



Standard Specification for Asbestos-Cement Storm Drain Pipe¹

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

1. Scope

1.1 This specification covers asbestos-cement pipe intended for use in storm-water drainage of highways, airports, farms, foundations, and other similar drainage systems.

1.2 The values stated in SI units are to be regarded as the standard. The values stated in parentheses are for information only.

1.3 **Warning**—Breathing of asbestos dust is hazardous. Asbestos and asbestos products present demonstrated health risks for users and for those with whom they come into contact. In addition to other precautions, when working with asbestos-cement products, minimize the dust that results. For information on the safe use of chrysotile asbestos, refer to “Safe Use of Chrysotile Asbestos: A Manual on Preventive and Control Measures.”²

1.4 *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. See for a specific hazard warning.*

2. Referenced Documents

2.1 ASTM Standards:³

C150 Specification for Portland Cement

C458 Test Method for Organic Fiber Content of Asbestos-Cement Products

C500 Test Methods for Asbestos-Cement Pipe

C595 Specification for Blended Hydraulic Cements

D2946 Terminology for Asbestos and Asbestos-Cement Products

¹ This specification is under the jurisdiction of ASTM Committee C17 on Fiber-Reinforced Cement Products and is the direct responsibility of C17.03 on Asbestos - Cement Sheet Products and Accessories.

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² Available from The Asbestos Institute, http://www.chrysotile.com/en/sr_use/manual.htm.

³ 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.

2.2 Federal Standard:

Fed. Std. No. 123 Marking for Shipment (Civil Agencies)⁴

2.3 Military Standard:

MIL-STD-129 Marking for Shipment and Storage⁴

2.4 Other Standards:

Uniform Freight Classification Rules⁵

National Motor Freight Classification Rules⁶

3. Terminology

3.1 Definitions:

3.1.1 *coupling, n*—in asbestos-cement conduit, sewer, underdrain and storm drain pipe—component made from a larger diameter pipe of the same type or class, or of Type II and a higher class, or produced otherwise to yield at least equal performance, for joining asbestos-cement pipe that when properly installed, forms a silt-tight joint, allows alignment corrections and slight changes in direction, and provides an assembled joint equivalent in serviceability and strength to the pipe sections. Alternatively, for storm drain couplings, plastic sleeves that, when properly installed develop sufficient tightness to prevent the surrounding soil from entering the drain, may be used as couplings.

3.1.2 *lot, n*—for pipe sizes 525 mm (21 in.) in diameter and smaller, each 300 lengths of pipe or less, of identical class and sized manufactured on each machine during a 24-h period. For pipe larger than 525 mm (21 in.), each 300 lengths of pipe or less, of identical class and size manufactured on each machine during a period of consecutive working days not exceeding seven days.

3.1.3 Additional terminology is given in Terminology D2946.

4. Classification

4.1 The types of pipe shall be shown as Type I and Type II corresponding to the chemical requirements given in 10.1.

⁴ Available from Standardization Documents Order Desk, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094 Attn: NPODS.

⁵ Available from the Uniform Classification Commission, Room 1106, 222 S. Riverside Plaza, Chicago, IL 60606.

⁶ Available from National Motor Freight Inc., 1616 P St. NW, Washington, DC 20036.

4.2 Asbestos-cement storm drain pipe furnished under this specification shall be designated as Class II, III, 2500D, IV, and V. The corresponding strength requirements are prescribed in [Table 1](#). The D_1 load is the crushing test load expressed in newtons per linear metre per of diameter. (The D load is the crushing test load expressed in pounds-force per linear ft per ft of diameter.) The pipe shall be furnished in 10, 15, 20, 25, 30, 36, 38, 41, 46, 51, 53, 61, 69, 76, 84, 91, 99 and 107-cm sizes (4, 6, 8, 10, 12, 14, 15, 16, 18, 20, 21, 24, 27, 30, 33, 36, 39 and 42-in. sizes).

5. Materials and Manufacture

5.1 Asbestos-cement storm drain pipe shall be composed of an intimate mixture of portland cement or portland blast-furnace slag cement meeting Specification [C150](#) or portland slag or pozzolan cements conforming to Specification [C595](#). The mixture shall not contain more than 0.2 % of non-deleterious organic components as determined by Test Method [C458](#). The material shall be of laminar construction formed under pressure to a homogeneous structure and cured to meet the physical and chemical requirements of this specification.

6. Dimensions, Mass, and Permissible Variations

6.1 The nominal length for asbestos-cement storm drain pipe shall be either 3 or 4 m (10 or 13 ft). A maximum of 15 % of the total footage of any one size and type for any order may be furnished, at the manufacturer's option, in pipe lengths shorter than specified nominal, but not shorter than 2 m (7 ft); these shall be termed random lengths.

6.2 A tolerance of 25 mm (± 1 in.) shall apply to nominal standard lengths. Random lengths shall be classified to 150 mm (+ 150–25 mm) [6 in. (+ 4.9–1.0 in.)] increments, allowing a tolerance of 124 mm (+ 4 $\frac{7}{8}$ in.) and –1 in.

6.3 The average inside diameter of the pipe may be less than the nominal size by not more than 6 mm (0.25 in.) or 1 $\frac{1}{2}$ %, whichever is greater.

7. Sampling

7.1 All material tested under this specification shall be in air-dried condition in equilibrium with atmospheric moisture.

7.2 For crushing tests, select one full length of pipe from each lot of each size, class, and type of pipe. Cut one test specimen 30 cm (12 in.) long from the unmachined portion of the selected length of pipe. (**Warning**—see [1.3](#).)

7.3 When uncombined calcium hydroxide tests are requested ([10.1](#)), take one sample from each lot of pipe and test

in accordance with Test Methods [C500](#). The sample to be tested may be taken from any one of the specimens selected for the crushing test.

8. Couplings

8.1 Each standard, short, or random length of pipe shall be provided with a coupling for the purpose of maintaining alignment and to ensure close joints.

9. Fittings

9.1 Asbestos-cement storm drain pipe fittings shall be suitable in size, crushing strength, and design for the pipe with which they will be furnished.

10. Test Methods

10.1 *Chemical Requirements*—When tested in accordance with Test Methods [C500](#), the amount of uncombined calcium hydroxide shall not exceed 1.0 % for Type II pipe.

NOTE 1—There are no chemical requirements for Type I pipe.

10.2 *Crushing Strength*—Conduct crushing tests before shipment. Lengths of pipe 30 cm (1 ft) long cut from unmachined portions of the pipe shall have the minimum crushing strength prescribed in [Table 1](#) when tested in accordance with the appropriate section of Test Methods [C500](#), Vee Shaped Three Edge Bearing Method.

11. Inspection

11.1 All material furnished under this specification shall conform to the requirements stated herein and shall be subjected to the factory inspection and tests prescribed in this specification. When requested by the purchaser in his order (see [Appendix X1](#)), the manufacturer shall notify the purchaser of the time that the inspection and testing will take place so that the purchaser may arrange for witnessing such tests and inspections at his own expense. Instead of such inspection, when requested, the manufacturer shall certify that his product conforms to the requirements of this specification.

11.2 Each pipe shall be inspected by the manufacturer before shipment for compliance with the standards for dimensions, tolerances, workmanship, and finish (see also [Section 7](#)).

12. Rejection

12.1 Failure of any specimen tested for crushing strength to withstand 75 % of the load specified in [10.2](#) shall be cause for rejection of the lot from which the test specimen was taken. When any specimen tested for crushing strength withstands over 75 % but under 100 % of the load specified in [10.2](#), one specimen shall be cut from each of two additional pipes of the same lot. Failure of either of these additional specimens to meet the strength requirements of [10.2](#) shall be cause for rejection of the entire lot from which the original sample was taken.

12.2 If the results of the uncombined calcium hydroxide test show that the sample failed to meet the specification requirements, two additional specimens shall be selected and sampled for each test. The failure of one of these two additional

TABLE 1 Minimum Crushing Loads

Pipe Class	Minimum Crushing Load	
	D_1 Load kN/m	(D Load) (lbf/ft)
II	22	(1500)
III	29	(2000)
2500 D	37	(2500)
IV	44	(3000)
V	55	(3750)



samples to meet the specification requirements of **10.1** shall be cause for rejection of the lot.

13. Product Marking and Shipping

13.1 Each standard and random length of pipe shall be marked by the manufacturer with the trade name, nominal size, class, and the date of manufacture, in alkali resistant ink or indelible paint.

13.2 Couplings and fittings shall be marked with the size and class.

13.3 Pipe, couplings, and fittings shall be prepared for commercial shipment so as to ensure acceptance by common or other carriers.

14. Keywords

14.1 asbestos; asbestos-cement; asbestos-cement pipe; drain; drain pipe; storm drain pipe

SUPPLEMENTARY REQUIREMENTS

The following supplementary requirements shall apply when material is supplied under this specification for U.S. Government procurement.

S1. Packaging

S1.1 Unless otherwise specified in the contract, the material shall be packaged in accordance with the producer's standard practice which will be acceptable to the carrier at lowest rates. Containers and packaging shall comply with Uniform Freight Classification Rules or National Motor Freight Classification Rules. Marking for shipment of such material shall be in accordance with Fed. Std. No. 123 for civil agencies and MIL-STD-129 for military agencies.

S2. Responsibility for Inspection

S2.1 Unless otherwise specified in the contract or purchase order, the producer is responsible for the testing of all material to assure compliance with the requirements specified herein. Except as otherwise specified in the contract or order, the producer may use his own or any other suitable facilities for the performance of the inspection and test requirements specified herein, unless disapproved by the purchaser. 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 assure that material conforms to prescribed requirements.

APPENDIX

(Nonmandatory Information)

X1. ADDITIONAL ORDERING INFORMATION

X1.1 It is suggested to the purchaser, without being made a part of this specification, that the purchaser may request inclusion of the following information in his order or agreement for purchase of the pipe:

X1.1.1 Any tests, in addition to those prescribed by this specification, as the special circumstances may require,

X1.1.2 The place or places where any additional tests are to be made,

X1.1.3 Description of the additional testing facilities,

X1.1.4 Who shall bear the expense of such additional tests.

X1.1.5 Whether such additional tests may be made by any sound sampling process or other method approved by the parties.

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