

TECHNICAL SPECIFICATIONS

CertainTeedCertainTeed Corporation
Pipe and Plastics Group

SPECIFICATIONS CLASSIFICATION:

A/C Standard Purchasing Specification

T.C.O. REF. NO.

10

SPECIFICATION NO:

507

PAGE NO.:

1

SUPERSEDES:

April 17, 1973

DATE OF ISSUE:

MAR 7 1979

DESCRIPTION:

Rubber Rings For Use With FLUID-TITE CG Pipe and Couplings

1.0 Use

These rubber rings are intended for use as seals in Fluid-Tite CG 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 shall be manufactured to the dimensions specified in the drawings of Figures 1, 2 and 3 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 in each shipment of rings shall be inspected in its entirety at a circumferential elongation 50% in excess of the original circumference by the manufacturer before shipment to P&PG. Defective rings shall be removed from each shipment before shipment is made. All rings are to be shipped on a first-in first-out basis; i.e. oldest rings are shipped first.

5.2 Appearance5.2.1 Surface

The surface shall be smooth and clean. Any matter either foreign or migratory from the compound that gives a dirty appearance shall be cause for rejection. The surface shall be free from pitting, cracks, air and flow marks, blisters, and all other imperfections which would detrimentally affect the ring in service. A slightly raised radius around the holes is acceptable.

CTD014995

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10

SPECIFICATION NO:

507

PAGE NO.:

4

SUPERSEDES:

September 9, 1975

DATE OF ISSUE:

MAR 7 1972

DESCRIPTION:

5.2.2 Body

5.2.3 Permissible Defects

5.5.3.1 Mold Imperfections

5.2.3.2 Cuts, Tears, Gouges

5.2.3.2.2 Gouges less than 1/16" in length and depth are permitted on the ring edge. No more than four such gouges are permitted with any one ring.

5.2.3.3 Flash

At the ring edge the allowable flash shall be .063" thickness, 1/16" high. Buffing to remove excessive flash from the ring edges shall be permitted.

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 CertainTeed Corporation Pipe and Plastics Group	SPECIFICATIONS CLASSIFICATION:							
	A/C Standard Purchasing Specification							
	T.C.O. REF. NO.	SPECIFICATION NO:	PAGE NO.:					
	10	507	3					
SUPERSEDES:					DATE OF ISSUE:			
December 10, 1974					MAR 7 1975			
DESCRIPTION: Rubber Rings For Use With FLUID-TITE CG Pipe and Couplings								
5.2.4 <u>Color Designations</u> Each rubber ring shall be identified by color coding. 5.2.4.1 Molded (CG) rings shall be color coded per Table A by a continuous color stripe at least 1/8 inch wide on the back of the ring. 5.2.4.2 Extruded (CGX-7) rings shall be color coded by marking the identification markings in the color ink specified in Table B. 5.2.5 <u>Identification Marks</u> 5.2.5.1 Letter size shall be as required to permit clear, concise wording. 5.2.5.2 The date of manufacture shall be shown by the number of the quarter and the last two digits of the year, such as ①-79 denoting first quarter 1979. 5.2.5.3 One quarter turn from the date code shall be the manufacturer's insignia, cavity and mold number. 5.2.5.4 One half turn from the date code shall be the words ⑧ FLUID-TITE CG (or CGX-7) followed by the size and class. i.e., ⑧ FLUID-TITE CG 8" 100/150/200 5.2.5.5 Three-quarters turn from the date code shall be the words--Combined C'pl'ng and Gasket U.S. Pat. 2,871,031 (only applies to molded CG rings). 5.3 <u>Splice</u> The splice (if any) shall be properly joined and sufficiently strong to withstand a 50% circumferential elongation without separation. 5.4 <u>Dimensions</u> The dimensions shall be as shown in Figures 1, 2 and 3.								
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PREPARED BY:		APPROVED BY:		R & D	MFG.	SALES	I.E.	OTHERS
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SPECIFICATIONS CLASSIFICATION:

A/C Standard Purchasing Specification

T.C.O. REF. NO.

12

SPECIFICATION NO:

507

PAGE NO.:

4

SUPERSEDES:

March 7, 1979

DATE OF ISSUE:

IAN 9 1980

DESCRIPTION:

Rubber Rings For Use With FLUID-TITE CG Pipe and Couplings

6.0 Test Methods

6.1 Appearance - Visual in accordance with paragraph 5.2.

6.2 Splice - In accordance with paragraph 5.3.

6.3 Dimensions - In accordance with P&PG Test Method TM-23A.

7.0 Acceptance and Rejection

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 sixty (60) 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 Packaging and Marking

8.1 Rings shall be shipped in the size carton as shown in the chart below. The cartons shall be plain and 275 pound test regular slotted carton. The flute is to run parallel to the height. All cartons are to be sealed using reinforced tape.

The markings on the carton may be either vendor's label or stencil. All cartons must show the identical marking that is on the ring, the number of rings in the carton and P&PG Purchase Order No.; i.e. 20" - 150 70/80 21" - 40/45/50 Fluid-Tite CG 60 (No. of rings) P&PG Order No.

CTD014998

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 CertainTeed Corporation Pipe and Plastics Group	SPECIFICATIONS CLASSIFICATION:		
	A/C Standard Purchasing Specification		
	T.C.O. REF. NO. 12	SPECIFICATION NO: 507	PAGE NO.: 5
SUPERSEDES: March 7, 1979		DATE OF ISSUE: JAN 9 1980	

DESCRIPTION:

Rubber Rings For Use With FLUID-TITE CG Pipe and Couplings

8.2

Carton Size					Carton Contents		
Inside Dimensions					Rings per Coil	No. Coils	No. Rings
Size	Class	Length	Width	Height			
6-	A11	16½	16½	16½	25	6	150
8	A11	16½	16½	16½	25	5	125
10	A11	16½	16½	16½	25	4	100
12	A11	16½	16½	16½	25	3	75
14	A11	21	21	10	25	2	50
16	A11	21	21	10	25	2	50
18	A11	31	31	15	10	6	60
20	A11	31	31	15	10	6	60
21	A11	31	31	15	10	6	60
24	A11	31	31	15	10	5	50

9.0 Mold Approval

All new or reworked molds must be approved by the Materials Laboratory Supervisor of P&PG before such molds are allowed to be placed in production.

All rings, which are to be finished in the normal production method, will be inspected for marking, visual defects, and dimensions in accordance with paragraph 6.0.

Dimensions - From experience, it is known that in order to insure that all rings produced in a given cavity will be within specification limits, the mold approval tolerances shall be 80% of the published plus tolerance and 80% of the published minus tolerance for the O.D., and 100% of the published tolerances for all other dimensions.

CTD014999

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A/C Standard Purchasing Specification

T.C.O. REF NO.

10

SPECIFICATION NO:

507

PAGE NO.:

6

SUPERSEDES:

January 21, 1977

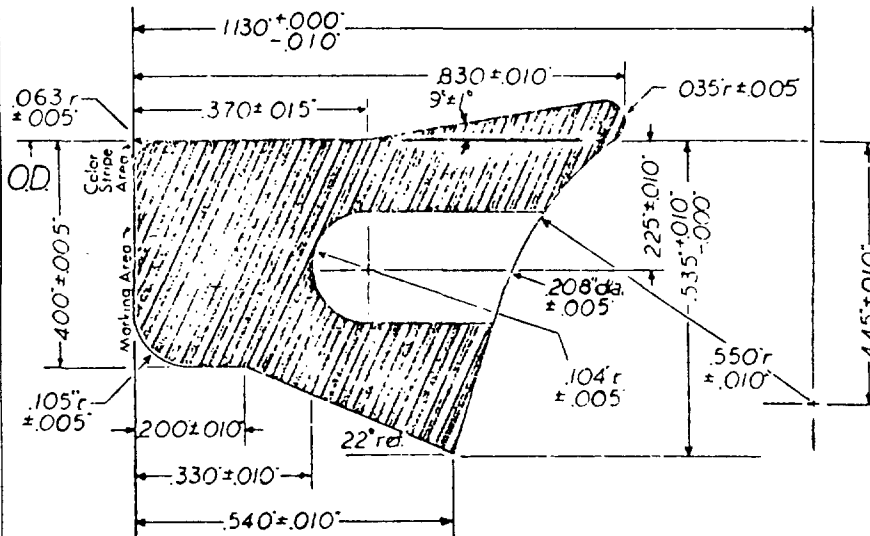
DATE OF ISSUE:

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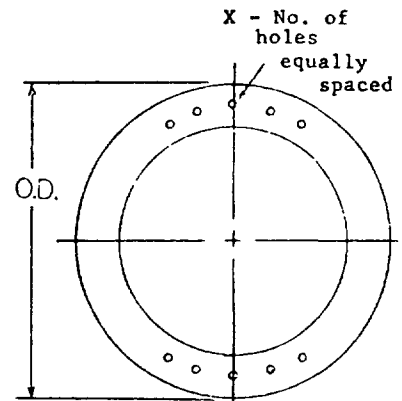
DESCRIPTION:

Rubber Rings For Use With Fluid-Tite CG Pipe and Couplings

Figure 1



CG Molded Rubber Ring



Product Line, Size, and Class		Irrigation	O.D. Inches	O.D. Tol. Inches	X-No. of Holes	Wt. Ring Lbs.
Pressure	Fluid Transmission					
4"	100/150/200*		5.57	±.020	38	.19
6"	100/150/200*	25/75	7.67	±.025	56	.25
8"	30/35/40/45	25/75*	9.59	±.035	68	.32
8"	100/150/200*		9.90	±.040	72	.33
10"	30/35/40	25/75*	11.69	±.045	84	.39
10"	100*		12.05	±.045	86	.41
10"	150/200*		12.47	±.050	92	.43
12"	30/35/40	25/75*	13.81	±.060	100	.46
12"	100*		14.27	±.060	104	.50
12"	150/200*		14.76	±.065	108	.52

* = Ring Marking

CTD015000

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A/C Standard Purchasing Specification

T.C.O. REF. NO.

11

SPECIFICATION NO:

507

PAGE NO.:

8

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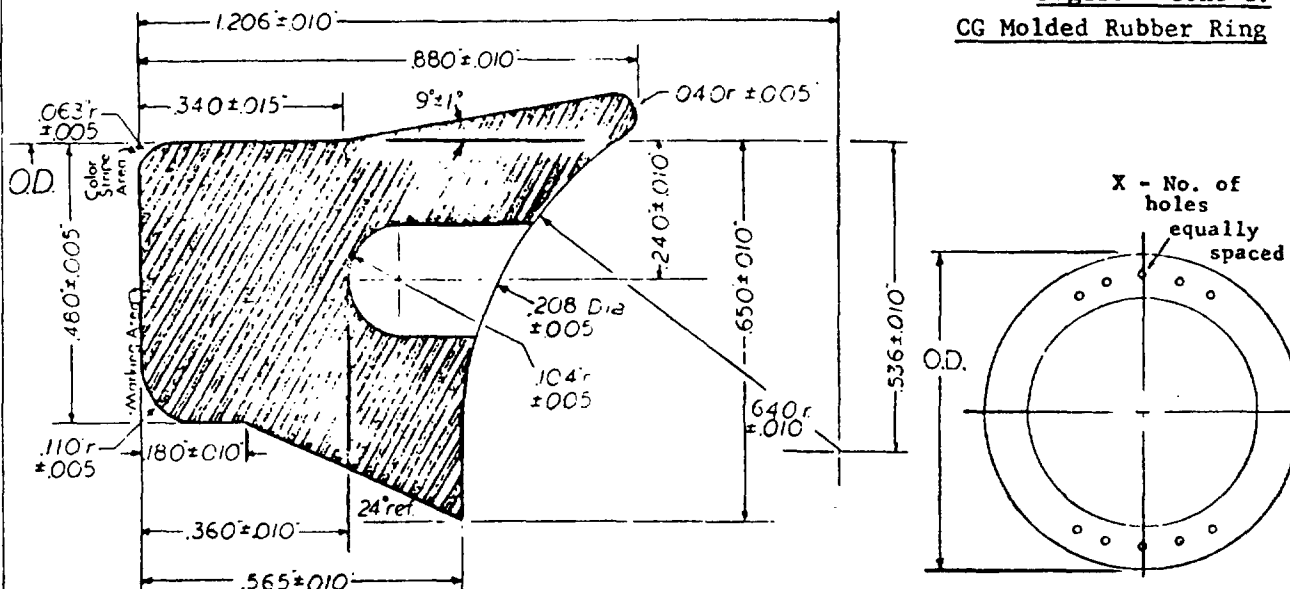
MAY 23 1979

DESCRIPTION:

Rubber Rings For Use With Fluid-Tite CG Pipe and Couplings

Figure 2 cont'd.

CG Molded Rubber Ring



Product Lines, Size, and Class			O.D. Inches	O.D. Tol. Inches	X No. of Holes
Pressure CG	Fluid Transmission	Irrigation			
18"-100	18"-30/35	25	20.30	+.090	150
	18"-40/45/50		20.92	+.090	154
	18"-60		21.53	+.095	158
18"-150	18"-70/80	25	21.98	+.095	162
	20"-30/35		22.47	+.095	166
	20"-40/45/50		23.22	+.095	170
20"-100	20"-60	21" 25	23.88	+.100	176
	20"-70/80		24.33	+.100	180
	21"-60		25.02	+.100	186
20"-150	21"-70/80	25	25.72	+.105	190
	24"-30/35		26.83	+.105	200
	24"-40/45/50		27.55	+.110	204
24"-100	24"-60	25	28.50	+.110	210
	24"-70/80		29.05	+.110	214

Note: Rings are marked for all uses.

CTD015002

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T.C.O. REF. NO.

10

SPECIFICATION NO:

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PAGE NO.:

9

SUPERSEDES:

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Rubber Rings For Use With Fluid-Tite CG Pipe and Couplings

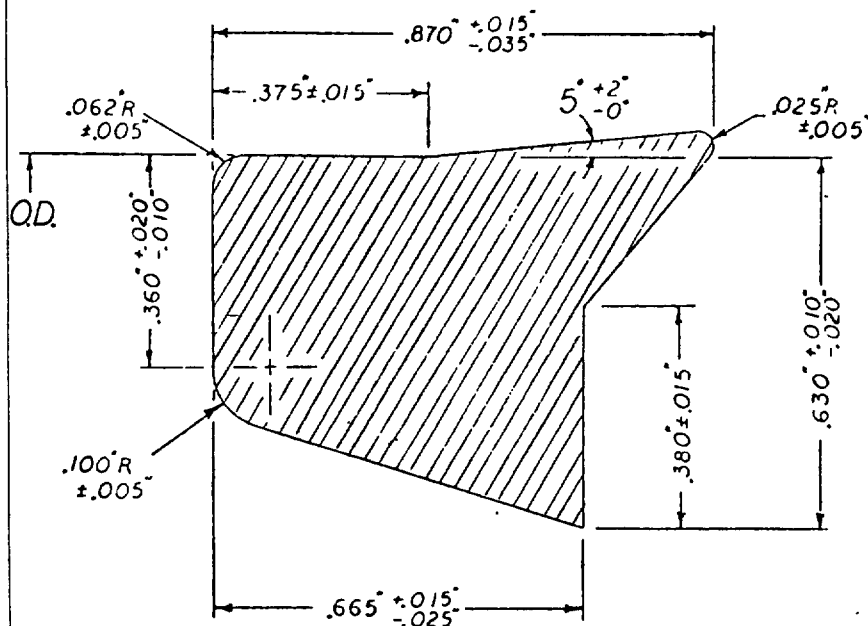
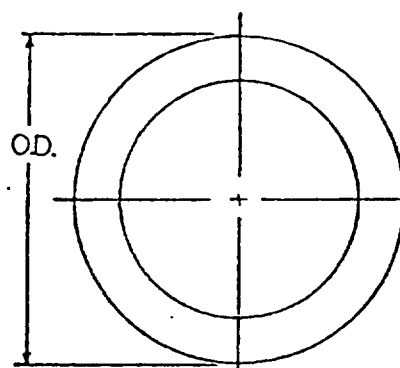


Figure 3
CGX-7 Extruded Rubber
Ring



Product Lines, Size and Class		O.D. Inches	O.D. Tol. Inches
Pressure CG	Fluid Transmission		
18" - 100	18" - 30/35	20.33	± .100
	18" - 40/45/50	20.95	± .100
	18" - 60	21.56	± .110
18" - 150	18" - 70/80	22.00	± .110
	18" - 90	23.24	± .110
	20" - 30/35	22.50	± .110
20" - 100	20" - 40/45/50	23.18	± .110
	20" - 60	23.90	± .120
20" - 150	20" - 70/80 21" - 40/45/50	24.35	± .120
	20" - 90	25.74	± .120
	21" - 30/35	23.59	± .120
21" - 60	21" - 60	25.04	± .120
	21" - 70/80	25.46	± .120
24" - 100	24" - 30/35	26.85	± .130
	24" - 40/45/50	27.57	± .130
	24" - 60	28.52	± .140
24" - 150	24" - 70/80	29.06	± .140

Note: Rings are marked for all uses.

CTD015003

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	T.C.O. REF. NO. 11	SPECIFICATION NO: 507	PAGE NO.: 10
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DESCRIPTION:

Rubber Rings For Use With Fluid-Tite CG Pipe and Couplings

Table A

Marking and Color Identification of CG Molded Rings

Product Lines, Size, and Class			Irrigation CG	Marking	Marking Color	
Pressure CG	Fluid Transmission				NR + SBR	NBR
4" 100/150/200				4" 100/150/200	Orange	Gray
6" 100/150/200	40/45/50/60/70/80/90		25/75	6" 100/150/200	Orange	Gray
8"	30/35/40/45		25/75	8" 25/75	Blue	Pink
8" 100/150/200	50/60/70/80/90			8" 100/150/200	Orange	Gray
10"	30/35/40		25/75	10" 25/75	Blue	Pink
10" 100	45/50			10" 100	Yellow	Brown
10" 150/200	60/70/80/90			10" 150/200	Orange	Gray
12"	30/35/40		25/75	12" 25/75	Blue	Pink
12" 100	45/50			12" 100	Yellow	Brown
12" 150/200	60/70/80/90			12" 150/200	Orange	Gray
14" 100	30/35/40		25/75	14" 100	Yellow	Brown
14"	45/50			14" 45/50	Red	Purple
14" 150/200	60/70/80/90			14" 150/200	Orange	Gray
15"	30/35/40		25/75	15" 25/75	Blue	Pink
15"	45/50			15" 45/50	Yellow	Brown
15"	60/70			15" 60/70	Orange	Gray
15"	80/90			15" 80/90	Green	White
16" 100	30/35/40		25/75	16" 100	Yellow	Brown
16"	45/50			16" 45/50	Red	Purple
16" 150/200	60/70/80/90			16" 150/200	Orange	Gray
18"	30/35		25	18" 30/35 T-25	Blue	Pink
18" 100	40/45/50			18" 100 40/45/50	Yellow	Brown
18"	60			18" 60	Green	White
18" 150	70/80			18" 150 70/80	Orange	Gray
20"	30/35		25	20" 30/35 T-25	Blue	Pink
20" 100	40/45/50 18" 90			20" 100 40/45/70 18"-90	Yellow	Brown
20"	60 21" 30/35	21" 25		20" 60 21" 30/35 21" 25	Green	White
20" 150	70/80 21" 40/45/50			20" 150 70/80 21" 40/45/50	Orange	Gray
21"	60			21" 60	Green	White
21"	70/80 20" 90			21" 70/80 20" 90	Orange	Gray
24"	30/35		25	24" 30/35 T-25	Blue	Pink
24" 100	40/45/50			24" 100 40/45/50	Yellow	Brown
24"	60			24" 60	Green	White
24" 150	70/80			24" 150 70/80	Orange	Gray

CTD015004

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<u>Table B</u> <u>Marking and Color Identification of CGX-7 Extruded Rings</u>																																																																																																												
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th colspan="2" style="text-align: left; padding: 5px;">Product Lines, Size and Class</th> <th style="text-align: center; padding: 5px;">O.D.</th> <th style="text-align: center; padding: 5px;">O.D. Tol.</th> <th colspan="2" style="text-align: center; padding: 5px;">Marking Color</th> </tr> <tr> <th style="text-align: left; padding: 5px;">Pressure CG</th> <th style="text-align: left; padding: 5px;">Fluid Transmission</th> <th style="text-align: center; padding: 5px;">Inches</th> <th style="text-align: center; padding: 5px;">Inches</th> <th style="text-align: center; padding: 5px;">NR + SBR</th> <th style="text-align: center; padding: 5px;">NBR</th> </tr> </thead> <tbody> <tr> <td rowspan="3" style="text-align: center; padding: 5px;">18" - 100</td> <td style="padding: 5px;">18" - 30/35</td> <td style="text-align: center; padding: 5px;">20.33</td> <td style="text-align: center; padding: 5px;">± .100</td> <td style="text-align: center; padding: 5px;">Blue</td> <td style="text-align: center; padding: 5px;">Pink</td> </tr> <tr> <td style="padding: 5px;">18" - 40/45/50</td> <td style="text-align: center; padding: 5px;">20.95</td> <td style="text-align: center; padding: 5px;">± .100</td> <td style="text-align: center; padding: 5px;">Yellow</td> <td style="text-align: center; padding: 5px;">Brown</td> </tr> <tr> <td style="padding: 5px;">18" - 60</td> <td style="text-align: center; padding: 5px;">21.56</td> <td style="text-align: center; padding: 5px;">± .110</td> <td style="text-align: center; padding: 5px;">Green</td> <td style="text-align: center; padding: 5px;">White</td> </tr> <tr> <td rowspan="3" style="text-align: center; padding: 5px;">18" - 150</td> <td style="padding: 5px;">18" - 70/80</td> <td style="text-align: center; padding: 5px;">22.00</td> <td style="text-align: center; padding: 5px;">± .110</td> <td style="text-align: center; padding: 5px;">Orange</td> <td style="text-align: center; padding: 5px;">Gray</td> </tr> <tr> <td style="padding: 5px;">18" - 90</td> <td style="text-align: center; padding: 5px;">23.24</td> <td style="text-align: center; padding: 5px;">± .110</td> <td style="text-align: center; padding: 5px;">Red</td> <td style="text-align: center; padding: 5px;">Purple</td> </tr> <tr> <td style="padding: 5px;">20" - 30/35</td> <td style="text-align: center; padding: 5px;">22.50</td> <td style="text-align: center; padding: 5px;">± .110</td> <td style="text-align: center; padding: 5px;">Blue</td> <td style="text-align: center; padding: 5px;">Pink</td> </tr> <tr> <td rowspan="3" style="text-align: center; padding: 5px;">20" - 100</td> <td style="padding: 5px;">20" - 40/45/50</td> <td style="text-align: center; padding: 5px;">23.18</td> <td style="text-align: center; padding: 5px;">± .110</td> <td style="text-align: center; padding: 5px;">Yellow</td> <td style="text-align: center; padding: 5px;">Brown</td> </tr> <tr> <td style="padding: 5px;">20" - 60</td> <td style="text-align: center; padding: 5px;">23.90</td> <td style="text-align: center; padding: 5px;">± .120</td> <td style="text-align: center; padding: 5px;">Green</td> <td style="text-align: center; padding: 5px;">White</td> </tr> <tr> <td style="padding: 5px;">20" - 70/80</td> <td style="text-align: center; padding: 5px;">24.35</td> <td style="text-align: center; padding: 5px;">± .120</td> <td style="text-align: center; padding: 5px;">Orange</td> <td style="text-align: center; padding: 5px;">Gray</td> </tr> <tr> <td rowspan="3" style="text-align: center; padding: 5px;">20" - 150</td> <td style="padding: 5px;">21" - 40/45/50</td> <td style="text-align: center; padding: 5px;">25.74</td> <td style="text-align: center; padding: 5px;">± .120</td> <td style="text-align: center; padding: 5px;">Red</td> <td style="text-align: center; padding: 5px;">Purple</td> </tr> <tr> <td style="padding: 5px;">21" - 30/35</td> <td style="text-align: center; padding: 5px;">23.59</td> <td style="text-align: center; padding: 5px;">± .120</td> <td style="text-align: center; padding: 5px;">Blue</td> <td style="text-align: center; padding: 5px;">Pink</td> </tr> <tr> <td style="padding: 5px;">21" - 60</td> <td style="text-align: center; padding: 5px;">25.04</td> <td style="text-align: center; padding: 5px;">± .120</td> <td style="text-align: center; padding: 5px;">Green</td> <td style="text-align: center; padding: 5px;">White</td> </tr> <tr> <td rowspan="3" style="text-align: center; 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O.D. Tol.	Marking Color		Pressure CG	Fluid Transmission	Inches	Inches	NR + SBR	NBR	18" - 100	18" - 30/35	20.33	± .100	Blue	Pink	18" - 40/45/50	20.95	± .100	Yellow	Brown	18" - 60	21.56	± .110	Green	White	18" - 150	18" - 70/80	22.00	± .110	Orange	Gray	18" - 90	23.24	± .110	Red	Purple	20" - 30/35	22.50	± .110	Blue	Pink	20" - 100	20" - 40/45/50	23.18	± .110	Yellow	Brown	20" - 60	23.90	± .120	Green	White	20" - 70/80	24.35	± .120	Orange	Gray	20" - 150	21" - 40/45/50	25.74	± .120	Red	Purple	21" - 30/35	23.59	± .120	Blue	Pink	21" - 60	25.04	± .120	Green	White	24" - 100	21" - 70/80	25.46	± .120	Orange	Gray	24" - 30/35	26.85	± .130	Blue	Pink	24" - 40/45/50	27.57	± .130	Yellow	Brown	24" - 150	24" - 60	28.52	± .140	Green	White	24" - 70/80	29.06	± .140	Orange	Gray
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TECHNICAL SPECIFICATIONS

CertainTeed

CertainTeed Corporation
Pipe and Plastics Group

SPECIFICATIONS CLASSIFICATION:

A/C Standard Purchasing Specification

T.C.O. REF. NO

10

SPECIFICATION NO:

507 Addendum

PAGE NO.:

1

SUPERSEDES:

April 17, 1979

DATE OF ISSUE:

MAR 1979

DESCRIPTION:

Rubber Rings For Use With Fluid-Tite CG 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-23A.

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 (A/C) shall be notified and samples representative of the defect(s) present in the shipment, if requested, shall be forwarded to the Quality Control Manager (A/C).

3.0 Approved Vendors

Molded CG Rings

Kirkhill Rubber Company
Brea, California

Approved to Manufacture: 6" and 8" Class 100/150/200; 14" Class 100; 10", 12", 14", 16" 18" and 20" Class 150/200; 12" 25/75.

Reeves Rubber Company
SanClemente, California

Approved to Manufacture: 10" thru 24" Class 100; 6" and 8" Class 100/150/200; 10" thru 24" Class 150/200; 6" thru 24" Class 30 thru 90; 8", 10", 12" and 15" Class 25/75.

Extruded CGX-7 Rings

Reeves Rubber Company and National Plastics both have dies, however, neither is approved. Reeves were out-of-spec dimensionally, while National Plastics didn't have an approved compound and the dimensions were out.

CTD015006

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

