



Standard Specification for “Fiberglass” (Glass-Fiber-Reinforced Thermosetting-Resin) Sewer Pipe¹

This standard is issued under the fixed designation D3262; 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.

1. Scope*

1.1 This specification covers machine-made fiberglass pipe, 8 in. (200 mm) through 156 in. (4000 mm), intended for use in gravity-flow systems for conveying sanitary sewage, storm water, and some industrial wastes. Both glass-fiber-reinforced thermosetting-resin pipe (RTRP) and glass-fiber-reinforced polymer mortar pipe (RPMP) are fiberglass pipes.

NOTE 1—For the purposes of this standard, polymer does not include natural polymers.

1.2 Although this specification is suited primarily for pipes to be installed in buried applications, it is acceptable to apply it to the extent applicable for other installations such as, but not limited to, jacking, tunnel lining and sliplining rehabilitation of existing pipelines.

NOTE 2—There is no known ISO equivalent to this standard.

1.3 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

1.4 The following safety hazards caveat pertains only to the test method portion, Section 8, of this specification. *This standard does not purport to address all of the safety problems, 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.*

2. Referenced Documents

2.1 *ASTM Standards*:²

[C33 Specification for Concrete Aggregates](#)

[D638 Test Method for Tensile Properties of Plastics](#)

[D695 Test Method for Compressive Properties of Rigid Plastics](#)

¹ This specification is under the jurisdiction of ASTM Committee D20 on Plastics and is the direct responsibility of Subcommittee D20.23 on Reinforced Plastic Piping Systems and Chemical Equipment.

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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.

[D883 Terminology Relating to Plastics](#)

[D1600 Terminology for Abbreviated Terms Relating to Plastics](#)

[D2412 Test Method for Determination of External Loading Characteristics of Plastic Pipe by Parallel-Plate Loading](#)

[D2584 Test Method for Ignition Loss of Cured Reinforced Resins](#)

[D2992 Practice for Obtaining Hydrostatic or Pressure Design Basis for “Fiberglass” \(Glass-Fiber-Reinforced Thermosetting-Resin\) Pipe and Fittings](#)

[D3567 Practice for Determining Dimensions of “Fiberglass” \(Glass-Fiber-Reinforced Thermosetting Resin\) Pipe and Fittings](#)

[D3681 Test Method for Chemical Resistance of “Fiberglass” \(Glass-Fiber-Reinforced Thermosetting-Resin\) Pipe in a Deflected Condition](#)

[D3892 Practice for Packaging/Packing of Plastics](#)

[D4161 Specification for “Fiberglass” \(Glass-Fiber-Reinforced Thermosetting-Resin\) Pipe Joints Using Flexible Elastomeric Seals](#)

[F412 Terminology Relating to Plastic Piping Systems](#)

[F477 Specification for Elastomeric Seals \(Gaskets\) for Joining Plastic Pipe](#)

2.2 *AWWA Standard*:

[Standard C-950, Glass-Fiber Reinforced Thermosetting Resin Pipe](#)³

3. Terminology

3.1 *Definitions*:

3.1.1 *General*—Unless otherwise indicated, definitions are in accordance with Terminology D883 or Terminology F412, and abbreviations are in accordance with Terminology D1600.

3.2 *Definitions of Terms Specific to This Standard*:

3.2.1 *fiberglass pipe*—tubular product containing glass fiber reinforcements embedded in or surrounded by cured thermosetting resin.

3.2.1.1 *Discussion*—The composite structure may contain aggregate, granular, or platlet fillers, thixotropic agents, pigments, or dyes, and thermoplastic or thermosetting liners.

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

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

3.2.2 *flexible joint*—a joint that is capable of axial displacement or angular rotation, or both.

3.2.3 *liner*—a resin layer, with or without filler or reinforcement, or both, forming the interior surface of the pipe.

3.2.4 *qualification test*—one or more tests used to prove the design of a product. Not a routine quality control test.

3.2.5 *reinforced polymer mortar pipe (RPMP)*—fiberglass pipe with aggregate.

3.2.6 *reinforced thermosetting resin pipe (RTRP)*—fiberglass pipe without aggregate.

3.2.7 *rigid joint*— a joint that is not capable of axial displacement or angular rotation.

3.2.8 *surface layer*—a resin layer, with or without filler or reinforcement, or both, applied to the exterior surface of the pipe structural wall.

4. Classification

4.1 *General*—This specification covers fiberglass sewer pipe defined by raw materials in the structural wall (type) and liner, surface layer material (grade), and pipe stiffness. Table 1 lists the types, liners, grades, and stiffnesses covered.

NOTE 3—All possible combinations of types, liners, grades, and stiffnesses may not be commercially available. It is acceptable to add additional types, liners, grades, and stiffnesses as they become commercially available. The purchaser should determine for himself or consult with the manufacturer for the proper type, liner, grade, and stiffness of pipe to be used under the installation and operating conditions that will exist for the project in which pipe is to be used.

4.2 *Designation Requirements*—The pipe materials designation code shall consist of the standard designation, ASTM D3262, followed by type, liner, and grade indicated in Arabic numerals, and pipe stiffness by a capital letter. Table 1 presents a summary of the designation requirements. Thus a complete material code shall consist of ASTM D3262, three numerals, and a capital letter.

NOTE 4—Examples of the designation codes are as follows: (1) ASTM D3262-1-1-3-A for glass–fiber–reinforced aggregate and polyester resin

mortar pipe with a reinforced thermoset liner and an unreinforced polyester resin and sand surface layer having a minimum pipe stiffness of 9 psi (62 kPa). (2) ASTM D3262-4-2-6-C for glass–fiber–reinforced epoxy resin pipe with an unreinforced thermoset liner, no surface layer, having a minimum pipe stiffness of 36 psi (248 kPa).

NOTE 5—Although the *Form and Style for ASTM Standards* manual requires that the type classification be roman numerals, it is recognized that few companies have stencil-cutting equipment for this style of type, and it is therefore acceptable to mark the product type in Arabic numbers.

5. Materials and Manufacture

5.1 *General*—The thermosetting resins, glass fiber reinforcements, fillers, and other materials, when combined as a composite structure, shall produce piping products that meet the performance requirements of this specification.

5.2 *Wall Composition*—The basic structural wall composition shall consist of a thermosetting resin, glass-fiber reinforcement, and if used, an aggregate filler.

5.2.1 *Resin*—A thermosetting polyester or epoxy resin, with or without filler.

5.2.2 *Reinforcement*—A commercial grade of glass fibers compatible with the resin used.

5.2.3 *Aggregate*—A siliceous sand conforming to the requirements of Specification C33, except that the requirements for gradation shall not apply.

5.3 *Liner and Surface Layer*—A liner or surface layer, or both, when incorporated into or onto the pipe, shall meet the structural requirements of this specification.

5.4 *Joints*—The pipe shall have a joining system that shall provide for fluid tightness for the intended service condition. Restrained or unrestrained and flexible or rigid joints are acceptable depending on the specific configuration and design conditions.

5.4.1 *Unrestrained*—Pipe joints capable of withstanding internal pressure but not longitudinal tensile loads.

5.4.1.1 *Coupling or Bell-and-Spigot Gasket Joints*, with a groove either on the spigot or in the bell to retain an elastomeric gasket that shall be the sole element of the joint to provide watertightness. For typical joint detail see Fig. 1.

TABLE 1 General Designation Requirements for Fiberglass Sewer Pipe

Designation Order	Property	Cell Limits ^A					
1	Type	1 glass-fiber-reinforced thermosetting polyester ^B resin mortar (RPMP polyester ^B)	2 glass-fiber-resin-reinforced thermosetting polyester ^B resin (RTRP polyester ^B)	3 glass-fiber-reinforced thermosetting epoxy resin mortar (RPMP epoxy)	4 glass-fiber-reinforced thermosetting epoxy resin (RTRP epoxy)		
2	Liner	1 reinforced thermoset liner	2 non-reinforced thermoset liner	3 thermoplastic liner	4 no liner		
3	Grade	1 polyester ^B resin surface layer—reinforced	2 polyester ^B resin surface layer—nonreinforced	3 polyester ^B resin and sand surface layer non-reinforced	4 epoxy resin surface layer—reinforced	5 epoxy resin surface layer—non-reinforced	6 no surface layer
4	Pipe stiffness psi (kPa)	A 9 (62)	B 18 (124)	C 36 (248)	D ^{A,B} 72 (496)		

^AThis cell-type format provides the means of identification and specification of piping materials. This cell-type format, however, is subject to misapplication since unobtainable property combinations can be selected if the user is not familiar with non-commercially available products. The manufacturer needs to be consulted.

^BFor the purposes of this specification, polyester includes vinyl ester resins.

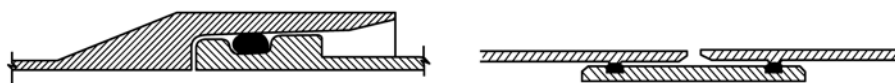


FIG. 1 Typical Joints

5.4.1.2 *Mechanical Coupling Joint*, with elastomeric seals.

5.4.1.3 *Butt Joint*, with laminated overlay.

5.4.1.4 *Flanged Joint*, both integral and loose ring.

5.4.2 *Restrained*—Pipe joints capable of withstanding internal pressure and longitudinal tensile loads.

5.4.2.1 Joints similar to those in 5.4.1.1 with supplemental restraining elements.

5.4.2.2 *Butt Joint*, with laminated overlay.

5.4.2.3 *Bell-and-Spigot*, with laminated overlay.

5.4.2.4 *Bell-and-Spigot*, adhesive-bonded joint: Three types of adhesive-bonded joints are permitted by this standard as follows:

(1) *Tapered bell-and-spigot*, an adhesive joint that is manufactured with a tapered socket for use in conjunction with a tapered spigot and a suitable adhesive.

(2) *Straight bell-and-spigot*, an adhesive joint that is manufactured with an untapered socket for use in conjunction with an untapered spigot and a suitable adhesive.

(3) *Tapered bell and straight spigot*, an adhesive joint that is manufactured with a tapered socket for use with an untapered spigot and a suitable adhesive.

5.4.2.5 *Flanged Joint*, both integral and loose ring.

5.4.2.6 *Mechanical Coupling*, an elastomeric sealed coupling with supplemental restraining elements.

5.4.2.7 *Threaded joints*.

NOTE 6—It is acceptable to add other types of joints as they become commercially available.

NOTE 7—Restrained joints typically increase service loads on the pipe to greater than those experienced with unrestrained joints. The purchaser is cautioned to take into consideration all conditions in the anticipated service and to consult the manufacturer regarding the suitability of a particular type and class of pipe for service with restrained joint systems.

5.5 *Gaskets*—Elastomeric gaskets used with this pipe shall conform to the requirements of Specification F477, except that composition of the elastomer shall be as agreed upon between the purchaser and the supplier for the particular exposure to oily or aggressive chemical environments.

6. Requirements

6.1 *Workmanship*—Each pipe shall be free from all defects including indentations, delaminations, bubbles, pinholes, cracks, pits, blisters, foreign inclusions, and resin-starved areas that, due to their nature, degree, or extent, detrimentally affect the strength and serviceability of the pipe. The pipe shall be as uniform as commercially practicable in color, opacity, density, and other physical properties.

6.1.1 The inside surface of each pipe shall be free of bulges, dents, ridges, and other defects that result in a variation of inside diameter of more than $\frac{1}{8}$ in. (3.2 mm) from that obtained on adjacent unaffected portions of the surface. No glass fiber reinforcement shall penetrate the interior surface of the pipe wall.

6.1.2 Joint sealing surfaces shall be free of dents, gouges, and other surface irregularities that will affect the integrity of the joints.

6.2 Dimensions:

6.2.1 *Pipe Diameters*—The pipe shall be supplied in the nominal diameters shown in Table 2 or Table 3. The tolerances shall be as shown in Table 2 or Table 3, when measured in accordance with 8.1.1.

6.2.2 *Lengths*—Pipe shall be supplied in nominal lengths of 10, 20, 30, 40, and 60 ft (3.05, 6.10, 9.15, 12.19, and 18.29 m). The actual laying length shall be the nominal length ± 2 in. (± 51 mm), when measured in accordance with 8.1.2. At least 90 % of the total footage of any one size and stiffness, excluding special-order lengths, shall be furnished in the nominal lengths specified by the purchaser. Random lengths, if furnished, shall not vary from the nominal lengths by more than 5 ft (1.53 m), or 25 %, whichever is less.

6.2.3 *Wall Thickness*—The average wall thickness of the pipe shall not be less than the nominal wall thickness published in the manufacturer's literature current at the time of purchase, and the minimum wall thickness at any point shall not be less than 87.5 % of the nominal wall thickness when measured in accordance with 8.1.3.

6.2.4 *Squareness of Pipe Ends*—All points around each end of a pipe unit shall fall within $\pm \frac{1}{4}$ in. (± 6.4 mm) or ± 0.5 % of the nominal diameter of the pipe, whichever is greater, to a plane perpendicular to the longitudinal axis of the pipe, when measured in accordance with 8.1.4.

6.3 Chemical Requirements:

6.3.1 *Long-Term*—Pipe specimens, when tested in accordance with 8.2.1, shall be capable of being deflected, without failure, at the 50 year strain level given in Table 4 when exposed to 1.0 *N* sulfuric acid.

NOTE 8—See Appendix X1 for derivation of the minimum sewer pipe chemical requirements given in Table 4.

NOTE 9—The calculations in Table 4 and Appendix X1 assume that the neutral axis is at the pipe wall midpoint. For pipe wall constructions that produce an altered neutral axis position, $2y$ shall be substituted for t to evaluate results and establish requirements. (y is the maximum distance from the neutral axis to the pipe surface.)

6.3.2 *Control Requirements*—Test pipe specimens periodically in accordance with 8.2.2, following the procedure of 8.2.2.1, or alternatively, the procedure of 8.2.2.2.

6.3.2.1 When the procedure of 8.2.2.1 is used, the following three criteria must be met: (a) the average failure time at each strain level must fall at or above the lower 95 % confidence limit of the originally determined regression line, (b) all specimen-failure times shall be greater than the lower 95 % prediction limit of the originally determined regression line, and (c) one third or more of the specimen-failure times must be on or above the originally determined regression line.