

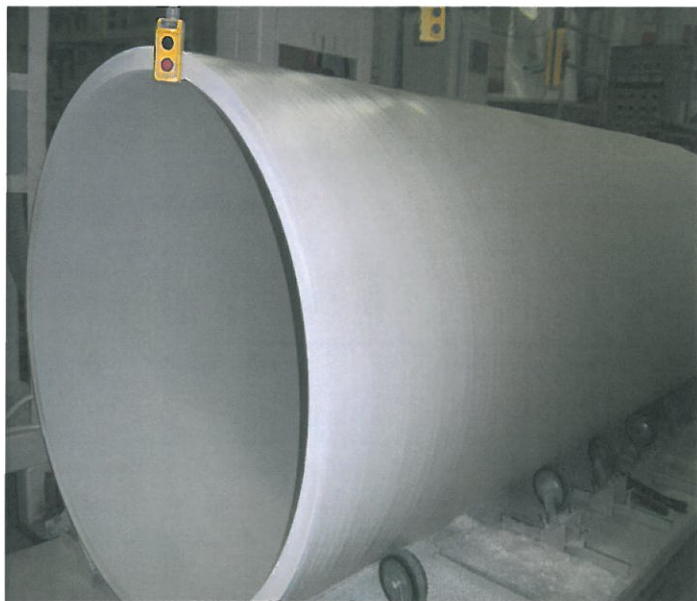
Vylon Pipe

TECHNICAL BULLETIN

Vylon Pipe Now Offers
PS 75 Pipe
21" – 54" Diameters

Vylon Pipe, the leading manufacturer of large diameter sewer pipe for the past 25 years, is announcing yet another innovation. In addition to offering a PS 46 pipe (a pipe stiffness of 46 psi), Vylon Pipe now offers a PS 75 pipe to meet the needs of those municipalities and sewer districts requiring higher pipe stiffness.

The Vylon PS 75 pipe has the same closed profile design as the PS 46 pipe, just a slightly taller profile and a thicker wall. The easy-to-install bell and spigot design is also the same. In fact, all the requirements of ASTM F 1803 are met with the new design. The only change is higher pipe stiffness, and, in addition, the same higher impact resistance of 440 ft-lbs as our PS 46 pipe for 30" through 54" diameters.



**Higher pipe stiffness and impact resistance!
Nothing comparable in any other plastic
or
fiberglass gravity flow sewer pipe standard!**

Yylon Pipe

Specification for PVC Heavy Duty (PS-75) Closed Profile Gravity Sewer Pipe (ASTM F 1803)

Scope

This specification designates the requirements for polyvinyl chloride (PVC) pipe and fittings made to a controlled inside diameter in sizes 21" to 54" with an integral bell and elastomeric seal joints which meets the requirements of ASTM F 1803.

Materials

Pipe and fittings 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 and dimensions shall meet the requirements of ASTM F 1803.

Joints

All pipe joints shall be of the bell and spigot type with elastomeric seals and conform to the requirements of ASTM D 3212. Gaskets shall be factory installed and chemically bonded to the bell end of the pipe, with part of the gasket surface visible on the exterior of the bell. Gasket material shall conform to the requirements of ASTM F 477. Factory tapered spigot ends shall be made of PVC and shall be formed during the manufacturing process by heating the inner and/or outer wall and remolding. Spigot ends formed by using filler materials such as rubber, neoprene or other filler materials that are attached or glued to the inner wall are not be acceptable.

Fittings

All fittings shall be fabricated from pipe meeting the requirements of these standards. Fabricated miter joints shall be reinforced by fusion heat welding.

Physical Requirements

Pipe stiffness - minimum pipe stiffness shall be 75 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 and ASTM F 1803. Pipe 21" through 27" in size will be capable of passing an impact test of 220 ft. lbs. Pipe 30 inches and larger shall be capable of passing an impact test of 440 ft/lbs. when tested at time of production. Independent laboratory certification shall be provided with the submittal that the pipe has been tested and found capable of meeting this requirement.

Ductility-there shall be no evidence of cracking or splitting when pipe is flattened in a circumferential orientation between two flat plates in accordance with the requirements of ASTM F 1803.

Air Tightness-Each length of pipe shall pass a factory 3.5 psi air test as required by ASTM F 1803.

Marking

Each pipe shall be identified with the name of manufacturer, nominal size, cell classification, ASTM designation F 1803, the pipe stiffness designation "PS-75" and manufacturer's date code.

Installation

Bedding, backfill and general installation requirements should comply with ASTM D 2321. Further details can be obtained from the Yylon PVC Gravity Sewer Pipe Installation Guide. Gaskets, bells and spigots shall be cleaned and free from soil or stones prior to assembly. Lubricants supplied by the pipe manufacturer shall be applied to the bell and spigot surface up to the assembly stop mark. Spigots should be aligned with the bell and be pushed or pulled into place so that the second assembly mark is just visible adjacent to the bell entry point.

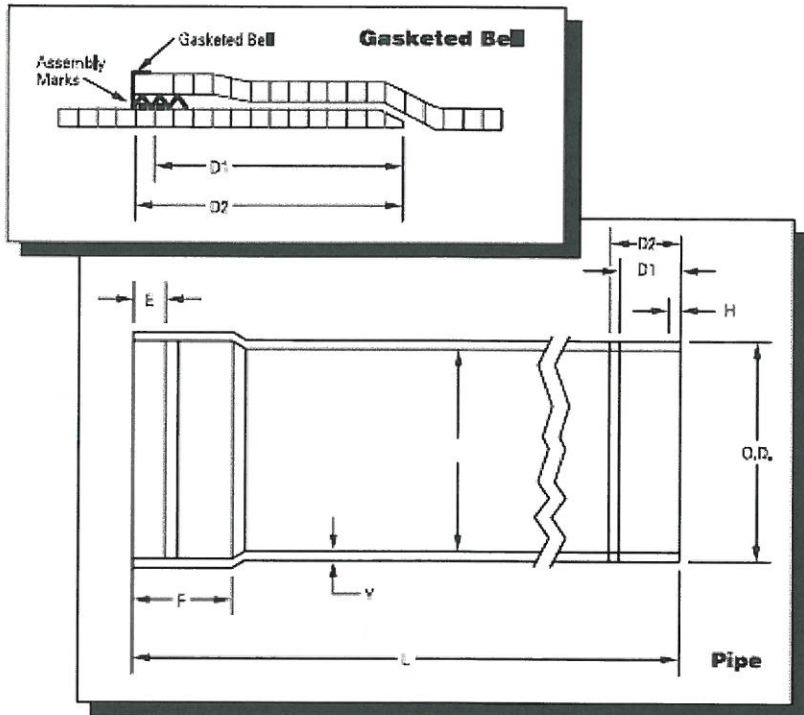


Table 1. Yylon Pipe Diameter Dimensions

NOMINAL SIZE	NOMINAL O.D.	BELL O.D.	NOMINAL I.D.	MINIMUM INNER WALL	Y MINIMUM PROFILE HEIGHT
21"	22.29	24.47	20.75	0.080	0.770
24"	25.24	27.62	23.50	0.100	0.870
27"	28.46	31.06	26.50	0.115	0.980
30"	31.69	34.50	29.50	0.125	1.095
36"	38.13	41.40	35.50	0.150	1.315
42"	44.58	48.30	41.50	0.180	1.540
48"	51.02	55.18	47.50	0.210	1.760
54"	57.47	62.08	53.50	0.225	1.985

Table 2. Yylon Pipe Diameter Dimensions

NOMINAL SIZE	SPIGOT HOMING MARKS D1	SPIGOT HOMING MARKS D2	E LIP MINIMUM	F SOCKET DEPTH	L LENGTH
21"	6.50	7.50	3.75	6.00	14' 9"
24"	6.50	7.50	3.75	6.00	14' 9"
27"	7.50	8.50	3.75	7.00	14' 10"
30"	7.50	8.50	3.75	7.00	14' 10"
36"	8.00	9.00	3.75	7.50	14' 10.5"
42"	8.25	9.25	3.75	7.75	14' 10.75"
48"	8.50	9.50	3.75	8.00	14' 11.5"
54"	8.50	9.50	3.75	8.00	15' 0"