

GRAVITY SEWER MAIN

TECHNICAL DATA SUBMITTAL

ASTM D 3034 SDR 35 PVC SEWER PIPE

NOMINAL SIZE (IN) (mm)	OUTER DIAMETER (IN)	MINIMUM WALL	14' LENGTH WEIGHT (LB/100')	20' LENGTH WEIGHT (LB/100')
4 (100)	4.215	0.120	105.7	104.2
6 (150)	6.275	0.180	232.6	229.0
8 (200)	8.400	0.240	417.8	410.3
10 (250)	10.500	0.300	657.4	643.9
12 (300)	12.500	0.360	944.1	922.7
15 (375)	15.300	0.437	1390.0	1361.0

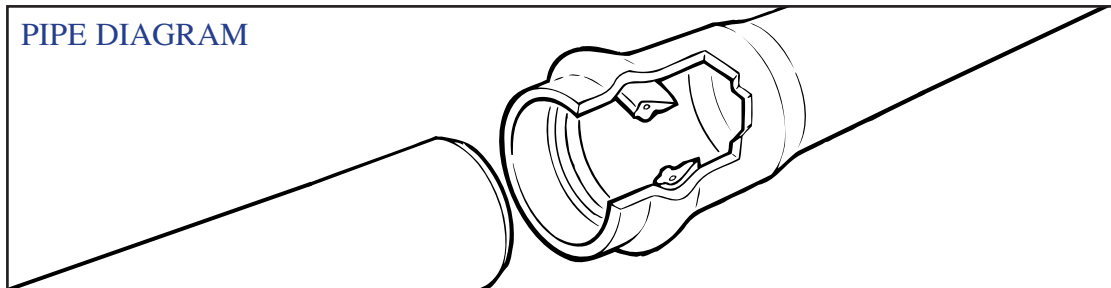
ASTM D 3034 SDR 26 PVC SEWER PIPE

NOMINAL SIZE (IN) (mm)	OUTER DIAMETER (IN)	MINIMUM WALL	14' LENGTH WEIGHT (LB/100')
4 (100)	4.215	0.162	150.0
6 (150)	6.275	0.241	320.0
8 (200)	8.400	0.323	580.0
10 (250)	10.500	0.404	900.0
12 (300)	12.500	0.481	1300.0
15 (375)	15.300	0.588	2000.0

ASTM F 679 (T-1 WALL) PVC SEWER PIPE

NOMINAL SIZE (IN) (mm)	OUTER DIAMETER (IN)	MINIMUM WALL	14' LENGTH WEIGHT (LB/100')	20' LENGTH WEIGHT (LB/100')
18 (450)	18.701	0.536	2115.0	2095.0

PIPE DIAGRAM



THE RIEBER SEALING SYSTEM

The Rieber system provides a proven pipe joint with an excellent track record in the field. It is the fastest growing system in the world because of its many advantages.

- Factory installed, locked-in gasket
- The pipe bell forms over the gasket, making a perfect fit
- Avoids the possibility of installing the wrong gasket
- Reduces installation problems
- The locked-in gasket eliminates gasket roll-out during joining
- The gasket is molded vs. extruded and spliced
- Works equally well under pressure or vacuum
- Three sealing points achieved vs. two
- LEAK-PROOF JOINTS
- "THE WORLDS BEST JOINT"

VINYLTECH SEWER PIPE

TECHNICAL DATA SUBMITTAL



CONFORMANCE

These specifications designate the requirements for manufacturing and installing Vinyltech PVC sewer pipe.

ASTM D 3034 - Standard Specification for Type PSM Poly (Vinyl Chloride) (PVC) Sewer Pipe and Fittings

ASTM F 679 - Standard Specification for Poly (Vinyl Chloride) (PVC) Large Diameter Plastic Gravity Sewer Pipe and fittings

ASTM D 3212 - Standard Specification for Joints for Drain and Sewer Plastic Pipes Using Flexible Elastomeric Seals

ASTM F 477 - Standard Specification for Elastomeric Seals (Gaskets) for Joining Plastic Pipe

ASTM D 1784 - Standard Specification for Rigid Poly (Vinyl Chloride) (PVC) Compounds and Chlorinated Poly (Vinyl Chloride) (CPVC) Compounds

ASTM D 2152 - Standard Test Method for Extruded Poly (Vinyl Chloride) (PVC) Pipe and Molded Fittings by Acetone Immersion

ASTM D 2444 - Standard Test Method for Determination of the Impact Resistance of Thermoplastic Pipe and Fittings by Means of Tup (Falling Weight)

ASTM D 2321 - Standard Practice for Underground Installation of Thermoplastic Pipe for Sewers and other Gravity-Flow Applications

ASTM D 2412 - Standard Test Method for Determination of External Loading Characteristics of Plastic Pipe by Parallel-Plate Loading

IAPMO (File No. 2128) - Uniform Plumbing Code (UPC) - Vinyltech sewer pipe is IAPMO listed for ASTM 3034 SDR 35 4-15 inch and SDR 26 4-12 inch.

PIPE COMPOUND

The pipe shall be extruded from compounds meeting the requirements of Cell Classification 12454-B, as defined in ASTM D 1784, *Standard Specification for Rigid Poly (Vinyl Chloride) (PVC) Compounds and Chlorinated Poly (Vinyl Chloride) (CPVC) Compounds*.

PIPE

Vinyltech pipe shall be manufactured in accordance with ASTM D 3034 (4"-15") and ASTM F 679 (18") (Wall Thickness T-1).

GASKET JOINT

The gasket shall be reinforced with a steel ring and meet the requirements of ASTM F477. Vinyltech pipe shall have an integral bell end with a locked-in factory installed gasket and shall meet the requirements of ASTM D 3212.

MARKING

The pipe shall be marked in accordance with ASTM D 3034 and F 679.

QUALITY CONTROL

Requirements for manufacturing and testing are conducted in strict accordance with ASTM specifications and are outlined in ASTM D 3034 and F 679.

INSTALLATION

Recommended installation procedure of Vinyltech Corporation and the Uni-Bell PVC Pipe Association are outlined in ASTM D 2321, *Underground Installation of Flexible Thermoplastic Sewer Pipe*. Vinyltech recommends the *Uni-Bell Handbook of PVC Pipe* as an invaluable resource guide.

ASSEMBLING THE PIPE

Assembling of Vinyltech PVC Sewer Pipe is easily accomplished by hand or by using a bar and block. A depth of entry mark is on each spigot end to serve as a visual check for rapid, accurate joint inspection. **Do not over insert.**

- 1) Remove any mud, sand, or other foreign matter from the belled and spigot ends of the pipe. Carefully clean the gasket area.
- 2) With a clean applicator (a brush or hand) lubricate the entire surface of the pipe from the spigot end to the depth of entry mark and the contact surface of the gasket with **Vinyltech Brand Lubricant**.
- 3) Brace the bell to avoid disturbing the already installed joints. Align the pipe, insert the spigot into the bell and push until the entry mark is reached. **Do not insert past the entry mark line.**



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AN  OTTERTAIL COMPANY

SEWER PIPE

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