



Standard Specification for Joints for Concrete Pipe and Manholes, Using Rubber Gaskets¹

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

1. Scope

1.1 This specification covers flexible watertight joints for concrete pipe and precast manhole sections, using rubber gaskets for sealing the joints, where infiltration or exfiltration is a factor in the design. The specification covers the design of joints and the requirements for rubber gaskets to be used therewith, for pipe conforming in all other respects to Specification C 14, Specification C 76, or Specification C 507 and precast manhole section conforming in all other respects to Specification C 478, provided that if there is conflict in permissible variations in dimensions the requirements of this specification for joints shall govern.

1.2 A complete metric companion to Specification C 443 has been developed—C 443M; therefore, no metric equivalents are presented in this specification.

NOTE 1—This specification covers the design, material, and performance of the rubber gasket joint only. Joints covered by this specification are normally adequate for hydrostatic pressures up to 13 psi (30 ft) without leakage, when tested in accordance with Section 10. Infiltration or exfiltration quantities for an installed pipeline are dependent upon many factors other than the joints, and allowable quantities must be covered by other specifications and suitable testing of the installed pipeline and system.

2. Referenced Documents

2.1 ASTM Standards:²

- C 14 Specification for Concrete Sewer, Storm Drain, and Culvert Pipe
- C 76 Specification for Reinforced Concrete Culvert, Storm Drain, and Sewer Pipe
- C 478 Specification for Precast Reinforced Concrete Manhole Sections

¹ This specification is under the jurisdiction of ASTM Committee C13 on Concrete Pipe and is the direct responsibility of Subcommittee C13.08 on Rubber Gaskets.

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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.

- C 497 Test Methods for Concrete Pipe, Manhole Sections, or Tile
- C 507 Specification for Reinforced Concrete Elliptical Culvert, Storm Drain, and Sewer Pipe
- C 822 Terminology Relating to Concrete Pipe and Related Products
- D 395 Test Methods for Rubber Property—Compression Set
- D 412 Test Methods for Vulcanized Rubber and Thermoplastic Rubbers and Thermoplastic Elastomers—Tension
- D 471 Test Method for Rubber Property—Effect of Liquids
- D 573 Test Method for Rubber—Deterioration in an Air Oven
- D 1149 Test Method for Rubber Deterioration—Surface Ozone Cracking in a Chamber
- D 2240 Test Method for Rubber Property—Durometer Hardness

3. Terminology

3.1 *Definitions*—For definitions of terms relating to concrete pipe, see Terminology C 822.

4. Basis of Acceptance

4.1 The acceptability of the pipe joints and gaskets shall be determined by the results of the physical tests prescribed in this specification, if and when required, and by inspection to determine whether the pipe joints and gaskets conform to this specification as to design and freedom from defects.

5. Materials and Manufacture for Gaskets

5.1 All rubber gaskets shall be extruded or molded and cured in such a manner that any cross section will be dense, homogeneous, and free of porosity, blisters, pitting, and other imperfections. The gaskets shall be extruded or molded to the specified size within a tolerance of $\pm 6\%$ on any dimension, measured at any cross section. The rubber gasket shall be fabricated from a high-grade rubber compound. The basic polymer shall be natural rubber, synthetic rubber, or a blend of both acceptable to the owner and meeting the physical requirements prescribed in Section 6.

6. Physical Requirements for Gaskets

6.1 *Testing*—Testing shall be in accordance with Section 9.

6.1.1 *Standard Gasket Requirement*—The gaskets shall meet with the following physical requirements:

Tensile strength, min	1200 psi
Elongation at break, min, %	350
Shore durometer hardness:	
Min	35 ^A
Max	65 ^A
Compression set, max, % of original deflection	25
Accelerated aging, max % of original	
Decrease in tensile strength	15
Decrease in elongation	20
Liquid immersion, max % weight increase	
Water absorption	10
Ozone resistance	no cracks in accordance with Test Method D 1149

^A Allowable variation ± 5 from manufacturer's specified hardness provided the actual hardness is within the limits of 35 to 65.

6.1.2 *Oil Resistant Gasket Requirements*—The compound shall contain not less than 50 % by volume oil resistant polymer and shall meet the following physical requirements:

Tensile strength, min, psi	1200
Elongation at break, min, %	350
Shore durometer hardness, nominal:	
Min	35 ^A
Max	65 ^A
Durometer aging, max, increase	15
Compression set, % (22 h at 158°F)	25
Accelerated aging (96 h at 158°F)	
Decrease in tensile strength, max, % of original	20
Decrease in elongation, max, % of original	40
Liquid immersion (volume change):	
Oil, max, % after immersion in ASTM #3 for 70 h at 212°F	80
Water, max, % after immersion for 48 h at 158°F	15
Ozone resistance, after 72 h exposure in 50 PPHM ozone concentration at 104°F	no visible cracking

^A Allowable variation ± 5 from manufacturers specified hardness provided the actual hardness is within the limits of 35 to 65.

6.2 If a splice is used in the manufacture of the gasket, the strength shall be such that the gasket shall withstand 100 % elongation over the part of the gasket which includes the splice with no visible separation of the splice. While in the stretched position, the gasket shall be rotated in the spliced area a minimum of 180° in each direction in order to inspect for separation. In addition, any portion of the splice shall be capable of passing a bend test without visible separation. The bend test for gaskets is defined as wrapping the portion of the unstretched gasket containing the splice a minimum of 180° and a maximum of 270° around a rod. For O-ring gaskets the diameter of the rod shall be equal to the cross-section diameter of the gasket. For noncircular gaskets, the rod diameter shall not be less than ½ in. or more than 1 in.

6.3 Gasket swell has a bearing on joint performance. The pipe manufacturer shall set appropriate limits for swell and durometer change of the gasket material and “wash off” for the gasket lubricant. These limits shall then be verified by test methods described in Test Methods C 497. Gasket Lubricant shall not be altered, corrupted, or diluted from its original formulation as tested and certified prior to use on the gasket for installation purposes.

7. Design of Joints

7.1 The manufacturer shall furnish the owner with the detailed design of the joint or joints including design and durometer hardness of the rubber gasket proposed to be furnished under this specification.

7.1.1 The joint design shall consist of a bell or groove on one end of a unit of pipe, and a spigot or tongue on the adjacent end of the joining pipe.

7.1.2 All surfaces of the joint upon or against which the gasket is capable of bearing shall be smooth, free of spalls, cracks or fractures, and imperfections that would adversely affect the performance of the joint.

7.1.3 The joints of the pipe shall be of such design that they will withstand the forces caused by the compression of the gasket when joined, without cracking or fracturing when tested in accordance with Section 10.

7.1.4 The angle of taper on the conic surfaces of the inside of the bell or groove and the outer surface of the spigot or tongue where the gasket seats shall be not more than 3.5° measured from the pipe axis, except that tapers up to 5° are not prohibited if proven adequate by plant tests as specified in Section 10 and approved by the owner. The conic surface on the spigot or tongue shall be modified to properly contain and seat the gasket.

7.1.5 The annular space between the gasket-bearing surfaces of the assembled and centered joint shall be not more than 75 % of the uncompressed thickness of the applied gasket including the manufacturer's tolerances of the joint and gasket. The joint design shall provide for the deflection of a pipe unit by opening one side of the outside perimeter of the joint ½ in. wider than the assembled position without reducing its watertightness. Where greater deflections are required than provided by the joint design, beveled joints or elbows must be provided.

7.1.6 The gasket shall be the sole element depended upon to make the joint flexible and watertight. The gasket shall be a continuous ring which fits snugly into the annular space between the overlapping surfaces of the assembled pipe joint to form a flexible watertight seal.

7.1.7 The gasket shall not be stretched more than 30 % of its original circumference when seated on the spigot or tongue end of the pipe.

7.1.8 Where the particular joint design utilizing a rubber gasket dictates the use of a lubricant to facilitate assembly, the lubricant composition shall have no detrimental effect on the performance of the gasket and joint due to prolonged exposure.

NOTE 2—Joints in an assembled position are defined as joints in the position after assembly in accordance with the manufacturer's design.

7.2 *Alternative Joint Designs*—When agreed upon by the owner, manufacturers are not prohibited from submitting to the owner detailed designs for joints and gaskets other than those described in Section 7. Design submissions shall include joint geometry, tolerances, gasket characteristics, proposed plant tests, gasket splice bend tests, and such other information as required by the owner to evaluate the joint design for field performance. Joints and gaskets of alternative joint designs shall at least meet all test requirements of this specification if permitted by the owner. Alternative joint designs shall be

acceptable provided the designs are approved by the owner prior to manufacture and provided the test pipe comply with the specified tests.

8. Permissible Variations in Dimensions

8.1 The planes formed by the ends of nonbeveled pipe shall not vary from the perpendicular to the pipe axis by more than $\frac{3}{16}$ in. for internal diameters or equivalent diameters 30 in. and smaller; or by more than $\frac{1}{4}$ in. for internal diameters or equivalent diameters 33 to 54 in. inclusive; or not more than $\frac{3}{8}$ in. for internal diameters or equivalent diameters 60 in. and larger.

8.2 The manufacturer's tolerances for the width of the annular space between the gasket bearing surfaces shall not vary by more than $\pm 10\%$ of the uncompressed thickness of the applied gasket.

9. Test Methods for Gaskets

9.1 The physical properties of the gaskets shall be determined in accordance with the following methods:

9.1.1 *Tensile Strength and Elongation*—Test Methods D 412.

9.1.2 *Hardness*—Test Method D 2240, with the exception of Section 5. The determination shall be taken directly on the gasket. The presser foot shall be applied on areas that are $\frac{1}{4}$ in. or greater in thickness. If $\frac{1}{4}$ in. or greater thickness is not available in the gasket, thinner samples shall be plied up to obtain this thickness.

9.1.3 *Compression Set*—Test Methods D 395, Method B. Test conditions to be 22 h at 70°C. Specimens shall not be prepared from laboratory prepared slabs or by direct molding.

9.1.4 *Accelerated Aging*—Test Method D 573. Test conditions to be 96 h at 70°C.

9.1.5 *Water Absorption*—Test Method D 471. Use distilled water for the standard test liquid. When a 1-in. wide test specimen cannot be obtained, use the greatest width obtainable from the test sample. Test conditions shall be 48 h at 70°C.

9.1.6 *Ozone Resistance*—Determine the resistance to ozone in accordance with Test Method D 1149.

9.1.6.1 Specimens shall be the test specimen length of the finished gasket cross-section.

9.1.6.2 Conduct test for 76 h in 50 PPHM concentration at $104 \pm 4^\circ\text{F}$ stressed to 20 % extension.

10. Performance Requirements for Joints

10.1 When required by the owner, assembled joints shall pass the following performance tests without leakage at the joints, and the manufacturer shall have the option of allowing the assembled joints to stand under a pressure of 13 psi or less, for a maximum of 24 h prior to the test:

10.1.1 *Pipes in Straight Alignment*—Hydrostatic pressure tests on joints shall be made on an assembly of two sections of pipe, properly connected in accordance with the joint design. At the option of the owner a second such test shall be required. Suitable bulkheads shall be provided either within the pipe adjacent to and on either side of the joint, or at the outer ends of the two joined pipe sections. No fillings or packings shall be placed prior to watertightness tests. After the pipe sections are

fitted together with the gasket or gaskets in place, the assembly shall be subjected to an internal hydrostatic pressure of 13 psi (30 ft) pressure head for 10 min. Moisture or beads of water appearing on the surface of the joint will not be considered as leakage. If leakage of joints should initially occur, the manufacturer shall have the option to extend the test period up to 24 h.

10.1.2 *Pipes in Maximum Deflected Position*—Upon completion of the test for pipes in straight alignment in 10.1.1, the test sections shall be deflected to create a position $\frac{1}{2}$ in. wider than the assembled position on one side of the outside perimeter of each joint and shall be subjected to an internal hydrostatic pressure of 10 psi for 10 min. Moisture or beads of water appearing on the surface of the joint will not be considered as leakage.

10.1.3 Unless prohibited by the owner at or before the time of placing an order for pipe with diameters 36 inches or larger, the manufacturer has the option to test the pipe joint for watertightness to the parameters established in sections 10.1.1 and 10.1.2 by methods which pressurize the rubber gasketed joint either internally or externally.

11. Storage

11.1 The gaskets shall be stored in as cool, clean, and shaded a place as practicable, preferably at 70°F or less.

11.2 The lubricant shall be stored in accordance to the lubricant manufacturer's recommended temperature range.

12. Inspection

12.1 The quality of the materials and the finished pipe joint and gasket shall be subject to inspection and approval by an inspector employed by the owner.

13. Certification

13.1 When requested by the owner, the manufacturer shall furnish written certification that the joint lubricant conforms to all requirements of this specification for the specific gaskets supplied.

14. Marking

14.1 *Lubricant*—The following information shall be clearly marked on each container of lubricant.

14.1.1 Name of lubricant manufacturer.

14.1.2 Usable temperature range for application and storage.

14.1.3 Shelf life.

14.1.4 Lot or batch number.

15. Repairs

15.1 Spalled areas, manufacturing imperfections, or damage during handling, of each pipe end, are not prohibited from being repaired and will be acceptable, if in the opinion of the owner, the repaired pipe conforms to the requirements of 7.1.2; provided the circumferential length of a single area to be repaired shall not exceed one fourth of the inside diameter or equivalent diameter of the pipe or the circumferential length of several areas combined does not exceed one half of the inside diameter or equivalent diameter of the pipe.



15.2 At the option of the owner, the pipe joint that has been repaired shall be subjected to the designated hydrostatic test in accordance with 10.1.1 and shall be accepted if it passes the hydrostatic test requirements.

16. Rejection

16.1 Pipe joints and gaskets shall be subject to rejection upon failure to conform to any of the requirements of this specification. Pipe that is damaged because of carelessness or

continuing failure to prevent recurrent imperfections in manufacture or damage during handling shall be subject to rejection.

16.2 Gaskets shall be subject to rejection whenever they show surface checking, weathering, or other deterioration prior to installation in the work.

17. Keywords

17.1 concrete pipe; joints; rubber gaskets

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