

Vylon® PVC Slipliner Pipe

Specification for PVC Large Diameter Closed Profile Slipliner Pipe (ASTM F-1803)

Scope

This specification designates the requirements for polyvinyl chloride (PVC) pipe made to a controlled inside diameter in sizes 21" to 54" with a flush joint (internal and external) and which meets the requirements of ASTM F-1803.

Materials

Pipe shall be made from polyvinyl chloride compounds which comply with the requirements for a minimum cell classification of 12364 as defined by ASTM D-1784.

Dimensions

Pipe sizes, inside diameters and typical dimensions shall conform to those listed in the table below. Diameters and sizes not currently found in ASTM F-1803 are acceptable provided they also meet the performance requirements of ASTM F-1803. Pipe lengths shall be available in 2'-16' sections with 16' being the standard length.

Joints

All pipe joints shall be connected with flush joint, PVC anti-disengaging couplers with internal restraining rings or ridges and elastomeric gaskets. Assembled joints shall conform to the requirements of ASTM D-3212. Each joint must allow a minimum of 2 degrees of joint deflection without leaking. Gasket material shall conform to the requirements of ASTM F-477.

Physical Requirements

Pipe stiffness – the minimum pipe stiffness shall be 46 psi when tested in accordance with ASTM D-2412.

Impact resistance – no visual cracking or splitting of the waterway wall shall be evidenced when tested in accordance with ASTM D-2444 with a 30 lb. weight, Tup B, flat plate holder B to a level of 220 ft. lbs.

Ductility – there shall be no evidence of cracking or splitting when pipe is flattened in a circumferential orientation between two flat plates to sixty percent (60%) of the original inside diameter or as required by ASTM F-1803.

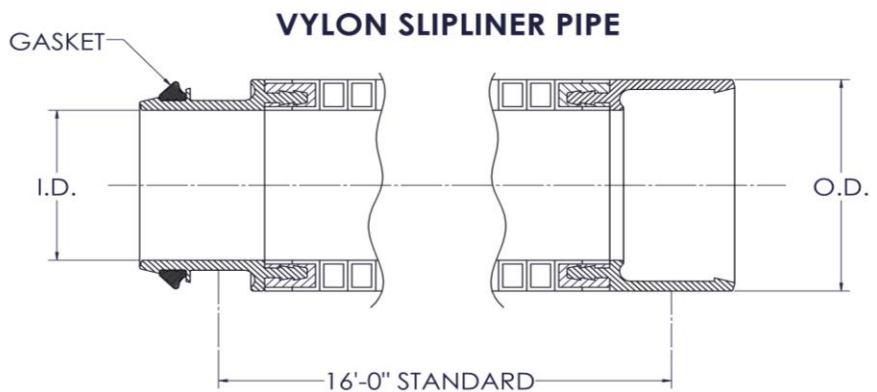
Marking

Each pipe shall be identified with the name of the manufacturer, nominal size, cell classification, ASTM designation F-1803, the pipe stiffness designation "PS-46 psi" and manufacturer's date code.

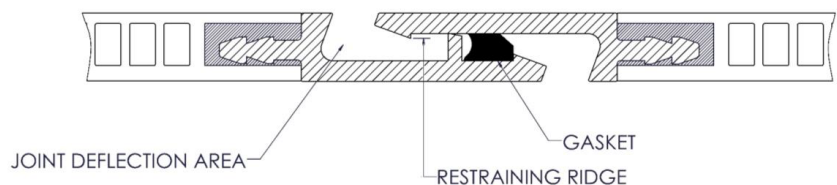
Installation

Sections of the liner pipe shall be field connected at the insertion point. Details of Slipliner installation can be obtained from the Vylon Slipliner Pipe Installation Guide. Lubricants supplied

by the pipe manufacturer shall be applied to the gasket surface prior to assembly.



VYLON SLIPLINER ANTI-DISENGAGING COUPLER



SIZE (IN.)	INSIDE DIAMETER (IN.)	NOMINAL O.D. (IN.)	PROFILE HEIGHT (IN.)	MIN. SIZE PIPE TO BE LINED (IN.)	LAY LENGTH (FT.)*
21	20.75	22.29	0.770	24	16.0
24	23.50	25.43	0.870	27	16.0
27	26.50	28.43	0.980	30	16.0
30	29.50	31.43	1.095	33	16.0
32	31.50	34.13	1.315	36	16.0
36	35.50	38.13	1.315	42	16.0
38	37.50	40.20	1.540	42	16.0
42	41.50	44.58	1.540	48	16.0
48	47.50	51.02	1.760	54	16.0
54	53.50	57.47	1.985	60	16.0

Special lengths as short as 2 feet are available.
Non-standard sizes are available