

TECHNICAL CHANGE ORDER

52 4/15/83

CertainTeed

CertainTeed Corporation
Pipe and Plastics Group

APPLICABLE TO:

A/C Standard Product Specification

Spec. #2 Sections A & B

DATE OF ISSUE:

SEP 28 1979

T.C.O. NO.:

49

PAGE NO.:

1

DESCRIPTION:

FLUID-TITE A/C Sewer Pipe, Couplings and Accessories
Classes 1500, 2400, 3300, 4000, 5000, 6000 and 7000 Sections A & B

PLAINTIFF'S EXHIBIT

CT-424

Purpose:

- 1) To revise 14", 15", 16" and 21" O.D. dimensions of pipe and the H and G dimension of couplings.

Ref: Letter J.P. Ungerman to M.R. Streepy, August 13, 1979
14", 15", 16" and 21" Fluid-Tite A/C Sewer Joints.

- 2) To reflect the changes (new design) of 14", 15", 16" and 21" pipe and coupling dimensions.
 - a) End Caps involving these sizes, now have dimensions to correspond with the new design.
 - b) A/C to A/C Increasers involving these sizes, also have dimensions to correspond with the new design.

Included in the notes of both End Caps and Increasers is a reference to Addendum pages A-1 and A-2 should dimensions for CG (old design) pipe and couplings be needed.

- 3) Addition of "handling label" reference to General Product Description.
- 4) In both Sections A and B, under the title Marking, a brief explanation as to where the "handling label" is attached.

Effective Date:

Date of issue.

CTD015286

Effect on Inventory:

Another reminder to keep inventories of the old design 14", 15", 16" and 21" pipe, couplings, rings and fittings as low as practical to speed up the transition to the new design when it occurs.

With regards to End Caps and Increasers, these inventories should also be kept as low as is practical where old design 14", 15", 16" and 21" sizes are involved.

PREPARED BY: <i>FDS</i>	APPROVED BY: <i>WRS</i>	SALES <i>WRS</i>	OTHERS
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CertainTeed CertainTeed Corporation Pipe and Plastics Group	APPLICABLE TO:		
	A/C Standard Product Specification		
	Spec. #2		Sections A & B
DATE OF ISSUE:	T.C.O. NO.:	PAGE NO.:	
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DESCRIPTION: FLUID-TITE A/C Sewer Pipe, Couplings and Accessories
 Classes 1500, 2400, 3300, 4000, 5000, 6000 and 7000 Sections A & B

Notes on Interchangeability:

As was mentioned in the March 5, 1979 issue of this specification and the February 12, 1979 issue of Standard Purchasing Spec. #531, the 14", 15", 16" and 21" new design rings are not compatible with the old couplings and the same is true for old rings and new couplings.

OLD DESIGN RINGS GO WITH OLD DESIGN COUPLINGS AND NEW DESIGN RINGS GO WITH NEW DESIGN COUPLINGS ONLY.

Concerning pipe and couplings, the 14" and 16" old and new designs are interchangeable provided the correct rings are used with the coupling.

THE 15" AND 21" OLD DESIGN PIPE SHOULD NOT BE USED WITH NEW COUPLINGS AND NEW DESIGN PIPE SHOULD NOT BE USED WITH OLD DESIGN COUPLINGS.

Disposition of Superseded Pages:

Destroy pages 3-2 and 3-3, 4-3 and 4-4, 5-3 to 5-6 all dated March 5, 1979, and pages 5-7 to 5-10 dated June 22, 1979, and replace with the attached pages. Addendum pages A-1 and A-2, which are printed on yellow paper, should be placed behind page 5-18 in your spec. book.

Also destroy pages 2-1 and 2-2 dated June 22, 1979 and replace with this issue of those pages.

CTD015287

PREPARED BY:	APPROVED BY:	DESIGN	MFG	SALES	FIELD	OTHERS
<i>FJB</i>	<i>MKS</i>	<i>JRM</i>	<i>WMA</i>	<i>JRA</i>		

TECHNICAL CHANGE ORDER

CertainTeed CertainTeed Corporation Pipe and Plastics Group	APPLICABLE TO: A/C Standard Product Specification Spec. #2		
	DATE OF ISSUE: JUN 22 1979	T.C.O. NO.: 48	PAGE NO.: 1

DESCRIPTION:
 FLUID-TITE A/C Sewer Pipe, Couplings and Accessories
 Classes 1500, 2400, 3300, 4000, 5000, 6000 and 7000 - Sections A and B

Purpose:

To make corrections to the Sewer Spec.

- 1) Asterisk removed from page 5-7.
- 2) 20" to 24" Increaser A/C to A/C, availability date correction.
- 3) 8" Heavy Elbows, Wyes and Tees B.O.D.'s corrected.
- 4) Removed PVC Manhole Adaptors which are now in Spec. #18.

Effective Date:

Date of issue.

Disposition of Superseded Pages:

Destroy pages 2-1, 3-1, 5-7 to 5-20 all dated March 5, 1979 of Spec. #2 in your A/C Standard Product Spec Book. Replace with the pages attached.

CTD015288

PREPARED BY: 	APPROVED BY: 	T.C.O. NO.: 48	INFO. NO.: 120	SALTS 120	OTHERS 120
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TECHNICAL CHANGE ORDER

CertainTeed CertainTeed Corporation Pipe and Plastics Group	APPLICABLE TO: A/C Standard Product Specification Spec. #2		
	DATE OF ISSUE: MAR 5 1979	T.C.O. NO.: 47	PAGE NO.: 1
DESCRIPTION: FLUID-TITE A/C Sewer Pipe, Couplings and Accessories Classes 1500, 2400, 3300, 4000, 5000, 6000 and 7000 Sections A and B			
<u>Purpose:</u> This revision to Spec #2 Sections A and B contains many significant changes that should be thoroughly reviewed by Q.C. and manufacturing. The changes are listed below: 1) Be aware that the intent at this time is to change the 14" and 16" Sewer Joint design to use a larger cross-section ring. Also 15" and 21" joints will be changed from Common Groove Sewer design to Fluid-Tite sewer. These changes were mentioned in the 2-12-79 issue of Purchasing Spec. #531 (for the rings) and are repeated below: <u>Note:</u> 14", 15", 16" and 21" new designs are not compatible with the old couplings and therefore are not interchangeable. The old rings go with the old couplings, and the new rings with the new couplings <u>only</u>. 14" and 16" pipe machining was changed only a minor amount, so either the new or the old combination of rings and couplings are compatible. In 15" and 21" the pipe "C" and "X" length machining will be changed so the old pipe should not be used with the new couplings and vice-versa. Please make sure you understand so that when the new ring molds are approved and inventories are available, we can phase out the old designs and bring on the new with as few problems as possible. The 14", 15", 16" and 21" size inventories of pipe, couplings, rings and fittings should be kept as low as practical to speed up the transition when it happens. The spec. shows both the old and new versions. The old version is printed on yellow paper to help highlight the fact that there are two designs during the transition period. Ref: Letter J. P. Ungerman to M. R. Streepy 1-15-79 - 14", 15", 16" Modified Fluid-Tite Sewer Joint Design.			
CTD015289			

PREPARED BY:	APPROVED BY:	R & D	MFG.	SALES	S.E.	OTHERS
<i>[Signature]</i>	<i>[Signature]</i>					

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TECHNICAL CHANGE ORDER

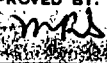
 CertainTeed Corporation Pipe and Plastics Group	APPLICABLE TO: A/C Standard Product Specification Spec. #2 <table border="1" style="width: 100%; border-collapse: collapse; margin-top: 5px;"> <tr> <td style="width: 33%; padding: 2px;">DATE OF ISSUE:</td> <td style="width: 33%; padding: 2px;">T.C.O. NO.:</td> <td style="width: 33%; padding: 2px;">PAGE NO.:</td> </tr> <tr> <td style="text-align: center; padding: 2px;">MAR 5 1979</td> <td style="text-align: center; padding: 2px;">47</td> <td style="text-align: center; padding: 2px;">2</td> </tr> </table>			DATE OF ISSUE:	T.C.O. NO.:	PAGE NO.:	MAR 5 1979	47	2
DATE OF ISSUE:	T.C.O. NO.:	PAGE NO.:							
MAR 5 1979	47	2							
DESCRIPTION: FLUID-TITE A/C Sewer Pipe, Couplings and Accessories Classes 1500, 2400, 3300, 4000, 5000, 6000 and 7000 Sections A and B									
2) A "t" dimension, which is the thickness at the OD₁ machining, has been added for all sizes. A 1% A.Q.L. was selected but may be revised in the future if ovality complaints persist. Ref: Letter A/C Sewer Pipe, Process Capability re "Min Wall Thickness Thru O.D.₁ From L.C. Kurfuerst dated 11-15-78. 3) Dimensions for Class 6000 and 7000 pipe, couplings and fittings have been added per Marketing's request in the 18" thru 24" sizes. These have been covered by several NSPS's in the past and are now standard products. 4) An alternate method for making small diameter Tees and Wyes has been shown. This method has been covered by NSPS for several years and uses pipe stock for the main rather than coupling stock. This method is applicable for the west coast plants only. 5) The B.O.D. tolerance for pipe and fittings have been changed. Generally pipe and some fittings were given minimum requirements only because excessive BOD will not affect their function. Couplings and most of the other fittings were given a +.25" -.00" tolerance because excessive B.O.D.'s can interfere with wye and tee clearances. The Formulations and Yields are going to be revised but will still be based on +.04" over the minimum B.O.D. The intent is that costs will control the B.O.D.'s. 6) B.O.D. tolerances have been added to the Manhole Stubs. This was important due to precast manholes and special adaptor rings which are available and cannot seal on excessively thick or declassified pipe. 7. PVC Manhole adaptors for 18" thru 27" PVC pipe were added. Ref: Letter J.P. Ungerman to M.R. Streepy dated 2-2-79 "Assignment #108-78 A/C Manhole Adaptors for 18" - 27" PSM PVC Pipe. 8. 12" Small Diameter Sewer FM's were removed. 9. Straightness requirement added (ASTM requirement not previously listed in spec).									

CTD015290

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TECHNICAL CHANGE ORDER

CertainTeed CertainTeed Corporation Pipe and Plastics Group	APPLICABLE TO: A/C Standard Product Specification Spec. #2					
	DATE OF ISSUE: MAR 5 1979	T.C.O. NO.: 47	PAGE NO.: 3			
DESCRIPTION: FLUID-TITE A/C Sewer Pipe, Couplings and Accessories Classes 1500, 2400, 3300, 4000, 5000, 6000 and 7000 Sections A and B						
10) Note about removing loose chips/lace curtains added. 11) Frequency of taking crush samples corrected to agree with outside specs. 12) Reference to Federal Spec. SS-P-331c corrected to SS-P-331d. 13) Prebelled marking requirement shown for 8" thru 24" sizes. 14) Increaser BOD's changed to use current pipe or coupling BOD's. 15) One certa-spacer required on 8" - 24" Elbows.						
<u>Effective Date:</u> Date of issue. The 14", 15", 16" and 21" size changeover to the new design won't take place until ring molds can be approved and inventories made and old design stocks are depleted.						
<u>Disposition of Superseded Pages:</u> Destroy Spec 2 Sections A and B. That is pages 1-1, 2-1, 3-1, 4-1 thru 4-16, 5-1 thru 5-16. All are dated February 18, 1977 except: 4-7, 4-8, 5-5, 5-6 which are dated 6-19-78 4-7, 4-10 which are dated 5-16-77 5-15, 5-16 which are dated 5-15-78 CTD015291 Replace with the new pages attached.						
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