



Designation: F794 – 21

Standard Specification for Poly(Vinyl Chloride) (PVC) Profile Gravity Sewer Pipe and Fittings Based on Controlled Inside Diameter¹

This standard is issued under the fixed designation F794; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ε) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope*

1.1 This specification covers requirements for poly(vinyl chloride) (PVC) profile sewer pipe and fittings with integral bell and elastomeric seal joints or plain end pipe with couplings in sizes (4 to 48 in.) based on a controlled inside diameter.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 The following safety hazard caveat pertains only to the test methods portion, Section 8, of this specification: *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

NOTE 1—Pipe and fittings produced to this specification should be installed in accordance with Practice D2321.

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

D618 Practice for Conditioning Plastics for Testing

D1600 Terminology for Abbreviated Terms Relating to Plastics

D1784 Classification System and Basis for Specification for

Rigid Poly(Vinyl Chloride) (PVC) Compounds and Chlorinated Poly(Vinyl Chloride) (CPVC) Compounds

D2122 Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings

D2152 Test Method for Adequacy of Fusion of Extruded Poly(Vinyl Chloride) (PVC) Pipe and Molded Fittings by Acetone Immersion

D2321 Practice for Underground Installation of Thermoplastic Pipe for Sewers and Other Gravity-Flow Applications

D2412 Test Method for Determination of External Loading Characteristics of Plastic Pipe by Parallel-Plate Loading

D2444 Practice for Determination of the Impact Resistance of Thermoplastic Pipe and Fittings by Means of a Tup (Falling Weight)

D2855 Practice for the Two-Step (Primer and Solvent Cement) Method of Joining Poly (Vinyl Chloride) (PVC) or Chlorinated Poly (Vinyl Chloride) (CPVC) Pipe and Piping Components with Tapered Sockets

D3034 Specification for Type PSM Poly(Vinyl Chloride) (PVC) Sewer Pipe and Fittings

D2312 Specification for Joints for Drain and Sewer Plastic Pipes Using Flexible Elastomeric Seals

F402 Practice for Safe Handling of Solvent Cements, Primers, and Cleaners Used for Joining Thermoplastic Pipe and Fittings

F412 Terminology Relating to Plastic Piping Systems

F477 Specification for Elastomeric Seals (Gaskets) for Joining Plastic Pipe

F679 Specification for Poly(Vinyl Chloride) (PVC) Large-Diameter Plastic Gravity Sewer Pipe and Fittings

2.2 *American Water Works Association (AWWA) Standard: AWWA Manual M45 Fiberglass Pipe Design*³

2.3 *Federal Standard:*

Fed. Std. No. 123 Marking for Shipment (Civil Agencies)⁴

2.4 *Military Standard:*

MIL-STD-129 Marking for Shipment and Storage⁴

¹ This specification is under the jurisdiction of ASTM Committee F17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.62 on Sewer. Current edition approved April 1, 2021. Published April 2021. Originally approved in 1983. Last previous edition approved in 2014 as F794 –03(2014). DOI: 10.1520/F0794-21.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Available from American Water Works Association (AWWA), 6666 W. Quincy Ave., Denver, CO 80235, <http://www.awwa.org>.

⁴ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, <http://dodssp.daps.dla.mil>.

*A Summary of Changes section appears at the end of this standard

3. Terminology

3.1 *Definitions*—Definitions are in accordance with Terminology F412, and abbreviations are in accordance with Terminology D1600, unless otherwise specified. The abbreviation for poly(vinyl chloride) is (PVC).

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *dual wall corrugated profile (DWCP) gravity sewer pipe*—a pipe product consisting of a smooth waterway braced circumferentially with an external corrugated wall (see Fig. 1)

3.2.2 *open profile (OP) gravity sewer pipe*—a pipe product consisting of an essentially smooth waterway braced circumferentially or spirally with outside projections or ribs (see Fig. 2).

4. Significance and Use

4.1 The requirements of this specification are intended to provide pipe and fittings suitable for nonpressure drainage of sewage and surface water.

NOTE 2—Industrial waste disposal lines should be installed only with the specific approval of the governing code authority since chemicals not commonly found in drains and sewers and temperatures in excess of 140°F may be encountered.

5. Materials

5.1 *Basic Materials*—The pipe and fittings shall be made of PVC plastic having a minimum cell classification of 12454 or 12364 as defined in Specification D1784. Homopolymer PVC compounds must meet or exceed the requirements of the above listed minimum cell classification number.

5.2 *Rework Material*—Clean rework material generated from the manufacturer's own pipe or fittings production may be used by the same manufacturer provided pipe or fittings produced meet all the requirements of this specification.

5.3 *Gaskets*—Elastomeric gaskets shall comply with the requirements described in Specification F477.

5.4 *Lubricant*—The lubricant used for assembly shall be suitable for use with PVC pipe and elastomeric seals for this application and have no detrimental effect on the gasket or on the pipe.

6. Joining Systems

6.1 *Gasketed Joint*—The integral bell gasketed joint, coupling, or fitting joints shall be designed so that when assembled, the gasket (which is attached to either the bell or the spigot) will be compressed radially on the pipe spigot or in the bell to form a water-tight seal. The joints shall be designed

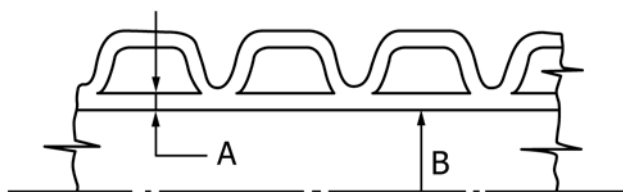


FIG. 1 Typical Dual Wall Corrugated Profile (DWCP)

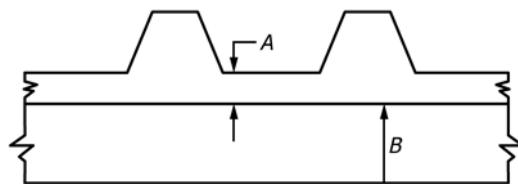


FIG. 2 Typical Open Profile (OP)

to comply with and show no sign of leakage when tested in accordance with 7.7 when assembled with pipe for which they are intended.

6.2 Couplings shall form a water-tight seal when assembled with plain end pipe and show no sign of leakage when tested in accordance with 7.7 when assembled with pipe for which they are intended.

NOTE 3—The outside diameters of products manufactured to this specification are not specified and therefore joint compatibility should be reviewed.

6.3 The joint shall be designed to avoid displacement of the gasket when assembled in accordance with the manufacturer's recommendation.

6.4 The assembly of joints shall be in accordance with the manufacturer's recommendations.

7. Requirements⁵

7.1 *Workmanship*—The pipe and fittings shall be essentially uniform in color, opacity, density, and other properties. The inside and outside surfaces shall be semimatte or glossy in appearance and free of chalking, sticky, or tacky material. The surfaces shall be free of excess bloom; that is, slight bloom is acceptable. The pipe walls shall be free of cracks, holes, blisters, voids, foreign inclusions, or other defects that are visible to the naked eye and that may affect the wall integrity. Bloom or chalking may develop in pipe exposed to direct rays of the sun (ultraviolet radiant energy) for extended periods and consequently these requirements do not apply to pipe after extended exposure to direct rays of the sun.

7.2 *Pipe and Fitting Dimensions:*

7.2.1 *Diameter*—The inside diameter of the pipe shall meet the requirements given in Table 1, Table 2, or Table 3 when measured in accordance with 8.4.1.

7.2.2 *Wall Thickness*—The minimum wall thickness of the waterway of pipe and fittings fabricated from pipe sections shall meet the requirements given in Table 1 for open profile; and Table 2 or Table 3 for dual wall corrugated profile pipe when measured in accordance with 8.4.2. The wall thickness of fittings fabricated from pipes meeting the requirements of Specification D3034, SDR 35 and Specification F679 are also satisfactory. Molded fittings when made with an open profile shall conform to the minimum wall thickness requirements given in Table 1.

7.2.3 *Bell Wall Thickness*—In the case of belled pipe and fittings fabricated from pipe sections, the thickness of the wall in the bell shall be considered satisfactory if it was formed

⁵ Supporting data are available at ASTM Headquarters. Request RR:F17-1020.