

## HANCOR BLUE SEAL<sup>®</sup> PIPE (per AASHTO) SPECIFICATIONS

### Scope

This specification describes 1050 to 1500 mm (42- through 60-inch) Hancor BLUE SEAL WT IB pipe (per AASHTO) for use in gravity flow applications.

### Pipe Requirements

BLUE SEAL<sup>®</sup> pipe shall have a smooth interior and annular exterior corrugations.

- 1050 to 1500 mm (42- through 60-inch) shall meet AASHTO M294, Type S or SP, or ASTM F2306.
- Manning's "n" value for use in design shall be 0.012.

### Joint Performance

Pipe shall be joined with the BLUE SEAL WT IB joint meeting the requirements of AASHTO M294, or ASTM F2306.

1050 to 1500 mm (42- through 60-inch) shall be watertight according to the requirements of ASTM D3212. Gaskets shall meet the requirements of ASTM F477. Gaskets shall be installed by the pipe manufacturer and covered with a removable, protective wrap to ensure the gasket is free from debris. A joint lubricant available from the manufacturer shall be used on the gasket and bell during assembly.

1050 to 1500 mm (42- through 60-inch) diameters shall have a reinforced bell with a polymer composite band. The bell tolerance device shall be installed by the manufacture.

### Fittings

Fittings shall conform to AASHTO M294, or ASTM F2306. Bell and spigot connections shall utilize a spun-on or welded bell and valley or saddle gasket meeting the watertight joint performance requirements of AASHTO M294 or ASTM F2306.

### Field Pipe and Joint Performance

To assure watertightness, field performance verification may be accomplished by testing in accordance with ASTM F2487. Appropriate safety precautions must be used when field-testing any pipe material. Contact the manufacturer for recommended leakage rates.

### Material Properties

Virgin material for pipe and fitting production shall be high-density polyethylene conforming with the minimum requirements of cell classification 435400C, as defined and described in the latest version of ASTM D3350, except that carbon black content should not exceed 4%. The virgin pipe material shall comply with the notched constant ligament-stress (NCLS) test as specified in Section 9.5 and 5.1 of AASHTO M294 and ASTM F2306, respectively.

### Installation

Installation shall be in accordance with ASTM D2321 and Hancor recommended installation guidelines with the exception that minimum cover in trafficked areas for 1050 and 1200 mm (42- and 48-inch) diameters shall be 0.3 m (one foot) and for 1350 and 1500 mm (54- and 60-inch) diameters shall be 0.6 m (2 ft) in single run applications. Backfill for minimum cover situations shall consist of Class 1, Class 2 (minimum 90% SPD) or Class 3 (minimum 90%) material. Maximum fill heights depend on embedment material and compaction level; please refer to Technical Note 2.01. Contact your local Hancor representative or visit our website at [www.hancor.com](http://www.hancor.com) for a copy of the latest installation guidelines.

### Pipe Dimensions

Nominal Diameter, mm (in)				
Pipe I.D. mm (in)	1050 (42)	1200 (48)	1350* (54)	1500 (60)
Pipe O.D.** mm (in)	1219 (48)	1372 (54)	1549 (61)	1702 (67)

\*Check with sales representative for availability by region.

\*\*Pipe O.D. values are provided for reference purposes only, values stated for 1050 to 1500 mm are  $\pm 25$  mm. Contact a sales representative for exact values.

## BLUE SEAL® (per AASHTO) JOINT SYSTEM

(Joint configuration & availability subject to change without notice. Product detail may differ slightly from actual product appearance.)

