

TECHNICAL SPECIFICATIONS

CertainTeedCertainTeed Corporation
Pipe and Plastics Group

SPECIFICATIONS CLASSIFICATION:

Standard Purchasing Specification

T.C.O. REF. NO.

SPECIFICATION NO:

PAGE NO.:

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502

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SUPERSEDES:

August 23, 1971

DATE OF ISSUE:

September 20, 1983

DESCRIPTION:

Stencil Ink to Mark A/C Pipe, Couplings, and Accessories

1.0 GENERAL1.1 Description

The inks described herein are insoluble inks that will withstand autoclaving and weathering. The colors presently used are black, green, orange and brown.

1.2 Use

The ink is intended to mark pipe and to identify the type pipe by color coding. The color codes are:

- | | |
|---|-----------|
| 1.2.1 Pressure Pipe Classes 100 and 200 | -- Black |
| 1.2.2 Pressure Pipe Class 150 | -- Orange |
| 1.2.3 Sewer Pipe All Classes | -- Green |
| 1.2.4 Irrigation Pipe and Transmission, all Types | -- Black |
| 1.2.5 Storm Drain Pipe | -- Brown |

1.3. Lot Size

For sampling and inspection purposes, a lot shall be defined as any color shipped at one time and identified by a code number.

2.0 REQUIREMENTS2.1 Special

All inks shall be approved in writing by the Director of Quality Assurance of CertainTeed Pipe and Plastics Group (P&PG) and referenced by a compound number assigned by the vendor. After approval, no change in the compound may be made without authorization, in writing, from the Director of Quality Assurance. When such a change is authorized, it shall be referenced by a new compound number. The manufacturer shall inform the Purchasing Department and the Director of Quality Assurance when such an authorized change is actually placed in effect.

2.2 Manufacturer's Inspection

The manufacturer shall perform such inspection and testing that all defective material is removed from each shipment before shipment is made to P&PG.

CTD014960

PREPARED BY:	APPROVED BY:	R & D	MFG.	SALES	I.E.	O.C.	OTHERS
<i>M. R. [Signature]</i>		<i>AS</i>	<i>RSB</i>	<i>J.E.A.</i>			<i>CJS</i>

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2.3 Viscosity

	<u>No. 4 Ford Cup</u>	<u>Equivalent No. 2 Brookfield Cup</u>
Efflux Time	10.0 sec. minimum	25 cp
	30.0 sec. maximum	98 cp

2.4 Autoclaving

Ink shall not fade, change color, or become chalky.

2.5 Weatherability

Ink shall maintain its original color.

2.6 Color

Ink shall be compared with P&PG standard stencil ink samples. A slight variation in color will be allowed.

3.0 TEST METHODS

3.1 Viscosity

ASTM Test Method D 1200-65 No. 4 Ford Viscosity Cup Method. Acceptable alternate method is No. 2 Brookfield Cup at 20 rpm 70°F $\pm$ 2°.

3.2 Autoclaving

A standard pipe or coupling to be done in plant. Twelve hours @ 150 psig. saturated steam.

3.3 Weatherability

Pipe or coupling samples that have been autoclaved shall be exposed to outdoor weathering for one year.

3.4 Color

For each approved color, vendors are to supply three appropriate colored samples to the standards section for filing with this spec. The samples shall be used for comparison purposes. The inks shall be painted on 3 1/2" x 5" white background cardboard.

4.0 PACKAGING AND MARKING

Stencil ink shall be packaged in one (1) gallon metal containers with a friction or screw top lid and spout for pouring. Each can shall be labeled or marked as a minimum to show the vendor's name, CertainTeed purchase order number, color of ink and vendor code for the ink. Shipping cartons shall be marked in the same fashion.

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5.0 <u>ACCEPTANCE AND REJECTION</u> CertainTeed Products Corporation reserves the right to reject any lot or lots found not conforming to the requirements of this specification. Such rejection or acceptance of lot, lots, or portions thereof 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 advised and the reason for the rejection explained. The vendor shall be given the opportunity to inspect rejected material or representative samples of the rejected material, prior to final disposition. The vendor must express his desire to inspect rejected material within seven (7) days after notification of the rejections and the physical inspection of rejected material must be performed within 30 days after the notification of rejections.							
CTD014962							
PREPARED BY:	APPROVED BY:	R & D	MFG.	SALES	I.E.	Q.C.	OTHERS
M. R. Streepy		1/	AB	J.R.A.			GBS

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<u>NOT TO BE DISTRIBUTED TO VENDORS</u> The following vendors have been approved as satisfactory sources for purchasing stencil ink. <table border="1"> <thead> <tr> <th><u>NAME AND ADDRESS</u></th> <th><u>COLOR</u></th> <th><u>COMPOUND NUMBER</u></th> </tr> </thead> <tbody> <tr> <td>Garvey-Labelmatic 11550 Adie Hd Maryland Heights, MO 63043</td> <td>Black</td> <td>"Ace of Spades"</td> </tr> <tr> <td>American Coding and Marking Ink Company 1220 North Avenue Plainfield, NJ 07062</td> <td>Black Orange Green Brown ** Blue *</td> <td>1600 1600 1600 1600 1600</td> </tr> <tr> <td colspan="3">(201) 756-0373</td> </tr> <tr> <td colspan="3">Attn: Richard A. Sweet Technical Director</td> </tr> </tbody> </table> * No longer applied to Irrigation pipe. ** This color is under test and expected to be approved at a later date.							<u>NAME AND ADDRESS</u>	<u>COLOR</u>	<u>COMPOUND NUMBER</u>	Garvey-Labelmatic 11550 Adie Hd Maryland Heights, MO 63043	Black	"Ace of Spades"	American Coding and Marking Ink Company 1220 North Avenue Plainfield, NJ 07062	Black Orange Green Brown ** Blue *	1600 1600 1600 1600 1600	(201) 756-0373			Attn: Richard A. Sweet Technical Director		
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