

Gasketed Sewer Pipe and Fittings

Submittal Data Sheet



Job or Customer:

Engineer:

Contractor:

Submitted by:

Date

Approved by:

Date

Order No:

Date

Specification:

introduction

Designed for various applications, IPEX Sewer Piping Systems provide advanced protection from cracking, leaking, corrosion and other threats that can compromise the integrity of sewer systems. IPEX sewer piping systems are made with a high-strength, high-impact PVC compound.

STANDARDS



D3034

D3212

F477

F679

F1336

Gasketed Sewer Pipe and Fittings

Product Data Sheet

PIPE AVAILABILITY

SDR35 4" through 8"

Size	14' Lengths	20' Lengths
4	339000	339003
6	339001	-
8	339002	-

SDR35 FITTINGS AVAILABILITY

Molded	4" through 15"
Fabricated	8" through 24"

Tees Bushings
Wyes Cleanouts
90° Elbows Couplings
11-1/4° Elbows Plugs
45° Elbows Caps
22-1/2° Elbows

SDR26 FITTINGS AVAILABILITY

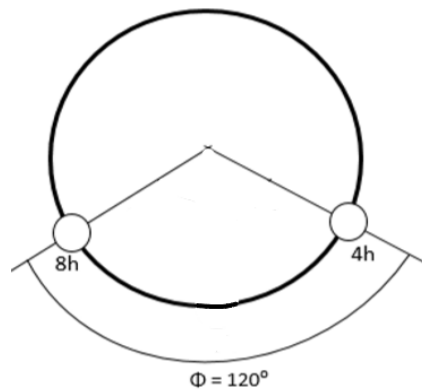
Molded	4" through 12"
Fabricated	6" through 24"

Tees Bushings
Wyes Cleanouts
90° Elbows Couplings
11-1/4° Elbows Caps
45° Elbows
22-1/2° Elbows

Gasketed Sewer Pipe and Fittings

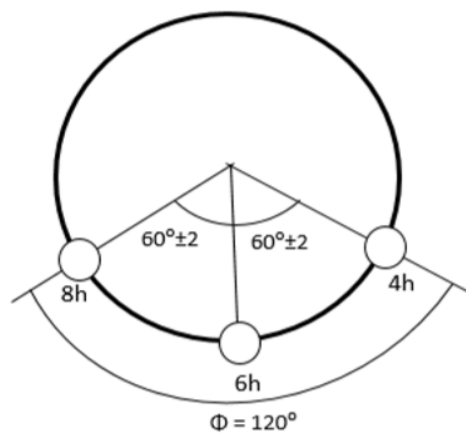
Perforation Patterns

2-Hole (Meets New England Specification)



2 Rows of 1/2" holes, 120° a part at 4-8 o'clock positions
2 Rows of 5/8" holes, 120° a part at 4-8 o'clock positions
Spacing between holes shall be 5"

3-Hole (Meets Ohio Specification)



3 Rows of 5/8" holes, 120° a part at 4-6-8 o'clock positions
Spacing between holes shall be 5"

Gasketed Sewer Pipe and Fittings

Handling & Installation



Handling and storage

PVC is strong, lightweight material. Piping made of this material is easily handled and, as a result, there is a tendency for them to be thrown about on the jobsite. Care should be taken in handling and storage to prevent damage to the pipe.

PVC pipe should be given adequate support at all times. It should not be stacked in large piles, especially in warm temperature conditions, as bottom pipe may become distorted and joining will become difficult.

Prolonged Outdoor Exposure

Prolonged exposure of PVC pipe to the direct rays of the sun will not damage the pipe. However, some mild discoloration may take place in the form of a milky film on the exposed surfaces. This change in color merely indicates that there has been a harmless chemical transformation at the surface of the pipe. A small reduction in impact strength could occur at the discolored surfaces but they are of a very small order and are not enough to cause problems in field installation.



WARNING

- **NEVER** use compressed air or gas in pipe and fittings.
- **NEVER** test pipe and fittings with compressed air or gas, or air-over-water boosters.
- **ONLY** use pipe for water and approved chemicals.



U.V. LIGHT

Care should be taken to avoid prolonged exposure to sunlight, which will cause discoloration of the material. If stored outdoors, products must be underneath an opaque covering, e.g. a tarpaulin.

If installed in a location exposed to sunlight, the pipework should be painted.

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Handling & Installation

Gasket Joint Installation

PVC sewer pipe with gasket joint design meets ASTM D3212. The gasket for this joint is made of an elastomeric ring in compliance with ASTM F477.

Step 1 Preparation

Keep both the spigot and the bell clean. It is good practice to lay PVC sewer pipe with bells forward so that the assembly operation will consist of pushing the spigot into the bell. This will minimize the possibility of contaminating the surfaces with foreign material. All assemblies should be concentric. Use only approved lubricant. The use of substitute lubricants may affect water quality or damage the gaskets.

Step 2 Cleaning

If the gasket is already installed: it is usually not necessary to remove the gasket for cleaning.

Clean the inside of the bell (including the face of the gasket), and the outside of the spigot with a rag, brush, or paper towel to remove any dirt or foreign material before assembling.

Step 3 Chamfering (if required)

The pipe is shipped with a chamfer on the end of the spigot. If there is no chamfer, follow the example of a factory-made spigot and machine a suitable chamfer.

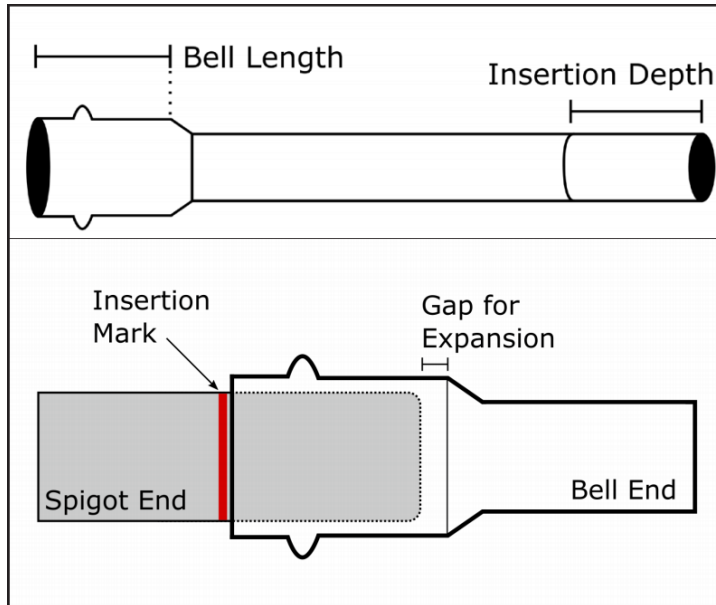


Step 4 Lubrication

Apply a thin coating of IPEX lubricant (equivalent to a brushed coating) using a glove, a rag, or a paint brush. Apply lubricant all around the pipe nose on chamfer and 1 1/2" back.

Gasketed Sewer Pipe and Fittings

Handling & Installation



Sewer Pipe	
Nominal Size	Insertion Depth (in.)
4"	4.75
6"	4.25
8"	4.5

NOTE: Gasket drawings are for information only. Actual gaskets may vary.

Step 5 Assembly

Keeping the spigot out of the dirt, position it so that the chamfer is resting against the gasket in the bell. Push the spigot into the bell until the assembly line on the spigot is even with the edge of the bell. If there are two assembly lines the edge of the bell should line up between them. The assembly effort can be delivered by hand in small diameters with the aid of a twist as the spigot enters the bell, or by using a bar and block. Other assembly methods include lever pullers, hydraulic jacks, and for large diameter pipes the IPEX Pipe Puller.

Notes for Assembly:

Where mechanical means, such as a backhoe, are used, the assembly effort should not be applied directly to the edge of the pipe. A two by four or a plank should be placed between the backhoe bucket and the edge of the pipe. The use of a backhoe bucket has the disadvantage that the backhoe operator is unable to see clearly when the assembly is complete. Thus, a helper should be located near the joint to signal when the assembly is complete. NOTE: Factory-made assembly lines on the pipe do not indicate correct assembly to fittings.

OVER-ASSEMBLY OF THE JOINT COULD DAMAGE THE BELL OF THIS OR ADJACENT PIPE LENGTHS. MAKE SURE THAT PREVIOUSLY ASSEMBLED JOINTS REMAIN UNDISTURBED.

If resistance is felt to the assembly, it may mean that the sealing gasket has somehow become dislodged. If so, the joint should be disassembled, cleaned, and reconstructed in accordance with the methods given above.

Gasketed Sewer Pipe and Fittings

Material Description

Short Form Specifications

General

Sewer lines used for sanitary sewer, storm sewer, and industrial effluent will be PVC DR35 sewer pipe and shall be in compliance with ASTM D3034.

MATERIALS

PVC compounds used in the manufacturing of PVC Gasketed Sewer Pipe and Fittings shall comply with the material requirements of ASTM D3034 and have cell classification of 12454 per ASTM D1784.

JOINTS

Sealing gaskets must meet the requirements of ASTM D3034 and ASTM F477. Joints must meet the requirements of ASTM D3212. In addition, the pipe joints must be able to withstand a minimum hydrostatic pressure of 50 psi (345 kPa) without leakage.

PIPE STIFFNESS

The minimum ring stiffness shall be 46 psi (320 kPa) for DR35 pipe. This stiffness will be determined using the test methods prescribed by ASTM D3034.

FITTINGS

Injection-molded gasketed PVC fittings shall meet the requirements of ASTM D3034 and ASTM F1336. Fabricated fittings must conform to ASTM F1336 and ASTM F679.

About the IPEX Group of Companies

As leading suppliers of thermoplastic piping systems, the IPEX Group of Companies provides our customers with some of the world's largest and most comprehensive product lines. All IPEX products are backed by more than 50 years of experience. With state-of-the-art manufacturing facilities and distribution centers across North America, we have established a reputation for product innovation, quality, end-user focus and performance.

Markets served by IPEX group products are:

- Electrical systems
- Telecommunications and utility piping systems
- PVC, CPVC, PP, PVDF, PE, ABS, and PEX pipe and fittings
- Industrial process piping systems
- Municipal pressure and gravity piping systems
- Plumbing and mechanical piping systems
- Electrofusion systems for gas and water
- Industrial, plumbing and electrical cements
- Irrigation systems

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