



Standard Specification for Compression Joints for Vitrified Clay Pipe and Fittings¹

This standard is issued under the fixed designation C 425; 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 approval. 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 Department of Defense.

1. Scope

1.1 This specification covers materials and test requirements for compression joints for vitrified clay pipe and fittings. See Specification C 700 for pipe specifications. The test requirements are applicable to pipe joint assemblies prior to field installation of pipe.

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

NOTE 1—Install pipe in accordance with Practice C 12.

1.3 The following precautionary caveat pertains only to the Test Requirements portion, Section 7, of this standard. *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.*

2. Referenced Documents

2.1 ASTM Standards:²

- A 167 Specification for Stainless and Heat-Resisting Chromium-Nickel Steel Plate, Sheet, and Strip
- A 240/A 240M Specification for Heat-Resisting Chromium and Chromium-Nickel Stainless Steel Plate, Sheet, and Strip for Pressure Vessels
- C 12 Practice for Installing Vitrified Clay Pipe Lines
- C 700 Specification for Vitrified Clay Pipe, Extra Strength, Standard Strength, and Perforated
- C 896 Terminology Relating to Clay Products
- D 395 Test Methods for Rubber Property—Compression Set

- D 412 Test Methods for Vulcanized Rubber and Thermoplastic Elastomers—Tension
- D 471 Test Method for Rubber Property—Effect of Liquids
- D 518 Test Method for Rubber Deterioration—Surface Cracking
- D 543 Practices for Evaluating the Resistance of Plastics to Chemical Reagents
- D 573 Test Method for Rubber—Deterioration in an Air Oven
- D 883 Terminology Relating to Plastics
- D 1149 Test Method for Rubber Deterioration—Surface Ozone Cracking in a Chamber
- D 1566 Terminology Relating to Rubber
- D 2240 Test Method for Rubber Property—Durometer Hardness

3. Terminology

- 3.1 *Definitions*—Terms relating to plastics and rubber shall be as defined in Terminologies D 883 and D 1566, respectively.
- 3.2 Terminology C 896 can be used for clarification of terminology in this specification.

4. Principles of Joint Design

- 4.1 Sealing elements shall be compressed between bearing surfaces to assure watertight integrity as required in Section 7.
- 4.2 Sealing elements shall either be bonded to bearing surfaces or be independent elements.

5. Materials and Manufacture

- 5.1 Rubber ring-sealing elements shall conform to the requirements of Table 1.
- 5.2 Rubber for other than ring-sealing elements shall conform to the requirements of Table 2.
- 5.3 Plastic components shall conform to the requirements of Table 3.
- 5.4 Metallic components shall be of corrosion-resistant metal conforming to Specifications A 167 and A 240/A 240M.
- 5.5 If any of the test specimens fail to meet the chemical resistance requirements, the manufacturer will be allowed a retest of two additional specimens, representative of the

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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.

TABLE 1 Tests for Rubber—Ring-Sealing Elements

NOTE—Except for the water absorption test (Test Method D 471), the tests shall be run on specimens cut from rubber test slabs representative of the finished product.

Test	Test Requirement	ASTM Standard
Chemical resistance:		D 543 [48 h at 23 ± 2°C]
1N sulfuric acid	no weight loss	
1N hydrochloric acid	no weight loss	
Tensile strength	1500 psi (10.4 MPa) min; 500 % min elongation at break	D 412
Hardness	Shore A durometer 35 min to 50 max	D 2240
Compression set	16 % max of original deflection	D 395, Method B [22 h at 70 ± 2°C]
Water absorption	5 % max	D 471—Immerse a 2-in. (51-mm) long section cut from a rubber-sealing element in distilled water for 7 days at 70 ± 2°C
Ozone resistance	no visible cracking under 2× specimen magnification using D 518, Procedure B, stretched 20 % and exposed to ozone concentrations of 0.5 ppm for 24 h at 40 ± 1°C	D 1149
Accelerated oven aging	80 % min of original tensile strength 75 % min of original elongation	D 573 [7 days at 70 ± 2°C]

TABLE 2 Tests for Rubber—Other than Ring-Sealing Elements

NOTE—Except for the water absorption test (Test Method D 471), the tests shall be run on specimens cut from rubber test slabs representative of the finished product.

Test	Test Requirements	ASTM Standard
Chemical resistance:		D 543 [48 h at 23 ± 2°C]
1N sulfuric acid	no weight loss	
1N hydrochloric acid	no weight loss	
Tensile strength	1000 psi (6.9 MPa) min; 250 % min elongation at break	D 412
Hardness	Shore A durometer 55 min to 70 max	D 2240
Compression set	20 % max of original deflection	D 395, Method B [22 h at 70 ± 2°C]
Water absorption	5 % max	D 471—Immerse a 2-in. (51-mm) long section cut from a rubber coupling in distilled water for 7 days at 70 ± 2°C
Ozone resistance	no visible cracking under 2× specimen magnification, using D 518, Procedure B, stretched 20 % and exposed to ozone concentrations of 0.5 ppm for 24 h at 40 ± 1°C	D 1149
Accelerated oven aging	85 % min of original tensile strength 85 % min of original elongation	D 573 [7 days at 70 ± 2°C]

TABLE 3 Tests for Plastic Materials

Test	Test Requirements	ASTM Standard
Chemical resistance:		D 543 (48 h at 23 ± 2°C)
1 N sulfuric acid	no weight loss	
1 N hydrochloric acid	no weight loss	

original material tested, for each one that failed. The jointing material will be acceptable if all retest specimens meet the test requirements.

5.6 Joints complying with this standard are suitable for most domestic and commercial applications. However, attention is called to the fact that industrial effluents vary in content, concentration, duration of discharge and temperature; and specific evaluations of joint performance in such environments are necessary. In those instances, consult the manufacturer.

6. Joint Specimen Preparation

6.1 When required, assembled joints representative of the pipe and joints to be used, shall be selected from the supplier's stock by the purchaser or his representative.

6.2 Specimens selected for the test shall be up to 0.25 % of the number of joints to be furnished. No fewer than two assembled joints shall be tested for each diameter of pipe furnished.

6.3 Test specimens shall not be taken from damaged joints or pipe.

7. Test Requirements for Joints

7.1 Joints shall meet the requirements of 7.1.1 and 7.1.2 or 7.1.1 and 7.1.3, when subjected to an internal 10-ft (3.1-m) head of water pressure (4.3 psi (30 kPa)), for a total test period of 1 h. The recommended temperature of the water, pipe, and atmosphere is 60 to 75°F (16 to 24°C).

7.1.1 Joints shall not leak when tested in the straight position and when deflected to amounts shown in Table 4. The ends of the test line shall only be restrained the amount that is necessary to prevent longitudinal movement. The deflection shall be determined by measuring the distance the free end of one pipe moves away from the center line in any direction while the other pipe remains fixed.

7.1.2 Assembled joints shall not leak when subjected to shear. The shear load shall be a force of 150 lbf/in. (26 kN/m) of nominal diameter uniformly applied over an arc of not less

TABLE 4 Deflection

Nominal Diameter, in. (mm)	Deflection of Pipe, in./linear ft (mm/linear m)
3 to 12 (76 to 305), incl	1/2 (42)
15 to 24 (380 to 610), incl	3/8 (31)
27 to 36 (685 to 915), incl	1/4 (21)
39 and 42 (990 and 1065)	3/16 (16)
48 (1220)	1/8 (10)

than 120° (2.1 rad) along a longitudinal distance of not more than 12 in. (305 mm) at the spigot end of one pipe. The load is applied immediately adjacent to the assembled joint with the

other pipe adequately secured and supported on blocks placed immediately adjacent to the joint.

7.1.3 Joints shall not leak when the jointed ends are displaced relative to one another in any direction perpendicular to the pipe axis a distance of 0.04 in./in. (0.04 mm/mm) of pipe diameter.

8. Keywords

8.1 bell; chemical resistance; clay pipe; compression joints; corrosion resistance; couplings; deflection; joints; sealing elements; shear; testing

SUPPLEMENTARY REQUIREMENTS

These requirements apply only to Federal/Military procurement, not domestic sales or transfers.

S1. Government/Military Procurement

S1.1 *Responsibility for Inspection*—Unless otherwise specified in the contract or purchase order, the producer is responsible for the performance of all inspection and test requirements specified herein. The producer may use his own or any other suitable facilities for the performance of the inspection and test requirements specified herein, unless the purchaser disapproves. The purchaser shall have the right to perform any of the inspections and tests set forth in this specification where such inspections are deemed necessary to ensure that material conforms to prescribed requirements.

NOTE S1.1—In U.S. Federal contracts, the contractor is responsible for inspection.

S2. Packaging and Marking for U.S. Government Procurement:

S2.1 *Packaging*—Unless otherwise specified in the contract, the materials shall be packaged in accordance with the supplier's standard practice in a manner ensuring arrival at destination in satisfactory condition and which will be acceptable to the carrier at lowest rates. Containers and packing shall comply with Uniform Freight Classification rules or National Motor Freight Classification rules.

S2.2 *Marking*—Marking for shipment shall be in accordance with Fed. Std. No. 123 for civil agencies and MIL-STD-129 for military agencies.

NOTE S2.1—The inclusion of U.S. Government procurement requirements should not be construed as an indication that the U.S. Government uses or endorses the products described in this document.

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