

TECHNICAL SPECIFICATION**IPS Pressure Pipe
Series 250 SDR17
Gasketed**

Cell classification 12454

SCOPE

This specification covers the requirements for PVC (polyvinyl chloride) pressure pipe with bell and spigot joints utilizing a double seal locked in (DSL) gasket. The pipe is Iron Pipe Size (IPS) in nominal sizes of 1-1/2" – 12" with a standard dimension ratio (SDR) of 17. This pipe meets the requirements of American Society of Testing and Materials (ASTM) standard D2241 and is certified to The National Sanitation Foundation (NSF) Standard 14.

MATERIALS

The pipe is manufactured from virgin PVC compound meeting the cell classification requirements of 12454 as defined by the American Society of Testing and Materials (ASTM) Standard D1784: *Standard Specification for Rigid PVC Compounds and CPVC Compounds*. This compound has a hydrostatic design basis rating of 4000 psi for water at 73.4 Deg F. The compound is certified to NSF Standard 61.

MARKING

Pipe markings are as specified in NSF 14 (NSF-pw) and ASTM D 2241.

PIPE

The pipe has a pressure rating of 250 psi at 73 Degrees F.

GASKETS

The pipe utilizes a double seal locked (DSL) gasket system that meets the requirements of ASTM D3139: *Standard Specification for Joints for Plastic Pressure Pipes Using Flexible Elastomeric Seals*. The gaskets are reinforced with a steel band and conform to the requirements of ASTM F477: *Standard Specification for Elastomeric Seals (Gaskets) for Joining Plastic Pipe*.

TEST REQUIREMENTS

Quality testing is as per Royal's Quality Control program and in accordance with the applicable NSF and ASTM standards.

PIPE DIMENSIONS

Nominal Size (in)	Outside Diameter, OD (in)	Wall Thickness, t (in)	Average Bell Depth (in)	Pipe Length, L (ft)
1-1/2	1.894 – 1.906	0.112 – 0.132	4-1/4"	20
2	2.369 – 2.381	0.140 – 0.160	4-3/4"	
2-1/2	2.868 – 2.882	0.169 – 0.189	5"	
3	3.492 – 3.508	0.206 – 0.231	5"	
4	4.491 – 4.509	0.265 – 0.297	6"	
6	6.614 – 6.636	0.390 – 0.437	7-1/4"	
8	8.610 – 8.637	0.508 – 0.569	8-1/4"	
10	10.736 – 10.763	0.632 – 0.708	8-1/4"	
12	12.735 – 12.765	0.750 – 0.840	10-1/4"	

