



# IPS SDR21 NON-PRESSURE FITTING SPECIFICATIONS

- 1.0 **GPk IPS SDR21 NON-PRESSURE FITTINGS** Shall be manufactured from pvc SDR21 Class 200 pipe that has a minimum cell classification of 12454 as defined in ASTM D 1784.
- 2.0 The **purpose** of GPk in-line fittings is to convey municipal sanitary and industrial wastes, storm water runoff and many other related applications. They are designed to be used in gravity flow and low pressure applications not to exceed 10.8 psi.
- 3.0 **Fabricated Fittings** are produced in sizes 4" through 12" diameter. A fabricated fitting is considered any fitting made from pipe or a combination of pipe and molded components.
- 4.0 **Chemical Resistance.** GPk fittings resist attack from certain alcohols, alkalies, salt solutions, acids and other types of chemicals. Refer to chemical resistance chart for suitability.
- 5.0 **Marking.** GPk fittings shall be marked with applicable size, "PVC", company name or logo, and IPS SDR21 Non-Pressure. The fittings and/or packaging shall include the manufacturer's date and shift code.
- 6.0 **Testing.** A test after installation of either low pressure air (Uni-B-6) or a water infiltration-exfiltration test is recommended.
- 7.0 **Backfilling and Tamping.** Backfilling should follow closely after assembly of pipe and fittings.
  - 7.1 **Backfilling** with proper material is important to achieve desired density in haunching area which enables pipe, fitting and soil to work together to meet designed load requirements. This eliminates excess deflection and shear breaks due to heavy loads. Approved material shall be used properly, compacted continuously above and around the pipe and fittings as well as between the fitting and trench wall. A cushion of approved material up to a minimum of 12" over the fittings and between the trench walls shall be applied in accordance with the engineers' specifications.
  - 7.2 **Tamping.** This shall be done by hand tamping of the embedment material between the trench wall of the service line fitting and riser connection. Tamping can also be done by mechanical tampers or by using water to consolidate the embedment material. **Extreme unstable ground conditions** may require wider trenches to enable you to compact a larger area around the pipe and fittings to the density consistent of the original ground surface conditions.
- 8.0 **Service Lines.** Normally, service lines from the property line to the collection sewer should be a minimum depth of 3 feet at the property line and should be laid in straight alignment and uniform slope of not less than 1/4" per foot for 4" nominal pipe and 1/8" per foot for 6" pipe. Where collection sewers are deeper than 7 feet a vertical standpipe of stack is permitted but not recommended, consult the project engineer for proper installation details. Deep sewer chimney and risers necessitate extreme care during backfilling. Where surface loading is anticipated the final backfill must be compacted to a density compatible with those surface loads to be encountered.
  - 8.1 **Backfilling around pipe service laterals on slope.** Extra attention should be given on slopes to prevent the newly backfilled trench from becoming a "French Drain." Before backfilling completely there is a tendency for ground and surface water to follow the direction of the looser soil. This flow may wash out soil from under or around pipe and branch line fittings, reducing or eliminating the support needed. To avoid this problem the backfilling should be of greater compaction. Tamping should be done in 4" layers and continued in this manner all the way up to ground or surface line of the trench. Concrete collars or other concrete poured around the fitting to stabilize unwanted movement is recommended to prevent water from undercutting the underside of the pipe and fittings.

**SUMMARY:** Due to various ground conditions and different situations, installation techniques vary widely. We warranty our products to be free of manufacturer's defects. We will not replace the products that are installed or used incorrectly. The design of the systems that our product is used in is a factor that cannot be overlooked.



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**Intro:** GPK manufactures IPS SDR21 drainage fittings to be used in gravity flow or low pressure applications. Fabricated fittings are produced in sizes 4" through 12" diameter.

**Material:** Fabricated fittings are manufactured from PVC pipe meeting the requirements of ASTM D 2241 for workmanship, extrusion quality, stiffness, impact resistance, dimensions and structural performance.

Extruded pipe components are made from PVC material with a minimum cell classification of 12454 as defined in ASTM D 1784.

**Pressure/Pressure Deflection:** Gasketed joints are tested in accordance with ASTM D 3212.  
Pressure: 10 minutes @ 10.8 psi.  
Vacuum: 10 minutes @ 22" Hg.

**Branch Bending:** The fused areas around the fabricated branches of tee, wye and tee-wye fittings are tested to ASTM F 1866 to verify their strength and integrity.

**Joining Methods:** Chemically Fused Solvent Weld Joints  
Solvent cement is handled and tested in accordance with ASTM D 2564 and D 2855. The Lap Shear Strength shall equal or exceed 900 psi @ 72 hours.

Heat Fusion Welded Joints (Butt Fusion Welds)

Elastomeric Seals (Gaskets)

Must meet all requirements of ASTM F 477 and D 3212. Fabricated saddle tees and saddle wyes shall have skirts which can be bonded to pipe.

GPK does not recommend gasket skirts where air tests are required.