	1/32	1/32
3/4	1.058	±0.004	0.020 (0.51)	1.046	±0.004	0.020 (0.51)	0.719	0.740	0.113	0.141	1.221	1/32	1/32
1	1.325	±0.005	0.020 (0.51)	1.310	±0.005	0.020 (0.51)	0.875	0.990	0.133	0.166	1.504	1/16	1/16
1 1/4	1.670	±0.005	0.024 (0.61)	1.655	±0.005	0.024 (0.61)	0.938	1.335	0.140	0.175	1.871	1/16	1/16
1 1/2	1.912	±0.006	0.024 (0.61)	1.894	±0.006	0.024 (0.61)	1.094	1.564	0.145	0.181	2.127	1/16	1/16
2	2.387	±0.006	0.024 (0.61)	2.369	±0.006	0.024 (0.61)	1.156	2.021	0.154	0.193	2.634	1/16	1/16
2 1/2	2.889	±0.007	0.030 (0.76)	2.868	±0.007	0.030 (0.76)	1.750	2.414	0.203	0.254	3.170	3/32	1/8
3	3.516	±0.008	0.030 (0.76)	3.492	±0.008	0.030 (0.76)	1.875	3.008	0.216	0.270	3.841	3/32	1/8
3 1/2	4.016	±0.008	0.030 (0.76)	3.992	±0.008	0.030 (0.76)	2.000	3.486	0.226	0.283	4.374	3/32	1/8
4	4.518	±0.009	0.030 (0.76)	4.491	±0.009	0.030 (0.76)	2.000	3.961	0.237	0.296	4.907	3/32	1/8
5	5.583	±0.010	0.060 (1.52)	5.553	±0.010	0.060 (1.52)	3.000	4.975	0.258	0.323	6.039	3/32	1/8
6	6.647	±0.011	0.060 (1.52)	6.614	±0.011	0.060 (1.52)	3.000	5.986	0.280	0.350	7.203	1/8	3/16
8	8.655	±0.015	0.090 (2.29)	8.610	±0.015	0.090 (2.29)	4.000	7.888	0.322	0.403	9.320	1/8	3/16
10	10.780	±0.015	0.100 (3.05)	10.735	±0.015	0.100 (3.05)	5.000	9.917	0.365	0.456	11.614	1/8	3/16
12	12.780	±0.015	0.120 (3.81)	12.735	±0.015	0.120 (3.81)	6.000	11.825	0.406	0.508	13.786	1/8	3/16

<sup>A</sup> The sketches and designs of fittings are illustrative only.

<sup>B</sup> Socket depth, measured from socket entrance face to socket bottom face.

<sup>C</sup> See 6.1.4.

$D_o$  = average outside diameter, in. (or mm), and  
 $t$  = minimum wall thickness, in. (or mm).

Fittings tested in accordance with 8.5 shall withstand the minimum burst pressure shown in Table 4.

6.3.2 Pressures shown are minimum burst pressures and do not imply rated working pressures. The burst pressure shall be used only as an indication of quality.

## 7. Workmanship, Finish, and Appearance

7.1 The fittings shall be homogeneous throughout and free of cracks, holes, foreign inclusions, or other defects. The fittings shall be as uniform as commercially practicable in color, opacity, density, and other physical properties.

## 8. Test Methods

8.1 *Conditioning*—Condition the test specimens at 73 ± 3.6°F (23 ± 2°C) and 50 ± 10 % relative humidity for not less than 40 h prior to test in accordance with Procedure A of Practice D618, for those tests where conditioning is required.