

## INSTALLATION GUIDE

# ASTM D1785 & D2241 SOLVENT WELDED PVC PIPE

## Underground Applications

### INTRODUCTION

The PVC pipe industry has published consensus standards that represent the most comprehensive documents for installation requirements and best practices. For ASTM D1785 and ASTM D2241 pipe used in underground applications, Westlake Pipe & Fittings promotes the use of the following standards as the primary sources of installation guidelines:

- ASTM D2774, *Standard Practice for Underground Installation of Thermoplastic Pressure Piping*
- ASTM D2855-15, *Standard Practice for Making Solvent-Cemented Joints with Poly(Vinyl Chloride) (PVC) Pipe and Fittings*
- ASTM F1668, *Standard Guide for Construction Procedures for Buried Plastic Pipe*
- IAPMO UPC 1, *Uniform Plumbing Code*

For more detailed technical information, refer to the PVC Pipe Association's *Handbook of PVC Pipe Design and Construction*.

When necessary, we have presented additional information specific to our product offering.

The statements contained in this installation guide are those of Westlake Pipe & Fittings and are not warranties, nor are they intended to be warranties.

### RECEIVING, HANDLING, & STORAGE

Follow ASTM F1668, Section 5 and ASTM D2774, Section 10.1 – 10.3.

### UV PROTECTION

AWWA M23, *PVC Pipe – Design and Installation*, pg. 7 states, "UV degradation of PVC pipe formulated for buried use will not have significant adverse effect with up to two full years of outdoor weathering and direct exposure to sunlight." When PVC pipe is properly covered and not exposed to sunlight, the allowable storage time is unlimited. The two year criteria is a cumulative value of the time the pipe is in exposed storage and is not based on the date of manufacture.

### TEMPERATURE CONSIDERATIONS

PVC will display a variation in physical properties with changes in temperature. Colder temperatures result in increases in pipe stiffness and tensile strength and decreases in impact strength. The decrease in impact strength requires care in handling during installation in cold temperatures.

The actual rate of expansion/contraction for PVC is 0.36 inch per 100 feet of pipe per 10°F temperature change. Thermal expansion/contraction causes stress in the pipe walls for solvent welded PVC pipe and must be mitigated by the use of expansion joints or other thermal stress management techniques.

Follow IAPMO UPC, Section IS 8-2006.2.4.3.

### TRENCH PREPARATION & CONSTRUCTION

Follow ASTM F1668, Sections 6, 7, & 8 and ASTM D2774 Section 6. Follow IAPMO UPC, Section 314 & 609.1-609.3 for building water distribution lines.

### BURIAL DEPTH

Minimum burial depth is governed by a few criteria. ASTM D2774, Section 6.4.2 states that "a minimum of 24 in. for pipe shall be required when subjected to heavy overhead traffic. In areas of light overhead traffic, a minimum of 12 to 18 in. is required." Westlake Pipe & Fittings recommends that this requirement is followed during project design and construction.

IAPMO UPC, Section 609.1 states that "building supply yard piping shall be not less than 12 inches below the average local frost depth. The cover shall be no less than 12 inches below finish grade."

Earth loads, from soil above a buried pipe, and live loads, from vehicles and objects on the surface, place vertical loads on the pipe that attempt to deform the pipe from a circle to an oval. The strength of the pipe wall, known as pipe stiffness, and the support afforded to the pipe by surrounding embedment soils counteracts these earth and live loads.

The Modified Iowa formula is widely used to calculate the expected in-situ deflection of PVC pipe at various depths and installation conditions. AWWA C605, Section 8.3, states that "the vertical cross-section long-term ring deflection of the pipe should not exceed 7.5 percent." We recommend that an engineer familiar with the Modified Iowa equation be consulted to determine if the embedment soil and pipe stiffness is adequate to counterbalance the loading conditions at specific burial depths.

### PIPE ASSEMBLY, INSTALLATION, & EMBEDMENT

Follow ASTM F1668, Sections 9, 10, 11, & 12 and ASTM D2774, Sections 5, 7.1, & 10.

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**BELL & SPIGOT ORIENTATION**

Westlake Pipe & Fittings recommends that the pipe's bell end points direction of work progress. When joining pipe, it is easier to insert the spigot into the bell than it is to push the bell over the spigot. This also reduces the risk of soil or rubble being scooped into the bell during assembly.

The direction of the pipe bell relative to the flow direction does not affect the performance of the pipe joint or system hydraulics.

**CLEANERS, PRIMERS & SOLVENT CEMENTS**

Follow ASTM D2855-15, Section 6.2, 6.3, and 6.4.

**PIPE CUTTING & JOINT PREPARATION**

Follow ASTM D2855-15, Section 7.1 through 7.6.

**APPLICATION OF PRIMER AND CEMENT**

Follow the procedure detailed in ASTM D2855-15, Section 7.7.

**COLD & HOT WEATHER NOTES**

Follow ASTM D2855, Section 8.4 and 8.5.

**INSTALLING PIPE THROUGH CASINGS**

Follow ASTM F1688, Section 16.

**CONNECTING PIPE TO APPURTENANCES & FITTINGS**

Follow ASTM D2774, Section 8. Follow the instructions of the appurtenance or fitting manufacturer including pipe trimming, pipe insertion, and bolt tightening guidelines. Appurtenances & fittings must be compatible with ASTM D1785 and D2241 PVC pipe sizes using the Iron Pipe Size (IPS) standard.

Mechanical restraint rings typically have grooved pads that bite into the pipe. These grooved pads place acceptable indentations into the pipe. In the event of removing the restraint ring from the pipe, the section of PVC pipe with the indentations should be cut-off and discarded. The same area of PVC pipe should not be re-indented as the strength of the pipe will be compromised.

**FIELD CUTTING**

Pipe can be easily cut with a power saw using an abrasive disc. Other cutting tools may be appropriate, depending on the size of the pipe. It is recommended that the pipe be marked around its entire circumference prior to cutting to ensure a square cut. Both portions of the pipe on either side of the cut line should be supported from below such that neither portion of pipe pulls at the other while it is being cut.

**PIPE BENDING & JOINT ANGULAR DEFLECTION**

Some changes in direction may be accomplished without the use of elbows, sweeps, or other fittings. Changes in direction can be accomplished by pipe bending or through angular joint deflection, BUT NOT BOTH, on the same segment of pipe.

**ANGULAR JOINT DEFLECTION**

Solvent welded PVC pipe does not permit angular deflection at the joint.

**LONGITUDINAL BENDING**

Due to the flexible nature of PVC, longitudinal bending of PVC pipe is possible as long as the flexural stress limits of the pipe are observed.

We recommend that only manual force be used to bend PVC pipe in open-cut trench installations. Using mechanical equipment could easily surpass the allowable flexural stress limits of the pipe. For this reason, longitudinal bending of pipe sized larger than 12" is not recommended due to the large forces required.

Table 1 displays the minimum bend radius, maximum angle of lateral deflection, and the maximum distance offset at the end of a flexed, solid wall pipe.

**THRUST RESTRAINT**

Solvent welded PVC pipe and fitting joints generally do not require additional thrust restraint methods. In the instance of connections made via other methods, follow ASTM D2774, Sections 7.3-7.5, and ASTM F1668, Section 19. Follow all thrust restraint manufacturer's requirements for installation methods especially bolt tightening specifications. Improper installation of external restraints can result in loss of joint seal or fracture of the pipe wall.

**BACKFILL**

Follow ASTM D2774, Section 9, and ASTM F1668, Section 13, 14, 17, & 18.

**APPURTENANCE PLACEMENT**

Follow ASTM D2774, Section 8.

**SERVICE CONNECTIONS**

Follow ASTM D2774, Section 7.6. Failure to use proper equipment made for drilling & tapping PVC pipe, sharp shell cutters, or correct technique may overstress and fracture PVC pipe. For more detailed information, we recommend consulting the PVC Pipe Association's UNI-PUB-08, *Tapping Guide for PVC Pressure Pipe*, available for free on [www.uni-bell.org](http://www.uni-bell.org).

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**ACCEPTANCE TESTING**

Follow ASTM F1688, Section 20 & 21. Also, follow ASTM D2774, Sections 11 and 12. Test pressures anywhere in the line must never exceed the temperature-corrected working pressure rating of the pipe. Only water should be used to test, never air.

**DISINFECTION OF POTABLE WATER LINES**

Follow AWWA C651, *Disinfecting Water Mains* or IAPMO UPC, Section 609.9.

Table 1: Longitudinal Bending of ASTM D1785 &amp; D2241 Pipe

Nom. Size	10' PIPE SEGMENTS			20' PIPE SEGMENTS		40' PIPE SEGMENTS	
	Min. Bend Radius	Max. Deflection Angle	Max. Offset of Flexed Pipe	Max. Deflection Angle	Max. Offset of Flexed Pipe	Max. Deflection Angle	Max. Offset of Flexed Pipe
	ft.	deg.	ft.	deg.	ft.	deg.	ft.
1/2	14.00	20.5	3.42	40.9	12.02		
3/4	17.50	16.4	2.78	32.7	10.24		
1	21.92	13.1	2.24	26.1	8.51		
1 1/4	27.67	10.4	1.79	20.7	6.92		
1 1/2	31.67	9.0	1.57	18.1	6.11		
2	39.58	7.2	1.26	14.5	4.95	29.0	18.55
2 1/2	47.92	6.0	1.04	12.0	4.11	23.9	15.75
3	58.33	4.9	0.86	9.8	3.40	19.6	13.19
4	75.00	3.8	0.67	7.6	2.65	15.3	10.42
6	110.42	2.6	0.45	5.2	1.81	10.4	7.17
8	143.75	2.0	0.35	4.0	1.39		
10	179.17	1.6	0.28	3.2	1.12		
12	212.50	1.3	0.24	2.7	0.94		