ASTM D1785 â€“ Standard Speciï¬•cation for Poly(Vinyl Chloride) (PVC) Plastic Pipe, Schedules 40, 80, and 120 / Testing Equipment

Description

6. Requirements

6.1 *Dimensions and Tolerances*:

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

6.2 ***Sustained Pressure***â€”The pipe shall not fail, balloon, burst, or weep as deï¬•ned in Test Method D1598, at the test pressures given in Tables 3-5 when tested in accordance with 8.4.

6.2.1 ***Accelerated Regression Test***â€”The accelerated regression test shall be used in place of both the sustained and burst pressure tests, at the option of the manufacturer. The test shall be conducted in accordance with 8.4.1. The pipe shall demonstrate a hydrostatic design basis projection at the 100 000-h intercept that meets the hydrostatic design basis category requirement (see Tables 3-5 and Test Method D2837) for the PVC material used in its manufacture. (*Example:* PVC 1120 pipe must have a minimum 100 000-h projection of 3830 psi (26.40 MPa) and 85 % lower conï¬•dence limit (LCL).

6.3 ***Burst Pressure***â€”The minimum burst pressures for PVC plastic pipe shall be as given in Table 6, when determined in accordance with Test Method D1599.

NOTE 7â€”Times greater than 60 s may be needed to bring large size specimens to burst pressure. The test is more difficult to pass using greater pressurizing times.

TABLE 1 Outside Diameters and Tolerances for PVC Plastic Pipe Schedules 40, 80, and 120, in. (mm)

Nominal Pipe Size	Outside Diameter	Tolerances		
		Average	Maximum Out-of-Roundness (maximum minus minimum diameter)	
			Schedule 40 sizes 3½ in. and over; Schedule 80 sizes 8 in. and over	Schedule 40 sizes 3 in. and less; Schedule 80 sizes 6 in. and less; Schedule 120 sizes all
⅛	0.405 (10.29)	±0.004 (±0.10)	...	0.016 (0.41)
¼	0.540 (13.72)	±0.004 (±0.10)	...	0.016 (0.41)
⅜	0.675 (17.14)	±0.004 (±0.10)	...	0.016 (0.41)
½	0.840 (21.34)	±0.004 (±0.10)	...	0.016 (0.41)
¾	1.050 (26.67)	±0.004 (±0.10)	...	0.020 (0.51)
1	1.315 (33.40)	±0.005 (±0.13)	...	0.020 (0.51)
1¼	1.660 (42.16)	±0.005 (±0.13)	...	0.024 (0.61)
1½	1.900 (48.26)	±0.006 (±0.15)	...	0.024 (0.61)
2	2.375 (60.32)	±0.006 (±0.15)	...	0.024 (0.61)
2½	2.875 (73.02)	±0.007 (±0.18)	...	0.030 (0.76)
3	3.500 (88.90)	±0.008 (±0.20)	...	0.030 (0.76)
3½	4.000 (101.60)	±0.008 (±0.20)	0.100 (2.54)	0.030 (0.76)
4	4.500 (114.30)	±0.009 (±0.23)	0.100 (2.54)	0.030 (0.76)
5	5.563 (141.30)	±0.010 (±0.25)	0.100 (2.54)	0.060 (1.52)
6	6.625 (168.28)	±0.011 (±0.28)	0.100 (2.54)	0.070 (1.78)
8	8.625 (219.08)	±0.015 (±0.38)	0.150 (3.81)	0.090 (2.29)
10	10.750 (273.05)	±0.015 (±0.38)	0.150 (3.81)	0.100 (2.54)
12	12.750 (323.85)	±0.015 (±0.38)	0.150 (3.81)	0.120 (3.05)
14	14.000 (355.60	±0.015 (±0.38)	0.200 (5.08)	...
16	16.000 (406.40)	±0.019 (±0.48)	0.320 (8.13)	...
18	18.000 (457.20)	±0.019 (±0.48)	0.360 (9.14)	...
20	20.000 (508.00)	±0.023 (±0.58)	0.400 (10.2)	...
24	24.000 (609.60)	±0.031 (±0.79)	0.480 (12.2)	...

TABLE 2 Wall Thicknesses and Tolerances for PVC Plastic Pipe, Schedules 40, 80, and 120,[A,B] in. (mm)

Nominal Pipe Size	Wall Thickness[A]					
	Schedule 40		Schedule 80		Schedule 120	
	Minimum	Tolerance	Minimum	Tolerance	Minimum	Tolerance
⅛	0.068 (1.73)	+0.020 (+0.51)	0.095 (2.41)	+0.020 (+0.51)	...	...
¼	0.088 (2.24)	+0.020 (+0.51)	0.119 (3.02)	+0.020 (+0.51)	...	...
⅜	0.091 (2.31)	+0.020 (+0.51)	0.126 (3.20)	+0.020 (+0.51)	...	...
½	0.109 (2.77)	+0.020 (+0.51)	0.147 (3.73)	+0.020 (+0.51)	0.170 (4.32)	+0.020 (+0.51)
¾	0.113 (2.87)	+0.020 (+0.51)	0.154 (3.91)	+0.020 (+0.51)	0.170 (4.32)	+0.020 (+0.51)
1	0.133 (3.38)	+0.020 (+0.51)	0.179 (4.55)	+0.021 (+0.53)	0.200 (5.08)	+0.024 (+0.61)
1¼	0.140 (3.56)	+0.020 (+0.51)	0.191 (4.85)	+0.023 (+0.58)	0.215 (5.46)	+0.026 (+0.66)
1½	0.145 (3.68)	+0.020 (+0.51)	0.200 (5.08)	+0.024 (+0.61)	0.225 (5.72)	+0.027 (+0.68)
2	0.154 (3.91)	+0.020 (+0.51)	0.218 (5.54)	+0.026 (+0.66)	0.250 (6.35)	+0.030 (+0.76)
2½	0.203 (5.16)	+0.024 (+0.61)	0.276 (7.01)	+0.033 (+0.84)	0.300 (7.62)	+0.036 (+0.91)
3	0.216 (5.49)	+0.026 (+0.66)	0.300 (7.62)	+0.036 (+0.91)	0.350 (8.89)	+0.042 (+1.07)
3½	0.226 (5.74)	+0.027 (+0.68)	0.318 (8.08)	+0.038 (+0.96)	0.350 (8.89)	+0.042 (+1.07)
4	0.237 (6.02)	+0.028 (+0.71)	0.337 (8.56)	+0.040 (+1.02)	0.437 (11.10)	+0.052 (+1.32)
5	0.258 (6.55)	+0.031 (+0.79)	0.375 (9.52)	+0.045 (+1.14)	0.500 (12.70)	+0.060 (+1.52)
6	0.280 (7.11)	+0.034 (+0.86)	0.432 (10.97)	+0.052 (+1.32)	0.562 (14.27)	+0.067 (+1.70)
8	0.322 (8.18)	+0.039 (+0.99)	0.500 (12.70)	+0.060 (+1.52)	0.718 (18.24)	+0.086 (+2.18)
10	0.365 (9.27)	+0.044 (+1.12)	0.593 (15.06)	+0.071 (+1.80)	0.843 (21.41)	+0.101 (+2.56)
12	0.406 (10.31)	+0.049 (+1.24)	0.687 (17.45)	+0.082 (+2.08)	1.000 (25.40)	+0.120 (+3.05)
14	0.437 (11.10)	+0.053 (+1.35)	0.750 (19.05)	+0.090 (+2.29)	...	...
16	0.500 (12.70)	+0.060 (+1.52)	0.843 (21.41)	+0.101 (+2.57)	...	...
18	0.562 (14.27)	+0.067 (+1.70)	0.937 (23.80)	+0.112 (+2.84)	...	...
20	0.593 (15.06)	+0.071 (+1.80)	1.031 (26.19)	+0.124 (+3.15)	...	...
24	0.687 (17.45)	+0.082 (+2.08)	1.218 (30.94)	+0.146 (+3.71)	...	...

[A] The minimum is the lowest wall thickness of the pipe at any cross section. The maximum permitted wall thickness, at any cross section, is the minimum wall thickness plus the stated tolerance. All tolerances are on the plus side of the minimum requirement.
[B] These dimensions conform to nominal IPS dimensions, with the exception that Schedule 120 wall thickness for pipe sizes ½ to 3½ in. (12.5 to 87.5 mm), inclusive, are special PVC plastic pipe sizes.

6.4 ***Flattening***â€”There shall be no evidence of splitting, cracking, or breaking when the pipe is tested in accordance with 8.6.

6.5 ***Extrusion Quality***â€”The pipe shall not ï¬‚ake or disintegrate when tested in accordance with Test Method D2152.

TABLE 3 Sustained Pressure Test Conditions for Water at 73°F (23°C) for PVC Plastic Pipe, Schedule 40

Nominal Pipe Size	Pressure Required for Test[A]			
	PVC1120 PVC1220 PVC2120	PVC2116	PVC2112	PVC2110
in.	psi			
⅛	1690	1360	1130	930
¼	1640	1310	1090	900
⅜	1310	1050	870	720
½	1250	1000	840	690
¾	1010	810	680	550
1	950	760	630	520
1¼	770	620	520	420
1½	690	560	460	380
2	580	470	390	320
2½	640	510	430	350
3	590	440	370	300
3½	500	400	340	280
4	470	370	310	260
5	410	330	270	220
6	370	300	250	200
8	330	260	220	180
10	300	240	200	160
12	280	220	180	150
14	270	220	180	150
16	270	220	180	150
18	270	220	180	150
20	260	210	170	140
24	250	200	170	140
in.	MPa			
⅛	11.65	9.38	7.79	6.41
¼	11.31	9.03	7.52	6.21
⅜	9.03	7.24	6.00	4.96
½	8.62	6.89	5.79	4.76
¾	6.96	5.58	4.69	3.79
1	6.55	5.24	4.34	3.59
1¼	5.31	4.27	3.59	2.90
1½	4.76	3.86	3.17	2.62
2	4.00	3.24	2.69	2.21
2½	4.41	3.52	2.96	2.41
3	4.07	3.03	2.55	2.07
3½	3.45	2.76	2.34	1.93
4	3.24	2.55	2.14	1.79
5	2.83	2.28	1.86	1.52
6	2.55	2.07	1.72	1.38
8	2.28	1.79	1.52	1.24
10	2.07	1.65	1.38	1.10
12	1.93	1.52	1.24	1.03
14	1.89	1.54	1.26	1.05
16	1.89	1.54	1.26	1.05
18	1.89	1.54	1.26	1.05
20	1.82	1.47	1.19	0.98
24	1.75	1.40	1.19	0.98

[A] The fiber stresses used to derive these test pressures are as follows:

	psi	MPa
PVC1120	4200	29.0
PVC1220	4200	29.0
PVC2120	4200	29.0
PVC2116	3360	23.2
PVC2112	2800	19.3
PVC2110	2300	15.9

TABLE 4 Sustained Pressure Test Conditions for Water at 73°F (23°C) for PVC Plastic Pipe, Schedule 80

Nominal Pipe Size	Pressure Required for Test[A]			
	PVC1120 PVC1220 PVC2120	PVC2116	PVC2112	PVC2110
in.	psi			
⅛	2570	2060	1720	1410
¼	2370	1900	1580	1300
⅜	1930	1540	1290	1060
½	1780	1430	1190	980
¾	1440	1160	960	790
1	1320	1060	880	720
1¼	1090	870	730	600
1½	990	790	660	540
2	850	680	570	460
2½	890	710	590	490
3	790	630	520	430
3½	730	580	480	400
4	680	540	450	370
5	610	490	400	330
6	590	470	390	320
8	520	410	340	280
10	490	390	330	270
12	480	380	320	260
14	470	380	320	260
16	470	370	310	260
18	460	370	310	250
20	460	370	300	250
24	450	360	300	250
in.	MPa			
⅛	17.72	14.21	11.86	9.72
¼	16.34	13.10	10.90	8.96
⅜	13.31	10.62	8.89	7.31
½	12.27	9.86	8.20	6.76
¾	9.93	8.00	6.62	5.45
1	9.10	7.31	6.07	4.96
1¼	7.52	6.00	5.03	4.14
1½	6.83	4.96	4.55	3.72
2	5.86	4.69	3.93	3.17
2½	6.14	4.90	4.07	3.38
3	5.45	4.34	3.59	2.96
3½	5.03	4.00	3.31	2.76
4	4.69	3.72	3.10	2.55
5	4.21	3.38	2.76	2.28
6	4.07	3.24	2.69	2.21
8	3.59	2.83	2.34	1.93
10	3.38	2.69	2.28	1.86
12	3.31	2.62	2.21	1.79
14	3.29	2.66	2.24	1.82
16	3.29	2.59	2.17	1.82
18	3.22	2.59	2.17	1.75
20	3.22	2.59	2.10	1.75
24	3.15	2.52	2.10	1.75

[A] The fiber stresses used to derive these test pressures are as follows:

	psi	MPa
PVC1120	4200	29.0
PVC1220	4200	29.0
PVC2120	4200	29.0
PVC2116	3360	23.2
PVC2112	2800	19.3
PVC2110	2300	15.9

8. Test Methods

8.1 *Conditioning*â€”Condition the test specimens at 73.4 +- 3.6Â°F (23 +- 2Â°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.

8.2 *Test Conditions*â€”Conduct tests in the standard laboratory atmosphere of 73.4 +- 3.6Â°F (23 +- 2Â°C) and 50 +- 10 % relative humidity, unless otherwise speciï¬•ed in the test methods or in this speciï¬•cation.

8.3 *Sampling*â€”The selection of the sample or samples of pipe shall be as agreed upon by the purchaser and seller. In case of no prior agreement, any sample selected by the testing laboratory shall be deemed adequate.

8.3.1 *Test Specimens*â€”Not less than 50 % of the test specimens required for any pressure test shall have at least a part of the marking in their central sections. The central section is that portion of pipe which is at least one pipe diameter away from an end closure.

8.4 ***Sustained Pressure Test***â€”Select the test specimens at random. Test individually with water at the internal pressures given in Tables 3-5, six specimens of pipe, each specimen at least ten times the nominal diameter in length, but not less than 10 in. (250 mm) or more than 3 ft (1 m) between end closures and bearing the permanent marking on the pipe. Maintain the specimens at the pressure indicated for a period of 1000 h. Hold the pressure as closely as possible, but within +-10 psi (+-70 kPa). Condition the specimens at the test temperature of 73.4Â°F (23Â°C) to within 3.6Â°F (+-2Â°C). Test in accordance with Test Method D1598, except maintain the pressure at the values given in Tables 3-5 for 1000 h. Failure of two of the six specimens tested shall constitute failure in the test. Failure of one of the six specimens tested in retest shall constitute failure in the test. Evidence of failure of the pipe shall be as deï¬•ned in Test Method D1598.

8.4.1 ***Accelerated Regression Testâ€”***Test in accordance with procedures in Test Method D1598, using either free end or restrained end ï¬•ttings. A minimum of six samples shall be tested. Test three specimens at a single pressure that will result in failures at or below 0.10 h. Test an additional three specimens at a single pressure that will result in failures at about 200 h. Generating additional data points to improve the LTHS or LCL, or both, is acceptable. No points shall be excluded unless an obvious defect is detected in the failure area of the test sample, or there was a malfunction of the equipment. Characterize the data using the least squares regression described in Test Method D2837.

8.5 ***Burst Pressure***â€”Determine the minimum burst pressure with at least ï¬•ve specimens in accordance with Test Method D1599. The time of testing of each specimen shall be between 60 and 70 s.

TABLE 5 Sustained Pressure Test Conditions for Water at 73°F (23°C) for PVC Plastic Pipe, Schedule 120

Nominal Pipe Size	Pressure Required for Test[A]			
	PVC1120 PVC1220 PVC2120	PVC2116	PVC2112	PVC2110
in.	psi			
½	2130	1710	1420	1170
¾	1620	1300	1080	890
1	1510	1200	1000	830
1¼	1250	1000	830	680
1½	1130	900	750	620
2	990	790	660	540
2½	980	780	650	540
3	930	750	620	510
3½	810	640	540	440
4	900	720	600	490
5	830	660	550	450
6	780	620	520	430
8	760	610	510	420
10	770	620	510	420
12	710	570	480	390
in.	MPa			
½	14.69	11.79	9.79	8.07
¾	11.17	8.96	7.45	6.14
1	10.41	8.27	6.89	5.72
1¼	8.62	6.89	5.72	4.69
1½	7.79	6.21	5.17	4.27
2	6.83	5.45	4.55	3.72
2½	6.76	5.38	4.48	3.72
3	6.41	5.17	4.27	3.52
3½	5.58	4.41	3.72	3.03
4	6.21	4.96	4.14	3.38
5	5.72	4.55	3.79	3.10
6	5.38	4.27	3.59	2.96
8	5.24	4.21	3.52	2.90
10	5.31	4.27	3.52	2.90
12	4.90	3.93	3.31	2.69

[A] The fiber stresses used to derive these test pressures are as follows:

	psi	MPa
PVC1120	4200	29.0
PVC1220	4200	29.0
PVC2120	4200	29.0
PVC2116	3360	23.2
PVC2112	2800	19.3
PVC2110	2300	15.9

TABLE 6 Burst Pressure Requirements for Water at 73°F (23°C) for PVC Plastic Pipe, Schedules 40, 80, and 120

Nominal Pipe Size	Min Burst Pressures[A]					
	Schedule 40		Schedule 80		Schedule 120	
	PVC1120 PVC1220 PVC2120	PVC2112 PVC2116 PVC2110	PVC1120 PVC1220 PVC2120	PVC2112 PVC2116 PVC2110	PVC1120 PVC1220 PVC2120	PVC211 PVC211 PVC211
in.	psi					
⅛	2580	2020	3920	3060	...	...
¼	2490	1950	3620	2830	...	...
⅜	1990	1560	2940	2300	...	...
½	1910	1490	2720	2120	3250	2540
¾	1540	1210	2200	1720	2470	1930
1	1440	1130	2020	1580	2300	1790
1¼	1180	920	1660	1300	1900	1490
1½	1060	830	1510	1180	1720	1340
2	890	690	1290	1010	1510	1180
2½	970	760	1360	1060	1490	1170
3	840	660	1200	940	1420	1110
3½	770	600	1110	860	1230	960
4	710	560	1040	810	1380	1080
5	620	390	930	720	1260	990
6	560	440	890	700	1190	930
8	500	390	790	620	1160	910
10	450	350	750	580	1170	920
12	420	330	730	570	1090	850
14	410	320	720	570	...	...
16	410	320	710	560	...	...
18	410	320	700	550	...	...
20	390	310	700	540	...	...
24	380	300	680	530	...	...
in.	MPa					
⅛	17.79	13.93	27.03	21.10	...	...
¼	17.17	13.45	24.96	19.52	...	...
⅜	13.72	10.76	20.27	15.86	...	...
½	13.17	10.27	18.76	14.62	22.41	17.52
¾	10.62	8.34	15.17	11.86	17.03	13.31
1	9.93	7.79	13.93	10.89	15.86	12.34
1¼	8.14	6.34	11.45	8.96	13.10	10.27
1½	7.31	5.72	10.41	8.14	11.86	9.24
2	6.14	4.76	8.89	6.96	10.41	8.14
2½	6.69	5.24	9.38	7.31	10.27	8.07
3	5.79	4.55	8.27	6.48	9.79	7.65
3½	5.31	4.14	7.65	5.93	8.48	6.62
4	4.90	3.86	7.17	5.58	9.51	7.45
5	4.27	2.69	6.41	4.96	8.69	6.83
6	3.86	3.03	6.14	4.83	8.20	6.41
8	3.45	2.69	5.45	4.27	8.00	6.27
10	3.10	2.41	5.17	4.00	8.07	6.34
12	2.90	2.28	5.03	3.93	7.52	5.86
14	2.87	2.24	5.04	3.99	...	...
16	2.87	2.24	4.97	3.92	...	...
18	2.87	2.24	4.90	3.85	...	...
20	2.73	2.17	4.90	3.78	...	...
24	2.66	2.10	4.76	3.71	...	...

[A] The fiber stresses used to derive these test pressures are as follows:

	psi	MPa
PVC1120	6400	44.1
PVC1220	6400	44.1
PVC2120	6400	44.1
PVC2116	5000	34.5
PVC2112	5000	34.5
PVC2110	5000	34.5

8.6 ***Flattening***â€”Flatten three specimens of the pipe each at least 2 in. (50 mm) long, between parallel plates in a suitable press until the distance between the plates is 40 % of the outside diameter of the pipe or the walls of the pipe touch, whichever occurs ï¬•rst. The rate of loading shall be uniform and such that the compression is completed within 2 to 5 min. On removal of the load examine the specimens for evidence of splitting, cracking, or breaking.

Hydrostatic Pressure Test Unit (***Sustained Pressure Test***, ***Elevated Temperature Sustained Pressure Test***, ***Burst Pressure***)

Hydrostatic Pressure Test Hot Water Bath

End Caps for Pressure Testing Type B

Bend Back Tester for Pipes

Category

1. Equipment for Standards
2. Standards