



Standard Specification for Joints for Concrete Box, Using Rubber Gaskets¹

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1. Scope

1.1 This specification covers flexible joints for concrete box sections, using rubber gaskets for leak resistant joints. The specification covers the design of joints and the requirements for rubber gaskets to be used therewith, for boxes conforming in all other respects to Specification C1433 or C1577, provided that if there is conflict in permissible variations in dimensions the requirements of this specification for joints shall govern.

1.2 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.

2. Referenced Documents

2.1 *ASTM Standards:*²

C497 Test Methods for Concrete Pipe, Manhole Sections, or Tile

C822 Terminology Relating to Concrete Pipe and Related Products

C1433 Specification for Precast Reinforced Concrete Monolithic Box Sections for Culverts, Storm Drains, and Sewers

C1577 Specification for Precast Reinforced Concrete Monolithic Box Sections for Culverts, Storm Drains, and Sewers Designed According to AASHTO LRFD

C1619 Specification for Elastomeric Seals for Joining Concrete Structures

3. Terminology

3.1 *Definitions*—For definitions of terms relating to concrete pipe, see Terminology C822.

4. Basis of Acceptance

4.1 The acceptability of the box joints and gaskets shall be determined by the results of the physical test prescribed in this

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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.

specification, if and when required, and by inspection to determine whether the box joints and gaskets conform to this specification as to design and freedom from defects.

5. Materials and Manufacture for Gaskets

5.1 The gasket shall be fabricated from a rubber compound. The basic polymer shall be natural rubber, synthetic rubber, or a blend of both meeting the physical requirements prescribed in Specification C1619.

5.1.1 Gaskets for standard use shall meet Class C requirements. Gaskets which require oil resistant properties shall meet Class D requirements.

5.2 Circular Cross-Section Gaskets:

5.2.1 Circular cross-section gaskets shall be extruded or molded to the specified size within a tolerance of $\pm 1/64$ in. (± 0.4 mm) or ± 1.5 % of the cord diameter, whichever is larger.

5.2.2 Circular cross-section gaskets shall have the nominal design cut length tolerance of ± 3 % for extruded and spliced gaskets.

5.3 Non-Circular Cross-Section Gaskets:

5.3.1 Non-circular cross-section gaskets shall be extruded or molded to the design size within a tolerance of $\pm 1/64$ in. (± 0.4 mm) or ± 3.0 % on any dimension, measured at any cross section, whichever is larger.

5.3.2 Non-circular cross-section gaskets shall have the nominal design cut length tolerance of ± 3 % for extruded and spliced gaskets.

6. Design of Joints

6.1 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.

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

6.1.2 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.

6.1.3 The joints of the box 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 9.

6.1.4 The angle of taper on the 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 9 and approved by the owner. The surface on the spigot or tongue shall be modified to properly position and seat the gasket.

6.1.5 The space between the gasket-bearing surfaces of the assembled and centered joint shall be not more than 75 % of the uncompressed thickness of the installed gasket with all manufacturing tolerances applied. Minimum tolerances shall not be less than 10 % of the installed gasket height. The minimum off-center gasket deformation of the assembled joint at design closure shall not be less than 15 %. The joint design shall provide for the deflection of a box unit by opening one side of the outside joint surface of the joint ½ in. (13 mm) wider than the designed position without causing the deformation of the gasket to be less than 10 %. Where greater deflections are required than provided by the joint design, beveled joints or elbows must be provided.

6.1.6 The gasket shall be the sole sealing element depended upon to make the joint flexible and leak resistant. The gasket shall be a continuous shape which fits snugly into the annular space between the overlapping surfaces of the assembled box joint.

6.1.7 The gasket shall not be stretched more than 30 % when seated on the spigot or tongue end of the box.

6.1.8 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 1—Joints in an assembled position are defined as joints in the position after assembly in accordance with the manufacturer's design.

6.2 *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 6. Design submissions shall include joint geometry, tolerances, gasket characteristics, gasket deformation, 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.

7. Permissible Variations in Dimensions

7.1 The planes formed by the ends of non-beveled box shall not vary from the perpendicular to the box axis by more than ⅛ in./ft (10 mm/m) of internal span with a maximum of ⅝ in. (16 mm) for all sizes through 7 ft (2100 mm) internal span, and a maximum of ¾ in. (19 mm) for internal spans greater than 7 ft (2100 mm), except where beveled ends for laying on curves are specified by the purchaser.

8. Test Methods for Gaskets

8.1 In addition to Specification C1619, the physical properties of the gaskets shall be determined in accordance with the following methods:

8.1.1 *Gasket Volume Determination*—Determine the volume of gasket sections in accordance to Test Method C497.

8.1.2 *Non-Circular Cross-Section Gasket Stretch Height*—Determine the stretch height of gasket sections in accordance to Test Method C497.

8.1.3 *Gasket Length*—Determine the stretch length of gasket sections in accordance to Test Method C497.

9. Performance Requirements for Joints

9.1 When required by the owner, assembled joints shall pass the following in plant performance test.

9.1.1 *Boxes in Straight Alignment*—Hydrostatic pressure tests on joints shall be made on an assembly of two sections of box, properly connected in accordance with the joint design. At the option of the owner a second such test shall be required. Suitable means shall be provided that allows pressure to be applied to the joint, either external or internal of the two joined box sections. No fillings or packings shall be placed prior to the tests. After the box sections are fitted together with the gasket or gaskets in place, the assembly shall be subjected to a hydrostatic pressure of 5 psi (35 kPa) for 10 min. Moisture or beads of water that drip from the joint that can be proven to seal and dry up on retesting are acceptable.

9.1.2 *Boxes in Maximum Deflected Position*—Upon completion of the test for boxes in straight alignment in 9.1.1, the test sections shall be deflected to create a position ½ in. (13 mm) 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 3 psi (21 kPa) for 10 min. Moisture or beads of water that drip from the joint that can be proven to seal and dry up on retesting are acceptable.

9.1.3 *Off-Center Alignment*—On completion of tests in 9.1.1 and 9.1.2 the assembly shall be loaded to cause maximum joint annular space to occur. The load shall be applied such that a differential load across the tested joint of 150 lb/in. (26.3 KN/mm) of span is obtained or concrete-to-concrete contact occurs. The assembly shall then be retested as set forth in 9.1.1.

10. Storage

10.1 The gaskets shall be stored in as cool, clean, and shaded place as practicable, preferably at 70°F (21°C) or less.

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

11. Inspection

11.1 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.

12. Certification

12.1 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.

13. Product Marking

13.1 *Lubricant*—The following information shall be clearly marked on each container of lubricant:

- 13.1.1 Name of lubricant manufacturer,
- 13.1.2 Usable temperature range for application and storage,
- 13.1.3 Shelf life, and
- 13.1.4 Lot or batch number.

14. Repairs

14.1 Spalled areas, manufacturing imperfections, or damage during handling of each box 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 6.1.2 provided the length of a single area to be repaired shall not exceed one fourth of the inside span of the box or the length of several areas combined does not exceed one half of the inside span of the box.

14.2 At the option of the owner, the box joint that has been repaired shall be subjected to the designated hydrostatic test in accordance with 9.1.1 and shall be accepted if it passes the hydrostatic test requirements.

15. Rejection

15.1 Box joints and gaskets shall be subject to rejection upon failure to conform to any of the requirements of this specification. Box that is damaged because of carelessness or continuing failure to prevent recurrent imperfections in manufacture or damage during handling shall be subject to rejection.

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

16. Keywords

16.1 concrete box; joints; rubber gaskets

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