



Standard Specification for Joints for IPS PVC Pipe Using Solvent Cement¹

This standard is issued under the fixed designation D2672; 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 reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

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

1. Scope*

1.1 This specification covers the socket produced for solvent cement joints on both pressure and non-pressure IPS pipe. It also covers the testing of the joints on both pressure and non-pressure pipe, and includes requirements for socket dimensions, burst pressure, and joint tightness tests of the solvent cemented joints. The tests described are not intended for routine quality control, but rather to evaluate the performance characteristics of the joint.

NOTE 1—On dual marked Schedule 40 DWV and potable water pipe, the socket bells must conform to the dimensional and physical requirements for pressure socket bells.

1.2 The text of this specification references notes, footnotes, and appendixes which provide explanatory material. These notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of the specification.

1.3 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.

NOTE 2—Changes in ground, water, or air temperature will produce expansion or contraction forces in PVC piping, and these will result in longitudinal shear stresses in the solvent cement joints. These stresses must be considered in the design and operation of the system.

NOTE 3—See Practice D618 for information relating to this specification.

1.4 The following safety hazards caveat pertains only to the test method portion, Section 10, 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 and health practices and determine the applicability of regulatory limitations prior to use.*

¹ This specification is under the jurisdiction of ASTM Committee F17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.20 on Joining.

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2. Referenced Documents

2.1 ASTM Standards:²

- D618 Practice for Conditioning Plastics for Testing
- D1599 Test Method for Resistance to Short-Time Hydraulic Pressure of Plastic Pipe, Tubing, and Fittings
- D1600 Terminology for Abbreviated Terms Relating to Plastics
- D1785 Specification for Poly(Vinyl Chloride) (PVC) Plastic Pipe, Schedules 40, 80, and 120
- D2122 Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings
- D2241 Specification for Poly(Vinyl Chloride) (PVC) Pressure-Rated Pipe (SDR Series)
- D2565 Practice for Xenon-Arc Exposure of Plastics Intended for Outdoor Applications
- D2665 Specification for Poly(Vinyl Chloride) (PVC) Plastic Drain, Waste, and Vent Pipe and Fittings
- D2855 Practice for Making Solvent-Cemented Joints with Poly(Vinyl Chloride) (PVC) Pipe and Fittings
- F412 Terminology Relating to Plastic Piping Systems
- F512 Specification for Smooth-Wall Poly(Vinyl Chloride) (PVC) Conduit and Fittings for Underground Installation
- F656 Specification for Primers for Use in Solvent Cement Joints of Poly(Vinyl Chloride) (PVC) Plastic Pipe and Fittings

2.2 NSF Standard:

- Standard No. 14 for Plastic Piping Components and Related Materials³

3. Terminology

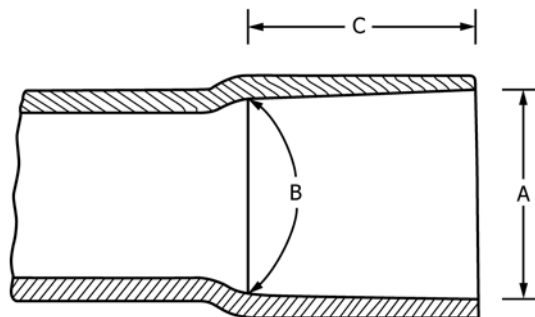
3.1 *Definitions*—Definitions are in accordance with Terminology F412 and abbreviations are in accordance with Terminology D1600, unless otherwise specified.

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 NSF International, P.O. Box 130140, 789 N. Dixboro Rd., Ann Arbor, MI 48113-0140, http://www.nsf.org.

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

TABLE 1 Tapered Sockets for Bell-End Pipe, in. (mm)



Pipe Size, in.	A Socket Entrance Diameter, in. (mm)			B Socket Bottom Diameter, in. (mm)			C Socket Length, in. (mm), min ^A	
	Nominal Diameter	Tolerance on Nominal Diameter	Maximum Out-of- Round ^B	Nominal Diameter	Tolerance on Nominal Diameter	Maximum Out-of- Round ^B	Pressure	Non-Press- sure ^C
1/8	0.417 (10.59)	±0.004 (±0.10)	0.024 (0.61)	0.401 (10.18)	±0.004 (±0.10)	0.024 (0.61)	0.500 (12.70)	...
1/4	0.552 (14.02)	±0.004 (±0.10)	0.024 (0.61)	0.536 (13.61)	±0.004 (±0.10)	0.024 (0.61)	0.500 (12.70)	...
3/8	0.687 (17.45)	±0.004 (±0.10)	0.024 (0.61)	0.671 (17.04)	±0.004 (±0.10)	0.024 (0.61)	0.750 (19.05)	...
1/2	0.848 (21.54)	±0.004 (±0.10)	0.024 (0.61)	0.836 (21.23)	±0.004 (±0.10)	0.024 (0.61)	1.000 (25.40)	1.000 (25.40)
3/4	1.058 (26.87)	±0.004 (±0.10)	0.028 (0.71)	1.046 (26.57)	±0.004 (±0.10)	0.028 (0.71)	1.250 (31.75)	1.000 (25.40)
1	1.325 (33.65)	±0.005 (±0.13)	0.030 (0.76)	1.310 (33.27)	±0.005 (±0.13)	0.030 (0.76)	1.500 (38.10)	1.000 (25.40)
1 1/4	1.670 (42.42)	±0.005 (±0.13)	0.034 (0.86)	1.655 (42.04)	±0.005 (±0.13)	0.034 (0.86)	1.750 (44.45)	1.250 (31.75)
1 1/2	1.912 (48.56)	±0.006 (±0.15)	0.036 (0.91)	1.894 (48.11)	±0.006 (±0.15)	0.036 (0.91)	2.000 (50.80)	1.375 (34.92)
2	2.387 (60.63)	±0.006 (±0.15)	0.036 (0.91)	2.363 (60.02)	±0.006 (±0.15)	0.036 (0.91)	2.250 (57.15)	1.750 (44.45)
2 1/2	2.889 (73.38)	±0.007 (±0.18)	0.044 (1.12)	2.861 (72.67)	±0.007 (±0.18)	0.044 (1.12)	2.500 (63.50)	2.000 (50.80)
3	3.516 (89.31)	±0.008 (±0.20)	0.046 (1.17)	3.484 (88.49)	±0.008 (±0.20)	0.046 (1.17)	3.250 (82.55)	2.875 (73.02)
3 1/2	4.016 (102.01)	±0.008 (±0.20)	0.046 (1.17)	3.984 (101.19)	±0.008 (±0.20)	0.046 (1.17)	3.500 (88.90)	3.125 (79.37)
4	4.518 (114.76)	±0.009 (±0.23)	0.048 (1.22)	4.482 (113.84)	±0.009 (±0.23)	0.048 (1.22)	4.000 (101.60)	3.375 (85.72)
5	5.583 (141.81)	±0.010 (±0.25)	0.080 (2.03)	5.543 (140.79)	±0.010 (±0.25)	0.080 (2.03)	4.000 (101.60)	4.000 (101.60)
6	6.647 (168.83)	±0.011 (±0.28)	0.082 (2.08)	6.603 (167.72)	±0.011 (±0.28)	0.082 (2.08)	6.000 (152.40)	5.000 (127.00)
8	8.655 (219.84)	±0.015 (±0.38)	0.120 (3.05)	8.598 (218.39)	±0.015 (±0.38)	0.120 (3.05)	6.000 (152.40)	5.000 (127.00)
10	10.776 (273.71)	±0.015 (±0.38)	0.130 (3.30)	10.722 (272.34)	±0.015 (±0.38)	0.130 (3.30)	7.500 (190.50)	6.500 (165.10)
12	12.778 (324.56)	±0.015 (±0.38)	0.150 (3.81)	12.721 (323.11)	±0.015 (±0.38)	0.150 (3.81)	8.500 (215.90)	7.500 (190.50)
14	14.035 (356.49)	±0.015 (±0.38)	0.150 (3.81)	13.985 (355.22)	±0.015 (±0.38)	0.150 (3.81)	9.000 (228.60)	8.000 (203.20)
16	16.045 (410.08)	±0.015 (±0.38)	0.160 (4.06)	15.980 (405.89)	±0.015 (±0.38)	0.160 (4.06)	10.000 (254.00)	9.000 (228.60)
18	18.055 (458.60)	±0.020 (±0.51)	0.180 (4.57)	17.980 (456.69)	±0.020 (±0.51)	0.180 (4.57)	12.000 (304.80)	10.000 (254.00)
20	20.065 (509.65)	±0.025 (±0.64)	0.200 (5.08)	19.980 (507.49)	±0.025 (±0.64)	0.200 (5.08)	12.000 (304.80)	11.000 (279.40)
24	24.075 (611.51)	±0.030 (±0.76)	0.240 (6.10)	23.970 (608.84)	±0.030 (±0.76)	0.240 (6.10)	12.000 (304.80)	12.000 (304.80)

^A All tolerances on minimum dimensions shall be on the plus side.

^B "Out-of-round" is defined as the maximum measured diameter less the minimum measured diameter.

^C Maximum length = +0.250 in. (6.350 mm).

4. Materials

4.1 *General*—PVC plastics used to make the pipe, which are belled under this specification, are designated in PVC product standards referencing this standard.

4.2 Solvent cements must conform to the requirements of Specification D2565.

4.3 Primers must conform to the requirements of Specification F656.

5. Requirements

5.1 Bell Socket Dimensions and Tolerances:

5.1.1 *Diameters and Length*—The diameter, lengths, and tolerances of the bell sockets shall be as shown in Table 1 when measured in accordance with Test Method D2122.

5.1.2 *Wall Thicknesses*—The minimum wall thicknesses of the sockets (bell) shall not be less than 90 % of the minimums shown for the pressure pipe in the applicable ASTM specification. For non-pressure pipe, the integral socket (bell) shall be

considered satisfactory when formed from pipe which meets the minimum wall thickness requirements of the applicable ASTM specification when measured in accordance with Test Method D2122.

5.2 Joint Tests:

5.2.1 *Burst Pressure*—The minimum burst pressures for pipe and (bell) socket on pressure pipe shall be as given for pressure pipe in the applicable ASTM specification when determined in accordance with 10.3.

5.2.2 *Joint Tightness*—The (bell) socket joint on non-pressure pipe shall not leak when tested in accordance with 10.4.

6. Workmanship

6.1 Each socket (bell) is required to be uniform in depth, circular in cross section concentric with the pipe, and to have an end as square as commercially practicable.