

TECHNICAL SPECIFICATIONS

FORM P927



CERTAIN-TEED PRODUCTS CORPORATION
PIPE DIVISION

SPECIFICATIONS CLASSIFICATION:

Standard Purchasing Specification

T.C.O. REF. NO.

11

SPECIFICATION NO:

530

PAGE NO.:

1

SUPERSEDES:

January 6, 1969

DATE OF ISSUE:

JAN 16 1973

DESCRIPTION:

Rubber Rings for Use With Bureau of Reclamation (B/R) Pipe and Couplings

1.0 USE

These rubber rings are intended for use as seals in Bureau of Reclamation (B/R) Couplings of asbestos-cement pipe. This seal is to prevent leaking from the inside out, and infiltration from the outside in. Rubber rings when placed in service shall meet the requirements of this specification.

2.0 CONFORMANCE

The rubber rings shall be made of an approved compound and meet the requirements of P&PG Purchasing Specification No. 506 and ASTM D-1869 latest issue.

3.0 DESIGN

All rings are circular in form and cross-section and shall be manufactured to the dimensions specified in Figure I of this specification.

4.0 LOT SIZE

For sampling and inspection purposes, a lot shall be defined as the quantity of rings of each size and type, received at one time.

5.0 REQUIREMENTS5.1 Manufacturer's Inspection

Each ring shall be inspected in its entirety at a circumferential elongation of 100 percent in excess of the original circumference by the manufacturer before shipment to P&PG. Defective rings shall be removed before shipment. All rings are to be shipped on a first-in first-out basis; i.e., oldest rings are shipped first.

5.2 Appearance

The surface and cross-section of the ring shall be smooth, clean, and free from porosity, blisters, pitting, and other imperfections.

5.3 Marking

Each rubber ring shall be marked as shown in Figure I. The size of the letters shall be 3/16" +0" -1/32" high, length to suit. Marking shall be clear and concise and not raised. The marking color shall be as follows and must not rub off: Natural and SBR - Yellow; Neoprene - Blue; NBR - Green. In sizes 6" through 12" the markings must appear at least

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 CERTAIN-TEED PRODUCTS CORPORATION PIPE DIVISION	SPECIFICATIONS CLASSIFICATION:					
	Standard Purchasing Specification					
	T.C.O. REF. NO.	SPECIFICATION NO.	PAGE NO.			
12	530	2				
SUPERSEDES:		DATE OF ISSUE:				
Jan. 16, 1973		NOV 27 1973				
DESCRIPTION:						
Rubber Rings for Use With Bureau of Reclamation (B/R) Pipe and Couplings						
once on each ring. In sizes 14" through 24" the markings must appear at least twice on each ring. Example: CPC 16" FT Class AC 30-35-40 4 9-72 B/R						
5.4 <u>Splice</u> The splice shall be properly joined and sufficiently strong to withstand 100 percent elongation. While elongated 100 percent, the splice shall be rotated 180° in each direction without separation or peeling. The splice shall also be able to withstand bending 180° to 270° over a mandrel of the same size cross-section of the ring. The splice shall be made on a bias cut.						
5.5 <u>Dimensions</u> The dimensions shall be as shown in Figure I.						
6.0 <u>TEST METHODS</u>						
6.1 <u>Appearance</u> - Visual in accordance with paragraph 5.2.						
6.2 <u>Splice</u> - In accordance with paragraph 5.4.						
6.3 <u>Dimensions</u> - In accordance with P&PG Test Method TM-28.						
7.0 <u>ACCEPTANCE AND REJECTION</u> P&PG reserves the right to reject any lot or lots found not conforming to the requirements of this specification. Such rejection or acceptance shall not be limited to the time of delivery, but shall be accomplished within thirty (30) days from receipt date. In the event of rejection, the vendor shall be immediately notified and the reason for the rejection explained. The vendor shall be given the opportunity to inspect representative samples of the rejected material. The vendor must express his desire to inspect rejected material within seven (7) days after notification of the rejection and the physical inspection must be performed within 30 days.						
8.0 <u>PACKAGING AND MARKING</u> Rings shall be shipped in suitable cartons to insure safe delivery. Only one size and class ring shall be in the individual cartons. Each carton shall be marked to show the vendor's name, size and class, elastomer, number of rings and P&PG Order Number. The letters B/R and the compound type, in 2" size, shall be placed on each carton.						
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T.C.O. REF. NO.

11

SPECIFICATION NO:

530

PAGE NO.:

3

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January 18, 1971

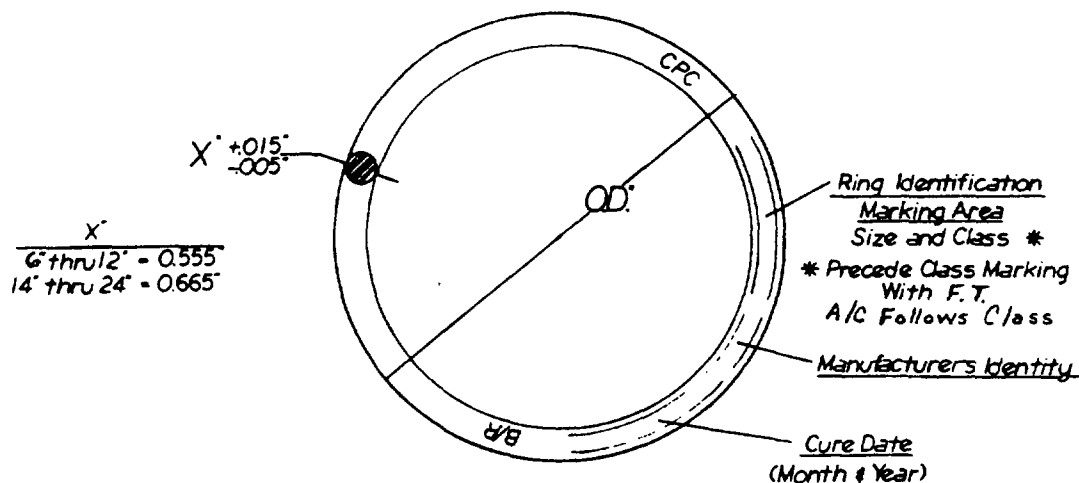
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DESCRIPTION:

Rubber Rings for Use With CPC Bureau of Reclamation (B/R) Pipe and Couplings
(May Also Be Used With Fluid Transmission (FT) Pipe and Couplings)

FIGURE 1



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T.C.O. REF. NO.

SPECIFICATION NO.

PAGE NO.:

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530

4

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DESCRIPTION:

Rubber Rings for Use With CPC Bureau of Reclamation (B/R) Pipe and Couplings
(May Also Be Used With Fluid Transmission (FT) Pipe and Couplings)

Size	Class	O.D. & Tolerance, Inches	Size	Class	O.D. & Tolerance, Inches
6"	40-45	7.57 +.100 -.060	18"	30-35	20.37 +.100 -.090
6"	50-60-70-80-90	7.79 +.100 -.060	18"	40-45-50	20.99 +.100 -.090
8"	30-35-40-45	9.68 +.100 -.060	18"	60	21.59 +.100 -.090
8"	50-60-70-80-90	9.99 +.100 -.060	18"	70-80	22.03 +.100 -.090
10"	30-35-40	11.78 +.100 -.070	18"	90	23.27 +.100 -.090
10"	45-50	12.13 +.100 -.070	20"	30-35	22.53 +.100 -.090
10"	60-70-80-90	12.55 +.100 -.070	20"	40-45-50	23.21 +.100 -.090
12"	30-35-40	13.88 +.100 -.070	20"	60	23.92 +.100 -.090
12"	45-50	14.33 +.100 -.070	20"	70-80	24.37 +.100 -.090
12"	60-70-80-90	14.81 +.100 -.070	20"	90	25.75 +.100 -.090
14"	30-35-40	16.12 +.100 -.080	21"	30-35	23.63 +.100 -.100
14"	45-50	16.55 +.100 -.080	21"	40-45-50	24.39 +.100 -.100
14"	60-70-80-90	17.27 +.100 -.080	21"	60	25.07 +.100 -.100
15"	30-35-40	17.16 +.100 -.080	21"	70-80	25.49 +.100 -.100
15"	45-50	17.73 +.100 -.080	21"	90	26.95 +.100 -.100
15"	60-70	18.33 +.100 -.080	24"	30-35	26.87 +.100 -.100
15"	80-90	19.04 +.100 -.080	24"	40-45-50	27.59 +.100 -.100
16"	30-35-40	18.20 +.100 -.080	24"	60	28.53 +.100 -.100
16"	45-50	18.79 +.100 -.080	24"	70-80	29.07 +.100 -.100
16"	60-70-80-90	19.51 +.100 -.080	24"	90	30.73 +.100 -.100

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August 27, 1971

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JAN 16 1973

DESCRIPTION:

Rubber Rings for Use With Bureau of Reclamation (B/R) Pipe and Couplings

NOT TO BE DISTRIBUTED TO VENDORS

1.0 INSPECTION

Sampling and inspection shall be carried out in accordance with P&PG Test Method TM-23.

2.0 REJECTION

The following procedure shall be followed on all rejected shipments.

2.1 The Headquarters Purchasing Department shall be notified. They will issue instructions on when and how the shipment is to be returned.

2.2 Quality Control Headquarters shall be notified and samples representative of the defect present in the shipment shall be forwarded to the Quality Control and Standards Manager.

3.0 APPROVED VENDORS

Reeves Rubber Co. 
San Clemente, California

Kirkhill Rubber Co. 
Brea, California

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