



Standard Specification for Polyethylene of Raised Temperature (PE-RT) Plastic Hot and Cold-Water Tubing and Distribution Systems¹

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1. Scope*

1.1 This specification establishes requirements for polyethylene of raised temperature (PE-RT) plastic hot- and cold-water tubing and distribution systems components made in one standard dimension ratio and intended for 100 psig (6.9 bar) water service up to and including a maximum working temperature of 180°F (82°C). Components are comprised of tubing, fittings, valves and manifolds. Tubing may incorporate an optional polymeric inner, middle or outer layer. Testing of Specification F1807 and F2159 fittings and PE-RT tubing to the requirements of this standard indicate that these fittings are appropriate for use with PE-RT piping systems. Requirements and test methods are included for materials, workmanship, dimensions and tolerances, burst pressure, sustained pressure, oxidative resistance, temperature cycling tests, bend strength and environmental stress cracking. Also included are tests related to system malfunctions. The components covered by this specification are intended for use in residential and commercial, hot and cold, potable water distribution systems.

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.

NOTE 1—Suggested hydrostatic design stresses and hydrostatic pressure ratings for tubing and fittings are listed in Appendix X1. UV labeling guidelines are provided in Appendix X2. Design, assembly, and installation considerations are provided in Appendix X3. An optional performance qualification and an in-plant quality control program are recommended in Appendix X4.

1.3 *Units*—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.

1.4 The following safety hazards caveat pertains only to the test methods portion, Section 7, 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.

2. Referenced Documents

2.1 ASTM Standards:²

- D618 Practice for Conditioning Plastics for Testing
- D1598 Test Method for Time-to-Failure of Plastic Pipe Under Constant Internal Pressure
- D1599 Test Method for Resistance to Short-Time Hydraulic Pressure of Plastic Pipe, Tubing, and Fittings
- D1600 Terminology for Abbreviated Terms Relating to Plastics
- D1898 Practice for Sampling of Plastics (Withdrawn 1998)³
- D2122 Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings
- D2749 Symbols for Dimensions of Plastic Pipe Fittings
- D2837 Test Method for Obtaining Hydrostatic Design Basis for Thermoplastic Pipe Materials or Pressure Design Basis for Thermoplastic Pipe Products
- D3350 Specification for Polyethylene Plastics Pipe and Fittings Materials
- D3895 Test Method for Oxidative-Induction Time of Polyolefins by Differential Scanning Calorimetry
- F412 Terminology Relating to Plastic Piping Systems
- F1282 Specification for Polyethylene/Aluminum/Polyethylene (PE-AL-PE) Composite Pressure Pipe
- F1473 Test Method for Notch Tensile Test to Measure the Resistance to Slow Crack Growth of Polyethylene Pipes and Resins
- F1807 Specification for Metal Insert Fittings Utilizing a Copper Crimp Ring for SDR9 Cross-linked Polyethylene (PEX) Tubing and SDR9 Polyethylene of Raised Temperature (PE-RT) Tubing
- F2023 Test Method for Evaluating the Oxidative Resistance

¹ This test method is under the jurisdiction of ASTM Committee F17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.26 on Olefin Based Pipe.

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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.

³ The last approved version of this historical standard is referenced on www.astm.org.

of Crosslinked Polyethylene (PEX) Tubing and Systems to Hot Chlorinated Water

F2159 Specification for Plastic Insert Fittings Utilizing a Copper Crimp Ring for SDR9 Cross-linked Polyethylene (PEX) Tubing and SDR9 Polyethylene of Raised Temperature (PE-RT) Tubing

2.2 *ANSI Standard*.⁴

B36.10 Standards Dimensions of Steel Pipe (NTS)

Z 17.1 Preferred Numbers

2.3 *Federal Standard*.⁵

FED-STD-123 Marking for Shipment (Civil Agencies)

2.4 *Military Standard*.⁵

MIL-STD-129 Marking for Shipment and Storage

2.5 *PPI Standards*.⁶

PPI TR-3 Policies and Procedures for Developing Hydrostatic Design Basis (HDB), Hydrostatic Design Stresses (HDS), Pressure Design Basis (PDB), Strength Design Basis (SDB), and Minimum Required Strength (MRS) Ratings for Thermoplastic Piping Materials or Pipe

PPI TR-4 PPI Listing of Hydrostatic Design Basis (HDB), Strength Design Basis (SDB), Pressure Design Basis (PDB) and Minimum Required Strength (MRS) Ratings for Thermoplastic Piping Materials or Pipe

2.6 *NSF Standards*.⁷

NSF 14 Standard No. 14 for Plastic Piping Components and Related Materials

NSF 61 Drinking Water System Components – Health Effects

2.7 *ISO Standard*.⁸

ISO 13760 : Plastics pipes for the conveyance of fluids under pressure -- Miner's rule -- Calculation method for cumulative damage

3. Terminology

3.1 Terminology used in this standard is in accordance with Terminologies **F412**, **D1600**, and **D2749** unless otherwise specified. The abbreviation for polyethylene of raised temperature is PE-RT. Plastic tubing denotes a particular diameter schedule of plastic pipe in which outside diameter of the tubing is equal to the nominal size plus 1/8 in. Plastic pipe outside diameter schedule conforms to ANSI B36.10.

3.2 *standard dimension ratio (SDR)*, *n*—a specific ratio of the average specified outside diameter to the minimum specified wall thickness (D_o/t) for outside diameter-controlled plastic pipe, the value of which is derived by adding one to the pertinent number selected from the ANSI Preferred Number Series 10. **F412**

3.2.1 *Discussion*—For PE-RT-tubing, it is calculated by dividing the average outside diameter of the tubing in inches or in millimeters by the minimum wall thickness in inches or millimeters. If the wall thickness calculated by this formula is less than 0.070 in. (1.78 mm) it shall be arbitrarily increased to 0.070 in. except for sizes 5/16 in. and smaller. The SDR values shall be rounded to the nearest 0.5

3.3 *Definitions of Terms Specific to This Standard*:

3.3.1 *hydrostatic design stress (HDS)*, *n*—the estimated maximum tensile stress the material is capable of withstanding continuously with a high degree of certainty that failure of the tube will not occur. This stress is circumferential when internal hydrostatic water pressure is applied. For materials with Hydrostatic Strength Classification 3 or 4 per Specification **D3350**, the HDS is equal to the hydrostatic design basis (HDB) times the design factor (DF) for water. For this standard, the design factor is equal to 0.5.

$$\begin{aligned} HDS &= HDB \times DF \\ &= HDB \times 0.5 \text{ (for this standard)} \end{aligned}$$

3.3.2 *relation between dimensions, hydrostatic design stress, and pressure rating*, *n*—the following expression, commonly known as the ISO equation, is used in this specification to relate dimensions, hydrostatic design stress, and pressure rating:

$$2HDS/P = (D_o/t) - 1 \quad (1)$$

or

$$2HDS/P = R - 1$$

where:

HDS = hydrostatic design stress, psi (or MPa),
P = pressure rating, psig (or MPa),
D_O = average outside diameter, in. (or mm),
t = minimum wall thickness, in. (or mm), and
R = standard dimension ratio, SDR.

3.3.3 *standard thermoplastic material designated code*, *n*—the pipe material designation code shall consist of the abbreviation for the type of plastic (PE) followed by Arabic numerals which describe the short term properties in accordance with Specification **D3350**, the hydrostatic design stress for water at 73°F (23°C) in units of 100 psi with any decimal figures dropped. Where the hydrostatic design stress code contains less than two figures, a zero is used before the number.

3.3.3.1 *Discussion*—Further information regarding testing and approval can be obtained from the National Sanitation Foundation or other accredited laboratory.

4. Classification

4.1 *Tubing*—This specification covers one PE-RT tubing material in one standard dimension ratio, 9.0, and by a maximum continuous use temperature that shall be 180°F (82°C), and by nominal tubing sizes from 1/8 through 6 in. 4.2

4.2 *Fittings*—This specification classifies fittings, including manifolds, intended for use in systems with PE-RT tubing, by a maximum continuous use temperature that shall be 180°F (82°C) and by nominal sizes from 1/8 in. through 6 in. on the

⁴ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

⁵ DLA Document Services Building 4/D 700 Robbins Avenue Philadelphia, PA 19111-5094 <http://quicksearch.dla.mil/>

⁶ Available from Plastics Pipe Institute (PPI), 105 Decker Court, Suite 825, Irving, TX 75062, <http://www.plasticpipe.org>.

⁷ Available from NSF International, P.O. Box 130140, 789 N. Dixboro Rd., Ann Arbor, MI 48113-0140, <http://www.nsf.org>.

⁸ Available from International Organization for Standardization (ISO), 1, ch. de la Voie-Creuse, Case postale 56, CH-1211, Geneva 20, Switzerland, <http://www.iso.ch>.

basis of resistance to burst pressure, hydrostatic sustained pressure, excessive temperature and pressure, and thermocycling.

5. Materials

5.1 General—The polyethylene used to make tubing shall be virgin plastic or reworked plastic, or both, as specified in 5.4, that meets the requirements of this standard and shall have a Plastic Pipe Institute (PPI) rating at 73°F (23°C) and 180°F (82°C). Fitting, manifold and valve materials shall meet the applicable requirements as described in Specifications F1807 or F2159. Fittings shall be made from materials that are generally regarded as corrosion resistant.

5.2 Basic Tubing Materials—PE-RT tubing meeting the requirements of this specification are primarily defined by two criteria namely, basic short-term properties, 5.2.1, and long-term hydrostatic properties, 5.2.2.

5.2.1 Basic Short-Term Properties—This specification covers tubing materials meeting the following requirements:

5.2.1.1 Classification—Polyethylene materials suitable for use in the manufacture of tubing under this specification shall be classified in accordance with Specification D3350 as shown in Table 1.

5.2.2 Long-Term Hydrostatic Strength—This specification covers PE-RT tubing which is further defined on the basis of long-term hydrostatic strength tests (Appendix X1). The material shall have a minimum pressure rating as per Table 2.

5.3 Barrier Layers—PE-RT tubing may incorporate an optional interior wall, mid wall or outer wall layer or a combination of such layers of non-PE-RT material for the express purpose of providing gas barrier properties to the pipe. The tubing shall meet the minimum wall thickness requirements of this standard without using the barrier layer thickness in the determinations. PE-RT tubing with a barrier layer within the wall of the tubing (neither exterior layer nor interior layer) shall demonstrate a hydrostatic design stress (HDS) rating equivalent to that of PE-RT tubing without a barrier layer. This determination shall be made in accordance with policies no less restrictive than those of the PPI TR-3 and meet the requirements of this standard.

5.4 Rework Material—Clean rework material of the same commercial designation, generated from the manufacturer's own tubing production shall not be used unless the tubing produced meet all the requirements of this specification. PE-RT tubing with a barrier layer shall not be used for rework material.

5.5 Tubing Material Designation—The tubing meeting the requirements of this specification shall be designated PE-RT.

TABLE 1 Required D3350 Cell Classification for PE-RT

Physical Properties:	Cell Classification
Density	3 or 4
Melt index	2, 3, 4, or 5
Flexural modulus	3 or higher
Tensile strength	2 or higher
Slow crack growth resistance	7
Hydrostatic Strength Classification	3 or 4

TABLE 2 Pressure Ratings for PE-RT SDR 9 Tubing for Water

Rated Temperature		Minimum Hydrostatic Design Stress		Minimum Pressure Rating for Water	
°F	(°C)	psi	(MPa)	psi	(bar)
73.4	(23)	640	(4.41)	160	(11.0)
180	(82.2)	400	(2.76)	100	(6.90)

5.6 Certification—Tubing and fittings intended for use in the transport of potable water shall be evaluated and certified as safe for this purpose by a testing agency acceptable to the local health authority. The evaluation shall be in accordance with the requirements for chemical extraction that are not less restrictive than those included in NSF Standard 61. The seal or mark of the laboratory making the evaluation shall be included on the tubing.

NOTE 2—Further information regarding testing and approval can be obtained from an accredited certification provider.

6. Requirements

6.1 Workmanship—The tubing shall be homogeneous throughout and free of visible cracks, holes, foreign inclusions, or other defects. The tubing shall be as uniform as commercially practicable in color, opacity, density, and other physical properties. For tubing that incorporates a barrier layer per 5.3 each layer shall meet the workmanship requirements per this section.

6.2 Dimensions and Tolerances:

6.2.1 Compliance with this specification requires that fittings contained in Specifications F1807 and F2159 must meet the Performance and Test Method requirements of this standard.

6.2.2 Outside Diameters of Tubing—The outside diameters and tolerances of the tubing including the layers shall be as shown in Table 3, when measured in accordance with 7.4 and 7.4.1.

6.2.3 Wall Thickness of Tubing—The wall thickness and tolerances shall be as shown in Table 4, when measured in accordance with 7.4 and 7.4.2.

6.2.3.1 Layer—Tubing that incorporates an inner, middle or outer layer shall meet the minimum wall thickness and tolerances requirements as specified in Table 4. In addition, the layer shall not result in the reduction of the total PE-RT material below that specified in Table 4. In the case of tubing with a middle layer, the total base PE-RT material wall thickness shall be the sum of the inner and outer base PE-RT material wall thicknesses.

6.2.4 Out-of-Roundness—The maximum out-of-roundness requirements shown in Table 3 for tubing, apply to the average measured diameter. Tubing shall be measured prior to coiling.

6.3 Sustained Pressure—The tubing and fittings, assembled using the manufacturer's instructions and tested as assemblies, shall not fail, balloon, burst, or weep at the test pressures given in Table 5 when tested in accordance with 7.5.

6.3.1 If present, valves shall be tested in the open or unrestricted position.

6.4 Burst Pressure—The tubing and fittings, assembled using the manufacturer's instructions and tested as assemblies,

TABLE 3 Outside Diameters and Tolerances for PE-RT Tubing

Nominal Tubing Size		Average Outside Diameter		Tolerances for Average Diameter		Out-of-Roundness ^A	
in.	(mm)	in.	(mm)	in.	(mm)	in.	(mm)
1/8	(3)	0.250	(6.35)	±0.003	(±0.08)	0.008	(0.20)
1/4	(7)	0.375	(9.52)	±0.003	(±0.08)	0.008	(0.20)
5/16	(8)	0.430	(10.92)	±0.003	(±0.08)	0.008	(0.20)
3/8	(10)	0.500	(12.70)	±0.003	(±0.08)	0.012	(0.32)
1/2	(13)	0.625	(15.88)	±0.004	(±0.10)	0.016	(0.40)
5/8	(16)	0.750	(19.05)	±0.004	(±0.10)	0.016	(0.40)
3/4	(19)	0.875	(22.22)	±0.004	(±0.10)	0.016	(0.40)
1	(25)	1.125	(28.58)	±0.005	(±0.12)	0.020	(0.48)
1 1/4	(32)	1.375	(34.92)	±0.005	(±0.12)	0.020	(0.48)
1 1/2	(38)	1.625	(41.28)	±0.006	(±0.16)	0.024	(0.60)
2	(51)	2.125	(53.98)	±0.006	(±0.16)	0.030	(0.76)
2 1/2	(64)	2.625	(66.68)	±0.007	(±0.18)	0.038	(0.95)
3	(76)	3.125	(79.38)	±0.008	(±0.20)	0.045	(1.14)
3 1/2	(89)	3.625	(92.08)	±0.008	(±0.20)	0.046	(1.16)
4	(102)	4.125	(104.78)	±0.009	(±0.23)	0.052	(1.32)
4 1/2	(114)	4.625	(117.48)	±0.009	(±0.23)	0.059	(1.49)
5	(127)	5.125	(130.18)	±0.010	(±0.25)	0.065	(1.65)
6	(152)	6.125	(155.58)	±0.011	(±0.28)	0.072	(1.83)

^A The Out-of-Roundness specification applies only to tubing prior to coiling.

TABLE 4 Wall Thickness and Tolerances for PE-RT SDR 9 Tubing^A

Nominal Tubing		Minimum Wall Thickness		Tolerance	
in.	(mm)	in.	(mm)	in.	(mm)
1/8	(3)	0.047 ^B	(1.19) ^B	+0.007	(+0.18)
1/4	(7)	0.062 ^B	(1.57) ^B	+0.010	(+0.25)
5/16	(8)	0.064	(1.63)	+0.010	(+0.25)
3/8	(10)	0.070 ^B	(1.78) ^B	+0.010	(+0.25)
1/2	(13)	0.070 ^B	(1.78) ^B	+0.010	(+0.25)
5/8	(16)	0.083	(2.12)	+0.010	(+0.25)
3/4	(19)	0.097	(2.47)	+0.010	(+0.25)
1	(25)	0.125	(3.18)	+0.013	(+0.33)
1 1/4	(32)	0.153	(3.88)	+0.015	(+0.38)
1 1/2	(38)	0.181	(4.59)	+0.019	(+0.48)
2	(51)	0.236	(6.00)	+0.024	(+0.61)
2 1/2	(64)	0.292	(7.41)	+0.030	(+0.76)
3	(76)	0.347	(8.82)	+0.033	(+0.84)
3 1/2	(89)	0.403	(10.23)	+0.035	(+0.89)
4	(102)	0.458	(11.64)	+0.040	(+1.02)
4 1/2	(114)	0.514	(13.05)	+0.045	(+1.14)
5	(127)	0.569	(14.46)	+0.050	(+1.27)
6	(152)	0.681	(17.29)	+0.060	(+1.52)

^A The minimum is the lowest wall thickness of the tubing at any cross section. The maximum permitted wall thickness, at any cross section, is the minimum wall thickness plus the stated tolerance. All tolerances are on the plus side of the minimum requirement.

^B For tubing sizes of 1/2 in. and below, wall thickness minimums are not functions of SDR.

TABLE 5 Sustained Water Pressure Test Condition for PE-RT SDR 9 Tubing

Nominal Tubing Size		Pressure Required for Test, psig A ^A (MPa)							
		For 1250 psi HDB at 73.4°F				For 1600 psi HDB at 73.4°F			
		73.4°F	(23°C)	180°F	(82.2°C)	73.4°F	(23°C)	180°F	(82.2°C)
1/8	(3)	595	(4.10)	355	(2.45)	740	(5.10)	355	(2.45)
1/4	(7)	515	(3.55)	305	(2.10)	635	(4.38)	305	(2.10)
5/16	(8)	455	(3.14)	270	(1.86)	560	(3.86)	270	(1.86)
3/8	(10)	425	(2.93)	250	(1.72)	520	(3.59)	250	(1.72)
1/2	(13)	330	(2.28)	195	(1.34)	405	(2.79)	195	(1.34)
5/8 and larger	(16 and larger)	325	(2.24)	190	(1.31)	400	(2.76)	190	(1.31)

^A The fiber stresses used to derive these test pressures are:

at 73.4°F (23.0°C) 1300 psi (8.96 MPa) for a 1250 psi HDB material and 1600 psi (11.0 MPa) for a 1600 psi HDB material

at 180°F (82.2°C) 770 psi (5.31 MPa)

shall meet the minimum burst pressure given in **Table 6**, when determined in accordance with **7.6**. Leakage or separation at any of the fittings tested shall constitute failure of the fitting.

6.4.1 If the manifold has more than one connection size, the test pressure selected from **Table 5** shall be based on the largest nominal tubing connection.

TABLE 6 Sustained Water Pressure Test Condition for PE-RT SDR 9 Tubing

Nominal Tubing Size		Pressure Required for Test, psig ^A (MPa)					
		For 1250 psi HDB at 73.4°F			For 1600 psi HDB at 73.4°F		
in.	(mm)	73.4°F (23°C)	180°F (82.2°C)		73.4°F (23°C)	180°F (82.2°C)	
1/8	(3)	870	(6.00)	495 (3.41)	1345	(9.28)	495 (3.41)
1/4	(7)	752	(5.19)	420 (2.90)	1150	(7.93)	420 (2.90)
5/16	(8)	660	(4.55)	370 (2.55)	1015	(7.00)	370 (2.55)
3/8	(10)	620	(4.27)	345 (2.38)	945	(6.52)	345 (2.38)
1/2	(13)	480	(3.31)	270 (1.86)	730	(5.03)	270 (1.86)
5/8 and larger	(16 and larger)	475	(3.27)	265 (1.83)	720	(4.97)	265 (1.83)

^A The fiber stresses used to derive these test pressures are:

at 73.4°F (23.0°C) 1900 psi (13.10 MPa) for a 1250 psi HDB material and 2900 psi (20.0 MPa) for a 1600 psi HDB material

at 180°F (82.2°C) 1065 psi (7.33 MPa)

6.5 Thermocycling:

6.5.1 Fittings, assembled using the manufacturer's instructions, shall not leak after completion of 1000 cycles between the temperatures of 60°F (16°C) and 180°F (82°C) when tested in accordance with 7.8.1.

6.6 *Oxidative Resistance in Potable Chlorinated Water Applications*—PE-RT tubing chlorine classification codes shall be determined based on a minimum extrapolated time-to-failure of 50 years when tested and evaluated in accordance with 7.8 and Table 7.

6.7 *Bent Tube*—The following requirement applies to tubing up to 1 in. nominal diameter. Bent tubing, with a radius of 6 times the outside diameter and consisting of a continuous bend length inducing not less than 90° angle, shall meet the 180°F (82.2°C) minimum hydrostatic sustained pressure strength requirements shown in Table 5 when tested in accordance with 7.9. The bend length and bend angle is kept throughout the testing period by rigid secures immediately outside the bend. The minimum test duration shall be 1000 h without failure.

NOTE 3—PE-RT tubing, larger than 1 in. nominal diameter, is typically installed as main distribution lines and is installed in straight runs. Fittings are used when a change in direction of 90° or greater and a bend radius of less than 6 times the outside diameter is needed. The test requirements in 6.8 are intended to evaluate PE-RT tubing installed in tight bend applications in accordance with the procedure in Appendix X3. This application applies to tubing up to and including 1 in. nominal diameter only.

6.8 *Excessive Temperature Hydrostatic Sustained*—Tubing and fittings, when tested as assemblies, shall not fail in less than 720 h when tested in accordance with 7.10. If present, valves shall be tested in the open or unrestricted position.

NOTE 4—Tests applicable to tubing and assemblies (6.4, 6.5, 6.8, 6.7, 6.8, and 6.9) are intended to be performance qualification tests and not tests required of each fitting.

6.9 *Environmental Stress Cracking*—There shall be no loss of pressure in the tubing, when tested in accordance with 7.11.

6.10 *Adhesion Test*—Tubing that incorporates an optional inner, middle or outer layer shall not show any delamination when tested in accordance with Section 9.3.1 of Specification F1282.

6.11 *Slow Crack Growth Resistance*—The slow crack growth resistance of the tubing material shall not be less than 500 h when tested in accordance with 7.12.

7. Test Methods

7.1 *Conditioning*—Condition the specimens at 73.4 ± 3.6°F (23 ± 2°C) and 50 ± 5 % relative humidity for not less than 40 h prior to test in accordance with Procedure A of Practice D618, for those tests where conditioning is required. In cases of disagreement, the tolerances shall be ± 1.8°F (± 1°C) and ± 2 % relative humidity.

7.2 *Test Conditions*—Conduct the test in the standard laboratory atmosphere of 73.4 ± 3.6°F (23 ± 2°C) and 50 ± 5 % relative humidity, unless otherwise specified in the test methods or in this specification. In cases of disagreement, the tolerances shall be ± 1.8°F (± 1°C) and ± 2 % relative humidity.

7.3 *Sampling*—A sufficient quantity of tubing or fittings, as agreed upon by the purchaser and the seller, shall be selected and tested to determine conformance with this specification (see Practice D1898). In the case of no prior agreement, random samples selected by the testing laboratory shall be deemed adequate.

7.3.1 *Test Specimens*—Unless otherwise specified in this standard or as agreed upon by the purchaser and the seller, the quantity and size of the specimens to be tested shall be as specified by the test method referred to in this standard. If present, valves shall be tested in the open or unrestricted position.

7.4 *Dimensions and Tolerances*—Use any length of tubing to determine the dimensions. Measure in accordance with Test Method D2122.

7.4.1 *Outside Diameter*—Measure the outside diameter of the tubing in accordance with Test Method D2122. The referee method of measurement is to be by circumferential wrap tape. The tolerance for out-of-roundness shall apply only to tubing prior to shipment. Averaging micrometer or vernier caliper measurements, four (4) maximum and minimum diameter

TABLE 7 Oxidative Resistance Classification Codes

Standard	CL1	CL2	CL3	CL4	CL5
Usage Ratios	75% at 73°F and 25% at 140°F	Reserved for future use	50% at 73°F and 50% at 140°F	Reserved for future use	100% at 140°F

measurements at any cross section, may be used for quality control checks if desired.

7.4.2 Wall Thickness—Make micrometer measurements of the wall thickness in accordance with Test Method **D2122** to determine the maximum and minimum values. Measure the wall thickness at both ends of the tubing to the nearest 0.001 in. (0.025 mm).

7.4.2.1 Layer—Make measurements of the layer or layers using either a video microscope, a microscope with 0.001 inch graduation or optical comparator to determine the maximum and minimum values.

7.5 Sustained Pressure Test—Select the test specimens at random. Test at least six joints and at least six tubing specimens as per Test Method **D1598** in water at 73°F (23°C) and 180°F (82.2°C) as shown in **Table 5**. Each specimen of tubing shall be at least five times the nominal diameter in length and not less than 12 in. (25 cm) or more than 3.0 ft (91 cm) between end closures. Maintain the specimens at the pressures indicated for the appropriate temperatures for a period of 1000 h. Failure of two of the six specimens tested at either temperature constitutes failure in the test. Failure of one of six tubing or fitting specimens tested at either temperature is cause for retest of six additional tubing or fitting specimens, respectively, at that temperature. Failure of one of six tubing or fitting specimens tested at either temperature in retest constitutes failure of the tubing or fitting, respectively, in the test. Failure of the tubing or fitting shall be defined in accordance with Test Method **D1598** and leakage or separation at any of the fittings tested shall constitute failure of the fitting. Delamination of the tubing shall constitute failure of the tubing.

7.6 Burst Pressure—Determine the tubing or fitting complies with the minimum burst pressure requirements by testing in accordance with Test Method **D1599** Method B. Test at least six joints and at least six tubing specimens as per Test Method **D1599** in water at 73°F (23°C) and 180°F (82.2°C) as shown in **Table 6**. Each specimen of tubing shall be at least five times the nominal diameter in length and not less than 12 in. (25 cm) or more than 3.0 ft (91 cm) between joints. Leakage or separation at any of the fittings tested shall constitute failure of the fitting.

7.6.1 If present, valves shall be tested in the open or unrestricted position.

7.7 Thermocycling:

7.7.1 Summary of Test Method—This test method describes a pass-fail test for thermally cycling PE-RT tubing and fittings assemblies over a critical temperature range for a selected number of cycles while subjected to a nominal internal pressure. This test method provides a measure of resistance to failure due to the combined effects of differential thermal expansion and creep for PE-RT tubing and fittings intended for continuous use up to and including 180°F (82°C).

7.7.2 Apparatus—A nitrogen or air source capable of maintaining a nominal internal pressure of 100 ± 10 psig (6.9 $\pm$ 0.69 bars) within the specimens is required. The immersion system shall consist of two water reservoirs controlled at $60 \pm 4^\circ\text{F}$ ($16 \pm 2^\circ\text{C}$) and $180 \pm 4^\circ\text{F}$ ($82 \pm 2^\circ\text{C}$). The specimen shall be cycled from one reservoir to the other or the hot and cold

water shall be alternately cycled over the test specimens automatically and returned to the proper reservoirs.

NOTE 5—Automatic cycling may be accomplished by pumping from each reservoir, through a delivery system having timer-actuated valves, to a specimen water trough having synchronized, timer-actuated return drains. Any automatic apparatus shall provide for complete immersion of the test specimen in the trough.

7.7.3 Sampling and Specimen Preparation—Select at least six joints from randomly selected specimens assembled per the manufacturer's instructions. Close the specimen assembly with any suitable end closures that allow "free-end" mounting and will not leak under the thermocycling conditions, and connect the specimen assembly to the pressure source.

7.7.3.1 If present, valves shall be tested in the open or unrestricted position.

7.7.4 Procedure—Pressurize the specimen assembly with nitrogen or air to 100 ± 10 psig (0.69 ± 0.069 MPa). Immerse in $60 \pm 4^\circ\text{F}$ ($16 \pm 2^\circ\text{C}$) water to determine if there are any initial leaks. All leaks shall be eliminated before the thermocycling test is started. Thermally cycle the specimen assembly either manually or automatically and under an internal pressure of 100 ± 10 psig (0.69 ± 0.069 MPa), alternately between $60 \pm 4^\circ\text{F}$ ($16 \pm 2^\circ\text{C}$) and $180 \pm 4^\circ\text{F}$ ($82 \pm 2^\circ\text{C}$) by means of immersion in water using the following test cycle: Water immersion at 180°F (82°C) 2 min (min) Air immersion at ambient 2 min (max) Water immersion at 60°F (16°C) 2 min (min) Air immersion at ambient 2 min (max) Upon the completion of 1000 thermal cycles, immerse the specimen assembly again in $60 \pm 4^\circ\text{F}$ ($16 \pm 2^\circ\text{C}$) water and check for any sign of gas leakage. Any evidence of leakage at the fitting or separation of the fitting from the tubing constitutes a failure.

7.7.5 Interpretation of Results—Failure of any one of six joints tested shall constitute failure of this test.

7.8 Oxidative Stability in Potable Chlorinated Water:

7.8.1 The test shall be conducted and the extrapolated time-to-failure shall be determined in accordance with Test Method **F2023**. The test fluid shall be prepared in accordance with 9.1.1 of Test Method **F2023**. The extrapolated time-to-failure shall be calculated using the coefficients from 13.1 of Test Method **F2023**, and using Miners Rule, calculate the estimated time to-failure for a hoop stress corresponding to a sustained internal pressure of 80 psig (551.7 kPa) for the DR of the tested specimens at the temperature exposure conditions and usage ratios defined in **Table 7** in accordance with ISO 13760.

7.8.2 Significance—The test need only be performed on representative pipe samples for the original validation of pipe made from a particular compound. A compound is defined as the PE-RT resin and the stabilization system.

7.9 Bent Tube Test—Determine in accordance with Test Method **D1598**, except for the following: Test at least six specimens, from randomly selected specimens assembled per the manufacturer's instructions. The test assembly shall be constructed so that there is a minimum length of 5 pipe diameters between joints. Test temperature shall be 180°F (82°C).

7.10 Excessive Temperature and Pressure Capability of Tubing and Fittings:

7.10.1 Determine in accordance with Test Method **D1598**, except for the following requirements:

7.10.1.1 Test at least six joints from randomly selected specimens assembled per the manufacturer's instructions with at least 5-pipe diameters between joints.

7.10.1.2 Condition tubing and fittings as assemblies in accordance with **7.1**.

7.10.1.3 Test temperature shall be $210 \pm 4^{\circ}\text{F}$ ($99 \pm 2^{\circ}\text{C}$).

7.10.1.4 The external test environment shall be air.

7.10.1.5 Fill the specimens with water and condition for 2 h at a temperature of $210 \pm 4^{\circ}\text{F}$ ($99 \pm 2^{\circ}\text{C}$) and a pressure of 30 ± 3 psi (207 ± 21 kPa)

7.10.1.6 Pressurize test specimens to the required pressure and maintain for 720 h. The pressure for PE-RT SDR 9 tubing shall be 150 psi (10.34 bar).

7.11 *Environmental Stress Cracking Test*—Use six randomly selected 10-in. (250-mm) long tubing specimens for this test. Make a notch on the inside of the tubing wall in the axial direction. The notch depth shall be 10 % of measured minimum wall thickness and the notch length 1 in. (25 mm). Use a sharp blade mounted in a jig to make this imperfection. Use a depth micrometer or other means for setting the blade in the jig so that the notch depth is controlled as specified. The notch shall be placed, at its nearest point, at least 1.5 times the nominal diameter away from end closures. Fill the tubing with the test medium which is 5 % “Igepal CO-630”⁹ mixed with 95 % of untreated water. The test is then made in accordance with **7.5**, under the pressures given in **Table 5**, except maintain the pressure for 100 h.

7.12 *Slow Crack Growth Resistance*—The test shall be conducted in accordance with Test Method **F1473** at a stress of 2.4 MPa with a modification in test temperature. Testing shall be performed at 90°C. The average failure time shall be calculated from two test specimens.

8. Retest and Rejection

8.1 If the results of any test(s) do not meet the requirements of this specification, the test(s) shall be conducted again only by agreement between the purchaser and seller. Under such agreement, minimum requirements shall not be lowered, changed, or modified, nor shall specification limits be changed. If upon retest, failure occurs, the quantity of product represented by the test(s) does not meet the requirements of this specification.

9. Marking

9.1 Tubing:

⁹ This method is based on the use of “Igepal Co-630,” a trademark for a nonylphenoxy poly (ethyleneoxy) ethanol, which may be obtained from GAF Corp., Dyestuff and Chemical Div., 140 W. 51st St., New York, NY 10020.

9.1.1 The marking shall be applied to the tubing in such a manner that it remains legible (easily read) after installation and inspection.

9.1.2 Marking shall be applied without indentation in some permanent manner so as to remain legible under normal handling and installation practice. Tubing that is difficult to mark without indenting shall be so marked provided (1) the marking does not reduce the wall thickness to less than the minimum value for the tubing, or (2) it is demonstrated that these marks have no effect on the long-term strength of the tubing, or both.

9.1.3 Markings, shall be required on tubing at intervals of not more than 5 ft (1.5 m).

9.1.4 Marking on the tubing shall include the following, spaced at intervals of not more than 5 ft:

9.1.4.1 Nominal tubing size (for example, 2 in.).

9.1.4.2 The material designation, PE-RT.

9.1.4.3 The Specification **D3350** cell classification for the material per Specification **D3350** and **Table 1**, for example PE344373

9.1.4.4 A distinctive marking that identify the presence of an inner, middle or outer layer.

9.1.4.5 Standard dimension ratio, SDR 9.

9.1.4.6 Pressure rating for water at 73°F (23°C) and 180°F (82.2°C) established by this specification.

9.1.4.7 ASTM designation F2769.

9.1.4.8 Manufacturer's name (or trademark) and production code.

9.1.4.9 Certification mark or seal of the laboratory making the evaluation for this purpose

9.1.4.10 Chlorine resistance classification codes as appropriate based on the tubing meeting the requirements of **6.7**, for example, CL1.

9.1.4.11 Standard designation(s) of the fitting systems(s) for which the tubing is recommended for use by the tubing manufacturer.

9.2 Fittings-Fittings shall be marked in accordance to the requirements of the ASTM standard to which the fittings are manufactured.

10. Quality Assurance

10.1 1 When the product is marked with this designation, F2769, the manufacturer affirms that the product was manufactured, inspected, sampled, and tested in accordance with this specification and has been found to meet the requirements of this specification.

11. Keywords

11.1 hot water; hydrostatic stress; PE-RT; pipe; plastic pipe; polyethylene of raised temperature; PPI; pressure; potable water; PERT; tubing



SUPPLEMENTARY REQUIREMENTS

GOVERNMENT/MILITARY PROCUREMENT

These requirements apply only to federal/military procurement, not domestic sales or transfers.

S1. Responsibility for Inspection

S1.1 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 Marketing 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 destina-

tion 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 specification.

APPENDIXES

(Nonmandatory Information)

X1. SOURCE OF HYDROSTATIC DESIGN STRESS OF TUBING

X1.1 The hydrostatic design basis (HDB) recommended by the Plastics Pipe Institute and published in PPI TR-4 is used to pressure rate PE-RT plastic tubing. The hydrostatic design basis at 73°F is defined in [Table 1](#). The hydrostatic design basis applies only to tubing meeting all the requirements of this specification.

X1.2 Refer also to Test Method [D2837](#) for HDB. Additional information regarding the method of test and other criteria used in developing the hydrostatic design basis may be obtained from the Plastics Pipe Institute, 105 Decker Court, Suite 825, Irving, TX 75062. The hydrostatic design basis may not be suitable for materials that show a wide departure from a straight-line plot of log stress versus log time to failure. All the

data available to date on PE-RT-tubing materials exhibit a straight-line plot under these plotting conditions.

X1.3 *Stabilizer Verification*—The oxidation induction time (OIT) as described in Test Method [D3895](#) may be used to monitor stabilizer content of a PE-RT material or freshly extruded tubing. Once the initial OIT value has been established for a specific compound, subsequent OIT values can be used to validate the stabilizer level in the tubing or compound without the need to run additional temperature tests. It should be mentioned that OIT tests are not an indicator of life expectancy, nor should differences in OIT values between compounds be construed to indicate differences in the stabilizer effectiveness of respective formulations.

X2. UV LABELING GUIDELINES FOR PE-RT TUBING

X2.1 PE-RT tubing should be kept in original packaging until time of use, and it should not be used in direct sunlight. To inform customers and users about the need to prevent accidental overexposure of PE-RT tubing to sunlight (UV light), it is recommended that a UV CAUTION label be applied to all PE-RT tubing packaging by the manufacturer.

X2.2 The text and content of the recommended label is as shown **X2.4**. “X” is the maximum cumulative time period as recommended by the tubing manufacturer for direct sunlight exposure without harm to the long-term performance characteristics of the PE-RT tubing.

X2.3 The recommended text may be incorporated into existing labels with other information. The universal “no-sun” symbol may be shown in color, black-and-white or grayscale, and should be positioned close to the recommended text.

X2.4 Caution Label:

Do not store PE-RT tubing unprotected outdoors.

Keep PE-RT tubing in the original packaging or under protective cover until time of installation.

Ensure that exposure to sunlight during installation does not exceed the maximum recommended UV exposure time of “X”.

X3. DESIGN, ASSEMBLY, AND INSTALLATION CONSIDERATIONS

X3.1 Design

X3.1.1 *Thermal Expansion*—The linear expansion rate for PE-RT is approximately 1.1 in./10°F temperature change for each 100 ft of tubing, or 28 mm/5.6°C temperature change for each 30 m of tubing. When installing long runs of tubing, allow $\frac{1}{8}$ to $\frac{3}{16}$ in. longitudinal clearance per ft (10 to 14 mm/m) of run to accommodate thermal expansion. Tubing should not be anchored rigidly to a support but allowed freedom of movement to expand and contract.

X3.1.2 *Water Heaters*—Components covered by this specification may not be suitable for use with the instantaneous type (coil or immersion) water heater. They are suitable for use with storage type water heaters with connections made in an approved manner.

X3.1.3 *Sweating*—Even though the thermal conductivity of PE-RT is several orders of magnitude lower than that of metal, sweating or condensation at a slow rate may occur under certain temperature and humidity conditions.

X3.1.4 *Water Hammer and Surge*—A PE-RT hot-water system will withstand repeated pressure surges, well in excess of its rated pressure, but water hammer arrestors may be advisable when solenoid valves or other quick-closing devices are used in the system. In designing for such situations, it is advisable to consult the tubing or fitting manufacturer for recommended surge pressure limits. Water hammer and surge pressure calculations are reviewed in Chapter 7, AWWA Manual M-11, Steel Pipe Design and Installation.

X3.1.5 *Horizontal Support Spacing*—The maximum recommended spacing between horizontal supports is 32 in. (800 mm) for nominal sizes up to 1 in. Maximum spacing for nominal sizes $1\frac{1}{4}$ in. and larger is 48 in. (1200 mm) or as stated in the manufacturer’s instructions. PE-RT tubing should not be rigidly secured to a stud or joist but should be secured with smooth plastic strap hangers, which permit ease of movement during expansion/contraction cycles.

X3.1.6 When PE-RT tubing are to be used in sealed central heating systems, the fact that all plastics allow for a certain amount of oxygen diffusion should be taken into consideration.

X3.2 Assembly

X3.2.1 *Insert Fittings*—A number of techniques have been developed where a fitting is firmly secured to the tubing. The fitting is placed inside the tube and a tool is employed to crimp a metallic lock ring around the tubing outside diameter adjacent to the fitting. This provides a mechanical lock with the tubing being wedged securely between the ring and the insert fitting.

X3.2.2 The manufacturer should be consulted regarding authorized fittings for use with PE-RT tubing.

X3.3 Installation

X3.3.1 *Storage and Handling*—PE-RT tubing and fittings should be stored under cover to avoid unnecessary dirt accumulation and long-term exposure to sunlight as per X3. Tubing can be stored in coils of number size and length recommended by the manufacturer. Care should be used in handling to ensure that unnecessary abuse, such as abrasion on concrete or crushing, is avoided.

X3.3.2 *Pressure Testing*—A pressure test with water at 100 psig (6.9 bar) on the system excluding the hot water heater is advisable to test for fitting leakage.

X3.3.3 *Repairs*—If a leak is discovered, that portion of the system should be drained and the actual part should be cut out. The tubing should be thoroughly dried and mechanical fitting(s) and if necessary, short length(s) of tubing should be installed

X3.3.4 *Soldering in the Area*—Soldered metal fittings should not be made closer than 18 in. (460 mm) to an installed plastic-to-metal adapter in the same water line.

X3.3.5 *Hot Bending of Tubing*—Hot bending, where the tubing is heated with a hot-air source (for example, heat gun), is not recommended.

X3.3.6 *Cold Bending of Tubing*—PE-RT SDR 9 tubing shall be bent at room temperature without the use of bending tools down to a minimum bending radius of 6 times outside diameter. Outside diameter is equal to nominal diameter plus $\frac{1}{8}$

in. Normal precaution is taken to avoid buckling or flattening. Fix the tubing by supports on both sides of the bend at installation.

X4. OPTIONAL PERFORMANCE

X4.1 Scope

X4.1.1 The following program covers performance qualification and in-plant quality control for component design and manufacture respectively to provide reasonable assurance that PE-RT hot-water distribution system components supplied under this specification shall consistently meet its requirements.

X4.2 Performance Qualifications

X4.2.1 Performance qualification tests shall be run initially on each component design, size, and formulation in accordance with the requirements of this specification. The test results shall be independently certified and shall be made available to the purchaser on request

X4.3 In-Plant Quality Control

X4.3.1 *Material*—The tubing material shall be PE-RT as defined in Section 4.1 of this specification. The manufacturer shall so certify.

X4.3.2 *Quality-Control Testing*—Tubing and fitting quality-control tests shall be run for each extrusion line or mold cavity in accordance with the requirements of this specification at a frequency agreed upon between the purchaser and the manufacturer. The program outlined in Table X4.1 is recommended. The test results shall be recorded and filed for inspection on request. Should a component fail to meet the specification in any test, production should be sampled back to the previous

TABLE X4.1 Suggested Quality-Control Program

Component	Property	Frequency	Requirement
Tubing	Workmanship	continuously	6.1
	Dimensions	hourly	6.2
	Burst pressure	daily	5.5
	Sustained pressure	3 months	5.4
	Bent tube	yearly	6.6
Fitting	Dimensions	hourly	6.2
	Burst pressure	daily	6.3

acceptable test result and tested to determine which components produced in the interim do not meet the requirement. Components that do not meet the requirements of this specification shall be rejected. See Table X4.2.

X4.3.3 *Marking*—A code number shall be included on the tubing that can be used to identify the manufacturer and the date of manufacture. Fittings shall be marked to identify the manufacturer and shall be coded or placed in dated containers to show the date of manufacture.

TABLE X4.2 Test Type Program

Component	Property	Requirement
Tubing	Hydrostatic design basis for each temperature	Test Method D2837
	Potable water	NSF 14
	Sustained pressure	6.4
Fittings	Thermocycling	6.5
	Potable water	NSF 14

SUMMARY OF CHANGES

Committee F17 has identified the location of selected changes to this standard since the last issue (F2769-10) that may impact the use of this standard.

(1) **X3.1.5** was modified to allow larger hanger spacing for nominal sizes 1¼ and larger.

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