



Standard Specification for Coextruded Poly(Vinyl Chloride) (PVC) Plastic Pipe With a Cellular Core¹

This standard is issued under the fixed designation F891; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ε) indicates an editorial change since the last revision or reapproval.

1. Scope*

1.1 This specification covers coextruded poly(vinyl chloride) (PVC) plastic pipe with a cellular core and concentric inner and outer solid layers, and is produced using a multilayer coextrusion die for nonpressure use in three series: an IPS Schedule 40 series for DWV; a PS series with an iron pipe size (IPS) outside diameter with varying wall thickness as required for pipe stiffnesses of 25, 50, and 100 for communication conduit, and a sewer and drain series.

1.2 The function of this specification is to provide standardization of product-technical data and serve as a purchasing guide.

1.3 The text of this specification references notes, footnotes, and appendixes which provide explanatory material. The notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of the specification.

NOTE 1—All the pipe series covered by this specification are permitted to be perforated or belled for joining by solvent cement or belled for joining by an elastomeric seal (gasket). Because this pipe is OD controlled, the inside diameter will vary, and therefore, the pipe ID is not suitable for use as a socket. (For more information see Specification D2672.)

NOTE 2—This standard specifies dimensional, performance and test requirements for plumbing and fluid handling applications, but does not address venting of combustion gases.

1.4 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.

NOTE 3—Specifications related to this specification are as follows: D2665, D2729, D3034, F512, F758, and F789.

1.5 *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, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.6 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

- D618 Practice for Conditioning Plastics for Testing
- D1600 Terminology for Abbreviated Terms Relating to Plastics (Withdrawn 2024)³
- D2122 Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings
- D2152 Test Method for Adequacy of Fusion of Extruded Poly(Vinyl Chloride) (PVC) Pipe and Molded Fittings by Acetone Immersion
- D2321 Practice for Underground Installation of Thermoplastic Pipe for Sewers and Other Gravity-Flow Applications
- D2412 Test Method for Determination of External Loading Characteristics of Plastic Pipe by Parallel-Plate Loading
- D2444 Practice for Determination of the Impact Resistance of Thermoplastic Pipe and Fittings by Means of a Tup (Falling Weight)
- D2564 Specification for Solvent Cements for Poly(Vinyl Chloride) (PVC) Plastic Piping Systems
- D2665 Specification for Poly(Vinyl Chloride) (PVC) Plastic Drain, Waste, and Vent Pipe and Fittings
- D2672 Specification for Joints for IPS PVC Pipe Using Solvent Cement
- D2729 Specification for Poly(Vinyl Chloride) (PVC) Sewer Pipe and Fittings
- D2855 Practice for the Two-Step (Primer and Solvent Cement) Method of Joining Poly (Vinyl Chloride) (PVC) or Chlorinated Poly (Vinyl Chloride) (CPVC) Pipe and Piping Components with Tapered Sockets

¹ This specification is under the jurisdiction of ASTM Committee F17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.25 on Vinyl Based Pipe.

Current edition approved April 1, 2024. Published April 2024. Originally approved in 1985. Last previous edition approved in 2023 as F891 – 23. DOI: 10.1520/F0891-24.

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.

- D3034** Specification for Type PSM Poly(Vinyl Chloride) (PVC) Sewer Pipe and Fittings
- D3212** Specification for Joints for Drain and Sewer Plastic Pipes Using Flexible Elastomeric Seals
- D3311** Specification for Drain, Waste, and Vent (DWV) Plastic Fittings Patterns
- D4396** Specification for Rigid Poly(Vinyl Chloride) (PVC) and Chlorinated Poly(Vinyl Chloride) (CPVC) Compounds for Plastic Pipe and Fittings Used in Nonpressure Applications
- F402** Practice for Safe Handling of Solvent Cements, Primers, and Cleaners Used for Joining Thermoplastic Pipe and Fittings
- F412** Terminology Relating to Plastic Piping Systems
- F477** Specification for Elastomeric Seals (Gaskets) for Joining Plastic Pipe
- F512** Specification for Smooth-Wall Poly(Vinyl Chloride) (PVC) Conduit and Fittings for Underground Installation
- F545** Specification for PVC and ABS Injected Solvent Cemented Plastic Pipe Joints (Withdrawn 2001)³
- F656** Specification for Primers for Use in Solvent Cement Joints of Poly(Vinyl Chloride) (PVC) Plastic Pipe and Fittings
- F758** Specification for Smooth-Wall Poly(Vinyl Chloride) (PVC) Plastic Underdrain Systems for Highway, Airport, and Similar Drainage
- F789** Specification for Type PS-46 and Type PS-115 Poly(Vinyl Chloride) (PVC) Plastic Gravity Flow Sewer Pipe and Fittings (Withdrawn 2004)³
- 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 *ANSI Standards:*
Z34.1 American National Standard for Certification-Third-Party Certification Program⁵
Z34.2 American National Standard for Certification-Self-Certification by Producer or Supplier⁵

3. Terminology

3.1 *Definitions*—Definitions are in accordance with Terminology **F412**, and abbreviations are in accordance with Terminology **D1600**, unless otherwise specified. The abbreviation for poly(vinyl chloride) plastic is PVC.

3.2 *Definitions:*

3.2.1 *cellular plastic*—a plastic containing numerous cells, intentionally introduced, interconnecting or not, distributed throughout the mass.

3.2.2 *coextruded pipe*—pipe consisting of two or more concentric layers of material bonded together in processing by any combination of temperature, pressure, grafting, crosslinking, or adhesion.

3.2.3 *coextrusion*—a process whereby two or more heated or unheated plastic material streams, forced through one or more shaping orifice(s), become one continuously formed piece.

3.3 *Definitions of Terms Specific to This Standard:*

3.3.1 *lot*—a lot shall consist of all pipe of the same size produced from one extrusion line during one designated shift.

3.3.2 *IPS Schedule 40 Series*—pipe produced to an iron pipe size (IPS) outside diameter (OD) with a Schedule 40 wall thickness for use as drain, waste, and vent pipe.

3.3.3 *PS Series*— pipe produced to an IPS outside diameter and having the required wall thickness to meet a designated pipe stiffness for use as communication conduit.

3.3.4 *sewer and drain series*—pipe produced to a sewer and drain outside diameter and having a minimum wall thickness to meet a designated pipe stiffness. for use as sewer and drain pipe.

4. Classification by Application

4.1 Coextruded PVC plastic pipe, in an IPS Schedule 40 series, for use as shown in **4.4**, is referenced in **Table 1**.

4.2 Coextruded PVC plastic pipe in a PS series with an IPS OD and varying wall thicknesses as required for pipe stiffnesses of 25 psi, 50 psi, and 100 psi, for use as shown in **4.5** is referenced in **Table 2**.

4.3 Coextruded PVC plastic pipe in a sewer and drain series for use as shown in **4.6** and **4.7** is referenced in **Table 2**.

4.4 Drain, waste, and vent pipe in IPS Schedule 40 series.

4.5 Underground communication conduit in PS series, not for underground electrical power distribution usage.

4.6 Nonpressure sewer and drain pipe for underground burial outside of the building.

4.7 Highway underdrain in sewer and drain series.

4.8 Recommendations for storage, joining, and installation are provided in **Appendix X1**, **Appendix X2**, and **Appendix X3**, respectively.

NOTE 4—Before installing pipe for industrial waste disposal use, the approval of the cognizant building code authority must be obtained, as conditions not commonly found in normal use may be encountered.

TABLE 1 Minimum Wall Thickness,⁴ Pipe Stiffness, and Impact Strength for IPS Schedule 40 Series

Nominal Pipe Size	Wall Thickness, in.	Pipe Stiffness, lbf/in. ²	Impact Strength, ft-lbf
1¼	0.140	600	40
1½	0.145	600	50
2	0.154	300	80
3	0.216	300	100
3½	0.226	250	100
4	0.237	200	100
5	0.258	120	100
6	0.280	120	120
8	0.322	100	120
10	0.365	60	120
12	0.406	50	120

⁴ The maximum wall thickness shall not be greater than 1.25 times the minimum wall thickness.

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

⁵ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.